



Birchwood Laboratories LLC
7900 Fuller Road
Eden Prairie, MN 55344
Tel: 952 937 7931
Fax: 952 937 7979
www.birchwoodtechnologies.com

ANTIQUE BLACK® M20 Antiquing Solution
Operating Instructions

PRODUCT DESCRIPTION

ANTIQUE BLACK® M20 Antiquing solution is a general purpose browning and blackening solution for use on copper, brass & bronze surfaces, and works on both solid and electroplated parts. Supplied as a liquid concentrate, the product is diluted with water to make up an immersion solution that operates at room temperature to produce medium-dark browns and black finishes. The finish can be highlighted for pleasing black, brown or US10B finishes.

OPERATING CONDITIONS

Bath Make-Up Concentration	20-25% by volume for dark brown/black 10-15% by volume for lighter brown shades.
Operating Temperature	Room Temperature
Equipment Construction	Acid-proof tank: plastic or PVC lined.
Ventilation	None required. No fumes.
Filtration	Desirable for production-scale tanks. Use acid-proof pump and 50-100 micron polypropylene filter element.

PARTS PROCESSING GUIDELINES

1. **CLEAN** and degrease the parts for five minutes in SAFE SCRUB® M Multi-Metal liquid cleaner, mixed at 10-20% by volume; 100-140° F. Or, use bead blast techniques.
OR, electroplate parts, applying a minimum thickness of 0.0002".
2. **RINSE** in clean water tank for 30 seconds, to remove cleaner/plating residues.
3. (Optional) **REMOVE TARNISH** and neutralize residual plating cyanide by immersing parts in 5% sulfuric acid or sulfuric acid salts; Room Temp; 1 minute. **RINSE** in clean water for 30 seconds.
4. **APPLY ANTIQUE FINISH** by immersing parts in ANTIQUE BLACK® M20 solution for 1-3 minutes, as needed, to produce the desired color. Agitate parts gently to assure solution contact with all surfaces.

5. **RINSE** in clean water tank for 20 seconds.
6. **DRY** the parts and apply lacquer. Or, **HIGHLIGHT** the finish with an abrasive or polishing wheel or in a vibratory finisher. Apply protective topcoat, such as clear lacquer, wax or oil. Note: the topcoat will enhance and darken the color of the finish as it is absorbed. The final color should be judged after the topcoat is applied.

BATH MAINTENANCE

The ANTIQUE BLACK® M20 bath can be operated as a permanent bath in the process line and is controlled by total acid titration, or by using the CCK Color Change Test Kit (available from Birchwood Technologies®). Other methods, such as total acid titration or Atomic Absorption (with a selenium lamp) may also be used. Maintain the bath strength at 80% of original make-up or higher. Keep tank covered when not in use to minimize contamination and evaporation.

Before Using This Product – Please Read, Understand and Follow all the Precautions shown on the Product Label and on the Safety Data Sheet.

The Safety Data Sheet can be found on our website:

<https://www.birchwoodtechnologies.com/Downloads/Safety.html>

Use Appropriate Warning Labels on any Container used to Store or Apply this Product.

PACKAGING

1, 5 gallon containers; 15 and 55 gallon non-returnable drums. Store indoors in closed containers.

NOTE: The information contained herein is provided in good faith and is believed to be correct as of the date below. However, Birchwood Laboratories LLC makes no representation as to the comprehensiveness or accuracy of the information. It is expected that individuals receiving the information will exercise their independent judgment in determining its appropriateness for a particular purpose. Accordingly, Birchwood Laboratories LLC will not be responsible for damages of any kind resulting from the use of or reliance upon such information.