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ANTIQUÉ BLACK® M80 Immersion Blackener
Operating Instructions

PRODUCT DESCRIPTION

ANTIQUÉ BLACK® M80 oxidizer is a room temperature blackening solution for brass, bronze and copper. Supplied as a liquid concentrate, it produces tightly adherent finishes with no excess ruboff. For this reason, coverage per gallon is extremely high – 400-500 ft²/gallon for black finishes; 600-800 ft²/gallon for brown finishes. ANTIQUÉ BLACK® M80 oxidizer offers finishers high quality antique finishes at a low operating cost in both rack and barrel process lines.

OPERATING CONDITIONS

Bath Makeup	10-20% by volume in tap water.
Operating Temperature/Time	Room Temp/1-3 minute immersion
Tank Construction	Plastic or acid proof material

PROCESSING PARTS

For brass plated surfaces, blackening works best when carried out immediately after plating:

1. BRASS PLATE, as normal (minimum thickness: 0.2 mil or 20 minutes plating time).
2. RINSE well in clean water.
3. NEUTRALIZE CYANIDE by immersing parts in “sour” rinse (2-5% sulfuric acid or 1 oz./gallon acid salts) to neutralize residual cyanide; 10 second immersion.
4. RINSE well in clean water.
5. BLACKEN by immersion in M80 bath for 1½-2 minutes for black tones or 30-90 seconds for brown tones.
6. RINSE well in clean water.
7. DRY, HIGHLIGHT if desired, & SEAL with lacquer or oil topcoat. Note: accelerated warm drying minimizes water staining.

For solid brass parts, the surface must be cleaned so they are free of oil and oxide, as follows:

1. CLEAN parts in alkaline soak cleaner, electrocleaner or ultrasonic cleaner; 70-150°F; 3-5 minutes.
2. RINSE well in clean water.
3. REMOVE TARNISH in mild acid solution -- 10% sulfuric acid or 4 oz./gallon acid salts.
4. RINSE well in clean water.
5. Continue with steps 5 through 7 above.

BATH MAINTENANCE

It is recommended that the bath be periodically tested with the BIRCHWOOD TECHNOLOGIES CCK-1 Color Change Test Kit, and maintained at 80% of its original strength or greater. A 50-100 micron particle filter works well to keep the production bath clean.

PACKAGING

5 gallon and 55 gallon non-returnable drums. Store in closed container.

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.

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