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OXYPRIME® POWDER Surface Conditioner (Patented)
Operating Instructions

PRODUCT DESCRIPTION

OXYPRIME® POWDER Surface Conditioner is used to apply a special base coat, or primer coat, on iron and steel in preparation for blackening by TRU TEMP® Low Temperature Black Oxide. Supplied as a free-flowing powder, the product dissolves in water, with good stirring, and operates at room temperature.

OPERATING CONDITIONS

To use as a Primer before TRU TEMP®

Mix 1 lb/gal in tap water.
Use at room temperature
with a 5-8 minute immersion time.
Tank: Plastic or acid-proof
Not needed. No fumes.
Desirable for densely loaded racks

Equipment Construction
Ventilation
Solution Agitation

PROCESS SEQUENCE

The OXYPRIME® POWDER Surface Conditioner is used as part of a multi-step blackening process, as follows:

1. **CLEAN** the metal parts by soaking in PRESTO KLEEN® HP alkaline cleaner (mixed at 8 oz/gallon; operated at 150° F; 5-8 minutes). Or, use other cleaning methods appropriate to the part condition, bead blasting, shot peening, etc., to remove surface soils and oxides.
2. **RINSE** in clean water; 30 seconds.
3. **APPLY PRIME COAT** by immersing parts in OXYPRIME® POWDER solution (operated at 70-140° F, for 5-8 minutes).
4. **RINSE** in clean water; 30 seconds.
5. **BLACKEN** in TRU TEMP® Black Oxide bath (operated at 200-205°F; 10-15 minutes).
6. **RINSE** in clean water; 30 seconds.

7. **SEAL** in a rust preventive appropriate to the end-use of the parts, such as:
DRI-TOUCH® AMBER IRP2 rust preventive for a soft waxy finish;
Or in SHEATH® RB1 water-displacing oil, for a slightly oily finish;
Or in SHEATH® WS12 water-soluble oil for fast-drying, slightly oily finish.

BATH MAINTENANCE

The OXYPRIME® POWDER solution can be maintained by testing for acid content, using the Go/NoGo Test Kit (available from Birchwood Technologies®). As the bath works, the acid content will gradually diminish and the solution will pick up iron from the parts being processed. The bath can be replenished by additions of OXYPRIME® POWDER. Eventually, the tank should be dumped and re-charged with a fresh mix. The spent bath is normally sewerable after pH adjustment.

PACKAGING AND STORAGE

40 pound and 400 pound non-returnable drums. Store in closed container in a dry area.

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.

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.

OXYPRIME® POWDER Primer
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