



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

OXYPRIME® XPL Liquid Primer/Prep (Patented)
Operating Instructions

DESCRIPTION

OXYPRIME® XPL Liquid Primer/Prep is used to apply a primer coat on ferrous metal surfaces in preparation for blackening by TRU TEMP® Low Temperature Black Oxide. Supplied as a liquid concentrate, the product is mixed with water and used at Room Temperatures in most installations, but can be heated as high as 150° F, if necessary, to increase its activity on non-reactive alloys, such as high speed steels, or to descale parts with surface rust or heat-treat scale. OXYPRIME XPL can be controlled by a color-change test kit or conventional titration.

OPERATING CONDITIONS

Bath Make-Up Concentration	10% by volume on low carbon steel 20% for tool steels/high alloys 30-50% for rusty/scaly parts
Operating Temperature	70° F for most parts 100-150° F for high alloys/derusting
Immersion Time	5-10 minutes, as needed.
Equipment Construction	Tank: plastic or acidproof Heater: Teflon coated
Ventilation	Desirable if solution is heated.

PROCESS SEQUENCE

The OXYPRIME® XPL Primer/Prep 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® XPL 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 XPL solution can be maintained by testing for free acid content, using the Go/NoGo Test Kit, or by conventional titration methods. As the bath works, the acid content will gradually diminish and the solution will dissolve iron from the parts being processed. Normal maintenance calls for periodic additions of OXYPRIME® XPL concentrate. The bath should be changed out every 3-6 months, depending on work load. Your Birchwood Technologies® representative can guide you.

PACKAGING AND STORAGE

5 gallon pail and 55 gallon non-returnable drums. Store indoors in closed containers.

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.