

BLACK OXIDE KIT COLD SYSTEM

Simple Dip & Coat Method

Professional Results In Minutes

The commercial gun blue manufacturers developed this new technique as a more environmentally friendly system than the commonly used hot application. Parts requiring blackening are simply placed in the liquid at room temperature. No electrical power is required.

Thoroughly clean the part to be blackened by either sandblasting, wire brushing, wire wool abrasive cleaning or by scrubbing in JEX, VIM or COMET household abrasive cleaner. Make sure you have removed all rust, paint, oil and grease.

Mix 500mL of Black Oxide Concentrate with 4.5L of distilled water in a plastic pail.

For DIPPING the RATIO of mixing for all sizes is 1 part black oxide solution to 9 parts water.

Immerse the part in the mixed Black Oxide Solution and swirl around for between 30 secs and 5 minutes. Alternatively, the part may simply be placed in the solution for 5-10 minutes. Remove the part from the solution and rinse in fresh water.

Immediately brush on or dip the part into the Penetrating Sealant and allow to soak in the liquid for 5-10 minutes. Shake off any excess and allow part to dry thoroughly before handling.

Some hardened or specialized steels will not readily accept the blackening process. To enhance blackening effect either warm the part to approx. 65 deg C, or warm the liquid to 27 deg C before use. To enhance corrosion resistance, pre-plate the part with either our Zinc or Copy Cad plating system for approx. 5-10 minutes prior to dipping in the Black Oxide System.

Wiping Method on items too Large to Dip

Thoroughly clean the part to be blackened by either sandblasting, wire brushing, wire wool abrasive cleaning or by scrubbing in JEX, VIM or COMET household abrasive cleaner. Make sure you have removed all rust, paint, oil and grease.

Mix 500mL of Black Oxide Concentrate with 1.5L of distilled water in a plastic pail.

For WIPING the RATIO of mixing is 1 part black oxide solution to 3 parts water.

Make sure the floor under the area to be blackened is protected. DO NOT let excess run off into the drain, the EPA will be unimpressed.

You can use any cloth as a swab to coat the steel, a paint roller with a soft covering will work and you can get the coating done quickly. The time for the parts to go black with this method can vary depending on the steel being blackened.

The steel should be wiped down with water to remove any remaining acid solution, dried and a sealer then applied. Our kits include a penetrating oil based sealer, but there are other options such as a 2 pack or a clear acrylic. Caswell seals a Clear Acrylic Gloss, CSEAL.