

APPLICATION DATA SHEET

BLACKFAST 181 IRON/STEEL BLACKING SOLUTION

USE: 25% solution in water.

APPLICATION: Blackfast 181 will chemically black cast iron and steels containing 12% chromium or less at room temperature (20°C). Blacking performance may be adversely affected by temperatures lower than 16°C. Preparation of the surface of the item to be blacked is carried out using one or more steps involving degreasing, pickling and conditioning using the appropriate Blackfast products with intermediate flowing water rinses. Once the surface is chemically clean and, if necessary, conditioned, the item is immersed in the Blackfast solution for 1 minute.

Components are normally jigged or barrelled with agitation if necessary to ensure all parts of the metal surface are in contact with the liquid. Following blacking, the item is rinsed in a flowing water bath and finally dipped in a dewatering oil such as Blackfast 825, 833 or 841 depending on the type of finish required. Thus a typical blacking line can involve 7 tanks (degreasing - rinse - conditioning - rinse - blacking - rinse - oiling).

TESTING AND CONTROL When in regular use, the performance of Blackfast 181 can be monitored readily by the appearance of the blacked components and the time taken to achieve the correct result. In addition a simple test can be undertaken to check the strength of the tank solution.

10ml of tank solution is placed in a transparent conical flask and a few drops of bromocresol green indicator added. The contents of the flask are titrated with a test solution (N/25 NaOH) until the original green colour has changed to blue. Consumption of 20ml of the test solution indicates a tank of the correct strength. For each one ml shortfall from the reading of 20ml, it is necessary to add 1.25% Blackfast 181 (i.e. for a 100 litre bath add 1.25 litres of Blackfast 181).

TANK MATERIAL Tanks should be of plastic, rubber lined steel or stainless steel.

PRODUCT SAFETY DATA SHEET: A safety data sheet is available.

Blackfast 181 is part of the Blackfast range of products for the treatment of iron, steel and aluminium at low temperatures.

Blackfast Chemicals continues to improve the quality and performance of its range of products and reserves the right to modify product formulations without prior notice.

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