

# APPLICATION DATA SHEET

## BLACKFAST 481 ALUMINIUM BLACKING SOLUTION

USE: 25% solution in water.

APPLICATION: Blackfast 481 when used with the other Blackfast Aluminium blacking products will chemically black Aluminium 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 Blackfast degreasing, etching and conditioning products with intermediate flowing water rinses. Once the surface is chemically clean and conditioned, the item is immersed in Blackfast 481 solution for 30 seconds to 1 minute. Components are normally jigged or placed in a basket and agitated 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 833 or 933 depending on the type of finish required. Thus a typical blacking line can involve 9 tanks (degreasing - rinse - etching - rinse - conditioning - rinse - blacking - rinse - oiling).

Local exhaust ventilation is recommended. The etching and conditioning solutions contain Sodium Hydroxide which react with Aluminium producing Hydrogen gas. Hydrogen can form explosive mixtures in air.

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

SOLUTION STRENGTH CONTROL The test is carried out by taking 10ml of Blackfast 481 blacking solution from the working tank and adding a few drops of bromocresol green. The solution becomes green/yellow in colour. 0.04M (N/25) Sodium Hydroxide is added until the solution turns blue. An addition of 8ml indicates the working solution is satisfactory. For each 1ml shortfall, it is necessary to top up the working tank with 3% Blackfast 481 concentrated solution.

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

Blackfast 481 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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