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**ALUMA BLACK® A15 Blackening Solution**  
Operating Instructions

**PRODUCT DESCRIPTION**

ALUMA BLACK® A15 Blackening Solution works on all forms of aluminum to form a non-dimensional black finish. Supplied as a liquid concentrate, the product is diluted with water and applied by immersion techniques. The finish can be sealed and used as a solid black finish on machine components, or highlighted to produce a simulated pewter finish on decorative hardware.

**OPERATING CONDITIONS**

Bath Makeup	33% by volume. (2 parts water + 1 part A15)
Equipment Construction	Plastic, or acid proof materials.
Ventilation	Desirable.

**BLACKENING PROCEDURES**

1. CLEAN & DEOXIDIZE the metal surface to remove all oils and oxide films. (All aluminum carries a transparent, natural oxide that must be removed prior to blackening) Acceptable methods of cleaning include bead blasting or chemical cleaning in SAFE SCRUB® M Multi-Metal Cleaner (mixed at 20% by volume and operated at 150° F). Typical immersion time is 5 – 8 minutes.
2. RINSE parts in clean water; 30 seconds.
3. BLACKEN by immersing parts in ALUMA BLACK solution until parts are uniformly gray/black in color.
4. RINSE in clean water; 30 seconds.
5. SEAL the black finish with SATIN SHIELD® SS10 acrylic sealant, or in CLEARLOK® urethane emulsion. Allow to dry.  
The parts may also be force air dried, and then highlight with an abrasive pad to produce an antique finish, and then apply appropriate topical sealant.

## **BATH MAINTENANCE**

As the ALUMA BLACK® bath operates, its concentration will gradually diminish. The bath should be replenished with A15 concentrate to restore normal strength, based on testing with the CCK test kit, or through free sample testing available from Birchwood Technologies®.

## **PACKAGING & STORAGE**

1, 5, and 55-gallon plastic containers, non-returnable drums. Store indoors in closed container.

***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. 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.

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