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**OXYPRIME® XT Primer/Prep**  
Operating Instructions

**PRODUCT DESCRIPTION**

OXYPRIME® XT Primer/Prep is specially formulated apply a base coat, or primer coat, on steel and stainless surfaces in preparation for blackening by TRU TEMP® XT Mid Temperature Black Oxide.

OXYPRIME® XT Primer/Prep operates at room temperatures in most installations but can be heated as high as 120° F, if necessary, to increase its activity on non-reactive alloys or parts with heavy surface rust or scale. OXYPRIME® SS operates as a semi-permanent bath and can be controlled by a color-change test kit.

**OPERATING CONDITIONS**

|                            |  |
|----------------------------|--|
| Bath Make-Up Concentration | 4 oz/gal for non-scaly parts<br>8 – 16 oz/gallon for descaling parts |
| Operating Temperature      | room temperature – 120° F  |
| Immersion Time             | 10 – 15 minutes.   |
| Equipment Construction     | Tank: Polypro or acidproof<br>Heater: Teflon                         |
| Ventilation                | Desirable if solution is heated.                                     |

**BLACKENING PROCEDURES**

The OXYPRIME® XT Primer/Prep is used as part of a multi-step process that utilizes the following sequence:

1. **CLEAN** the parts in PRESTO KLEEN® HP, mixed at 8 – 12oz/gal and operated at 150°F. Typical immersion time of 8 minutes.
2. **RINSE** in clean flowing water; 30 seconds.
3. **APPLY PRIMER** in OXYPRIME® XT solution; room temp – 120°F; 10 – 15 minutes.
4. **RINSE** in clean flowing water; 30 seconds.

5. **BLACKEN** in TRU TEMP® XT bath; 250 – 260° F; 15 – 20 minutes.
6. **RINSE** in clean flowing water; 30 seconds.
7. **SEAL** in a rust preventive topcoat appropriate to the end use of the article:  
Use DRI TOUCH® AMBER IRP2 solvent-based sealant for dry-to-touch finish or use SHEATH® PLUS water-soluble oil (at 15% by volume) for oily finish.

### **BATH MAINTENANCE**

The OXYPRIME® XT solution can be maintained by testing for total acid content, using the Go/NoGo Test Kit (available from Birchwood Technologies®). As the bath works, the acid content will gradually diminish, and the solution will pick up small amounts of dissolved iron from the parts being processed.

Normal maintenance calls for periodic additions of OXYPRIME® XT powder. The bath should be changed out periodically, depending on work load. Your Birchwood Technologies® representative can guide you on process design and solution maintenance.

### **PACKAGING AND STORAGE**

40 pound and 400 pound non-returnable drums. Store 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.