

# PLATING PRODUCTS IND PVT LTD

Plot No.G 527, Phase 2, UPSIDC, M.G. Road, Industrial Area, Tehsil Dhaulana, Dist. Hapur, Uttarpradesh 201015.

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Gala No. 116, Saraf Udyog Bhavan, Chincholi Phatak, Malad (West), Mumbai – 400 064.

Phone: 9821340134/ 8104437477 Email: [lab@platingproducts.in](mailto:lab@platingproducts.in) or [info@platingproducts.in](mailto:info@platingproducts.in)

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## Technical Data Sheet

### NICKEL FREE BLAK 327

#### Room Temperature Oxidizing Solution for Copper, Brass, Bronze, White Metal, Silver and Tin/Lead Alloys

**Nickel free blak 327** liquid concentrate is diluted with water and used at room temperature as an immersion “oxidizing” solution. The colors produced vary from brown on white metal, silver and tin/lead to purple, grey to black, and gun metal blue on copper, brass and bronze. These colors are also depended upon immersion time and concentration.

#### INSTRUCTIONS

**Nickel free blak 327** liquid concentrate is diluted with water and used at room temperature. For better and fast reaction the solution is heated to 60°C. The color, depth of color and reaction rate is controlled by varying the concentration and the length of immersion. Prior to charging a production tank, some experimentation should be done with properly prepared sample parts to determine the conditions required to produce the desired finish. As a starting point, dilute one (1) part **Blak 327** concentrate with four (4) parts water and immerse parts 30 seconds to five minutes. Varying the amount of water will shorten or lengthen the immersion time. The concentration range is 10 - 20% by volume.

#### EQUIPMENT REQUIRED

Acid resistant tanks, tumbling barrels, baskets and racks must be used with the **Blak 327** and **E-Pik** solutions. Plastic, plastic lined, rubber lined, glass or stoneware are suitable. Mild steel may be used for the cleaning, rinsing and sealant tanks.

#### BLACKENING PROCEDURE

1. Thoroughly clean and degrease pieces to be blackened with **PPI's E-Kleen 146** or **E-Kleen 152**.
2. Rinse with cold water.
3. Remove surface oxide if present with **PPI's E-Pik 215**.
4. Rinse with cold water.
5. Immerse pieces in **Blak 327** solution for the length of time necessary to achieve the depth of black.
6. Rinse with hot or cold water and force dry.
7. A variety of attractive antiqued or “highlighted” finishes are produced by buffing, scratch brushing, barrel or vibratory burnishing.
8. A protective topcoat of **PPI's E-Tec 521** wax or **E-Tec 520** clear lacquer should be applied to enhance the color and give added corrosion resistance and abrasion resistance.

## **SOLUTION MAINTENANCE**

The solution is gradually depleted through use but may be replenished indefinitely with periodic additions of **Nickel free blak 327** concentrate. The strength of solution can be maintained by noting the time of immersion. When the time required to produce the desired depth of black increases, add sufficient concentrate to reduce the time to your established standard. The frequency of additions will depend upon the volume of work processed.

## **CAUTION**

The **Nickel free blak 327** solution is mildly acidic. Avoid contact with eyes, skin and clothing. Wear eye protection (glasses, goggles, or face shield), protective gloves and aprons when mixing solutions and while working with the solutions. In case of contact flush skin and eyes with generous amounts of cold water and obtain medical attention.

Avoid contact of **Blak 327** concentrate and solutions with alkaline materials. Do not mix **Blak 327** with any other chemicals or solutions.

Do not use **Blak 327** without first reading and understanding the **MATERIAL SAFETY DATA SHEET** furnished by **PPI**.

## **PACKAGING**

One (1), five (5), Thirty-Five (35) and Two hundred 200 Litre non-returnable containers.

## **IMPORTANT NOTICE : for industrial use only.**

The following is made in lieu of all warranties , expressed or implied , including the implied warranties of merchantability and fitness for purpose.

Neither seller nor manufacturer shall be liable either in tort or in contract for any loss or damage , direct , incidental or consequential arising out of the use or the inability to use the product

