



Product Bulletin

Better Chemistry. Better Business.

Black-Magic™ RT Predip P

Product Code: 2260018
Revised Date: 01/11/2013

Black-Magic™ RT Predip P

Black-Magic™ RT Predip P is a mildly acidic surface conditioner/activator used prior to the application of Black Magic RT S20, S25 or S26 finishes on iron and steel.

Black-Magic™ RT Predip P is used as a mild activator for difficult-to-blacken passive steel surfaces or as a conditioner to enhance the RT S20, S25 or S26 procedure.

Black-Magic™ RT Predip P liquid concentrate is normally diluted to 7% by volume in water and used at temperatures of 100° F - 130° F.

INSTRUCTIONS

EQUIPMENT

Acid-resistant polypropylene PVC, plastic-coated or rubber-lined tanks, hooks, baskets and tumbling barrels must be used with the **Black-Magic™ RT Predip P** solutions. A stainless steel tank is permissible for the **Black-Magic™ RT Predip P** solution. However, stainless steel cannot be used for baskets, hooks or barrels which will be immersed in the Black Magic RT S20, S25 or S26 blackening solutions.

SURFACE PREPARATION

Surfaces to be conditioned and/or activated prior to blackening must first be thoroughly cleaned with a solution of Mi-Clean™100. The type and degree of surface soil will determine the length of time required for cleaning and the cleaning temperature. (See Mi-Clean 100 instruction sheet).

Surface rust, if present, must be removed following the cleaning cycle. Lightly rusted surfaces should be derusted with a solution of Hubbard-Hall's Acid Salt W (dry acid salts) and heavily rusted surfaces with a solution of Deruster 11J.

TYPICAL FINISHING PROCEDURE

1. Thoroughly clean (and derust, if necessary).
2. Water rinse
3. **Black-Magic™ RT Predip P**
4. Water rinse



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5. Blacken with Black-Magic™ RT S20, S25 or S26.
6. Water rinse
7. Seal

Please refer to Black-Magic™ RT S20, S25 or S26 instruction sheet for more complete processing instructions.

SOLUTION MAKEUP, REPLENISHMENT AND MAINTENANCE

The preferred concentration for a **Black-Magic™ RT Predip P** working solution is 7% by volume in water. Prior to charging a production tank, some experimentation should be done with properly prepared sample parts, using dilutions of 3% to 7% by volume and operating temperatures of 100 to 130° F. Immersion times should be varied from one (1) to 5 minutes to determine the best parameters to obtain the ultimate depth of black.

Test Kit:

1. Using a 5 ml syringe, transfer 5 ml of **Black-Magic™ RT Predip P** working solution into a mixing bottle. Fill bottle ½ way with clean water.
2. Add 8 to 10 drops phenolphthalein indicator to the sample solution in the beaker.
3. Add 1.0N Sodium Hydroxide, drop wise to the solution with constant swirling until the solution turns a faint permanent pink color. Record the number of drops added.

%/vol **Black-Magic™ RT PREDIP P** drops of 1.0N sodium hydroxide x 0.35

CAUTION

The **Black-Magic™ RT Predip P** concentrate and working solutions are mildly acidic. Avoid contact with eyes, skin and clothing. Wear eye protection (glasses, goggles or face shield), protective gloves and rubber apron when mixing solutions and while working with the solutions.

Avoid contact of **Black-Magic™ RT Predip P** concentrate and solution with alkali materials.

DO NOT MIX Black-Magic™ RT Predip P WITH ANY OTHER CHEMICALS OR SOLUTIONS.



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WARRANTY

THE QUALITY OF THIS PRODUCT IS GUARANTEED ON SHIPMENT FROM OUR PLANT. IF THE USE RECOMMENDATIONS ARE FOLLOWED, DESIRED RESULTS WILL BE OBTAINED. SINCE THE USE OF OUR PRODUCTS IS BEYOND OUR CONTROL, NO GUARANTEE EXPRESSED OR IMPLIED IS MADE AS TO THE EFFECTS OF SUCH USE, OR THE RESULTS TO BE OBTAINED.