



Better Chemistry. **Better Business.**

Black-Magic™ RT Predip S

Product Code: 2260001
Revised Date: 01/11/2013

Black-Magic™ RT Predip S

A surface conditioner/activator used prior to the application of Black Magic RT-S finishes on iron and steel.

RT Predip S is used as an activator for difficult-to-blacken passive steel surfaces or as a conditioner to enhance the depth of black when iridescent finishes are obtained by using the standard Black Magic RT-S procedure.

RT Predip S liquid concentrate is normally diluted to 10% by volume in water and used at temperatures of 75°F to 120°F.

INSTRUCTIONS

EQUIPMENT

Acid-resistant polypropylene, PVC, plastic-coated or rubber-lined tanks, hooks, baskets and tumbling barrels must be used with the **RT Predip S** solutions. A stainless steel tank is permissible for the **RT Predip Solution**. However, stainless steel cannot be used for baskets, hooks or barrels which will be immersed in the Black Magic RT-S 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 Alkaline Deruster 2.

TYPICAL FINISHING PROCEDURE

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



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4. Water rinse
5. Blacken with Black-Magic™ RT-S
6. Water rinse
7. Seal

Please refer to Black Magic RT-S instruction sheet for more complete processing instructions.

SOLUTION MAKEUP, REPLENISHMENT AND MAINTENANCE

The preferred concentration for a **RT Predip S** working solution is 10% by volume in water. Prior to charging a production tank, some experimentation should be done with properly prepared sample parts, using dilutions of 5% to 10% by volume and operating temperatures of 75° to 120°F.

Immersion times should be varied from one (1) to 5 minutes to determine the best parameters to obtain the ultimate depth of black.

The strength of the **RT Predip S** working solution is easily determined with the following procedure:

1. Transfer 5 ml of **RT Predip S** working solution to a 250 ml beaker with a 10 ml graduated cylinder. Rinse the graduated cylinder with clean water and add to the 250 ml beaker.
2. Add 8 to 10 drops phenolphthalein indicator to the sample solution in the beaker.
3. Using the 4 oz. dropping bottle containing 1.0N sodium hydroxide, add drops to the sample solution in the 250 ml beaker with constant swirling until the solution turns a faint permanent pink color. Count the drops as they are being added.
4. Concentration of **RT Predip S** (fl. oz/gallon) = Number of drops of 1.0N sodium hydroxide x 0.80.

OR

Concentration of **RT Predip S** (% by volume) = Number of drops of 1.0N sodium hydroxide x 0.60.

A test kit is available and contains:

- 1 each 10 ml Graduated Cylinder
- 1 each 250 ml Beaker
- 1 each 2 oz Dropping bottle of phenolphthalein indicator
- 1 each 4 oz Dropping bottle of 1.0N sodium hydroxide



Product Bulletin

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CAUTION

The **RT Predip S** 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 **RT Predip S** concentrate and solution with alkali materials.

DO NOT MIX RT PREDIP S WITH ANY OTHER CHEMICALS OR SOLUTIONS.

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.