

Accu-LABS INC.

4831 S. Whipple Avenue
Chicago IL 60632
Phone: 773.523.3100 Fax: 773.523.4008
www.accu-labs.com

A2LA Accredited ISO/IEC 17025:2005 Certificate # 2558.01

407 BLACKEN OIL

407 BLACKEN OIL is a water soluble rust retardant oil that contains a minimum of 84% oil and naphthenate sulfonate type emulsifiers. The oil is used diluted with quantities of water. 407 BLACKEN OIL contains rust inhibiting compounds to protect steel against rust of the order of 10-15 hours in salt spray when applied from a dilution of 25% by volume with water.

OPERATING CONDITIONS:

Concentration	5 – 90% by volume with water
Temperature	Ambient - 150°F DO NOT EXCEED 150°F

MAKE-UP: 407 BLACKEN OIL is used diluted with various quantities of water. When a heavy film is needed, a dilution of one volume of oil to three volumes of water is recommended. When thin films are desired, dilutions up to 9 volumes of water to 1 volume of oil are used. The oil water mixture is best applied by heating the mixture to 150°F that facilitates drying of the water from the oil film. DO NOT EXCEED 150°F as this can cause a breakdown of the emulsion.

APPLICATION: Parts chemically blackened in alkaline oxidizing solutions should have the surface alkali neutralized by means of dipping for a 1 oz. /gal. of chromic acid 1-3 seconds before treating with 407 BLACKEN OIL. This is done because traces of alkali may lessen the salt spray resistance of #407 BLACKEN OIL.

EQUIPMENT: 407 BLACKEN OIL solutions may be contained in steel, stainless steel, or lined tanks. It can be heated with steel steam coils or Plate coils.

CAUTION: Always wear eye and personal protective gear when handling or working with this product. Read MSDS prior to use.

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