

# ACCU-LABS INC.

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**A2LA Accredited ISO/IEC 17025:2005 Certificate # 2558.01**

## **PATOX 15**

### **BLACKENING COMPOUND FOR COPPER AND ITS ALLOYS**

ACCU-LABS PATOX 15 produces a stable, adherent, and durable black oxide coating on copper and its alloys. The appearance of the finish is dependent upon the condition of the surface. Beautiful glossy black finishes are obtained on buffed or burnished copper and brass. Dull finishes are obtained on sand blasted or etched surfaces. PATOX 15 coatings being stable and absorbent provide a good base for organic finishes such as paints and lacquers.

The coating produced by PATOX 15 is a hard cupric oxide, which is extremely chemically and physically stable, and can withstand severe handling deformations and wear. PATOX 15 coatings withstand temperatures up to 400°F, without breaking down.

Copper alloys of 90% or more present no problems in blackening. Alloys containing less than 90% copper are more difficult to blacken and require the use of PATOX 15A Activator to insure the attainment of a good uniform deep black.

#### **OPERATING GUIDELINES (Alloys Containing Over 90% Copper)**

<b>Concentration</b>	<b>1 ½ lb PATOX 15 per gallon of water</b>
<b>Temperature</b>	<b>210-215°F</b>
<b>Tank</b>	<b>Mild or stainless steel</b>
<b>Time of Immersion</b>	<b>5-10 minutes</b>

- 1. Clean**
- 2. Water Rinse**
- 3. Acid Dip**
- 4. Water Rinse**
- 5. Blacken in PATOX 15**
- 6. Rinse**
- 7. Hot water rinse**
- 8. Dry**

## **OPERATING GUIDELINES**

### **Alloys Containing 65-90% Copper**

<b>Concentration</b>	<b>1 lb PATOX per gallon of water</b>
<b>Temperature</b>	<b>Boiling point</b>
<b>Tank</b>	<b>Mild steel</b>
<b>Time of Immersion</b>	<b>1-3 minutes</b>

- 1. Clean**
- 2. Water rinse**
- 3. Acid dip**
- 4. Rinse in cold running water**
- 5. Activate in PATOX 15A Brass Activator**
- 6. Water rinse**
- 7. Blacken in PATOX 15**
- 8. Water rinse**
- 9. Hot water rinse**
- 10. Dry**

**CAUTION: PATOX 15A and PATOX 15 are strong alkalis and strong oxidizing agents. Contact with organic material, reducing agents should be avoided. Neoprene gloves, aprons, and goggles should be worn when handling PATOX 15A and 15.**

### **NOTICE OF NON WARRANTY**

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