SBX™ Gel

SBX™ Gel is a room temperature blackening process for iron and steel. This product can be used on hot and cold rolled carbon steels, cast iron, alloy steel, forged steel and powdered metal. It does not blacken stainless steel.

Features/Benefits

- Room temperature operation to save costs
- Black finish that matches a hot black oxide process
- Excellent corrosion protection

Equipment

SBX™ Gel is acidic and so acid resistant tanks, barrels, racks, hooks and baskets should be used. Polypropylene, polyethylene or PVC material can be used for parts containers. Plastic or rubber lined tanks are agreeable. A continuous circulation and filtration system through a 50 micron filter is required for SBX™ Gel to remove solid by-products.

Operating Conditions

To blacken parts, they first must have a clean surface without rust to ensure uniform finish. Presence of air bubbles gives uneven black surface; therefore, agitation is a key to breaking up the air bubbles and creating good contact with solution. Large volume of small parts requires a rotating, perforated plastic barrel.

Process Steps

1. Clean parts with alkaline cleaner.
2. Rinse for at least 30 seconds in a bottom fed overflowing cold water rinse.
3. Blacken in SBX™ Gel.
4. Cold water rinse
5. Seal the finish with oil while still wet from the preceding rinse.

Concentration	8-16%	Optimum 10%
Temperature	Ambient	
Time	1-5 minutes	

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Replenishment and Maintenance

Depletion of SBX™ Gel is caused by use and drag-out and is replenished with periodic additions of concentrate. The amount of additions can be tracked via a titration or the time is takes for a part to blacken. For example, if a part that typically takes 2 minutes to blacken is now taking 4 minutes, then add sufficient amount of concentrate to reduce the oxidizing time back to 2 minutes. Frequency of additions is highly dependent on volume of parts and surface area. Small and frequent additions are preferable to avoid defective parts.13

The data and statements contained in this bulletin are based on testing information and are believed to be accurate and reliable. This bulletin is not a Guarantee or Warranty, express or implied regarding the products use. The product is sold on the condition that the purchaser will do their own tests to determine the suitability of the product in a particular application.

READ THE SDS BEFORE USING THIS PRODUCT

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