



KROHN INDUSTRIES

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Black -FreeTM **BLACK ANTIQUE PLATE** **(Decorative)**

Product Description:

Black-FreeTM is a black antique plating solution which is used over many different metals. The solution plates a rich black coating which is easily relievable with minor abrasion.

Black-FreeTM offers an easily maintainable alternative to flammable and toxic black lacquer dipping baths.

Black-FreeTM is supplied as ready to use, for ease of set-up and trouble free operation.

Applications:

To plate over Tin, Pewter, Copper, Brass, Nickel, Gold, Sterling Silver, and most other similar metals.

Cautions: Read all safety information before using this product.

1. Use only with proper ventilation.
2. Wear gloves, safety goggles, apron.
3. Avoid contact with eyes and skin.

Operating Conditions:

Temperature	120-140°F (49-65°C)
Current Density	3-4 Volts (10-40 ASF) 30 seconds-2 minutes
PH	10-11
Beaker	Pyrex
Anodes	Stainless Steel

Bath Set Up:

1. Fill beaker with **Black-Free™** and heat to 130°F.
2. Check connections from rectifier to anode and work, be sure the negative (-) and positive (+) wires are connected properly. The work should be charged negative (-), and the anode positive (+).
Turn rectifier on.
3. Plate for 30-60 seconds at 3-4 volts depending on size of part and degree of blackness desired.
4. Larger parts require slightly higher voltage, while smaller parts require lower voltage. If part shows any browning and is not dark then the voltage needs to be increased.
5. After plating rinse part thoroughly in water and dry, or relieve while wet.
6. Relieving: There are many ways to remove the black surface from the high areas. A few are a scratch pad, a tumbler, or a vibratory finisher.
7. Lacquering the surface afterwards will add a shine to the antique.

Discard and Replace:

Black-Free™ is a rugged bath and guidelines have been provided to help assure the long life of this bath. If, however, a problem should arise that cannot be solved by any of the above recommendations, or recommendations by our or any other qualified laboratory, the bath may need to be replaced: Transfer to a DOT approved container. Check with local authorities for proper disposal methods.