

# TECHNICAL DATA SHEET

## Blackodise PS MS-110

### An alkaline Blackodise salts for Black coating on Iron and Steel

#### 1. PRODUCT DESCRIPTION

Black PS MS -52/MS-110 product adherent, non flaking and corrosion resistant

Black coating on iron and steel parts by immersion process. Sealing of the black

Coating is necessary and can be achieved by oiling, waxing or lacquering.

Finish depends upon the preparation of base metal and final oiling, waxing or

Lacquering. Bright finish can be achieved by polishing the surface to fine degree

and by giving a coat of high-bodied glossy clear baking enamel on untouched

Black finish. Shot blasting polishing with greaseless composition or etching the

Basis surface can obtain no reflective finish.

#### 2. ADVANTAGES

Tolerant to copper & Iron contamination resulting in the elimination of red submit. Lower drag out & tank spray because of effective surface-active agents. Low Sludge formation resulting in the economy of heating.

Suitable to wide range of Iron alloy, carbon, steel cast and malleable irons. Coating thickness upto 3-5

Microns can be obtained.

#### 3. OPERATING PARAMETERS

Black PS MS-52/ MS-110 : 0.9 / 1.0 Kg per litre

Working Temperature : 135°C-145°C

Contact Time : 5-15 mins

Application Type : Dipping

#### 4. MAINTENANCE

To get desired resulted; the solution should boil within the operating temperature

of 135-145°C. If the solution boils, below 135°C, black PS MS-52 salt should be

added to increase the boiling point. For every 1C rise 20-25g/l of salt is required.

Water evaporates from the bath and the boiling point of the solution slowly

increases. If the boiling point of the solution increases more than 145°C, water

should be added to maintain the boiling range of 138-145°C.

The temperature of the solution should not be allowed to rise above 150°C, as the bath constituents will get destroyed.

Since operating temperature of the solution is above the boiling point of water, addition of water should be made very carefully to avoid splattering and eruption of the solution.

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5 **EQUIPMENT**

Steel or stainless steel tanks, heaters, etc. are suitable for black PS MS 52/MS-110

process. For addition of water 3/8" water pipe should be fitted just above normal

solution level. The end of the pipe should be capped and 1/8" hole should be drilled in the pipe on the side facing the tank wall. Also the end of the pipe should be covered with a splashguard to minimize the spread of solution spray when the cold water comes in contact with solution.

6. **PREPARATION OF SOLUTION**

Clean the tank free of grease, rust and scale. Fill half of its capacity with clean

the cold water. Slowly add the salt by stirring. Dissolve the salt and make up

level. Heat the solution to the required temperature and use the bath.

7. **SEQUENCE OF OPERATION**

Surface preparation

Degrease

Rinse

Pickle in acid or alkaline solution

Rinse

Black PS MS-52/MS-110

Water Rinse

Dry

Oil, Wax and Lacquer.

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