



# THE COMPLEAT SCULPTOR

90 Vandam Street New York NY 10013  
212-243-6074 TCS@SCULPT.com  
800-9-SCULPT www.SCULPT.com

## ANTIQUÉ BLACK® M20 OXIDIZER Instructions

### DESCRIPTION

ANTIQUÉ BLACK® M20 oxidizer is a Room Temperature chemical conversion finish for brass, bronze and copper. The product is diluted with water, used at room temperature and produces colors from a light to dark browns and black, with no dimensional or structural change in the base metal. ANTIQUÉ BLACK M20 oxidizer can be used on solid or electroplated surfaces to produce pleasing antique black, brown or US10B finishes.

### OPERATING CONDITIONS

Bath Make-Up Concentration	20-25% by volume for dark brown and black finishes. 10-15% by volume for lighter brown shades.
Operating Temperature	Room Temperature
Equipment Construction	Acid-proof tank: plastic or stainless steel.
Ventilation	None required. No fumes.
Filtration	Desirable for production-scale tanks. Use 50-100 micron polypropylene filter element.

### PARTS PROCESSING GUIDELINES

- CLEAN** and degrease the parts for five minutes in SAFE SCRUB® M Multi-Metal liquid cleaner, mixed at 10-20% by volume; 100-140° F. Or, use bead blast techniques. If parts are electroplated, apply a minimum of thickness of 0.0002" or plating.
- RINSE** in clean water tank for 20 seconds, to remove cleaner/plating residues.
- (Optional) **REMOVE TARNISH** and neutralize residual plating cyanide by immersing parts in weak (2-5%) sulfuric acid; Room Temp; 1-2 minutes. **RINSE** in clean water for 20 seconds.
- BLACKEN OR BROWN** parts in ANTIQUÉ BLACK M20 solution for 1-3 minutes or as long as necessary to produce the desired color. Agitate parts gently to assure solution contact with all surfaces.
- RINSE** in clean water tank for 20 seconds.
- DRY** the parts and **APPLY LACQUER**. Or, **HIGHLIGHT** the finish with an abrasive or polishing wheel or in a vibratory finisher. **APPLY PROTECTIVE TOPCOAT**, such as clear lacquer, wax or oil. Note: the topcoat will enhance and darken the color of the finish as it is absorbed. The final color should be judged after the topcoat is applied.

### BATH MAINTENANCE

The M20 bath can be operated as a permanent bath in the process line and is controlled by total acid titration, or by using the CCK Test Kit. Other methods, such as Atomic Absorption, may also be used. Maintain the bath strength at 80% of original make-up or higher. Keep tank covered when not in use to minimize contamination and evaporation.

**CAUTION:** This product contains mineral acid. DO NOT TAKE INTERNALLY.  
**PLEASE READ MATERIAL SAFETY DATA SHEET BEFORE USING.**

**NOTE:** The information contained herein is provided in good faith and is believed to be correct as of the date hereof. However, the manufacturer makes no representation as to the comprehensiveness or accuracy of the information. It is expected that individuals receiving the information will exercise their independent judgment in determining its appropriateness for a particular purpose. Accordingly, the manufacturer will not be responsible for damages of any kind resulting from the use of or reliance upon such information. NO REPRESENTATIONS OR WARRANTIES, EITHER EXPRESS OR IMPLIED, OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE OR OF ANY OTHER NATURE ARE MADE HEREUNDER TO WHICH THE INFORMATION REFERS.

10/04 ANTIQUÉ BLACK® M20

Technical Support (212) 367-7561  
www.SCULPT.com

