



THE COMPLEAT SCULPTOR

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ANTIQU BROWN® M38 OXIDIZER - Instructions

DESCRIPTION

ANTIQU BROWN® M38 oxidizer is a Room Temperature browning solution for brass, bronze & copper. Supplied as a liquid concentrate, the product is diluted with water and used at room temperature to produce attractive finishes ranging from golden to chocolate brown, with no dimensional or structural change in the base metal. ANTIQU BROWN M38 oxidizer can be used on solid or electroplated surfaces to produce pleasing antique or US10B finishes

OPERATING CONDITIONS

Bath Make-Up Concentration	20-25% by volume for medium-dark brown finishes 10-15% by volume for golden brown shades.
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

1. **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. If parts are electroplated, apply a minimum plating thickness of 0.0002".
2. **RINSE** in clean water tank for 20 seconds, to remove cleaner/plating residues.
3. (Optional) **REMOVE TARNISH** and neutralize residual plating cyanide by immersing parts in a solution of OXYPRIME® POWDER, mixed at 1 lb/gal at Room Temperature for 1-3 minutes; Or use 5-10% sulfuric acid at Room Temp for 1-2 minutes. **RINSE** in clean water for 20 seconds.
4. **APPLY BROWN FINISH** by immersing parts in ANTIQU BROWN M38 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.
5. **RINSE** in clean water tank for 20 seconds.
6. **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 M38 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 (available from BIRCHWOOD CASEY). 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.

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