

## SUGGESTED PROCESS

Alumilite Black Coloring - Model 700 BDL Trigger Guard

Finish

1. Select parts after Op. 36 and prior to Op. 40, avoiding any with obvious defects.
2. Rough polish floor plate - 180 grit oil wheel.
3. Finish floor plate - 400 grit oil wheel.
4. Finish guard and floor plate using loose cloth buff and combination buffing compound, obtained first by applying Atlantic 180A, followed by an application of LeaRock buffing compound.
5. Parts to be carefully inspected at this point for finish and for casting defects (mainly porosity).

Anodizing and Coloring

1. Rack parts on titanium rack in manner to insure good contact with floor plate.
2. Clean. Diversey 909 - 6 oz./gal. - 180°F.
3. Cold rinse.
4. Nitric Octane dip - very short (15 sec. in lab. tank).
5. Cold rinse.
6. Conc. Nitric dip - 20-30 sec.
7. Cold rinse.
8. Anodize. 15% H<sub>2</sub>SO<sub>4</sub> electrolyte - 70°F. - 1 hour.  
Amps: 2.5 per part (max.) to be maintained during cycle.  
Voltage starts at approx. 8 and at end of cycle is about 16.
9. Cold rinse.
10. 5% sodium Bicarbonate dip - 120°F. - 5 min.
11. Cold rinse.
12. Dye. Sandoz BK - 10g/1 l pH 6.0 - 150°F. - 20 min.
13. Cold rinse.
14. Seal. Nickel Acetate - 5g/l - pH 5.5 to 5.8 - 190°F. - 5 min.
15. Cold rinse.
16. Hot rinse - to dry.
17. Oil - Kwikseal (Dulite) or equivalent.

The above process will produce a deep black color sufficient to cover streaks and flow lines in the casting. Rejects should only be due to porosity, etc. in casting, or defective polish

DTP:M 6-11-64