

Customer Guidelines for Black Oxide

Size and Weight Limitations

Maximum dimension of parts we can black oxide is 96" long and 52" wide. Please call us with specific dimensions to verify. Maximum weight is 1500 pounds. Parts longer than 60" may be subject to additional fees.

Dropping Parts Off

When dropping off parts for processing, please include as much information on your paperwork as available: PO numbers, required pick up dates, if certifications are needed, etc. If you do not have paperwork to accompany your parts, please complete a *Parts Drop off Sheet* available by the drop off table. We make every effort to keep your parts together and anything you can do to help us identify how many pieces, number of containers or a description of the parts is helpful.

Special Handling Required

Information referencing any special processing requirements is necessary at drop off. Examples may include special handling required due to "soft" metal or critical edges and surfaces, packaging requirements, specified corrosion inhibitors (wax, acrylic, and oil), etc. If black oxide is specified without a corrosion inhibitor, oil will be assumed. Please let us know on the paperwork accompanying your parts.

Turn Around Time

We understand timely turn-around is essential to your business and we will do everything we can to get your parts done ASAP. Small orders dropped off before 7:00PM should be done the next morning for pick up but cannot be guaranteed. Requested completion time is helpful and we will make every effort to meet your schedule. Our shipping/receiving hours are from 7:00AM to 4:00PM, but after hour service may be available.

Large Plates

Holes are needed in the corners of large plates for lifting. Depending on the size and weight of the plate, at least $\frac{3}{8}$ " holes are needed in each corner, preferably not threaded. If possible, $\frac{1}{2}$ " diameter holes are better.

Preparation of Metal

Please remove any markings made by crayons or markers as we will not be able to black oxide the steel over these. Adhesives from tape will cause this problem also and we are usually not able to see it before we black oxide it. Please inform us if you need help removing this.

Special Circumstances with Parts

Welded hollow parts either need to be welded completely tight or have drain holes in the ends. Without a tight weld, caustic chemicals can become trapped and later seep out potentially burning someone and will leave a white residue. Parts that are pressed together have the potential to have caustic salts trapped between them and "bleed out" a white powder. "Blind" holes have the potential to trap salts as well. We make every effort to rinse them out completely, please let us know if you have issues with this.

Different Types of Metals

Our process does not blacken stainless steel. Varying degrees of "black" are achieved with cast, powdered metals, certain heat treat processes and hot rolled steel. The black oxide process will dissolve any aluminum and chrome. Premier Finishing cannot process any parts that have been zinc plated.

Thank you for your business. We are always open to suggestions to make your "experience" with Premier Finishing better.