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**OPERATING INSTRUCTIONS FOR PHOSPHATE DIP-330**  
**Liquid Manganese Phosphate Concentrate**  
**PRODUCES WWII PARKERIZE FINISH**

Phosphate Dip-330 produces a crystalline manganese phosphate coating for steel and iron surfaces with coating weights up 5000 mgs/square foot. *(Will not adhere to stainless, cooper, brass, aluminum or bronze. If these metals are placed into the bath, the bath will become polluted and will have to be discarded)* Du-Lite's Kwikseal® Oil aids rapid break-in of moving parts without scoring or scuffing and provides excellent corrosion resistance from rust. Phosphate Dip-330 is mainly used on military equipment like M1 Garand, Colt 1911, M 1 carbine and WWII machine gun mounts and other military equipment. Phosphate Dip 330 produces a dark black color on finished work and may have fine, medium or coarse crystals depending on the pretreatment used. ***Du-Lite also sells Phosphate Dip-440 Liquid Zinc Phosphate Concentrate which produces a light gray color to finished parts.***

**Equipment:** The process tank and piping for use with the Phosphate Dip-330 solution should be of type 304, 316 or other 300 series stainless steel. When heating solution with hot water or steam, heating coil should be made of type 316 stainless steel.

**WARNING:** When phosphating firearms it is important to plug the barrel and receiver part of the firearm to prevent Phosphate Dip-330 from entering the internal parts of the firearm. If Phosphate Dip-330 is allowed to enter you can permanently damage the internal surfaces. Barrels can be plugged with silicone rubber plugs shaped to fit snugly in the end of the barrel and receiver. (These silicone rubber plugs are available for an additional cost from The Du-lite Corporation).

**OPERATING CONDITIONS:**

|                                   |                                    |
|-----------------------------------|------------------------------------|
| Solution Make Up: 10%             | Phosphate Dip - 330 plus 90% Water |
| Immersion Time: 10 minutes normal | Temperature: 190°-200° F (93-99°C) |

**Typical Solution Make-Up**

| PROCESS TANK VOLUME | 1 GALLON   | 5 GALLONS | 10 GALLONS | 100 GALLONS |
|---------------------|------------|-----------|------------|-------------|
| Phosphate Dip-330   | 13 oz.     | 2 quarts  | 4 quarts   | 10 gallons  |
| Water               | 3 ½ quarts | 18 quarts | 36 quarts  | 90 gallons  |

**Make-Up Procedure:**

1. Fill clean stainless steel tank about three-quarters full with water.
2. Heat to approximately 150°-160°F, and then add 10 gallons (38 liters) of Phosphate Dip-330 for each 100 gallons of working solution. *(Phosphate Dip 330 processing tank can be heated with an electrically heated hot plate or gas burners)*
3. For best results when starting up a new bath – add iron to the solution by:
  - a. Hang steel wool or scrap iron in the heated solution for about one hour.  
*(Be sure to degrease the oil off the steel wool before hanging it in the Phosphate Dip – 330 bath.)*
  - b. Now heat solution to 190° - 200°F and the bath is ready to use.

**Preparations for parts to be Phosphate Dip – 330:**

1. Disassemble all parts which are made of steel or iron to be Phosphate Dip - 330.
2. Heavily greased or oiled parts should be degreased by going through a solvent such as mineral spirits, acetone, lacquer thinner or paint remover.
3. Next, clean parts in Du-Lite's #45 Soak Cleaner heated to 150°, 12 oz. per gallon cleaner for 12 –15 minutes.
4. Rinse cleaner off in overflowing cold water rinse.
5. Dry parts thoroughly.
6. Remove any old manganese phosphate coating, rust, scale, and heat discoloration from welded parts by glass bead blasting them. Manganese phosphate will build up inside the rifle bore and chamber area of firearms being coated. We recommend that you insert a silicone rubber plug at both ends of the barrel before glass bead blasting and going into the manganese phosphate solution. (Silicone rubber plugs are available from Du-lite Corporation if needed.) Never glass bead parts that has heavy oil or grease on them because this will contaminate the glass beads that are used and will redeposit this grease and oil on the next parts that are being processed. Glass bead is a much cleaner process than using ordinary sand in your sand blasting equipment. After glass bead blasting the parts, do not touch parts with your bare hands. The oil in your fingertips will produce uneven or bare spots on the final manganese phosphate finish. Use white gloves, thongs or hanging wires to remove parts from the blasting cabinet then go directly to your phosphate tanking for processing. Do not let your freshly glass beaded parts sit for more than 1 hour before processing through your Phosphate Dip - 330 tanks.
7. Immerse rifle barrels with rubber plugs in the bore and receiver area into the Phosphate Dip –330 solution for approximately 10 minutes
8. Remove freshly treated parts from Phosphate Dip 330 tank and rinse in overflowing cold water tank for 1 minute.

**WARNING: DIFFERENT HARDNESSES AND COMPOSITIONS OF THE METALS USED IN THE COMPLETED FIREARM ASSEMBLY, WILL PRODUCE DIFFERENT SHADES TO THE FINAL FINISH OF DIFFERENT PARTS USED ON THE GUN.**

9. Place parts in Du-Lite's Kwikseal® Oil Tank for 30 seconds to 1 minute. Hang parts over the Kwikseal tank to allow excess oil to drip off.
10. During the operation of Phosphate Dip – 330, sludge is formed as a by-product of the chemical reaction in forming phosphate coatings on ferrous metals. This sludge will settle to the bottom of the tank and should not be stirred up while parts are being processed; otherwise dusty coatings may result. Steam or heating coils must be mounted in the sides of tanks to allow for this sludge condition.
11. **DISPOSAL:** Follow Du-Lite's recommendations for disposing an acid based solution. Also, consult local, state and federal authorities for waste disposal requirements. The information presented herein, while not guaranteed, is to the best of our knowledge true and accurate. No warranty or guarantee expressed or implied is made regarding the performance of any products, since the manner of use is beyond our control.

THE PRODUCTS MENTIONED IN THESE INSTRUCTIONS ARE FOR INDUSTRIAL USE ONLY

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