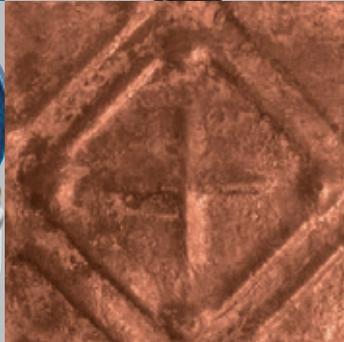


**AIDI**  
ARCHITECTURAL  
IRON DESIGNS, INC.

PAINTS &  
PATINAS



**RUSTRESOLVE**  
The Eco-Friendly Way to Fight Rust



# VINYLAST™ High Performance Coatings for Ironwork

## Benefits of Using VINYLAST™ Paints

- No primer necessary for interior or galvanized applications
- Fast drying and non-drip
- Excellent adhesion to hot dipped galvanizing
- Superior rust protection
- Suitable for aluminum and structural steel
- Chip resistant satin finish



SUPPLIED IN 250ML, 1 LITER, 2.5 LITER, 5 LITER AND 20 LITER CONTAINERS



*The perfect solution for touching up and painting small objects.*

	ITEM NUMBER
Vynylast™ Black	<b>113/26</b>
Vynylast™ Dark Brown	<b>113/45</b>
Vynylast™ Pure White	<b>113/46</b>
400ml cans	

**0001**  
**Smithy Black**  
Glossy also available

**0002**  
**Dark Brown**

**8022**  
**Black Brown**

**NEW**

**0003**  
**Graphite**

**6006**  
**Grey Olive**

**7030**  
**Stone Grey**

**Sparkle**  
**Silver**

**9006**  
**Aluminum**

**3009**  
**Red Oxide**

**1013**  
**Pearl White**

**9010**  
**Pure White**

**1021**  
**Traffic Yellow**

**6005**  
**Moss Green**

**6010**  
**Grass Green**

**3000**  
**Fire Red**

## FAQs About VINYLAST™ Paint

### How is Vinylast™ better than regular paint?



Vinylast™ is high quality and does not require a primer, it does not drip and it dries fast unlike most other paints. It also offers better surface protection against rust. It has excellent adhesion even to hot dipped galvanized surfaces. And it gives a beautiful, chip resistant satin sheen finish.

### Can I spray this paint?

Yes, the paint can be used in any conventional sprayer. It can also be used with Electrostatic and airless sprayers.

### The paint is very thick. What thinner should I use?

Although any industrial grade thinner will work, we recommend using Xylene. Up to 15% thinner may be added in a conventional sprayer.

### Do I need to apply a primer?

Vinylast does not need a primer in order to adhere to the steel. If a primer is preferred, we recommend Rourke's Fast Primer Zinc Phosphate.

### Can I use Vinylast™ over galvanizing?

Absolutely. Although a top quality paint for using directly onto mild steel, Vinylast™ was specially developed to adhere to galvanized steelwork. Vinylast™ bonds extremely well to galvanizing without the requirement of any kind of primer or surface abrasion.

### What if I have a non-galvanized surface for an exterior job?

Although we always recommend galvanizing for exterior work, Vinylast™ still offers a superior finish and more durability than most paints. A primer is not required but if preferred, we recommend Rourke's Fast Primer Zinc Phosphate. Apply 2 to 3 coats of Vinylast™ in order to achieve the required film thickness.

### Can I use Vinylast™ over Aluminum?

Yes, Vinylast™ works very well over aluminum. However, you may need an etch primer or a T-wash primer, or you may need to abrade especially for very smooth surfaces.

### What kind of maintenance is required?

Vinylast™ is virtually a maintenance free finish which will last for many years, especially when applied over a galvanized surface. You can repaint over Vinylast™ painted work after cleaning it.

### How does Vinylast™ compare to powder coating?

Vinylast™ looks better on good quality decorative ironwork than most powder finishes. Powder coating is also difficult to repair or touch up. It does not adhere well to galvanized products without surface preparation.

### For MSDS Sheets and detailed product information see:

[www.archirondesign.com/vinylast](http://www.archirondesign.com/vinylast)

**VOC Content: 585 grams per liter. Please check local VOC requirements before using this product.**

PLEASE ASK FOR DATA SHEETS AND READ THESE BEFORE USING OUR PAINTS. NOTE: Coverage figures provided are only approximate and we cannot be held responsible for any variation. Coverage figures depend on equipment, the operator, thickness applied and the design/type of the work being painted.

**staygold**

A long lasting gold paint used for highlighting railheads, rosettes and other features. For steel and aluminum. Thin with Xylene if necessary.

**113/30 – 1 liter**

### FAST PRIMER ZINC PHOSPHATE

A high quality, general purpose, conventional anti-corrosive primer containing zinc phosphate to help prevent rust. Recommended application by spraying but small areas can be brushed on. Coverage (approx.) 15 sq. meters per liter.

	Item Number
Grey 1 liter	113/15
Grey 2.5 liters	113/16
Grey 5 liters	113/17
Grey 20 liters	113/17-20L
Red Oxide 1 liter	113/18
Red Oxide 2.5 liters	113/19
Red Oxide 5 liters	113/20
Red Oxide 20 liters	113/20-20L

### INDUSTRIAL THINNERS (XYLENE)

An all purpose thinner for use with Vinylast™, Fast Primer Zinc Phosphate, and Staygold.

	Item Number
1 liter	113/23
5 liters	113/24
25 liters	113/25

## Patinas

### Create Antique and Highlighted Finishes

Supplied in 375 ml tins.



112/6 Gold



112/7 Copper



112/8 Silver



112/11 Pale Blue



112/10 Pale Green



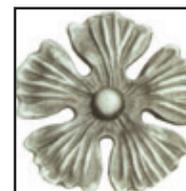
112/9 Green



Gold Patina on a White 9010 base coat always brings life to a fine piece of ironwork.



Our all time favorite is Smithy Black 0001, with Copper Patina.



This classic finish is Graphite 0003 Vinylast with Silver Patina highlights.

## HELPING TO CREATE A HEALTHY ENVIRONMENT

# AQUALAST™

**Aqualast™, our greener paint option for ironwork, is water based, environmentally friendly and works as well as our original Vinylast paint.**

- ☞ Minimal solvent content (Less than 2%)
- ☞ Thin and clean with water, not solvents
- ☞ Operator friendly
- ☞ Apply directly to galvanized steel
- ☞ Long lasting
- ☞ Low maintenance
- ☞ Professional quality finish



**SUPPLIED IN:**  
1 LITER  
2.5 LITER  
5 LITER

**AQUA0001**  
Smithy Black

**AQUA0002**  
Dark Brown

**AQUA0003**  
Graphite

**AQUA9010**  
Pure White

Most exterior paints have a high solvent content of 50%+, which evaporates into the atmosphere. AQUALAST, however, has a minimal solvent content of less than 2%, offering huge benefits to the environment.

Water based coatings require well controlled environmental conditions to ensure adequate drying. We recommend that AQUALAST be applied in a suitable paint shop with good air movement, heat and the availability to maintain a temperature of above 55°F and relative humidity levels of below 70%, especially during the winter months.

### COMPARISON

	Aqualast	Vinylast
VOC	Low	High
Clean up	Water	Xylene
Thinner	Water	Xylene
Goes over galvanizing	✓	✓
Fast Drying	Depends on Humidity	✓
No Primer Needed	✓	✓
Interior or Exterior Use	✓	✓

## FAQs About AQUALAST™ Paint

### How is Aqualast™ better than regular paint?

Aqualast™ is high quality and does not require a primer, it does not drip unlike most other paints. It also offers better surface protection against rust. It has excellent adhesion even to hot dipped galvanized surfaces. And it gives a beautiful, chip resistant satin sheen finish.

### Can I spray this paint?

Yes, the paint can be used in any conventional sprayer. It can also be used with Electrostatic and airless sprayers. To thin you may use water.

### Can I use Aqualast™ over galvanizing?

Absolutely. Although a top quality paint for using directly onto mild steel, Aqualast™ was specially developed to adhere to galvanized steelwork. Aqualast™ bonds extremely well to galvanizing without any kind of primer or surface abrasion required.

### What if I have a non-galvanized surface for an exterior job?

Although we always recommend galvanizing for exterior work, Aqualast™ still offers a superior finish and more durability than most paints. A primer is not required but if preferred, we recommend our Fast Primer Zinc Phosphate. Apply 2 to 3 coats of Aqualast™ in order to achieve the required film thickness.

For an MSDS Sheet and detailed product information see:  
[www.archirondesign.com](http://www.archirondesign.com)  
VOC Content: 0 grams per liter.

### Can I use Aqualast™ over Aluminum?

Yes, Aqualast™ works very well over aluminum also. However, we recommend using an etch primer or a T-wash primer, or abrading the surface, especially for very smooth surfaces.

### What kind of maintenance is required?

Aqualast™ is virtually a maintenance free finish which lasts for many years, especially when applied over a galvanized surface. You can repaint over Aqualast™ painted work after cleaning it.

### How does Aqualast™ compare to powder coating?

Aqualast™ looks better on good quality decorative ironwork than most powder finishes. Powder coating is also difficult to repair or touch up. It does not adhere well to galvanized products without surface preparation.

### Benefits of Using AQUALAST Paints

- No primer necessary
- Excellent adhesion to hot dipped galvanizing
- Superior rust protection
- Suitable for aluminum and structural steel
- Chip resistant satin finish

# RUSTRESOLVE - RUST CONVERTER

What does **RUSTRESOLVE** do?

The Eco-Friendly Way to Fight Rust



**RUSTRESOLVE** offers an easy and effective way to deal with existing rust without the need for sandblasting or hours of wire brushing. Simply wire brush off any flaking rust and apply **RUSTRESOLVE**. Within minutes, the rust will disappear and the surface will turn a bluish black color that you can paint over.

## RUSTRESOLVE

- Is a complex mixture of vinyl acrylic copolymer and tannic acid for the treatment of corroded steel and iron surfaces.
- Is a strong, yet eco-friendly, zero VOC product that neutralizes the corrosion process. It then further protects the surface by forming a film with low permeability to water vapor and oxygen.
- Is self priming but for long term protection it is advisable to overcoat with a suitable water or solvent based midcoat or topcoat.
- One liter can treats 8-9 square meters.
- Can be used in the following areas: Manufacturing, Agriculture, Automotive, Chemical, Marine, Heavy Engineering, Building and Construction, DIY, etc.



Call 800-784-7444 or visit [www.archirondesign.com/rustresolve](http://www.archirondesign.com/rustresolve) to place your order

112/15 - 250ml

112/13 - 1 Liter

112/14 - 5 Liters

## Application

Surfaces should be wire brushed to remove loose rust and washed with water to remove soluble salts as they inhibit the conversion process. Surfaces should also be free of oil and grease.

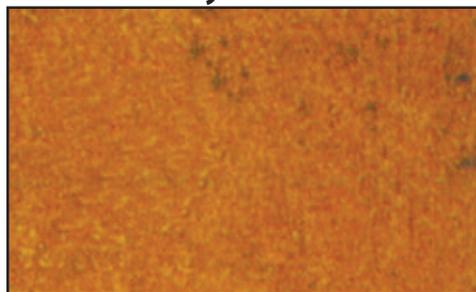
**RUSTRESOLVE** has been designed for application by spray and brush. By airless spray a dry film thickness of up to 60 microns can be achieved without sagging. The addition of further water may be necessary for air assisted spraying. By brush application, a dry film thickness of 40 microns per coat is considered optimum.

**RUSTRESOLVE** can be applied over damp surfaces and dries quickly under suitable temperature and humidity conditions. Immediately after use, equipment should be washed in water to remove all traces of **RUSTRESOLVE**.

## Drying Conditions

Temperature, humidity, air movement and film thickness all affect drying time. Under ideal conditions, a 100 micron wet film of **RUSTRESOLVE** will be dry to the touch in approximately 10 minutes at 68°F, whereas at 50°F and with little air movement, this time can be as long as 2 hours. **RUSTRESOLVE** should not be applied at temperatures below 50°F, or when there is risk of condensation or rain during this drying period.

Rusty Surface



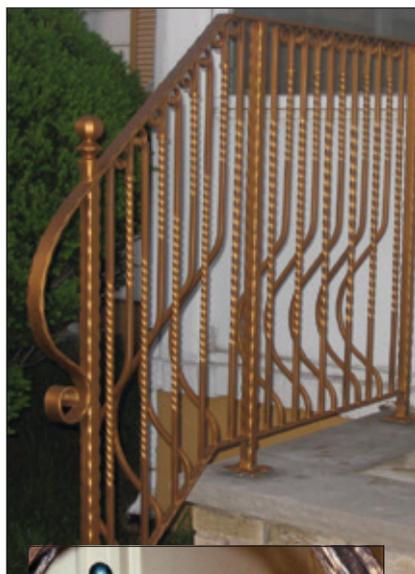
After **RUSTRESOLVE** Application



PAINT &  
PATINAS

Visit [www.archirondesign.com/resource-center](http://www.archirondesign.com/resource-center) to download the MSDS sheet from our technical library.

# GILDERS PASTE



Grainger Metal Works  
Nichols, SC



Peter's Metal Studio



High Gloss Powder Coated  
over Gilders Paste™

Looking for a unique way to highlight or decorate your ironwork?

*Gilders Paste™* is a collection of highly concentrated colorful metallic and colored wax based pastes that can be easily applied to a project. *Gilders Paste™* can be used to color and highlight features or produce a gilded finish.

Apply with finger, soft brush or cloth in rubbing motion or by letting your imagination determine the application medium to create a unique finish!

*Gilders Paste™* can be layered one on top of the other or mixed together to create an endless finish and a color palette that won't fade.

Thin with small amounts of paint thinner to transform the highly concentrated *Gilders Paste™* into paint for your projects or artwork for a stained or washed appearance.

By lightly polishing with a soft cloth, our metallic *Gilders Paste™* will produce a gilded finish. Clean up with soap and warm water or paint thinner.

Thinning will more than double coverage.

Small, 30 ml (1 oz.), covers over 30 sq. ft.  
Large, 100 ml (3 oz.), covers over 100 sq. ft.

# GILDERS PASTE



(Colors may vary slightly from printed medium)

Small, 30 ml (1 oz.), covers over 30 sq. ft.  
Large, 100 ml (3 oz.), covers over 100 sq. ft.



## WARNING:

COMBUSTIBLE. Do not store or use near open flame. KEEP OUT OF REACH OF CHILDREN. NOT FOR USE IN HEALTH CARE FACILITIES. For further health information contact a poison control center. Use in well ventilated area. Request a materials safety data sheet when using in manufacturing. Keep in the original container with the lid closed to prevent the product from drying out and store upside down. Use a small amount of paint thinner to soften. Avoid heat, sparks, flame and other ignition sources.

## Use Gilders Paste-on:

Picture Frames, Etched Glass, Furniture, Antique Restoration, Finials, Crafts, Embossed Molding, Miter Joints, Ornate Fretwork, Rope & Dental, Chair Railing, Curtain Rods, Ceramics, Gilding Restoration, Bisque Ware, Plaster, Home Décor Stenciling, Gessoed Surfaces, Stone, Paper, Wax, Leather, Textiles, Plastics, previously painted or any clean, dry surface.

## SUGGESTIONS

Substrate surface should be dry and clean, free of dirt, oil, grease and scale.

*Gilders Paste™* can be directly applied with your finger, sponge, paint - tooth - stencil brushes, cloth, rubber stamps etc... All colors can be thinned out to further extend, wash, stain or paint your project.

Blending *Gilders Paste™* is as easy as mixing two or more colors to match and touch up existing color schemes or to create a custom color.

Drying time varies depending on materials, thickness of application and substrate, approximately 30 - 60 minutes to the touch on dry, low porosity, debris free surfaces.

Lightly polishing metallic colors with a soft cloth, after 12 hours of drying, will produce a gilded finish.

Will accept an overcoat, such as UV solvent based stable clear lacquer, varnish, acrylic, or clear powder coating to achieve a uniform appearance where the *Gilders Paste™* was not used, or, to provide increased durability to areas where repeated.

## TIPS & TECHNIQUES

For very smooth surfaces, such as gloss paint, plastic, ceramics and furniture, it is recommended to abrade the surfaces with 0000 grade steel wool or fine sandpaper or apply a recommended primer.

Layering substrates with a solid base color and then stenciling, sponging or wiping another color over base coat can produce unique affects and blends.

Polishing the base coat immediately after application with a dry cloth or slightly wetting it with a thinner will remove *Gilders Paste™* from the relief detail and highlight depressed details. Lightly brushing *Gilders Paste™* over the top will highlight the relief details without polishing.

Store above 55°F. Apply above 60°F. If *Gilders Paste™* becomes dry, add a little paint thinner or mineral spirits, mix, and you are ready to go.

# Sculpt Nouveau

Patinas and Metal Finishes



Scan this code for a general overview of Sculpt Nouveau products.



Throughout this section QR Codes are placed next to various products. Once scanned, a video will display demonstrating the application process of that product.

For those applications where a painted finish won't do or to achieve a natural finish on your metalwork project, use our range of Sculpt Nouveau patinas and metal finishes. There are typically **3 steps** to achieve a good finish:

**STEP 1 - Clean the Metal** use Metal Cleaner Degreaser

**STEP 2 - Apply Patina** (see material and choose your patina)

**Traditional Patinas** - All contain acids

**Smart Stains and Patina Stains** - Do not contain acids

## Bronze Brass & Copper

**CHOOSE:**

**Birchwood Technologies M38-Brown**  
Color achieved: Brown

**Birchwood Technologies M24-Black**  
Color achieved: Black

**Black Magic**  
Color achieved: Orange/Black on bonded material, brown/black on cleaned material

**Darkening Patina**  
Color achieved: Brown

**Slate Black**  
Color achieved: Black or if burnished back with steel wool can be an antique brown

**Japanese Brown**  
Color achieved: Golden

**Tiffany Green**  
Color achieved: Green

**Smart Stain-Brown**  
Color achieved: Brown

**Smart Stain-Black**  
Color achieved: Black

**Patina Stains-All Colors**

## IRON & STEEL

**CHOOSE:**

**Birchwood Technologies PC-9 Presto Black**  
Color achieved: Black

**Black Magic**  
Color achieved: Rich Black

**Darkening Patina**  
Color achieved: Transparent Brown

**Slate Black**  
Color achieved: Brownish Black

**Japanese Brown**  
Color achieved: Brown

**Smart Stain-Brown**  
Color achieved: Brown

**Smart Stain-Black**  
Color achieved: Black

**Patina Stains-All Colors**

## ALUMINUM

**CHOOSE:**

**Birchwood Technologies A-14 Black**  
Color achieved: Black

**Slate Black**  
Color achieved: Deep Brown

**Smart Stain-Brown**  
Color achieved: Brown

**Smart Stain-Black**  
Color achieved: Black

**Patina Stains-All Colors**

## STAINLESS STEEL

**CHOOSE:**

**Slate Black**  
Color achieved: Red/Brown

**Stainless Black**  
Color achieved: Black

**Smart Stain-Brown**  
Color achieved: Brown

**Smart Stain-Black**  
Color achieved: Black

**Patina Stains-All Colors**

**STEP 3 - Seal the surface to protect the finish**

Clear Guard

Ever-Clear

Metal Oil

Metal Wax

Smart Coat

## STEP 1 - Metal Cleaning

The surface of the material you are working on should be clean and free of any dirt or grease. When working with iron, steel or aluminum you may want to remove rust and fire scale. The best method for cleaning most materials is to sandblast. Different types of blasting material may be used in order to achieve the desired surface. Wire wheels or Scotch-Brite Pads are another method of cleaning.

Be careful not to leave any polishing compound on the surface. A good metal cleaner is a great way to get the surface ready to work on. Sometimes mild acids are used, but they can interfere with the patina process that comes later. Sculpt Nouveau's Metal Cleaner/Degreaser is a great metal cleaner. It works on both ferrous and non-ferrous metals.

### **SUR08ZMDD**

8 oz. Metal Cleaner and Degreaser

### **SUR32ZMDD**

32 oz. Metal Cleaner and Degreaser

### **SUR01GMDD**

1 gallon Metal Cleaner and Degreaser



## METAL CLEANER DEGREASER

Sculpt Nouveau's Metal Cleaner and Degreaser has been specially developed for the rapid and complete removal of rust, dirt, oil, and grease from most metal surfaces in preparation for finish applications.

This ready-to-use formula removes oxidation quickly and efficiently without leaving any residue or buildup that would prevent finish adhesion. Additionally, the Metal Cleaner and Degreaser contain corrosion inhibitors that protect the metal surface during cleaning.

The Metal Cleaner and Degreaser is not a polish and will remove the finish on polished and plated surfaces. It is available in 8 oz., 32 oz., and 1 gal. sizes. The 8 oz. and 32 oz. sizes include a spray top.

### **Instructions for Application on Bronze, Brass, and Copper:**

- (1) Apply the cleaner with a brush, sponge or rag.
- (2) Let stand on the metal for approx. 5 minutes.
- (3) Rub with a green or gray Scotch-Brite pad.
- (4) Rinse with water.
- (5) Repeat if necessary.
- (6) Dry the surface.
- (7) Apply the desired finish to the metal surface.

### **Instructions for Application on Iron, Steel, and Aluminum:**

- (1) Repeat the steps above, but dry quickly and thoroughly so that rust does not begin to form. Do not clean your metal until you are ready to apply the patina.
- (2) Apply your desired finish immediately to the clean metal. You must apply the patina as soon as possible and seal as soon as it is completely dry.

## **DO NOT USE ACETONE to clean your metal surface**

The acetone leaves a residue on the surface which will interfere with the adhesion of the sealers and will alter the patina and/or cause it to not react properly.

# SCULPT NOUVEAU PATINAS AND METAL FINISHES

## STEP 2 - Apply the Appropriate Patina

There are two main categories of patina: 1) Those which contain acids; 2) Those which do not contain acids. This is important to know if you wish to patina iron, steel, or aluminum, as acids will cause rust or oxidation.

**Types of Patinas that Sculpt Nouveau makes:**

- **Traditional Patinas** - All contain acids
- **Smart Stains and Patina Stains** - Do not contain acids

Each type of patina is available in a range of colors. The colors may be mixed together within the group to form a different shade, except for the Traditional Patinas which may also be applied one over the other. The different types may be applied over each other or mottled around areas to make the patina more interesting.

Note: When layering the different patinas, it's best to apply those which contain acids first.

When working directly on metal, the most important factor in using Sculpt Nouveau's products successfully will be to have the surface of the metal clean. Sandblasting is the best way to achieve this. An orbital sander may be used on flat surfaces, although if this is not an option, Sculpt Nouveau Metal Cleaner is what we recommend.

When using a patina\* from a group that does not contain acids, warming the metal is the best way to get them to adhere. Warming can be done by: (1) Putting the metal in the sun; (2) Using a heat gun or paint peeler; (3) Using a patina torch.

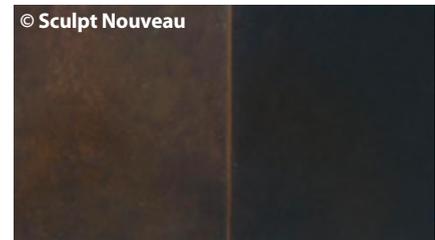
Sculpt Nouveau's patinas do not protect the metals from further natural changes once they have been applied. Also, most patinas will have a chalkiness, which will rub or rinse off. We recommend applying a clear sealer once the patina is finished.

\*For Patina Stains, heat is not recommended. If the metal is too hot the patina may end up looking wrinkled.

### Birchwood Technologies Patinas (cold application)

Birchwood Technologies makes different formulas for the different metals. For bronze, brass and copper there are choices of brown or black applied by spray, brush or immersion. There are separate formulas for iron, steel and aluminum.

The patina solution being concentrated, is then diluted from 1 part distilled water to 1 part Birchwood Technologies to 3 parts of distilled water to 1 part Birchwood Technologies. Using the solution too strong will cause many problems.



Birchwood Technologies M38 (left) and M24 (right) Patina applied hot to copper

#### M-38 Brown (FOR BRONZE, BRASS & COPPER)

##### BIR08ZM38

8 oz. Birchwood Technologies M38 Brown for Bronze, Brass, & Copper

##### BIR32ZM38

32 oz. Birchwood Technologies M38 Brown for Bronze, Brass, & Copper

##### BIR01GM38

1 gallon Birchwood Technologies M38 Brown for Bronze, Brass, & Copper



#### M-24 Black (FOR BRONZE, BRASS & COPPER)

##### BIR08ZM24

8 oz. Birchwood Technologies M24 Black for Bronze, Brass, & Copper

##### BIR32ZM24

32 oz. Birchwood Technologies M24 Black for Bronze, Brass, & Copper

##### BIR01GM24

1 gallon Birchwood Technologies M24 Black for Bronze, Brass, & Copper



#### PC-9 Presto Black (FOR IRON AND STEEL ONLY)

##### BIR08ZPC9

8 oz. Birchwood Technologies PC9 Black Patina for Iron & Steel

##### BIR32ZPC9

32 oz. Birchwood Technologies PC9 Black Patina for Iron & Steel

##### BIR01GPC9

1 gallon Birchwood Technologies PC9 Black Patina for Iron & Steel



#### A-14 Black (FOR ALUMINUM)

##### BIR08ZA14

8 oz. Birchwood Technologies A14 Black for Aluminum

##### BIR32ZA14

32 oz. Birchwood Technologies A14 Black for Aluminum

##### BIR01GA14

1 gallon Birchwood Technologies A14 Black for Aluminum



## STEP 2 - Apply the Appropriate Patina *(continued)*

### Black Magic Traditional Patina (cold application)

Black Magic Patina instantly creates a beautiful rich black patina on clean iron & steel. Rust will not occur immediately as with other darkening patinas. Water rinsing is a good neutralizer and will not cause rust. Rust will occur after 12 hours if a clear sealer is not applied.

Black Magic will darken bonded bronze, brass, and copper castings to an orange-black color. Black Magic creates a beautiful brown-black patina on cleaned bronze, brass, and copper.



© Sculpt Nouveau

*Black Magic Patina applied cold to cold rolled steel, then burnished with steel wool*

#### TBK08ZMAG

8 oz. Black Magic Traditional Patina

#### TBK32ZMAG

32 oz. Black Magic Traditional Patina

#### TBK01GMAG

1 gallon Black Magic Traditional Patina



### Traditional Darkening Patina (cold application)

Darkening patina is great for aging or darkening metals.

This patina may also be used on bronze, brass and copper. It creates a beautiful brown color. This patina is often diluted with distilled water; otherwise the patina will be very dark. For a nice transparent brown, it may also be applied on iron and steel. Apply a clear sealer or wax after the patina is dry.

#### TBR08ZDAR

8 oz. Traditional Darkening Patina

#### TBR32ZDAR

32 oz. Traditional Darkening Patina

#### TBR01GDAR

1 gallon Traditional Darkening Patina



### Slate Black Traditional Patina (cold or hot application)

Slate Black is a versatile and unique finish for use on iron, steel, stainless steel, aluminum, bronze, brass, or copper.

Applied hot, Slate Black will create a deep brown patina on aluminum and a red-green finish on stainless steel. On iron, steel, and nonferrous metals, Slate Black will form a black patina when applied cold.

Before applying this patina, sandblasting or sanding is required to clean the surface of oil, oxides, and residues. Slate Black may be applied as a spray or in an immersion process. Depending on the application method chosen, the results will range from a uniform solid color to a layered textured appearance. Slate Black Patina may be diluted up to 50% with distilled water depending on the desired strength of finish. The finish may be burnished wet or dry. Additional patinas can be layered over a Slate Black base. When dry, protect the finish with multiple coats of a clear sealer.

#### TBK08ZSLT

8 oz. Slate Black Traditional Patina

#### TBK32ZSLT

32 oz. Slate Black Traditional Patina

#### TBK01GSLT

1 gallon Slate Black Traditional Patina



*Slate Black Patina applied cold to aluminum*

*Slate Black Patina applied hot to stainless steel*

# SCULPT NOUVEAU PATINAS AND METAL FINISHES

## STEP 2 - Apply the Appropriate Patina *(continued)*

### Stainless Black Traditional Patina (cold application)

Stainless Black is made to create a black patina finish on stainless steel.

In order for this patina to react, you must remove the nickel and chrome from the surface before applying the patina.

Clean the metal surface before application. Sandblasting is the recommended method but you may also use an orbital sander with 80 to 120 grit sandpaper, or the metal can also be soaked in muriatic acid. Apply by spray or immersion. The solution may be diluted with distilled water, but it is usually used in its full strength. The amount of dilution will depend on your metal and the color desired. A normal dilution range would be between 25% - 50%. Apply a clear sealer. Tinted clear stains are beautiful when applied over this patina.

#### TBK08ZSTA

8 oz. Stainless Black Traditional Patina

#### TBK32ZSTA

32 oz. Stainless Black Traditional Patina

#### TBK01GSTA

1 gallon Stainless Black Traditional Patina



© Sculpt Nouveau



*Traditional Stainless Black Patina lightly sprayed on stainless steel*

### Japanese Brown Traditional Patina (cold or hot application)

This patina may also be used on bronze, brass and copper but is mainly used on iron and steel. When applied to bronze, brass or copper, it will result in a golden color. When applied cold on iron and steel, a brown rust will form. When applied to heated steel, a dark chocolate brown will form. Clean the metal surface before application. If the metal is smooth it will be a shinier patina. If the metal surface is sandblasted it will look more like satin. Heat will darken the color as well as make it less mottled. Rinsing is not mandatory. If you don't rinse, leave the patina alone for 24 hours before applying a clear sealer. Do not use on aluminum, galvanized or stainless steel.

#### TBR08ZJBR

8 oz. Japanese Brown Traditional Patina

#### TBR32ZJBR

32 oz. Japanese Brown Traditional Patina

#### TBR01GJBR

1 gallon Japanese Brown Traditional Patina



© Sculpt Nouveau



*Japanese Brown Patina applied hot to hot rolled steel*

### Universal Patina (hot application)

Universal Patinas are non-reactive, UV safe, do not contain acids and are environmentally friendly with no VOC's.

Any metal surface needs to be cleaned before application. For best adhesion, Universals should be applied hot. Heat the metal to approximately 180°F-220°F. Universals are heat tolerant, scratch resistant, and may be used as a base for other patinas. A clear sealer is always recommended to protect your finish.

#### UNI08ZRUS

8 oz. Rust Universal Patina

#### UNI32ZRUS

8 oz. Rust Universal Patina

#### UNI01GRUS

8 oz. Rust Universal Patina



## STEP 2 - Apply the Appropriate Patina *(continued)*

### Tiffany Green Traditional Patina (cold application)

This is a beautiful stable green. It is an old formula developed by Tiffany for Tiffany lamp bases. If it is overlapped or applied heavily it may “pop off” and will tend to go a little blue. Tiffany Green tends to be slow to react, but worth the wait. To see the results, let it sit overnight.

Clean the metal first as with any other patina. Spray, brush, or sponge on the patina. Let the reaction work for 2 - 6 hours. Reapply if a deeper color is desired. No rinsing is necessary. If used on iron or steel, rust will occur. Don't use on aluminum. Set with a clear sealer when done. For indoor or outdoor use.



Tiffany Green Patina applied cold to copper



- TGR08ZTGR**  
8 oz. Tiffany Green Traditional Patina
- TGR32ZTGR**  
32 oz. Tiffany Green Traditional Patina
- TGR01GTGR**  
1 gallon Tiffany Green Traditional Patina



### Smart Stains (cold application)

Smart Stain is a strong, non-hazardous, fast drying patina system. It has no VOC's and no odor. Smart Stain contains UV inhibitors and will not fade outdoors if maintained properly. It will clean up with warm, sudsy water.

Smart Stain is very versatile. All colors are transparent and may be blended or layered onto any metal including iron, steel and aluminum. When applying Smart Stain onto a bare surface, we recommend that the surface be oil-free and slightly roughed up. To alter or enhance the color, Smart Stain may be applied over another patina surface once dry.

Smart Stain is made by combining finely ground, naturally occurring colored oxides with a water base polymer/resin binder. It is sold in concentrated form and may be diluted with distilled water up to 25% to increase transparency. Only Smart Coat should be used to dilute it any further.

Instructions for Application:

- (1) Shake well.
- (2) Clean the surface of the material and make sure it is completely dry before applying Smart Stain.
- (3) Apply by spray, sponge, roller, or brush. Apply as many coats as needed to achieve the desired color. If applying over a patina, make sure the first layer of Smart Stain saturates the rust or patina. Allow 1 hour to fully cure between coats.

For exterior applications, Smart Stains should be sealed with three layers of Smart Coat, Clear Guard or Ever Clear. Maintenance requirements will vary by location. In most environments, regular application of Sculpt Nouveau's Metal Wax or Metal Oil, over the clear coat, is sufficient to maintain this finish.

- SST08ZBRN**  
8 oz. Brown Smart Stain
- SST32ZBRN**  
32 oz. Brown Smart Stain
- SST01GBRN**  
1 gallon Brown Smart Stain



- SST08ZBLK**  
8 oz. Black Smart Stain
- SST32ZBLK**  
32 oz. Black Smart Stain
- SST01GBLK**  
1 gallon Black Smart Stain



**NOTE:**  
Smart Stains may be applied to warmed metal. Heat metal with a heat gun or torch up to 120°F. Apply by any method to achieve desired effect. Seal when dry.

## STEP 2 - Apply the Appropriate Patina *(continued)*

### Patina Stains (cold application)

Patina Stains are blended to match chemical or traditional patinas, but are easier to apply and manage. They are UV stable.

These stains may be sprayed, brushed, or rubbed on any metal. They may be thinned to produce a lighter shade. One gallon of Patina Stain covers approximately 300 sq/ft. For best results, over-spray with Clear Guard EF after application.

The stains are available in black, brown, brass, bronze, red, verde (copper green), yellow and rust for all metal surfaces. The standard environmentally friendly formula has low VOC, no solvent odor, and may be thinned with Clear Guard EF or Sculpt Nouveau Solvent Thinner.

Patina Stains are also available in 12oz. spray cans in every color. Spray cans are only shipped by ground.

Patina Stain Application Instructions:

- (1) If working on non-patinated metal, clean the surface as needed. Examples would be: Wipe down with a clean cloth, sand or burnish with a Scotch-Brite pad. Clean with Sculpt Nouveau's Metal Cleaner.
- (2) Make sure that the surface is completely dry by heating with a heat gun or patina torch.
- (3) Applying with a sprayer will give the most consistent results. You may also apply with a brush or sponge.
- (4) Let the Patina Stain cure a minimum of 2 hours and apply more coats if desired. You may also layer on different colors of Patina Stain.
- (5) Apply as many coats as needed, making sure the first layer of stain saturates the rust or patina on your surface.
- (6) Apply 1-2 layers of clear finish. This will depend on your situation (indoor, outdoor, what type of metal - more layers of clear for ferrous metals).
- (7) Apply clear or colored wax 24 hours after the last layer of clear sealer.

#### PSN08ZBLK

8 oz. Black Patina Stain

#### PSN12ZBLK

12 oz. Black Patina Stain in Aerosol Spray Can

#### PSN32ZBLK

32 oz. Black Patina Stain

#### PSN01GBLK

1 gallon Black Patina Stain

#### PSN08ZBRN

8 oz. Brown Patina Stain

#### PSN12ZBRN

12 oz. Brown Patina Stain in Aerosol Spray Can

#### PSN32ZBRN

32 oz. Brown Patina Stain

#### PSN01GBRN

1 gallon Brown Patina Stain

#### PSN08ZBRA

8 oz. Brass Patina Stain

#### PSN12ZBRA

12 oz. Brass Patina Stain in Aerosol Spray Can

#### PSN32ZBRA

32 oz. Brass Patina Stain

#### PSN01GBRA

1 gallon Brass Patina Stain

#### PSN08ZBRO

8 oz. Bronze Patina Stain

#### PSN12ZBRO

12 oz. Bronze Patina Stain in Aerosol Spray Can

#### PSN32ZBRO

32 oz. Bronze Patina Stain

#### PSN01GBRO

1 gallon Bronze Patina Stain

#### PSN08ZCOP

8 oz. Copper Patina Stain

#### PSN12ZCOP

12 oz. Copper Patina Stain in Aerosol Spray Can

#### PSN32ZCOP

32 oz. Copper Patina Stain

#### PSN01GCOP

1 gallon Copper Patina Stain

#### PSN08ZSIL

8 oz. Silver Patina Stain

#### PSN12ZSIL

12 oz. Silver Patina Stain in Aerosol Spray Can

#### PSN32ZSIL

32 oz. Silver Patina Stain

#### PSN01GSIL

1 gallon Silver Patina Stain

#### PSN08ZRED

8 oz. Red Patina Stain

#### PSN12ZRED

12 oz. Red Patina Stain in Aerosol Spray Can

#### PSN32ZRED

32 oz. Red Patina Stain

#### PSN01GRED

1 gallon Red Patina Stain

#### PSN08ZVER

8 oz. Verde Patina Stain

#### PSN12ZVER

12 oz. Verde Patina Stain in Aerosol Spray Can

#### PSN32ZVER

32 oz. Verde Patina Stain

#### PSN01GVER

1 gallon Verde Patina Stain

#### PSN08ZYEL

8 oz. Yellow Patina Stain

#### PSN12ZYEL

12 oz. Yellow Patina Stain in Aerosol Spray Can

#### PSN32ZYEL

32 oz. Yellow Patina Stain

#### PSN01GYEL

1 gallon Yellow Patina Stain

#### PSN08ZBLU

8 oz. Blue Patina Stain

#### PSN12ZBLU

12 oz. Blue Patina Stain in Aerosol Spray Can

#### PSN32ZBLU

32 oz. Blue Patina Stain

#### PSN01GBLU

1 gallon Blue Patina Stain



## STEP 3 - Apply a Protective Sealer

A protective Clear Sealer would be used to protect material from the environment or to set a finish. Iron, steel and aluminum need a protective coating to keep from oxidizing or rusting. A polished surface on bronze, brass, or copper will tarnish without protection. After achieving a patina or color on your material, the protective coating will help it last longer and help to keep it from changing. We suggest applying a clear coating in almost every instance. The best way to apply any brand of clear sealer is to spray it on. Spraying reduces bubbles and ridges formed by the brush, which help to break down the product faster. Small propellant applicators are available, made by Badger or Crown, if you do not have a compressor. Two or three light coats are preferable to one heavy coat, letting each dry before applying the next. No protective sealer will last forever. A regular maintenance program is needed and should be scheduled according to the individual conditions. Wax may be applied over the clear sealer to add even more protection.

### Clear Guard (indoor use)

Clear Guard is a clear, durable, air drying lacquer that results in a hard, fast drying, and tarnish resistant film. It has excellent adhesion to bronze, brass, copper, and other metals as well as to patinas and rusted metal. Clear Guard is suitable for use with all types of application equipment including sprayers. Because of its unique chemistry, orange peel is virtually non-existent. Clear Guard is UV stable and highly resistant to weather, water, and chemical damage. It also resists marring and perspiration better than most solvent lacquers.

#### Handling/Mixing:

Loosen lid carefully. Container may be under slight pressure. Mix thoroughly before use. Use Sculpt Nouveau's Solvent Thinner to thin your application if necessary - usually 20% - be careful not to over thin.

#### Application:

Apply 2 - 3 coats, making sure the first layer of lacquer saturates the rust or patina. If spraying, use a HVLP sprayer at approximately 20 psi with a 1.2 - 1.4 orifice tip. Allow 1 hour for drying between coats.

### Smart Coat (indoor or outdoor use)

Smart Coat is a strong yet non-hazardous, zero VOC, non-odor, one part, self hardening, non-yellowing, and non-cracking, top coat. Smart Coat works well over patinas, rust-oxides, as well as all clean polished metals. It may be diluted with water to allow for a penetration of heavy oxides. The finish is beautiful, durable, and hard. Smart Coat is a polymer/resin, yet dilutes and cleans up with water and is eco friendly. Smart Coat tacks up and hardens quickly to a beautiful hard, thin coating that is fast drying.

#### Application Conditions:

90°F (32°C) and below 85% humidity to ensure proper drying. This sealer is self leveling and may be brush applied. You may put the Smart Coat into your own sprayer (like a Crown, or Preval) or a HVLP sprayer. No dilution is necessary while spraying. May be diluted up to 25% with distilled water. Avoid applying in very windy and dusty conditions. Cover surrounding areas to protect from spray mist.

#### CGD08ZLQS

8 oz. Clear Guard Satin

#### CGD12ZLQS

12 oz. Aerosol Spray Satin

#### CGD32ZLQS

32 oz. Clear Guard Satin

#### CGD01GLQS

1 gallon Clear Guard Satin



#### CGD08ZLQM

8 oz. Clear Guard Matte

#### CGD12ZLQM

12 oz. Aerosol Spray Matte

#### CGD32ZLQM

32 oz. Clear Guard Matte

#### CGD01GLQM

1 gallon Clear Guard Matte



#### SCO08ZMAT

8 oz. Smart Coat 1K Matte

#### SCO32ZMAT

32 oz. Smart Coat 1K Matte

#### SCO01GMAT

1 gallon Smart Coat 1K Matte

#### SCO08ZSAT

8 oz. Smart Coat 1K Satin

#### SCO32ZSAT

32 oz. Smart Coat 1K Satin

#### SCO01GSAT

1 gallon Smart Coat 1K Satin



## STEP 3 - Apply a Protective Sealer *(continued)*

### Ever Clear (indoor or outdoor use)

Ever Clear is a clear, air drying two part urethane coating designed to provide the best and strongest protection for most surfaces and finishes. We have been able to reduce the VOCs and also improve the two part formula.

Ever Clear is not a water based formula. Use Sculpt Nouveau Solvent Thinner when reducing Ever Clear in order to keep the VOC level low. Ever Clear tacks up quickly and should be used for the difficult finishes such as counter-tops, fountains, or ocean environments. It works extremely well on all metals, wood, terracotta, ceramics, and concrete. Ever Clear provides unusually strong under-film tarnish protection. When deciding which two part clear coating to choose, Ever Clear would be the best in all circumstances as it will be compliant with the EPA, it is strong, clear, and has a fast tack time. Full cure time is 5 to 7 days.

#### Handling/Mixing:

Combine Sculpt Nouveau's Ever Clear Parts A and B at a 3:1 ratio. First, thoroughly mix Part A first and then mix Part A with Part B for 10 minutes. It is important to mix thoroughly to fully blend the two parts. It is recommended before using coating to let it sit for 10 - 15 minutes in an opaque covered container. Allow the coating to adjust to room temperature (70°F– 85°F). Filter the Ever Clear with supplied 18 micron filter. Pot life is approximately 6 hours. Do not use after this amount of time.

#### Surface Prep

Surfaces to be coated must be sound, clean, dry and free from grease, oil and other contaminants. Do not use acetone or any solvent for any type of surface prep or treatment. To achieve good bonding and drying, the ideal ambient temperature should be between 50°F and 80°F and humidity below 50%.

#### Application:

Spray application is the preferred method, although brushing or flow coating may be used. If applying with a brush, use a high quality natural bristle brush. When using the matte formula, brushing is not advised. Any dust collected on the cleaned metal should be blown or wiped off with a clean cloth before coating is applied. Coating should be applied in full coats. The second coat should be applied in about an hour. If you are unable to apply the second coat in a timely manner, you may lightly sand the first coat, so that the second coat will adhere. Take measures to minimize dust and debris falling on your coated products. Metal surfaces should be at room temperature (70°F–85°F).

**SPRAY:** Thinning is not necessary, or recommended, when using spray equipment with Ever Clear. If thinning is desired, use up to 20% Sculpt Nouveau Solvent Thinner. For best results use a good quality HVLP sprayer. Make sure that the spray equipment is clean and at room temperature. Spray at the lowest possible psi so that it lays down lightly, usually about 20 psi with a 1.2 - 1.4 orifice tip.

**DRYING TIME:** The coating air dries to the touch in less than 1 hour – depending on room temperature and may be forced dried faster at 250°F. The coating air dries solid/hard film within 4 hours, depending on coating thickness, temperature, etc. **Full cure dry time will be 5-7 days.**

Ever Clear two-part is packaged with detailed instructions and filters for mixing. One gallon typically covers 125 sq. ft. with the recommended 2 coats.

#### ECL12ZSAT

12 oz. Aerosol Spray  
Ever Clear 2K Satin

#### ECL32ZSAT

32 oz. Ever Clear 2K Satin

#### ECL01GSAT

1 gallon Ever Clear 2K Satin



#### ECL12ZMAT

12 oz. Aerosol Spray  
Ever Clear 2K Matte

#### ECL32ZMAT

32 oz. Ever Clear 2K Matte

#### ECL01GMAT

1 gallon Ever Clear 2K Matte



#### ECL12ZGLS

12 oz. Aerosol Spray  
Ever Clear 2K Gloss

#### ECL32ZGLS

32 oz. Ever Clear 2K Gloss

#### ECL01GGLS

1 gallon Ever Clear 2K Gloss



#### ECL12ZSUG

12 oz. Aerosol Spray  
Ever Clear 2K Super Gloss

#### ECL32ZSUG

32 oz. Ever Clear 2K Super Gloss

#### ECL01GSUG

1 gallon Ever Clear 2K Super Gloss

# SCULPT NOUVEAU PATINAS AND METAL FINISHES

## STEP 3 - Apply a Protective Sealer *(continued)*

### Metal Oil (indoor or outdoor use)

Metal Oils can be used on all metals. They have UV & Corrosive Inhibitors. Apply only thin coats of the Metal Oil with a soft cloth, brush, or spray to the clean metal or dry patinated surface. Burnish lightly with a clean cloth. Allow 3 to 12 hours to dry. Apply two coats. The oil is best applied to a surface at moderate temperatures around 70° F. Allow oil to cure for 3-4 days and a clear top coat or wax may be applied over the dried oil. For indoor or outdoor use.

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*Brown Metal Oil applied to brass knob.*

- OIL08ZCLR**  
8 oz. Clear Metal Oil
- OIL32ZCLR**  
32 oz. Clear Metal Oil
- OIL01GCLR**  
1 gallon Clear Metal Oil



- OIL08ZBLK**  
8 oz. Black Metal Oil
- OIL32ZBLK**  
32 oz. Black Metal Oil
- OIL01GBLK**  
1 gallon Black Metal Oil



### Metal Wax (indoor or outdoor use)

The finest quality waxes have been blended into a nonabrasive formula specifically to protect patinas and metal finishes. These waxes contain UV inhibitors and hardeners making them incredibly durable and long lasting on all types of metal.

#### General Tips:

These metal waxes can be applied to hot or cold surfaces. However, they should not be applied to extremely hot surfaces.

When applying, smooth down any ridges or bumps. Stippling with a brush may be the preferred method of application so as to not create streaking on the surface. Try not to let the clear wax fill up in any recessed areas as it may turn opaque when dry. Build up in recessed areas may be desirable with the colored waxes.

Burnish the finish when the wax is dry (usually 1-2 hours). The colored waxes generally take longer to dry. If you are applying the wax to a hot surface, let the surface cool down completely, then buff. Use a lint-free cloth (such as a microfiber cloth) to buff. Do not wait too long as the wax will become too hard to burnish.

#### Maintenance:

Lightly clean the surface every six months or as needed with a non-ionic soap like Ivory® Soap. Dry completely and reapply a new layer of wax with a brush. When dry, buff as before. If the wax is maintained regularly, there is a good chance the clear sealer will last a long time.

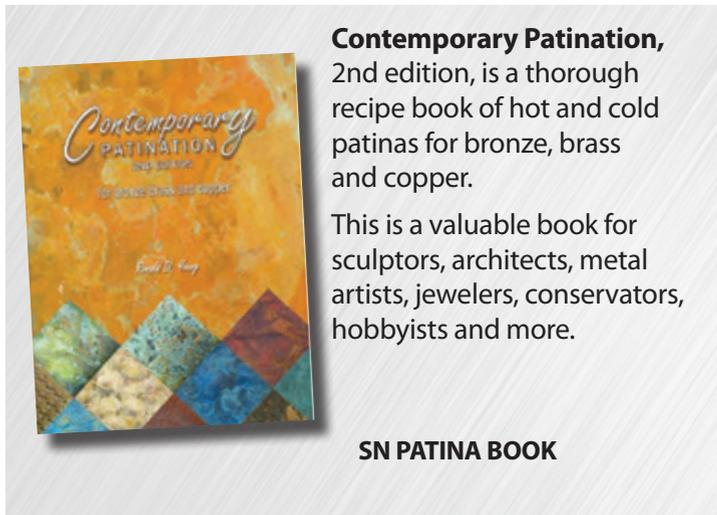
- MWX08ZCLR**  
8 oz. Clear Metal Wax
- MWX32ZCLR**  
32 oz. Clear Metal Wax
- MWX01GCLR**  
1 gallon Clear Metal Wax



- MWX08ZBLK**  
8 oz. Black Metal Wax
- MWX32ZBLK**  
32 oz. Black Metal Wax
- MWX01GBLK**  
1 gallon Black Metal Wax



# SCULPT NOUVEAU PATINAS AND METAL FINISHES



**Contemporary Patination**, 2nd edition, is a thorough recipe book of hot and cold patinas for bronze, brass and copper.

This is a valuable book for sculptors, architects, metal artists, jewelers, conservators, hobbyists and more.

**SN PATINA BOOK**

## Solvent Thinner

Sculpt Nouveau Solvent Thinner has no VOC's and is a very effective replacement for Xylene. It may be used to thin all solvent products. For best results when spraying a solvent lacquer, thin with up to 20% Sculpt Nouveau Solvent Thinner. Wear gloves, goggles and protective clothing. Do not ingest.

**STH08ZSTH**  
8 oz. Solvent Thinner  
**STH32ZSTH**  
32 oz. Solvent Thinner  
**STH01GSTH**  
Solvent Thinner



## FAQS

### What happens if the product freezes?

Nothing, just let the product thaw and mix well.

### What is the shelf life of the products?

For the most part, there is no shelf life. Japanese Brown has a shelf life of one year if left unopened. Some other products such as the Metal Oil and Clear Coats (Matte) have to be stirred well because the ingredients settle.

### What is the coverage per product?

Coverage for our patinas are approximately 1½ sq. ft per ounce, except for the black patinas. They may only give 1 sq. ft. per ounce because they have to be reapplied to achieve a deep coloration.

Birchwood Casey Patinas will usually give double this coverage because they work better if they are diluted up to 50% with distilled water.

Clear Coats coverage is 250 sq. ft. per gallon for one coat. For the recommended 2 coats, the coverage will be 125 sq. ft.

Patina Stains will cover 200 sq. ft. per gallon undiluted. Since they are usually diluted, the square footage will depend on the dilution rate.

Waxes and Oil will cover approximately 3 sq. ft. per ounce.

### What is cold patina?

A process of applying patina chemical solutions directly to the unheated surface of the metal. "Cold Patina" is a term used for applying patinas without heating the metal. The best room or air temperature for these patinas is between 65° and 75° F. Often they involve cycles of applications involving layers of patina. The three basic techniques of applying the patina are to use a brush, sponge, or spray bottle. There are also some very interesting ancient techniques where the metal object is buried in substances soaked with the patina or wrapped in cloth soaked with a patina. A characteristic of most cold patinas is that they are opaque.

### What is hot patina?

This is the most widely used technique. The surface of the metal is heated with a torch to open its pores, usually to around 200° F. The patina chemical solutions are then applied with a brush or by spraying. As the metal cools, the patina is locked in. An easy test for the correct temperature is to sprinkle a few drops of distilled water from a spray bottle onto the hot metal surface. If the water sizzles it is the correct temperature. If the water runs off, the metal is too cold. If the water balls up, it is too hot. A characteristic of some hot patinas is that they are transparent. There are three ways the metal may be heated: 1) The most common method is using a propane torch with a 5-gallon propane bottle or using a torch with a gas/air mix used with an air compressor; 2) Using a hair dryer or a paint peeler; 3) Placing the object in the sun or oven.

### How do I get the "oil rubbed bronze" look on steel?

The steel can be darkened first with Black Magic or PC9, then a brown and yellow Patina Stain applied over the top. Then sealed with Ever Clear.

A nice dark brown is formed by heating the metal first to 180°F to 220°F and applying Japanese Brown, then sealing it with Ever Clear.

Here are some videos:

The leaf video shows mainly yellow and brown, but it would look more like the dark oil rubbed bronze if there is a black base first.



The aluminum video shows the blackening process, Patina Stain and Yellow Dye-Oxide process. The same process will be used on steel, except instead of using A-14, either Black Magic or PC9 would be used to blacken the steel.

