
AUROMEX[®]

TECHNICAL

INSTRUCTIONS

DATA SHEETS

DECORMEX EF99MX **HIGH EFFICIENCY ELECTROFORMING GOLD PROCESS**

INTRODUCTION

The AUROMEX **DECORMEX EF99MX** is a newly developed high efficiency neutral gold process, specially designed to give a hard, ductile and fine grained deposits at thickness in excess of 1.25mm (0.050 inches). This process is advantageous to many applications and ideal for electroforming purpose, for building up thick deposits where subsequent finishing is not required.

FEATURES

- * Matte to Satin finish deposits
- * Deposits are hard and highly ductile
- * Non-critical in operation and control
- * No accumulation of deleterious brightener decomposition products
- * Exceptional throwing and covering power
- * High Cathode Efficiency and Good thickness distribution

DEPOSIT PROPERTIES

Appearance	: Matte to Satin Finish (rich lemon yellow colour)
Deposit purity	: 99.9% up
Karat	: 24 Kt
Hardness	: 110 - 140 mHv20g
Deposit Density	: 18.7 - 19.0 g / dm ²
For 1 micron deposit	: 187 - 190 mgm / dm ²

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CHEMICALS CORPORATION

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EQUIPMENT

- Tanks Polypropylene or PVC glass fiber reinforced tanks are suitable. Heating is required and temperature regulation is essential. Therefore,
- Heater thermostatically controlled immersion heater are recommended.
- Rectifier A standard D C power supply should be used with an ampere output capacity sufficient to meet the requirements of the plating operation. The power supply should be equipped with a voltmeter, ammeter and step less control for accurate regulation of the current.
- Filtration The solution should be filtered continuously through polypropylene or cotton cartridges to maintain clarity.
- Agitation Moderate to vigorous agitation is necessary to maintain uniform metal distribution. Jet Stream and mechanical agitation at 7-14 m/min may be used.
- Anodes Insoluble anodes should be used, Platinised Titanium anodes with an area sufficient to provide a maximum current density of $0.25A / dm^2$ are recommended.

PLATING BATH PREPARATION :

AUROMEX **DECORMEX EF99MX** make up chemicals are supplied in unit form. Each unit contains all the products required to make 10 litres working solution. It does not contain gold.

The following instructions are for the preparation of 10 litres of solution.-

Material required :-

Gold potassium Cyanide (68.3%)	220 gms.
Decormex EF99MX Make Up Salt (Code 88190)	1 kg
Decormex EF99MX Make Up Brightener (Code 88191)	100 mls.
Decormex EF99MX Acid Adjustment Solution (Code 88195)	
Potassium Hydroxide (A.R. Grade)	

Make up Procedures :

1. Pour 6 litres of demineralised or distilled water into the clean plating tank.
2. Add in the 1.0 kgs Make Up Salt (Code 88190), stir until completely dissolved and then add the 100 mls. Make Up Brightener (Code 88191).
3. Check and adjust pH to 6.5 with Decormex EF99MX acid or 10% Potassium Hydroxide solution.
4. Dissolve the gold potassium cyanide in a separate quantity of demineralised or distilled water, and then add to the above solution.
5. Stir and check the pH again. Adjust to pH 6.5 if necessary.
6. Dilute the solution to 10 litres with demineralised or distilled water. The solution is then ready to use.

OPERATING CONDITIONS :

	<u>UNIT</u>	<u>RANGE</u>	<u>OPTIMUM</u>
Metallic gold content	g/l	12 - 20	15
pH electrometric		6.0 – 7.0	6.5
Temperature		30 - 50	40
Cathode current density	A/dm ²	0.3 – 0.8	0.5
Density	Be	6 - 20	8
Anode : Cathode ratio		3:1 – 5:1	4:1
Agitation		moderate	moderate
Plating rate	μ m/hour	50 - 65	60

BATH MAINTENANCE

Gold metal content of the solution should be maintained at the recommended concentration (12-20 g/l) by periodic additions of gold potassium cyanide 68.3%. Replenisher Brightener is supplied as a liquid in units of 100 mls. One unit contains all the necessary agents to be added with the appropriate quantity of gold salts corresponding to 100 grams of gold metal.

Replenishment should be based on regular analysis but under optimum operating conditions, **DECORMEX EF99MX** process deposit metal at the following rates

<u>Amp-min</u>	<u>Gold consumed</u>
850	100 grams

For every 100 grams gold replenishment (147 grams 68.3% PGC) add one units (100 mls) **DECORMEX EF99MX** Replenisher Brightener (Code 88198).

Conductivity : Specific gravity of the solution should be maintained between 6-20 baume. If for any reason excessive drag out occurs, and specific gravity of the solution drops below 6 Be conducting salt (Code 88199) should be added to the solution. For every 16 g/l addition of this conducting salt will increase 1 Be at 35°C.

pH adjustment : The pH of the solution will rise slowly during use and should be checked periodically. To lower the solution pH by addition of Decormex Acid. To increase pH by addition of 10% potassium hydroxide solution.

PACKING :

DECORMEX EF99MX Make Up Salt (Code 88190)	1 kg / unit
DECORMEX EF99MX Make Up Brightener (Code 88191)	100 mls / unit
DECORMEX EF99MX Replenisher Brightener (Code 88198)	100 mls / unit
DECORMEX EF99MX Conducting Salt (Code 88199)	1 , 2 , 25 kgs / pack
DECORMEX EF99MX Acid Adjustment Solution (Code 88195)	1 , 2 , 5 litres / pack