
AUROMEX®

TECHNICAL

INSTRUCTIONS

DATA SHEETS

DECORMEX NIC HIGH SPEED ACID HARD GOLD ELECTROPLATING PROCESS

INTRODUCTION

AUROMEX DECORMEX NIC is a new complexed metallic brightened high speed / high efficiency acid hard gold electroplating process specially formulated for high quality jewelry, spectacle frames, watch cases and cutlery.

DECORMEX NIC is an based on an entirely new acid gold electrolyte that contains an effective metallic complex. High efficiency, even distribution characteristics and an exceptional throwing power make DECORMEX NIC an economic process to use. Increased output is obtained with a plating rate of 45-75 mgm/amp-min (2.4 - 4.0 minutes to deposit one micron at 1.0 A/ dm² depends on the operating temperature).

DECORMEX NIC produces mirror bright deposits of approximate 23 - 23.5 karats that are uniform pale yellow in color. There is no need to employ special additional finishing procedures with this process. Hardness values in the range 180 - 250 Vickers prolong the fine appearance and value of DECORMEX NIC coatings and eliminate wear point problems. The deposits are non-porous and resistant to tarnishing and corrosion.

PROCESS FEATURES

- * Higher cathode efficiency and ability to plate thicker deposit.
- * Excellent distribution and throwing power.
- * Good corrosion resistance.
- * Lower internal stress of deposits.
- * Wear and abrasion resistant.
- * Good tolerance to metallic impurities.
- * Easy to operate.

DEPOSIT CHARACTERISTICS

Appearance	Mirror bright, lustrous deposit
Deposit purity	96 - 98% approx.
Karat	23 - 23.5 Karats
Hardness	180 - 250 mHv _{20g}
Deposit density	17.0 – 18.0 g/cm ²
For 1 micron deposit	170 – 180 mgm/dm ²
Color of deposit	Hamilton 7

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CHEMICALS CORPORATION

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EQUIPMENT REQUIRED

Tank	Polypropylene or PVC glass fiber reinforced tank are suitable.
Heaters	Heating is required and temperature regulation is essential. Therefore, thermostatically controlled immersion heater are recommended.
Rectifier	A standard DC 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 stepless 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.

PREPARATION OF SOLUTION

The following instructions are for the preparation of 10 litres of Electrolytes.

Materials required :

Potassium Gold Cyanide (68.3%)	58.5 grams
DECORMEX NIC make up salt (Code 8030)	1.7 kgs.
DECORMEX NIC make up Brightener (Code 8031)	500 mls.
DECORMEX Acid (Code 8032)	
Potassium Hydroxide	

Make up procedures :

1. Pour 6 litres of demineralised or distilled water into the clean plating tank.
2. Add in the 1.7 kgs. Make Up Salt (Code 8030), stir until completely dissolved and then add the 500 mls. Make Up Brightener (Code 8031).
3. Check and adjust pH to 4.5 with 10% potassium hydroxide or **DECORMEX** Acid.
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 pH to 4.5 if necessary with **DECORMEX** Acid or potassium hydroxide.
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	3.0-6.0	4.0
pH electrometric		4.3-4.8	4.5
Temperature	°C	30-50	35
Cathode current density	A/dm ²		
Still Vat plating		0.5-2.0	1.0
Barrel plating		0.2-0.4	0.2
Density	°Be	13-18	15
Anode : cathode ratio, Vat		3:1-5:1	4:1
Barrel		2:1-3:1	2:1
Agitation			vigorous
Plating rate	mgm/Amp-min	45-75	55
Time to deposit 1u at 1 A/dm ²	min	2.4-4.0	3.5

BATH MAINTENANCE

Gold metal content of the solution should be maintained at the recommended concentration (3-6 g/l) by periodic additions of gold potassium cyanide 68.3%. Replenishing 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 NIC** process deposit metal at the following rates.

<u>Amp-min</u>	<u>Gold consumed</u>
1860	100 grams (at 35°C, 1 ASD)

As drag out losses cannot be accounted for accurately, analytical checks should be performed periodically.

For every 100 grams gold replenishment (147 grams 68.3% PGC) add one units (100 mls.) **DECORMEX NIC** Replenishing Brightener (Code 8075).

CONDUCTIVITY : Specific gravity of the solution should be maintained between 13-18 Brume. If for any reason excessive drag out occurs, and the specific gravity of the solution drops below 12 °Be, conducting salts (Code 8050) should be added to the solution. For every 16 g/l addition of this conduction 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% w/v potassium hydroxide.

CONTROL OF IMPURITIES

In general, any metallic impurities could interface with the operation of the DECORMEX gold bath. Introduction of metallic impurities into the bath should be prevented by proper rinsing of the parts to be plated and a DECORMEX S-100 gold strike prior to gold plating.

PACKING

When ordering, reference should be made to the following code numbers :

DECORMEX NIC Make Up Salt (Code 8030)	1.7 kgs/unit
DECORMEX NIC Make Up Brightener (Code 8031)	500 mls/unit
DECORMEX NIC Replenishing Brightener (Code 8075)	100 mls/unit
DECORMEX NIC Conducting Salt (Code 8050)	1,2,5 kgs/pack
DECORMEX NIC Special Conducting Salt (Code 8055)	1,2,5 kgs/pack
DECORMEX NIC Acid (Code 8032)	1,2,5 kgs/pack