
Palli Ex Palladium Solution

Description

Palli EX plating solution is a pure palladium plating solution for decorative use. It produces a white, bright finish that can almost substitute for rhodium. Palli EX can be directly applied to nickel or copper based alloys.

Application

Palli EX plating solutions are used in bath plating units. Preparation for this plating is electrocleaning of the work pieces. Electrical current must flow between the work pieces and the contact clip. Upon completing the plating process, the pieces are rinsed off.

It is important to avoid drag out of the plating solution.

Operating Information

Palladium Content	10 gr. / gal.
Temperature.....	130° - 150° F
Agitation	Mild
Time	30 sec. – 1 min
Voltage.....	1 – 2 Volts
pH	5.5 to 6.0 (Optimum 5.8)
Specific Gravity	8° Baume Minimum
Current Density.....	5 to 15 ASF
Current Efficiency	60% to 80%
Deposition Rate	5-7 microinches / minute @ 8-10 ASF

For higher thickness, increase Palladium content as required

Supplied Form

Ready to Use

Replenishing

Palladium - Maintain at 10 grams per gallon. Replenish approximately 80 ml Palli EX Concentrate (2 grams Palladium) per ampere hour.

Baumé - Maintain at 8° Baumé minimum by adding Palli EX Make-Up Salts.

pH - 5.5 to 6.0 (Raise pH: with Potassium Hydroxide; lower with Phosphoric Acid).

Palli EX Brightener: Replenished based on deposit appearance.

Note: After initial break-in of the Palli-EX Bath, solution must be filtered continuously through a carbon pack in order to maintain the bright white deposit. Change carbon pack twice weekly

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Caution

Chemicals and materials used in electroplating techniques can be hazardous to your health. During use, storage, transportation and disposal caution must be observed.

Equipment

Anodes Platinized Titanium
Anode Cathode Ratio 1:1 Minimum
Agitation..... Mild
Tank..... Plastic or Glass
