

TWL: TECHNOLOGY WITHOUT LIMITS, INC.

57 Service Road, West Warwick, RI 02893

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(800) 545-4570 ext. 244

Gold Plating Colors Technical Operating Data (Ready To Use 1Lt)

Pg1

Operating Parameter	1N Pale green yellow color	2N Yellow 14Kt color	3N Yellow 18Kt color	4N Rose color	5N Dark Rose color
pH	7.8-8.2	7.8-8.2	7.8-8.2	7.8-8.2	7.8-8.2
T°C	50-55	50-55	50-55	50-55	50-55
Volts	6.0-10.0	6.0-10.0	6.0-10.0	6.0-10.0	6.0-10.0
CD A/Dm²	0.5-1.0	0.5-1.0	0.5-1.0	0.5-1.0	0.5-1.0
Time (sec.)	30-60	30-60	30-60	30-60	30-60
Agitation	Moderate	Moderate	Moderate	Moderate	Moderate
Anode	S.S.	S.S.	S.S.	S.S.	S.S.

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Pg2

TROUBLESHOOTING AND PROCESS MANAGMENT:

ACTION or PROBLEM	CAUSE	REMEDY
To get more yellow deposit color		<ul style="list-style-type: none">- Rise temperature, 3-5 °C- Reduce voltage, 0.5 V- Rise anodic surface (1-2 SS anodes)
To get more white-green deposit color		<ul style="list-style-type: none">- Rise voltage, 0.5 V- Reduce anodic surface (1-2 SS anodes)- Move or stir pieces or solution
To get more red deposit color		<ul style="list-style-type: none">- Red. anodic surface (1-2 SS anodes)- Rise voltage, 0.5 V- Reduce temperature, 3-5 °C
To get more white-grey deposit color		<ul style="list-style-type: none">- Rise voltage, 0.5 V
Deposit dark-brown	<ol style="list-style-type: none">1. Bad anodes and cathode contacts2. Stainless steel anodes oxidized3. Poor conductivity4. Solution polluted of organic material5. Solution polluted of ions metals6. Bad preparation of pieces	<ol style="list-style-type: none">1. clean contacts2. Brush anodes3. Carbon treatment and filtration and control rinse water quality4. Change solution5. Change degreasing and/or neutralization solutions
Deposit faded (pale)	<ol style="list-style-type: none">1. Low content of gold2. Poor conductivity	<ol style="list-style-type: none">6. clean contacts7. Brush anodes8. Carbon treatment and filtration and control rinse water quality9. Change solution