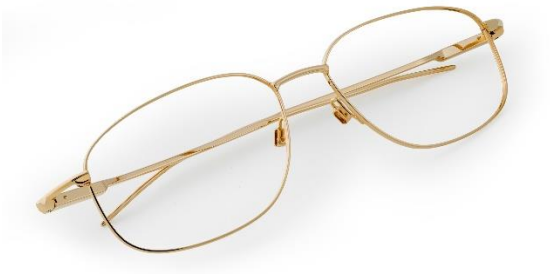
Aurega® blend Pd 9000

Pale gold deposits with extraordinary corrosion resistance

The goldprocess Aurega® blend Pd 9000 is a neutral sulfite electrolyte which produces mirrorbright deposits with a hardness of about 260 - 320 HV_{20}. This type of process is widely used for decorative plating in the spectacle industry as well as for watches and jewellery. Layers from Aurega® blend Pd 9000 have an extraordinary corrosion resistance and are colour constant up to approx. 250°C. They are of 21 – 22 ct.



Properties and benefits

- colour constant up to 250°C
- sulfite
- corrosion resistant
- free of nickel and cobalt
- L* = = 83, a = +6, b = +18

Application area

- Jewellery
- Optical frame industry

Technical Data

Electrolyte properties		
Parameter	Range	Optimum
Specific gravity	13 - 14°Bé/20°C	
pH-Value	6,8 – 7,0	6,9
Gold	3,0 – 5,0 g/l	4,5 g/l
Palladium	1,9 – 2,1 g/l	2,0 g/l
Palladium for more yellow deposits	0,8 – 1,5 g/l	
Sulfite	35 – 40 g/l	
Temperature	54 – 56 °C	55 °C
Agitation	necessary, approx. 5 - 7 cm/sec	
Anodes	Pt/Ti-Anodes	
Anode/Cathode ratio	approx. 4:1	
Current density rack	approx. 0,5 – 0,8 A/dm²	
Current density barrel	approx. 0,3 – 0,5 A/dm²	
Current efficiency	approx. 80 – 90 mg/Amin	
Time of exposition for 1µm at 0,7 A/dm²	approx. 2,7 min	

Deposit characteristics

Appearance ..... pale gold

Hardness ..... 260 – 320 Hv_{20}

Carats ..... 21 – 22 ct

Products available

3480000 ..... Aurega® blend Pd 9000 Make up 3:5

3480500 ..... Aurega® blend Pd 9000 Replenisher 1

3480600 ..... Aurega® blend Pd 9000 Replenisher 2

3480900 ..... Aurega® blend Pd Buffer salt

1048100 ..... Aurega® blend Pd 9000 Purification resin

1162400 ..... Aurega® Gold solution 9000

3480400 ..... Aurega® Palladium solution 9000

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