

Metal deposits



# Pallega® blend Sn

## Mirror bright white palladium alloy deposits

Pallega® blend Sn process is a weak alkaline electrolyte from which bright, decorative white levelled alloy layers can be deposited. Pallega® blend Sn has been formulated to get crack free and non-porous layers. A typical field of application is the watch, bijou and optical frame production. Pallega® blend Sn enables deposits of thicknesses up to 10 microns with mirror bright finish, that is the reason why it can be used as an excellent corrosion protective nickel substitute.



### Properties and benefits

- White colored alloy of Pd-Sn
- Alloy composition Pd-Sn approx. 80/20 – 70/30
- Mirror bright up to 10  $\mu$
- RoHS and CLEAR-compliant
- Superior corrosion resistance
- higher abrasion resistance than pure palladium
- Strongly reduced losses through drag out due to low palladium content
- $L^* = 83, a = +1, b = +6,5$

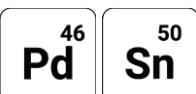
### Application area

- Jewellery
- Watches
- Optical frames
- Technical applications

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## Technical Data

### Electrolyte parameters

Parameter	Range	Optimum
Specific gravity	9 – 12°Bé/20°C	
pH-Value	8,0 – 8,5	
Palladium	5,0 – 7,0 g/l	6,0 g/l
Tin <sup>2+</sup>	3,5 – 4,5 g/l	4,0 g/l
Temperature	45 °C	
Agitation	Approx. 4 cm/sec	
Anodes	Mixed oxide	
Cathodic current density	0,5 – 2,0 A/dm <sup>2</sup>	1 A/dm <sup>2</sup>
Anodic current density	0,2 – 0,3 A/dm <sup>2</sup>	
Rate of deposition	approx.3 min/µm at 1 A/dm <sup>2</sup>	

### Deposit characteristics

Appearance.....	.....silver grey
Specific gravity of the deposit.....	.....10,9 g/cm <sup>3</sup> for an alloy 75% Pd, 25% Sn

## Products available

3469600 .....	Pallega® blend Sn Ready to use
3469610 .....	Pallega® blend Sn Make up 7:10
3469630 .....	Pallega® blend Sn Replenisher 1
3469640 .....	Pallega® blend Sn Replenisher 2
3469650 .....	Pallega® blend Sn Wetting agent
3469660 .....	Pallega® blend Sn Density correcting salt
3474000 .....	Pallega® Palladium solution 100

FOR ANY FURTHER INFORMATION WE WILL BE PLEASED TO BE AT YOUR DISPOSAL  
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