

GOLD PLATING BATH FOR THICK COATING 1g/l PURE GOLD COLOR

Colour **Yellow**

[L: 82,0 a: 8,1 b: 33,6 c: 34,6]

Product description

LEGORGROUP has developed the latest formulation in gold plating solution for bath able to deposit gold directly onto stainless steel or difficult metals as titanium.

Recommended applications

This new acid based process is both easy to use and safe. GFX1 contains 1 g/l of gold, however is not intended to substitute either our GF or GT series plating solution. GFX1 operates as a primer on Stainless Steel prior to decorative deposition. It must be followed by either our GT or GF gold plating solution. The main characteristics are :

- Gold concentration 1 g/l
- wide range of working parameters

Deposit data

Density [g/cm ³]	19.1
Hardness [HV 0.01]	170 - 190
Thickness [µm]	0,1 µ/min
Appearance	Shiny

Operating data

	Range	Optimum
Gold concentration (g/l)	0.5 - 2.0	1.0
Cobalt concentration (g/l)	0,25 - 1.0	0.5
pH	1.0 - 1.5	1.2
Time of exposure [s]	60 - 120	90
Operating temperature [°C]	40 - 50	45
Voltage [V]	2.5 - 3.5	3
Solution density [°Bé]	8 - 12	10
Current density [A/dm ²]	1 - 5	3
Cathode efficiency [mg/Amin"]	16	
Agitation	Necessaria	
Solution stirring	Filter pump for volumes > 10 l	
Deposition rate at 1 A/dm ² [µm/min]	0.1	0.1

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Additional informations

Packaging

The product comes in a high-density polyethylene bottle with a heat-sealed poly laminate aluminium-polyethylene underlid.

Preparing objects

For maximum performance the objects to be treated should be cleaned beforehand using ultrasound washing treatments and special cleaning agents, then subjected to electrolytic degreasing treatment. For best results use of the SGR1 (see technical sheet) electrolytic degreaser is recommended.

Temperature

GFX1 gives excellent performance in a temperature range between 40°C and 50°C.

Equipment

In order to operate with best results using GFX1, processing systems assembled in PVC (polyvinylchloride) or PP (polypropylene) or PIREX are advised, complete with:

- Complete rectifier with amperometer and voltmeter, with low alternate current residue
- Thermoregulated heaters
- Ampereminutes or Amperehours counter
- Platinum or Platinum plated titanium anodes
- Magnetic entrainment filtering pumps with woven polypropylene cartridges (5-15 micron), boiled and washed before usage. (only for volumes bigger than 10 liters)

Preparing 10 l of plating bath

The products for GFX1 bath forming are ready-to-use

Galvanic Bath Maintenance

GFX1 does not require adding.

Safety Information

Caution: GFX1 gold plating bath is a chemical solution of acid nature. Caution should be exercised when using the product, avoiding contact with the eyes and skin. Use gloves and safety goggles. For further information please refer to the relative safety sheet.

<u>Solutions for plating</u>	<u>Code</u>
Thick gold plating solution	GFX1