Technical data sheet and product guideline

GP1-3N

3N yellow gold pen plating solution

PEN

Color coordinates

L	**87.8**
a	**4.2**
b	**26.4**
c	**26.7**

Product form

Metal concentration	**1 g/ 100 ml**
Form	**Liquid**
Material color	**Greenish transparent**
Storage time	**2 years**
Format	**Ready to use**
Chemical type	**Cyanide based**
Volume	**100 ml**

Operating data

	Range	Optimal
Voltage (V)	**5-10**	**8**
Working temperature (°C)	**20 - 30**	**25**
pH	**5-10**	**8**
Deposition speed	**5-10**	**8**

Metal concentration

Metal	Range (g/l)	Optimal (g/l)
Gold	**10**	

Deposit data

Purity (%)	**99.999**
Hardness (HV 0,01)	**90 - 100**
Density (g/cm3)	**19.6**
Thickness (um)	**0.1 - 0.3**
Appearance	**Shiny**
Color	**3N yellow gold**

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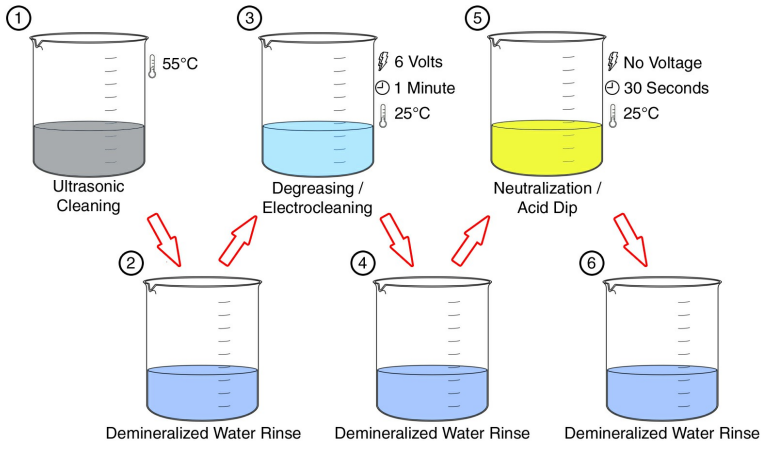
Preparation

GP1-3N is a ready-to-use pen plating solution at the concentration of 1 g/ 100 ml. No preparation is required.

Equipment

Power supply: Pen plating machine (5 Amp – 12 Volt rectifier)
Anode: A pen with a platinum collar
Tips: Fiber (white or brown)

Pre treatment



Bath maintenance

Use until the rhodium solution is completely exhausted without incorporating replenishment or additives.

Post treatment

Electrolyte should be removed from the surface as quick as possible. Rinse off the bath rests in a recovery rinse (still rinse).
Rinse the parts in running water and dry.

Safety information

Being an acidic solution, the electrolyte is corrosive therefore is an irritant to the skin, eyes and mucous membranes. Caution should be exercised when using the product, avoiding contact with the eyes and skin. Use gloves and safety goggles. Keep away from cyanide based chemicals. For further information please refer to the relative MSDS.

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Additional hints

Choosing the correct voltage
The best voltage for using GP1-1N is to be chosen upon the kind of tip used on the pen:
White tips: 8 -10 V
Brown tips: 7 - 9 V
PENGRAF: 3 - 5 V

Packaging

Your jewelry technology provider LEGOR GROUP
LEGOR GROUP S.p.A. - Via del Lavoro,1 - 36050 Bressanvido (VI) Italy - tel. +39 0444 467911 - fax +39 0444 660677- info@legor.com - www.legorgroup.com