

PLATING PRODUCTS IND PVT LTD

Plot No.G 527, Phase 2, UPSIDC, M.G. Road, Industrial Area, Tehsil Dhaulana, Dist. Hapur, Uttarpradesh 201015.

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Gala No. 116, Saraf Udyog Bhavan, Chincholi Phatak, Malad (West), Mumbai – 400 064.

Phone: 9821340134/ 8104437477 Email: lab@platingproducts.in or info@platingproducts.in

Technical Data Sheet

P-BRITE WB

WHITE BRONZE

P-Brite WB is a tin -copper formulation which produces the much desired white-bronze color for architectural trim , snap , fasteners , zip sliders etc.

P-Brite WB has outstanding throwing power and stability. The brightener does not decompose and is relatively unaffected by the presence of organic and metallic contamination that effects other Brightener systems.

P-Brite WB is an easy to maintain bath with very low brightener consumption that produces uniform color and consistent results.

It is a single additive replenishment brightener system.

P-Brite WB maybe readily plated in either barrel or rack installations.

THE PROCESS

P-Brite WB Operating conditions

	Range	Optimum	Unit
Copper content	5-8.5	6.8	gm/lit
Tin Content	9-14	12.9	gm/lit
Sodium Cyanide	35-40	38	gm/lit

Sodium Carbonate	25–35	28	gm/lit
P-Brite WB-R	0.5% by volume		
300-W,Wetter	0.125% by volume	Operating Temperature	45–60C

FUNCTION OF ADDITION AGENTS

P-Brite WB BRIGHTENER is a make-up brightener and is used during the initial charge.

P-Brite WB BRIGHTENER is also added as the replenisher brightener and is added as needed by Hull Cell test to maintain the luster of the plate. It is consumed at a rate of approximately 100ml every 1000 amp./hours.

300-W provides wetting , reduces gassing and reduces the effects of organic contamination. The quantity is not critical, but enough should be present to provide for a small amount of foam on the surface.

P-Brite WB Replenisher is a replenisher for alloy metals and is added at 400 – 500 ml at every 1000 amp / hours

Periodically, a sample of the solution should be sent to PPI lab for comparative analysis before making any addition.

Anode : Graphite Anode

Anode to cathode ratio: 2:1

Cathode current density: 1 to 80 ASF

AGITATION

Air , cathode rod or barrel rotation (2-3 RPM). Air agitation is preferred because it permits higher current density plating.

FILTRATION

Constant filtration with two turnovers per hour is required.

VOLTAGE

Up to 12 volts for barrel plating and 1 to 7.5 volts for rack plating.

pH

Not monitored , but over 10.5.

TANK

Rubber or Koroseal lined steel or polypropylene.

VENTILATION

Forced ventilation required.

HEATING ELEMENTS

Titanium preferred.

Process Hints :

The articles to be plated have to be free from Oxide , oil and grease. Before plating , adequate degreasing , pickling as well as thorough rinsing operation is necessary . It is advisable to immerse the articles in 2-5% Sodium Cyanide solution as pre-dip before plating in **P-Brite WB** process.

Troubleshooting:

PROBLEMS	CAUSE	REMEDY
1. Colour to yellow	<ul style="list-style-type: none"> • Low tin content • Low cyanide 	<ul style="list-style-type: none"> • Add Replenisher • Add Cyanide
2. Colour to pale or whitish	□ pH too low	□ Add hydroxide
3. Bloomed Deposit	<ul style="list-style-type: none"> • High Temperature • Incorrect tin : copper ratio 	<ul style="list-style-type: none"> • Adjust the temperature • Adjust the ratio
4. Burning in HCD	<ul style="list-style-type: none"> • High Temperature • Low alloy content 	<ul style="list-style-type: none"> • Adjust the temperature • Add Replenisher
5. Colour non uniform	□ Too low cyanide	□ Add cyanide

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Neither seller nor manufacturer shall be liable either in tort or in contract for any loss or damage , direct , incidental or consequential arising out of the use or the inability to use the product.