

PLATING PRODUCTS IND PVT LTD

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Technical Data Sheet

P-Brite 180

Bright Acid Tin Plating Process

P-Brite 180 is a stable bath which deposits a leveled, brilliant plate with excellent solderability.

P-Brite 180 baths have a wide window of operation in regard to concentration and operate well with low tin concentration.

BATH MAKE UP

100 GALLONS

Stannous Sulfate 24 pounds

Sulfuric Acid C.P. 10 gallons

P-Brite 180-M Make-Up 2 gallons

P-Brite 180-B Brightener 3 quarts

OPERATING CONDITIONS

OPTIMUM

Range

Tin Metal	1.8 oz/gal	0.5 - 2.5 oz/gal
Sulfuric Acid	10% by volume	8 - 12% by volume
P-Brite 180-M	2% by volume	
P-Brite 180-B	0.75% by volume	
Temperature	70°F	65 – 80°F

Agitation: Barrel: Rotation is sufficient Rack:

Rod is sufficient

Voltage: 6 volts

Cooling coils: Teflon or Teflon coated

Filtration: Continuous

Anodes: 99.9% pure tin slabs

Anode Bags: Not required

Tank: Plastic or rubber lined steel

Anode Hooks: Monel or titanium

BRIGHTENER MAINTENANCE ADDITION

The **P-Brite 180-M** and **P-Brite 180-B** additives **should always be diluted** with equal amounts of water before being added to the bath.

The **P-Brite 180-M** make up additive is consumed mainly by drag-out. The amount of drag-out can be measured by the consumption of Sulfuric Acid. When acid additions are made, one quart of **P-Brite 180-M** should be added per one gallon of Sulfuric Acid. The **P-Brite 180-B** brightener is consumed on an ampere hour basis. Additions should be made at 1 gallon **P-Brite 180-B** per 10,000 - 12,000 ampere hours.

A two (2) amp, 4 min., 80°F, Hull Cell panel can also be used to determine the additions of **P-Brite 180-B**.

BATH CONTROL

Stannous Sulfate:

1. Pipette 5 ml tin plating solution into 500 ml Erlenmeyer flask.
2. Add:
 - a) 100 ml Deionized water
 - b) 50 ml Conc. HCl.
 - c) about 1/2 gram Sodium Bicarbonate slowly, to dispel air.
 - d) 1 cc Starch Indicator Solution
3. Titrate with 0.1N Potassium Iodate to a blue color which persists for 30 seconds.

oz/gal Stannous Sulfate = ml 0.1N Iodate titrated x 0.287 oz/gal

Tin metal = ml 0.1N Iodate titrated x 0.158

SULFURIC ACID

1. Pipette 5 ml tin plating solution into 250 ml Erlenmeyer flask.
2. Add
 - a) 50 ml (4%) Ammonium Oxalate Solution
 - b) 5 ml Methyl Red Indicator
3. Titrate with 1.0N NaOH to color change from red to yellow.

% by vol. H₂SO₄ = ml 1.0N NaOH titrated x 0.53

The tin metal and Sulfuric Acid concentrations should be analyzed on a regular basis and maintained within their recommended limits.

SAFE HANDLING

Use acid resistant apron, gloves and eye shields when making Sulfuric Acid additions. When making up a new bath of **P-Brite 180**, fill the tank approximately half full with cold water and then slowly and cautiously add the required amount of Sulfuric Acid. Stir continuously during addition. Do not allow solution temperature to exceed 150°F during mixing.

Stannous Sulfate should be slurried in a pail of cold water prior to adding to the bath with continuous stirring.

Following mixing, bring the bath close to final volume with water leaving room for the diluted **180M** and **180B**.

Working baths of **P-Brite 180** must be well ventilated for acid fumes.

The **P-Brite 180-M** make up and **P-Brite 180-B** brightener are non-hazardous. However, good industrial hygienic procedures should be followed.

IMPORTANT NOTICE! For Industrial Use Only

The following is made in lieu of all warranties, expressed or implied, including the implied warranties of merchantability and fitness for purpose: seller's and manufacturer's only obligation shall be to replace such quantity of the product as proved to be defective. Before using, user shall determine the suitability of the product for its intended use, and user assumes all risk and liability whatsoever in connection therewith. **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.**