

PLATING PRODUCTS INC.

Shop no 16, Neelkamal housing, society, chincholi, phatak, malad(w), mum:64 tel:991-22-2885315 fax: 91-22-28838753
e-mail: platingproducts@gmail.com web: www.platingproducts.in

TECHNICAL DATA

ANTHRACITE MUD

Anthracite plating is widely used in hardware sectors, jewelry industries to give a much appreciated premium black finish. Anthracite finish is highly corrosion resistant

ANTHRACITE-MUD electrolyte will give the deposit in dark shade while ANTHRACITE – MUL will give a lighter shade

Bath Setup

Tank Material	Glass reinforced PVC or rubber-lined M.S. Tank
Heating	Electric bath heater and steam coil made of TEFLON or through indirectly heated bath.
Fitting	All fittings in the direct contact with the electrolyte such as thermometers made of glass or porcelain must have coatings of PVC, rubber or TEFLON.
Anodes	Pure nickel anodes (not S nickel) Total anode surface must be at least equivalent to surface area. The anodes must be hung into pure nickel hooks. Titanium baskets must not be used.

Filter Pumps	Only plastic filter pumps may be used so that no metal parts come in contact with the electrolyte.
Bath Agitation	Bath agitation is necessary and should be achieved if possible through an extensive filter unit or through a corresponding agitator. If this possibilities are not given movement can be made horizontally or vertically

OPERATING CONDITION

Current density	0.1 – 4dm ² at 0.3-1.5 volts
Temperature	58 – 75 Celsius
Extraction	Necessary
Placing of parts	Without current to ensure wetting. Use drag out to conserve electrolyte. Adjust pH – Value of drag out rinse to 3-4 with hydrochloric acid to prevent metal precipitation
Acid Dip	Prior to plating in Gun metal parts must be dipped into hydrochloric acid
Filtration	If electrolyte is continuously operated continuous filtration will be necessary
Density	Approx 17 Be at 20 Celsius
pH value	5 - 5.4 (the pH-value must never be below 4 and above 7)

MAINTENANCE

pH value to low	Below 4.7 restore to 5 by adding Anthracite part 1
-----------------	--

pH value to high Above 5.4, lower by adding chemically pure hydrochloric acid 1:4 diluted with distilled water
NOTE : Lowering the ph value with concentrated hydrochloric acid will corrode the bath

Control of anthracite As per analysis
Part 1 content

Control of nickel content As per analysis



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.

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.