

USER INSTRUCTIONS

PALLADOR 102

PALLADIUM FOR PLATING SOLUTION

Colour : **White palladium**

Use : **Bath**

Colour coordinates : **L:85.5**

a:0.8

b:4.2

Product description

PALLADOR 102 is a ready-to-use palladium plating bath purposely designed for flash plating. PALLADOR 102 is characterised by the considerable compactness and resistance of the galvanic layer which makes it particularly suitable as a barrier against the diffusion of gold deposits on copper and its alloys. These characteristics of compactness and resistance also make PALLADOR 102 particularly suitable for use as an intermediate layer between white gold and rhodium, considerably reducing the possibility of scratches and abrasion of the rhodium-plated layer affecting the alloy below.

Operating conditions

Parameter	Average suggested value
Deposition time	90 seconds
Temperature	28 °C
Voltage	2.2 V
Current density	0.5 A/dm ²
Cathodic efficiency	20 mg/Amin
Deposition speed	0.1 um/min
Anodes	Ti/Pt net
Agitation	Moderate
Ventilation	Necessary

Maintenance of plating bath

For small plating solution volumes (up to 10 litres) we suggest to use the bath without replenisher . For higher volumes we suggest to use the related replenisher composing the bath:

- **PALLADOR 100RP or PALLADOR 120RP:** add 20 ml of **PALLADOR 100RPA or PALLADOR 120RPA** and 20 ml of **PALLADOR 100RPB or PALLADOR 120RPB** every 100 Amin.
- **PALLADOR 100RA :** add after analysis.
- **PALLADOR 100RB :** add after analysis.
- **PALLADOR 100WA :** add after analysis.
- **PALLADOR 100S :** add after analysis.

Safety Information

Please refer to the safety data sheets for any information regarding safety and disposal (MSDS).

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Products related

Cod.Articles	Description	Colour	Packaging
PD012901	PALLADOR 102 Palladium plating solution ready to use	White	2 g/L
PD013001	PALLADOR 100RP palladium replenisher 100 g/L		1 L + 1 L
PD013101	PALLADOR 120RP palladium replenisher 20 g/200ml		2X200 ml
PD013201	PALLADOR 100RA brightener for palladium plating		1 L
PD013301	PALLADOR 100RB brightener for palladium plating		1 L
PD013401	PALLADOR 100WA brightener for palladium plating		1 L
PD013501	PALLADOR 100S Conducting salts for palladium plating		1 Kg