

USER INSTRUCTIONS

PALLADOR 405

PALLADIUM FOR PLATING SOLUTION

Colour : **White palladium**

Use : **Bath**

Colour coordinates : **L:85.0**

a:1.0

b:4.2

Product description

PALLADOR 405 is a palladium-Indium plating bath purposely designed for flash or thickness plating. PALLADOR 405 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 405 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	240 seconds
Temperature	40 °C
Voltage	2.2 V
Current density	1 A/dm ²
Cathodic efficiency	30 mg/Amin
Deposition speed	0.27 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 400RP** or **PALLADOR 420RP**: add 7 g of **PALLADOR 400RPA** or **PALLADOR 420RPA** and 35 ml of **PALLADOR 400RPB** or **PALLADOR 420RPB** every 100 Amin.
- **PALLADOR 400RA** : add after analysis.
- **PALLADOR 400RB** : add after analysis.
- **PALLADOR 400RC** : add after analysis.
- **PALLADOR 400RI** : add after analysis.
- **PALLADOR 400WA** : add after analysis.
- **PALLADOR 400S** : 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
PD014501	PALLADOR 405 Palladium-indium ready to use solution	White	5 g/l
PD014601	PALLADOR 400RP Palladium replenisher 100 g		100 g + 1 L
PD014701	PALLADOR 420RP Palladium replenisher 20 g		20 g + 200 ml
PD014801	PALLADOR 400RI Indium brightener additive		1 L
PD014901	PALLADOR 400RB Brightener additive		1 L
PD015001	PALLADOR 400WA Wetting agent		1 L
PD015101	PALLADOR 400RC Additive		1 L
PD015201	PALLADOR 400RA Additive		1 L
PD015301	PALLADOR 400BS Make up solution		1 L
PD015401	PALLADOR 400S Conducting salts		1 kg