

USER INSTRUCTIONS

RUTENOR 305

RUTHENIUM FOR PLATING BATH

Colour : **Dark grey**

Use : **Bath**

Colour coordinates : **L:60.0**

a:0.4

b:0.8

Product description

RUTENOR 305 is a ruthenium plating bath with incomparable technical and qualitative characteristics. The properties of the deposit make this plating bath a point of reference for all goldsmiths looking for a premium finishing gunmetal for their items.

Operating conditions

Parameter	Average suggested value
Deposition time	300 seconds
Temperature	60 °C
Voltage	2.0 V
Current density	2.0 A/dm ²
Cathodic efficiency	2 mg/Amin
Deposition speed	0.02 u/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:

- **RUTENOR 350R** : add 8 ml every 100 Amin.
- **RUTENOR 300RA** : add 16 ml every 100 Amin.
- **RUTENOR 300SP** : add after analysis.
- **RUTENOR 300S** : add after analysis.

Safety Information

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

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Preparation of the galvanic bath

In order to prepare 1 L of ready to use solution is necessary following the right steps :

1. Arrange the working tank switching on the ventilation and all the safety devices.
2. Add 1 bottle of RUTENOR 305C containing 5g/200ml
3. Add 800 ml of demineralised water and mix
4. Set the right working temperature

Wait till the working temperature and start with plating operation

Preparation of the galvanic bath (with concentrated/make-up products)

In case of make up starting from single components, follow the next steps to prepare 100 liters of ready to use solution at 5 g/l of Ruthenium metal.

1. Add in the working tank the amount of RUTENOR 300BS
2. Add 100ml/l of RUTENOR 350R (Tot. 10 liters = 500 g)
3. Fill up the working tank with distilled water, switch on the filter pumps and heaters to 60-65°C
4. After reaching the working temperature, add 200 ml/l of RUTENOR 300RA (tot.20 liters)
5. wait one hour before starting the plating operations

Products related

Cod.Articles	Description	Colour	Packaging
RU011701	RUTENOR 305C Concentrated ruthenium for bath	Gunmetal	200 ml
RU010501	RUTENOR 350R Ruthenium replenisher 50 g/L		1 L
RU012301	RUTENOR 300S conducting salts		1 kg
RU012201	RUTENOR 300RA Blackening additive		1 L
RU010405	RUTENOR 300SP Brightener additive		1 L