

UNISTAR BRASS SALT

UNISTAR BRASS SALT is an alkaline cyanide based brass salt which gives rich yellow golden deposit. The process can be used in both barrel and vat. The deposit obtained is rich golden yellow colour depending upon the current density and temperature of the bath. Various shades from pale yellow to reddish gold may be obtained by varying the temperature and current density.

BATH COMPOSITION

UNISTAR BRASS SALT : 75 - 100 g/ltr

AMMONIUM CHLORIDE: 3 g/ltr

OPERATING CONDITIONS

Cathode current density : 5 - 8 A/sq.ft

Voltage : 2.5 - 3.0 volts

PH : 9.8 - 10.8V

Temperature : 40° - 50°C

BATH PREPARATION

Fill the tank with 2/3rd full of water and add the required quantity of UNISTAR BRASS SALT slowly with stirring to dissolve the salt completely. Make up the level with water and add the required quantity of ammonium chloride and stir to dissolve completely. Heat the solution to working temp. Solution is now ready for use.

EQUIPMENT

PVC lined Ms tanks or unlined steel tanks may be used. It is advisable to use lined tanks.

HEATING

Stainless steel immersion heaters can be used.

MAINTENANCE:

The solution can be analysed regularly to determine the copper and zinc content and addition of gold brass salt should be made regularly. The solution is to be maintained in the following range

Copper :	8.5 –9.5
Zinc :	7.5 –8.5 g/ltr
Free sodium cyanide :	14.0g/ltr

The ammonia gets consumed during plating and a replenishment addition of 2.3 g/ltr per day is recommended.

ANODES

For decorative brass plating anodes having a composition of 60% copper and 40% zinc are used for richer brass colour brass anodes having 70% copper and 30% zinc may be used. The anodes should be of high purity and free from lead.

NOTE

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