

UNISTAR ZINC SALT

UNISTAR ZINC SALT is a high performance addition agent for cyanide zinc plating bath. The system produces brilliant bright deposits for both barrel and rack plating operations.

The system gives zinc deposits with chrome like brilliance and excellent low current density coverage. The deposits produced are bright and ductile and accepts all chromate layers.

UNISTAR ZINC SALT has good tolerance to temperature and high carbonate concentrations. The system can be used with different ratios of zinc to cyanide concentrations.

BATH COMPOSITION OPERATING CONDITIONS

UNISTAR ZINC SALT	200g/ltr
UNISTAR ZINC BRIGHTENER	2 – 4 m/ltr
UNISTAR ZINC PURIFIER	4 ml/ltr

	VAT	BARREL
Cathode current density	2.0 - 4.0A/dm ²	0.5 - 1.0A/dm ²
Bath voltage	2.0 - 5.0volts	10 - 15volts
Temperature	20° - 30°C	20° - 40°C
Fume extraction	Recommended	Recommended

SOLUTION PREPARATION

A fresh rubber lined tank is to be leached by filling it with 2% caustic solution for a minimum of 12 hours.

Fill the tank to half its volume with clear water. Add calculated amount of UNISTAR ZINC SALT and stir the solution until the salts are dissolved completely. Allow it to cool.

Add 4ml/ltr. UNISTAR ZINC PURIFIER, stir and allow it to settle overnight.

The next day filter the solution and make up the level with water. Add UNISTAR ZINC SALT Now the solution is ready for plating.

MAINTENANCE:

The required concentration of the bath constituents can be maintained by periodic analysis.

UNISTAR ZINC SALT BRIGHTENER is the only additive required for the make up as well as maintenance.

Addition of 150ml - 250ml. for 1000 Amp. hours is recommended. However exact amount required depends on solution composition, temperature, operating current density, degree of brilliance required, impurity level in the bath and the type of plating i.e. Vat or Barrel. Higher additions are required for barrel plating than vat plating.

UNISTAR ZINC PURIFIER is added regularly to remove any metallic impurities. Addition of purifier can be controlled by lead acetate paper. The colour of paper should be brown. White shows lack of purifier, and black shows excess of purifier. Approximately 40ml. of UNISTAR ZINC PURIFIER is recommended for 100ltr. of the bath.

NOTE

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