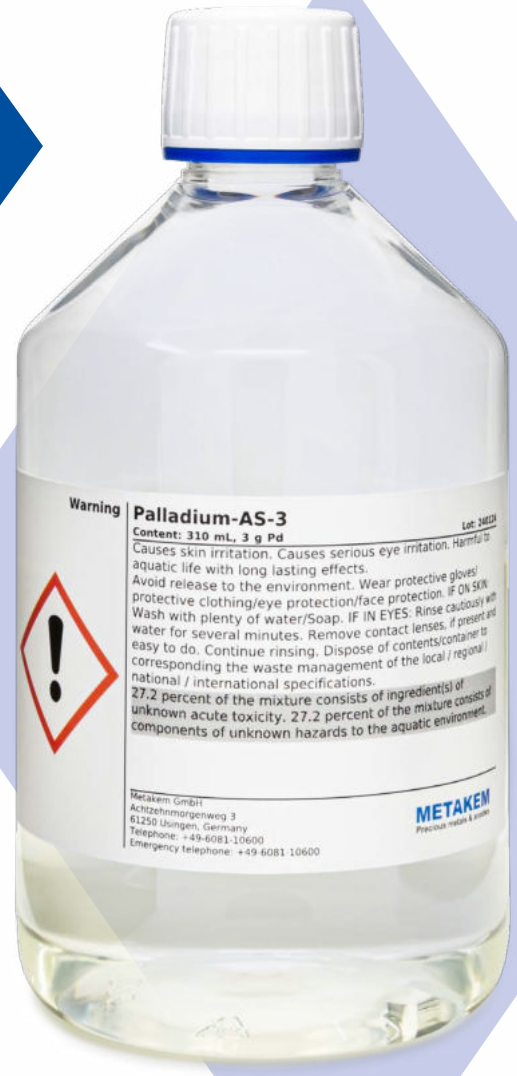
46 106,42
Pd
Palladium

METAKEM
Precious metals & anodes

Palladium-AS-3

High-quality palladium electrolyte for brilliant white coatings

MADE IN GERMANY



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46 106,42
Pd
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Precious metal baths

Palladium-AS-3

Working conditions

Pd content:	3 g / L
pH value:	7.6 – 8.0
Temperature:	30 – 60°C (optimum: 45°C)
Current density:	0.3 – 1.5 A / dm² (optimum: 1 A / dm²)
Power yield:	~ 25 mg / Amin

Tips for eliminating errors

	too low	too high
pH value:	burns	no problems
pH value:	dull, blotchy deposition	low impact
Temperature:	dull deposition	reduction of Pd
Current density:	no influence	burnt layers
Stirring:	defects in the lustre of the Pd-layer	no problems

Bath approach:

Instructions for 1 L bath:
Bath preparation is supplied as a concentrate. Dilute 310 ml of the concentrate with 690 ml of distilled water to obtain a ready-to-use bath with a palladium concentration of 3 g / L. Then adjust the pH to 7.6 – 8 with ammonia.

Request product:
→ metakem.de/en/request

Palladium-AS-3 is a slightly alkaline palladium bath for brilliant white coatings up to 1.5 µm thickness.
The palladium layer is tension-free and adhesive.

Required Equipment

- Polypropylene container
- Filter pump
- Bath agitation
- PTFE or glass heating elements
- Platinised titanium anode*
- Exhaustion

Procedure

Clean grease, oil and polishing pastes from the product before coating with **Palladium-AS-3**.

Flash-gold plating or pre-coating with palladium in a separate bath is suitable as a pre-treatment.
This ensures very good adhesion and ductility of the deposited palladium. Bath movement is recommended at a bath temperature of 30 – 40°C.

Regeneration

The palladium content of the bath is supplemented by adding **Palladium-AS-3-R1**. When adding 1 g of palladium, additions of 5 ml of **Palladium-AS-3-R2** and 5 ml of **Palladium-AS-3-R3** are also required.

Post Treatment

Thorough rinsing of the product in running water after coating is necessary to maintain the high gloss of the surface. Rhodium and platinum can be deposited on the high-gloss palladium layer.

Safety and Disposal

The **Palladium-AS-3** bath contains ammonium salts and is slightly alkaline. Ammonia escapes during operation. Exhaustion above the bath is required.

Please contact us regarding the disposal of the electrolyte and its rinsing baths. Metal-free solutions must be disposed of in accordance with local waste water regulations.

* Ask about our customised METAKEM anodes.

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