

# Gold Plating

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Common Name	Also Known as	Typical Bath Constituents	Power Supply Recommendations	Typical Pulse Settings (if Used)	Typical Operating Parameters
<b>Acid Cyanide Gold</b>	Class E-3	Gold as $\text{KAu}(\text{CN})_2$ (8 g/L)	<1% ripple	High Frequency (HFP); Do Not Use Low Frequency Pulse (LFP)	Anodes: Platinum-Clad Columbium
		Citric Acid (60 g/L)	Amp-hr meter (gold metal additions based on A-hr meter readings)	Duty Cycle: 50%	Replenishment: 1 oz Gold/12 A-hr
		Cobalt or Nickel Metal (0.2 - 0.75 g/L)	Pulse Recommended	1 ms ON Time	Filter Continuously
			Totalizer (tracks gold usage to prevent misuse or theft)	1 ms OFF Time	Carbon Treat (Sensitive to Organics)
					Agitation: Moderate to Vigorous
					Operating Temp (Rack): 70 to 90 F
					Operating Temp (Barrel): 120 to 140 F
					Typical pH (range): 3.8 to 4.3
					Output Voltage (Power Supply Max Rating): 6 VDC
					Current Density [Rack]: 5-20 ASF (0.5-2.0 ASD)
			Current Density [Barrel]: 1-5 ASF (0.1-0.5 ASD)		