

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
Alkaline Cyanide Gold (Matte Finish)	Class D-1	Gold as $\text{KAu}(\text{CN})_2$ (8-20 g/L)	<1% ripple	High Frequency (HFP); Do Not Use Low Frequency Pulse (LFP)	Anodes: 316 SS
		Dipotassium Phosphate (22-45 g/L)	Amp-hr meter (gold metal additions based on A-hr meter readings)	Duty Cycle: 50%	Replenishment: 1 oz Gold/4.5 A-hr
		Potassium Cyanide (15-30 g/L)	Straight DC (Pulse Optional - Question Whether Pulse is Effective in Barrel Plating)	1 ms ON Time	Filter Periodically
			Totalizer (tracks gold usage to prevent misuse or theft)	1 ms OFF Time	Carbon Treat (Sensitive to Organics)
					Agitation: Moderate to Vigorous
					Operating temp: 120 to 160 F
					Typical pH: 12
					Output Voltage (Power Supply Max Rating): 6 VDC
					Current Density [Rack]: 3-5 ASF (0.3-0.5 ASD)
					Current Density [Barrel]: 1-2 ASF (0.1-0.2 ASD)