

Gold Plating

Dynatronix makes no warranty as to the accuracy of the information contained herein. Information has been compiled from numerous sources and may be subject to inaccuracies. Dynatronix reserves the right to make changes and/or corrections to the data herein. Information presented consists of generally-accepted operating parameters used in the metal finishing industry. This information is provided for convenience only, and is not to be construed as specific recommendations by Dynatronix, Inc. Power supply recommendations are for initial settings when first setting up the process. Actual operational settings may vary depending on the substrate, chemistry, operating parameters, and actual testing by the end-user.

Common Name	Also Known as	Typical Bath Constituents	Power Supply Recommendations	Typical Pulse Settings (if Used)	Typical Operating Parameters
Barrel Gold	Classes A, B	Gold as $\text{KAu}(\text{CN})_2$ (6 g/L)	<1% ripple	High Frequency (HFP); Do Not Use Low Frequency Pulse (LFP)	Anodes: 316 SS
		Free Cyanide as NaCN (30 g/L)	Amp-hr meter (gold metal additions based on A-hr meter readings)	Duty Cycle: 50%	Filter Periodically
		Disodium Phosphate (23 g/L)	Straight DC (Pulse Optional, but not Rare - Question Whether Pulse is Effective)	1 ms ON Time	Agitation: Not Required
			Totalizer (tracks gold usage to prevent misuse or theft)	1 ms OFF Time	Operating temp: 100 to 120 F
					Typical pH (range): 10 to 11
					Output Voltage (Power Supply Max Rating): 6 VDC
					Current Density: 1-2 ASF (0.1-0.2 ASD)