

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
Decorative 24K Gold	Classes A, B, C, Sometimes Class G	Gold Cyanide (1.25 - 2 g/L)	<1% ripple	High Frequency (HFP); Do Not Use Low Frequency Pulse (LFP)	Anodes: 316 SS
		Free Potassium Cyanide (7.5 g/L)	Amp-hr meter (gold metal additions based on A-hr meter readings)	Duty Cycle: 50%	Filter Periodically
		Dipotassium Phosphate (15 g/L)	Straight DC (Pulse Optional, but not Typical)	1 ms ON Time	Agitation: Not Required
			Totalizer (tracks gold usage to prevent misuse or theft)	1 ms OFF Time	Operating temp: 140 - 160 F
					Typical pH: 10 - 11
					Output Voltage (Power Supply Max Rating): 6 VDC
					Current Density: 10-40 ASF (1.0-4.0 ASD)