



TECHNICAL DATA SHEET

GOLDSTAR 2000

Acid Gold Plating Process

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Process Information

The process of acidic-gold plating “Gold Star 2000” allows to obtain homogeneous layers of decorative gold, both as regarding the colour and thickness , with a high level of hardness and resistance towards abrasion, operating in short time-periods. The basic bath, working at a low metal content, does not contains cyanides and hence allows the elimination of problems connected with purification. The deposit has a gold metal content not below 90%; hence big advantages are derived as concerning resistance to corrosion.

Working Parameters

Density	13-14 Bé
Temperature	45-50°C
pH value	3,8-4,8
Electrolyte agitation	necessary
Current density	0,5-1 A/dm ² (movement) 1-3 A/dm ² (compressed air)

The tanks should be coated in PVC. The heating material can be stainless steel, porcelain or Teflon. The preparation of the bath is done by adding the already heated ready-to-use solution, the brightener required, and mixing the electrolyte well. Dissolve the double salt gold potassium cyanide in hot water and then add it to do bath stirring it homogeneously.

Working Cycle

The gold bath “GoldStar 2000” is specifically used for decorative type deposits. It can be also utilized for other objectives like deposits. It can be also utilized for other objectives like electric goldplating having however a higher gold content.

Optimal Cycle

Nickel plating
Recovery
Rinse
Activation
Rinse
Gold Bath
Recovery
Rinse
Hot Rinse

In certain cases even a pre-gold bath can be foreseen.

Make up

BATH COMPOSITION

GOLDSTAR 2000 Make-up solution	% 100
GoldStar 2000 brightener	1-1,5 cc/l (for air agitated baths) 1,5-2 cc/l (for rack movement baths)
Double salt Gold Potassium Cyanide	0,3-0,5 g/l



Maintenance

Daily check of the density. Do not go below values 9 Bé; wanting to increase the density, add ready-to-use solution.

Polish consumption

The is added with a ratio of 500 cc. of every 100 g of gold metal added (corresponding to 150 g of double salt of gold potassium, given that the latter contains 68% of gold metal.)

Note:

This instructions have been written for general conditions of use. If however following the instructions there are anomalies, then we would ask you to contact our technical service.

Health and Safety

Material Safety Data Sheets are available for all GALVANO MONDO products, they are normally issued with relevant quotations and Technical Data Sheets. They explain hazards associated with the product following classification by European Statutory Requirements. Normally more than one product will be used in a process. Risk evaluation of the process is the users responsibility because the user controls men, materials, methods and machines. The user must consider all of the substances present in the solution, whether they present a risk to people and the environment, whether abatement measures are needed.