



Gold Plating Services

Technical Data Sheet

Bright Nickel Plating Solution

Bath Application

Gold Plating Services' ***Bright Nickel Plating Solution*** is a nickel sulfate electroplating solution that will plate a bright level deposit with good physical properties and is very receptive to subsequent plating such as chrome, gold, rhodium, or other decorative plates. This nickel plate is ideal for decorative applications where the malleability of the nickel is not an issue.

Content- Nickel sulfate 10 oz/qt.

Operating Conditions

Temperature -	135° to 155° F - Optimum 140°F
Anode to Cathode Ratio -	2:1 or higher
pH -	3.5 - 4.5 – Optimum 4
Filtration -	Continuous for larger baths, after use for smaller baths if needed
Current Density Cathode -	20 - 50 A/sq. ft.
Voltage -	Dependent on the size of the tank: 5-7 volts for a smaller tank, 6-12 for a larger tank
Anode -	Nickel - The solution nickel will be replenished by anode corrosion. The anode must be bagged to avoid deposit roughness. Check often for disintegration.
Agitation -	Agitation through cathode or solution movement.
Shelf Life -	If stored at room temperature, properly sealed solutions have a shelf life of about two years.

Note: Brighteners in the solution work best at high temperatures and a higher voltage/current. If deposit is appearing matte or hazy, this can be a sign that the anode ratio needs to be adjusted or the voltage/current is too low. No need to polish a matte deposit; make adjustments and replate.