



Gold Plating Services Technical Data Sheet

Bright Palladium Solution

Bath & Brush Application

Gold Plating Services' Bright Palladium Solution is a pure palladium plating solution for decorative use, commonly known as white gold. It produces a premium, white, mirror-bright finish that plates quickly and can substitute for rhodium. The deposited finish is tarnish resistant, very durable, and nickel free. This solution produces a deposit that can serve as a diffusion barrier under gold plating in most cases.

Mohs Hardness -	4.75
Content -	2.5 grams palladium/liter

Operating Conditions

Temperature -	120° F (Too high of temperature can cause burning.)
Time -	15 - 30 seconds for a normal decorative plate; plating generally does not exceed 2 minutes for a heavy plate due to metallic hardness
pH -	5.5 - 6 (optimum 5.8)
Bath Voltage -	1.5 - 2 Volts (optimum 2 Volts)
Brush Voltage -	3.5 Volts
Bath Anode -	Bagged Graphite or Platinized Titanium (\$\$)
Brush Anode -	Platinized Titanium bit with cotton sleeve
Filtration -	Optional
Agitation -	Relative movement between work and solution is recommended.

The surface to be plated must be clean and free of any corrosion or oxidation and should "wet out" prior to activation. Activation of the surface should be appropriate for the base material. The activated surface should not be touched and should be rinsed and electroplated prior to drying to prevent re-oxidation.

Read and understand SDS sheets before using. For professional use by trained technicians only.