

## **TECHNICAL DATA SHEET**

### **DIRECT BRASS SALT**

Direct Brass Salt is a composite salt for brass plating of artificial jewellery, frames and mass produced products. This process is generally used for decorative purpose on top of nickel both for barrel and vat plating. The brass deposits obtained is normally a rich golden yellow colour but any shade from a pale yellow to reddish gold may be obtained from the same bath by varying the temperature and current density.

#### **BATH COMPOSITION :**

<b>Constituents</b>	<b>Concentration</b>
Direct Brass Salt	100-150 gm/l
Ammonium Chloride	2-3 gm/l

#### **OPERATING CONDITIONS:**

Cathode current density	3-6 amp/sq.ft
Voltage	3-5 volts
pH	10-10.8
Temperature	30-50°C

#### **SOLUTION PREPARATION :**

- Add 2/3<sup>rd</sup> level of tank with DM water.
- Add required quantity of Direct Brass Salt with stirring.
- Add Ammonium chloride with stirring.
- Make up the level with DM water.
- Bath is ready to start.

#### **EQUIPMENT :**

PP, stainless steel tanks are recommended.

## **MAINTENANCE:**

Addition of Direct Brass Salt is recommended for regular maintenance of copper and zinc metal. Lack of free cyanide will lead to pinkish deposits and should be analysed to maintain optimum concentration. Ammonium chloride is consumed during electrolysis hence it is recommended to add 50-100 gm/100 ltr of bath as its deficiency will lead to pinkish deposits.

## **ANODES :**

Cast or laminated brass anodes containing 70-80% copper is preferred. Annealed brass plates may also be used.

## **CYCLE:**

- Alkaline soak cleaning / electrolytic cleaning.
- Water rinse.
- Water rinse.
- Acid dip. Sulphuric 10%.
- Water rinse.
- Water rinse.
- Brass plate.
- Water rinse.
- water rinse.
- Dip Lacquer.
- Dry.

## **DISCLAIMER:**

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