

## TECHNICAL DATA SHEET

### CHROME 101

CHROME 101 Bath is easy to operate designed for decorative and hard chromium plating. CHROME 101 bath is easy to operate and maintain and has no etching properties.

#### BATH MAKE –UP :

	<b>Decorative</b>	<b>Hard</b>
CHROME 101 Salt	230-250 g/l	300-350 g/l
CHROME 101 Conducting Salt	5-15 g/l	5-10 g/l

#### OPERATING CONDITIONS :

	<b>Optimum</b>	<b>Range</b>
Cathode current density	15-30 A/dm <sup>2</sup>	15-25 A/dm <sup>2</sup>
Anode current density	5-25 A/dm <sup>2</sup>	5-10 A/dm <sup>2</sup>
Temperature	55-60°C	40-50°C
Density	18-20° Be.	22-26° Be
Anodes	(Lead Antimony/Lead Tin )	(Lead Antimony/Lead Tin )

#### BATH PREPARATION :

- Fill the plating tank approximately 2/3<sup>rd</sup> of volume with hot DM water.
- Add the required quantity of salt gradually with stirring and make up to the operating volume with water.
- Dummy the electrolyte for 3-4 hours at 5 volts.
- Bath is ready for plating.

#### EQUIPMENTS :

M.S. tank lined with lead – antimony for flexible PVC can be used. Tanks should be fitted with fume extraction units. Silica, Teflon or Titanium heaters are recommended. Proper cooling arrangement should be made for controlling rise in temperature because of high voltage.

**POWER SUPPLY:**

Three phase rectifiers with residual ripple below 5% is recommended.

**MAINTANANCE :**

Periodic analysis of bath is recommended for maintaining chromic acid and sulphate ratio. For increasing density CHROME 101Salt should be added. For reducing sulphate barium carbonate or barium hydroxide should be added.

**CAUTION:**

Operator should be provided with protective clothing, rubber gloves and chemical goggles and care should be taken to avoid breathing dust from the product. In the event of contact with eyes or skin flush with ample quantity with water.

**DISCLAIMER :**

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