

TECHNICAL DATA SHEET

DULL TIN SALT

Tin plating is widely used for products which come in contact with foodstuff and non – ferrous electrical items. It provides protection against atmospheric corrosion and improve soldering properties. Due to extremely high throwing power it can be used both for vat and barrel applications.

OPERATING INSTRUCTIONS:

| | For vat plating | For barrel plating |
|-------------------------|--------------------------|---------------------------|
| Dull Tin Salt | 100 gms./ltr | 200 gms./ltr |
| Temperature | 60-80°C | 60-80°C |
| Voltage | 3 – 5 volts | 10 - 12 volts |
| Cathode current density | 15-20 amp/sq.ft. | 15-20 amp/sq.ft. |
| Anodes | Pure rolled or cast- Tin | Pure rolled or cast- Tin |

EQUIPMENT:

A plain stainless steel welded tank is recommended. Heaters made of steel or quartz can be used for heating purposes.

MAKE-UP:

Fill the tank 2/3rd of full water and heat the water to 50°C. Add the required amount of Tin Salt slowly with stirring. After complete dissolution, make up the operating level by adding DM water.

MAINTENANCE:

The solution should be analysed periodically for free caustic soda content and tin content.

| | Vat | barrel |
|-------------------|------------|---------------|
| Tin | 26-28 g/l | 50-52 g/l |
| Free caustic soda | 6-12 g/l | 12-24 g/l |

While working with the bath, the anodes should be covered with a greenish-yellow film. The same can be achieved by dunning the bath at about 40amp/sq.ft before plating the jobs. The unfiled anodes should not remain in the bath when not in use. In case of high anode density a black film is obtained in anodes. Such films should be removed by pickling or sourcing and a greenish – yellow film is to be formed on the anode. If Dark or spongy deposits are obtained which is due to presents of stannite in the bath, oxidize the solution by adding 2 ml/ltr of hydrogen peroxide(20 vol).

WASTE TREATMENT:

Neutralize the spent solutions as to pH 7.5 – 8.0 before discharging into sewer.

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