



## INSTRUCTIONS FOR USING SUPERBRITE® RHODIUM PLATING SOLUTIONS

The cleaning and preparation process is one of the most important steps in achieving the results you are looking for when electroplating. The jewelry surface must be prepared and cleaned properly in order to get your desired results. All jewelry must be free of oils, dirt, polishing compounds, electrocleaner, ultrasonic cleaner, fingerprints, soaps and acids.

***Before using the Rhodium plating solutions, it is important to read the Safety Data Sheet and plating instructions for proper use, mixing instructions and handling. These can be found on our website at [www.cohler.com](http://www.cohler.com).***

1. Prepare all pieces to be plated to a brilliant high polish free of scratches.
2. Place all pieces to be plated into the hot ultrasonic cleaner for 5- 10 minutes.
3. Rinse well in distilled water.
4. Steam
5. Use Electroking™ to electroclean your pieces at 2-6 volts, 140 degrees F for 15-30 seconds using a stainless anode.
6. Rinse well in distilled water so that none of the chemicals can carry over into your rhodium bath.
7. **Rhodium Bath plating** – Platinized titanium anode, 4 volts, room temperature for 20-30 seconds. ***Never heat the bath rhodium***
8. **Rhodium Pen plating**- Plate at 6 volts. A larger item may require you to plate at a higher voltage so start lower and work your way up.
9. Rinse well to remove all chemicals, steam or wipe with a soft cloth to avoid water spots.

***It is important to change the distilled water rinses often so that you don't have a carryover of chemicals to your rhodium bath as this can contaminate your bath quickly***

## SUPERBRITE™ RHODIUM BATH SOLUTION CONCENTRATE MIXING INSTRUCTIONS

***Under ventilation, mix the rhodium and water slowly so that you do not have a volatile reaction or overflow the beaker by mixing too quickly or using too much water.***

**½ gram bath concentrate**- In a beaker, add enough distilled water to bring the level up to 250 ml's with the rhodium and water together. Mix well

**1 gram bath concentrate**-In a beaker, add enough distilled water to bring the level up to 500 ml's with the rhodium and water together. Mix well

**2 gram bath concentrate**- In a beaker, add enough distilled water to bring the level up to 1000 ml's with the rhodium and water together. Mix well

## **SUPERBRITE™ RHODIUM BATH SOLUTIONS**

½ pints, pints and quarts are ready to use as is. Everything needed is already contained in the bath for you. If the level of the bath gets low due to evaporation or drag out, you should add distilled water to bring the bath back up to the original level. The solutions are meant to be used as a complete bath.

**Using part of the bottle and then adding the new rhodium onto the spent solutions will create an imbalance in your bath and cause dark plating.** If you only want to use half of the bottle, use that entire portion till it is spent, discard that portion and use the remaining new rhodium that was in your bottle as your new bath. ***Never mix the old spent solutions and new rhodium together.***

## **SUPERBRITE™ RHODIUM REPLENISHER SOLUTION CONCENTRATE MIXING INSTRUCTIONS**

In order to get the same bright white results as you did with the original **SUPERBRITE™** rhodium bath, you must use **SUPERBRITE™** replenisher concentrate. ***If there is any doubt that your bath has been contaminated, do not replenish with new rhodium. Start over with a new plating bath.*** Charcoal cleaning your bath will not solve a metal contamination issue.

Add 1 gram of rhodium replenisher to a pint bath, mix well.

Add 2 grams of rhodium replenisher to a quart bath, mix well.

## **SPECIALTY RHODIUM BATHS THAT CONTAIN MORE THAN 1 GRAM PER PINT OR 2 GRAMS PER QUART**

These are highly concentrated baths that are used from start to finish and then are discarded when all the rhodium is spent. ***Do not replenish these baths***