



**KROHN INDUSTRIES**  
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## **Nickel-Mirror<sup>TM</sup>** **Bright Mirror Nickel Plate** **(Mirror)**

### **Product Description**

**Nickel-Mirror<sup>TM</sup>** is a bright nickel plating bath which can be used as a nickel flash over sterling silver or as a heavy nickel plate over many different substrates. It is ideal for all types of metals. The control over the bath is very easy due to a superb combination of brighteners which provide excellent coverage and leveling ability.

**Nickel-Mirror<sup>TM</sup>** offers an easily maintainable alternative to other nickel plating baths.

**Nickel-Mirror<sup>TM</sup>** is supplied as ready to use, for ease of set-up along with replenishers for controllable, trouble free maintenance and operation.

### **Applications:**

Over Gold, Copper, Brass, and Silver metals. Use over Copper Primer<sup>TM</sup> and/or Copper Mirror<sup>TM</sup>

### **Cautions: Read all safety information before using this product**

1. Use only with proper ventilation.
2. Wear gloves, safety goggles, and apron.
3. Avoid contact with eyes and skin.
4. Do not heat over 180° F.
5. Mix well before using.

### **Operating Conditions:**

Temperature	120-150°F (49° - 65°C)
Current Density	2-4 Volts (10-40 ASF)
PH	3.8-4.2
Beaker	Pyrex
Anodes	Nickel Anode
	15-30 micro inches per minute

### Bath Set Up:

1. Fill beaker with **Nickel-Mirror™** & heat to 140° F.
2. Check connections from rectifier to anode and work to be sure the negative (-) and positive (+) wires are connected properly. The work should be charged negative (-), and the anode positive (+). Turn Rectifier On.
3. Plate for 1-10 minutes at 2-4 volts depending on size of part and degree of shine desired.
4. Larger parts require slightly higher voltage, while smaller parts require lower voltage. If part shows any burning such as dark deposits around the edges, you are burning the part and must lower the voltage. If part is not shiny after 5-10 minutes of plating, voltage is too low, therefore, increase voltage slightly.
5. After plating rinse part thoroughly in water and continue plating process with a **Decorative** finish such as gold or silver.
6. If you are not going to continue the plating process immediately, then dry the part thoroughly. When you continue the plating process, re-activate the part in **Activator-T™** to assure better adhesion.

### Trouble Shooting:

Pieces not Plating

- Check power supply, make sure switch is on.
- If switch is on, check fuse.
- Check connections from power supply to anode or cathode (part).

Pieces turn dark gray or black

- Anode/cathode connections are reversed.
- Current is too high.

Pieces turn hazy, cloudy, too dull

- Current too low. Adjust to higher current.
- Plate for a longer time.
- Organics are too high. Solution is used up - discard.

### Discard & Replace:

**Nickel-Mirror™** is a rugged bath and guidelines have been provided to help assure the long life of this bath. If, however, a problem should arise that cannot be solved by any of the above recommendations, or recommendations by our or any other qualified laboratory, the bath may need to be replaced: Transfer to a D.O.T. approved container. Check with local authorities for proper disposal.