EARTHCOAT™
Decorative Gold Plating Solution 14K, 18K, 24K, and Rose colors
(Decorative)

Product Description

EARTHCOAT™ is a resilient gold plating solution which deposits a flash plate of gold over nickel, sterling silver, gold, rhodium, and most other similar metals. The color control of EARTHCOAT™ gold plating is very easy due to a superb combination of brighteners which provide excellent coverage and leveling ability. EARTHCOAT™ offers a cyanide-free alternative to other hazardous gold plating solutions. EARTHCOAT™ is supplied as ready to use, for ease of set-up and operation.

Applications:

Over nickel, sterling silver, gold, rhodium, and most other similar metals.

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.

Operating Conditions:

<table>
<thead>
<tr>
<th>Temperature</th>
<th>140°F (60°C)</th>
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<tbody>
<tr>
<td>Current Density</td>
<td>3-4 Volts (5-10 ASF)</td>
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<tr>
<td>PH</td>
<td>9.2-10.0</td>
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<tr>
<td>Beaker</td>
<td>Pyrex</td>
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<tr>
<td>Anodes</td>
<td>Stainless Steel</td>
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<td>1 micro inch per minute</td>
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Bath Set Up:

1. Fill beaker with EARTHCOAT™ gold plating & 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 30-45 seconds at 3-4 volts depending on size of part and coverage desired.
4. Larger parts require slightly higher voltage (4V), while smaller parts require lower voltage (2-3V). If part shows any burning such as a dark or rich orange deposit around the edges, you are burning the part and must lower the voltage. If part is not a gold color after 45-60 seconds of plating, voltage is too low, therefore, increase voltage slightly.
5. After gold plating rinse part thoroughly in deionized water and dry completely with either a steam cleaner or a hot air dryer.

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, dark
  - Current too low. Adjust to higher current.
  - Temperature is low. Heat to 140 F.
  - Plate for a longer time.
  - Organics are too high. Solution is used up - discard.

- Pieces are too rich in gold color
  - Current too low. Adjust to higher current.
  - Plate for a shorter time.
  - If solution is old, organics are too high. Solution is used up - discard.

Discard & Replace:

EARTHCOAT™ is a rugged solution and is designed to help assure long life. 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.