



UltraPure White Rhodium 100ml/2g Bath Checklist and procedure:

Usage parameters:

Anode: Platinized Titanium (PT)

Temp: 50 C / 120 F

Voltage: 3.0 – 5.0 V

Plating Time: 15 – 55 seconds

Bath Characteristics:

Deposition Efficiency 7.5 mg/A/Min.)

Thickness: 0.18 - 0.45 microns

Specific Weight: 3.7 – 4.2 using Baume Hydrometer

Procedure: Check all temperatures, connections, volts at anode and cathode.

Into a perfectly clean heat-resistant beaker pour 900ml of deionized water then add the 100ml rhodium 2gram concentrate to this. Stir, heat, and follow the instructions below.

- 1) Polish
- 2) Ultrasonic cleaning
- 3) Electrocleaning (using Durston Electrocleaner)
- 4) Rinse (x2) in regular or Deionized (DI) Water
- 5) Acid Activation (using Durston Activator)
- 6) DI Rinse (x3)
- 7) UltraPure Rhodium
- 8) Drag-out rinse.
- 9) DI water rinse (x2)

Tips for the best results:

- DO NOT overheat the rhodium bath. Temperatures higher than 60 C /140 F will break-up the whitening agents in the bath.
- REMOVE the PT anode when not in use. This will greatly extend the anode life.
- Due to evaporation of the water content the rhodium bath volume will decrease over time. It is recommended to fill the solution back up to the 1L full volume with Deionized (DI) water as needed.
- A spray bottle full of DI water can be used to spray rhodium droplets that cling to the part back into the bath. This has the added advantage of helping maintain the volume of the bath with clean DI water. Be sure not to overdo it and exceed 1L in volume.
- Keep the bath covered when not in use.
- Spent rhodium solution and the first DI water post-rinse should be saved. These solutions can be recycled for a small return.