



KROHN INDUSTRIES
Quality & Service Since 1955



INSTRUCTIONS FOR USING SUPERBRITE® RHODIUM PLATING SOLUTIONS

Cleaning and preparation is one of the most important steps in the plating process. All items must be free of oils, fingerprints, dirt, polishing compounds, cleaners, and soaps. Before using Superbrite® Rhodium plating solution, it is important to read the Safety Data Sheet, plating and mixing instructions. These can be found on our website at www.krohnindustries.com.

1. Polish all pieces to be plated to a mirror finish free of scratches.
2. Clean all pieces to be plated into a heated ultrasonic for 2 - 3 minutes.
3. Rinse well in distilled water.
4. Use Electroking™ to electroclean pieces at 2-6 volts, 140°F (60 °C) for 15-30 seconds using a stainless anode.
5. Rinse thoroughly in distilled water ensuring the electrocleaner does not carry over into the rhodium solution.
6. Do no steam clean.
7. **Rhodium Bath plating** – Using a platinized titanium anode, plate at room temperature using 4 volts for 20-30 seconds. **Never heat the rhodium bath.**
8. **Rhodium Pen plating** – Plate at 6 volts. Larger items may require higher voltage.
9. Rinse well in distilled water and steam clean or wipe with a soft cloth to avoid water spots.

It is important to [change the distilled rinse water](#) often to prevent the carryover of chemicals to your rhodium bath and contaminate your bath.

SUPERBRITE™ RHODIUM BATH SOLUTION

1. Bath solutions are shipped ready to use. No additional water is needed.
2. The intended use of these solutions is for a full bath application. Partially using the bottle and then mixing in new rhodium with the remaining old solution will lead to an imbalance in the bath, resulting in darkened plating.
3. When using a portion of the bottle, use the entire portion until the solution is spent, discard that portion, and use fresh rhodium to start a new bath.
4. **Never mix spent solution and fresh rhodium solution together.**
5. When the level of the bath gets low due to evaporation or drag out, add distilled water to bring the bath back up to the original level.

MIXING INSTRUCTIONS: SUPERBRITE™ RHODIUM REPLENISHER

Only replenish with **SUPERBRITE™** replenisher. ***Do not replenish a contaminated solution. Start over with a fresh plating bath, if contaminated.***

Add 1 gram of **SUPERBRITE™** replenisher to a spent 1-pint bath, mix well.

Add 2 grams of **SUPERBRITE™** replenisher to a spent 1-quart bath, mix well.

MIXING INSTRUCTIONS: SUPERBRITE™ RHODIUM BATH CONCENTRATE

Under ventilation, slowly mix the rhodium concentrate with distilled water, as the solution will heat while mixing.

½ gram bath concentrate – Pour the concentrate into a beaker, add distilled water to bring the level up to 250 ml's, and mix well.

1 gram bath concentrate – Pour the concentrate into a beaker, add distilled water to bring the level up to 500 ml's, and mix well.

2 gram bath concentrate – Pour the concentrate into a beaker, add distilled water to bring the level up to 1,000 ml's, and mix well.

Plate following **SUPERBRITE™** rhodium bath instructions on page 1.

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

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