

USER INSTRUCTIONS

NICKELOR 101

NICKEL FOR PLATING SOLUTION

Colour : **Gray nickel**

Use : **Bath**

Colour coordinates : **L:83.6**

a:0.7

b:6.2

Product description

NICKELOR 100 series are a nickel plating bath purposely designed for flash or thickness plating. The processes are characterised by the considerable compactness and resistance of the galvanic layer which makes it particularly suitable as a barrier against the diffusion of copper, silver and its alloys. These characteristics of compactness and resistance also make NICKELOR 100 particularly suitable for use as an intermediate layer very hard and bright considerably reducing the possibility of scratches and abrasion of the plated articles.

Operating conditions

Parameter	Average suggested value
Deposition time	1200 seconds
Temperature	55 °C
Voltage	5.0 V
Current density	3.0 A/dm ²
Cathodic efficiency	16 mg/Amin
Deposition speed	0.6 um/min
Anodes	Nickel
Agitation	Moderate
Ventilation	Necessary

Maintenance of plating bath

For small plating solution volumes (up to 10 litres) we suggest to use the bath without replenisher . For higher volumes we suggest to use the related replenisher composing the bath:

- **NICKELOR 113** : add 0.7 ml every 100 Amin.
- **NICKELOR 100SL** : add 0.5 ml every 100 Amin.
- **NICKELOR 100P** : add 0.5 ml every 100 Amin.
- **NICKELOR 100TM** : add 1 ml every 100 Amin.
- **NICKELOR 110** : add after analysis.
- **NICKELOR 100S** : add after analysis.
- **NICKELOR 100F** : add after analysis.
- **NICKELOR 130** : add after analysis.

Safety Information

Please refer to the safety data sheets for any information regarding safety and disposal (MSDS).

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Products related

Cod.Articles	Description	Colour	Packaging
NI013601	NICKELOR 101 Nichel plating solution ready to use	Gray	1 L
NI013610	NICKELOR 101 Nichel plating solution ready to use	Gray	10 L
NI010325	NICKELOR 110 Primary brightener additive	—	10-25 L
NI010625	NICKELOR 130 Levelling additive	—	10-25 L
NI010410	NICKELOR 113 Complete brightener additive	—	10-25 L
NI010725	NICKELOR 100F Co-brightener additive	—	10-25 L
NI010805	NICKELOR 100P Co-brightener additive	—	10-25 L
NI011105	NICKELOR 100SL Secondary brightener additive	—	10-25 L
NI012610	NICKELOR 100TM Wetting agent additive	—	10-25 L