



Version: 10 April 2017

# AURUNA<sup>®</sup> 502

## ROSE GOLD ELECTROLYTE

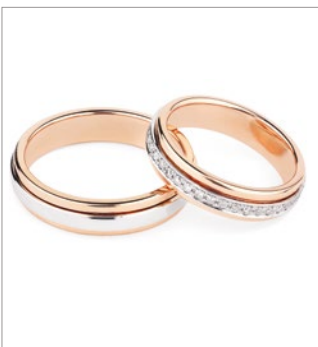


### Neutral, Cadmium-Free Electrolyte for Red Layers

AURUNA<sup>®</sup> 502 is a neutral, cadmium-free gold copper electrolyte working without free cyanide. The red surfaces are bright, very hard and abrasion-resistant.

AURUNA<sup>®</sup> 502 is mainly used for decorative coatings, but it is suitable for technical applications such as slip rings as well. As gold-saving, low-carat layers, the surface exhibits very good corrosion and tarnish resistance.

The gold copper electrolyte can be used for rack and barrel plating, it can deposit layers of up to max. 10 µm in thickness.



### Advantages

- Gold-saving coatings (approx. 18 ct)
- Cadmium-free
- Red gold-copper layers
- Resistant to tarnishing and corrosion
- Maximum layer thickness approx. 10 µm
- High hardness (380 - 400 HV), abrasion-resistant
- Suitable for rack and barrel

### Applications

- Accessories
- Jewellery
- Watches
- Bathroom fittings
- Lighting
- Spectacle frames
- Writing implements
- Slip rings

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### TECHNICAL SPECIFICATIONS

Electrolyte characteristics		Coating characteristics	
Electrolyte type	Neutral	Coating	Gold-copper
Metal content	4 (3.5 - 4.5) g/l Au 3 (2.5 - 3.5) g/l Cu	Alloy composition (according to ASTM B 488-01)	75 wt.% Au 25 wt.% Cu
pH value	7.5 (7.2 - 8.0)	Colour of deposit	Red
Operating temperature	57 (55 - 60) °C	Brightness	Bright
Current density range	0.5 (0.3 - 0.8) A/dm <sup>2</sup>	Hardness of deposit HV 0.015 (Vickers) approx. values	380 - 400 HV
Plating speed	Approx. 0.15 µm/min at 0.5 A/dm <sup>2</sup>	Max. coating thickness	Approx. 10 µm
Anode material	Pt-Ti (type PLATINODE® Pt/Ti)	Density of the coating	Approx. 15 g/cm <sup>3</sup>

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Electroplating

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