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AURUNA[®] 526

BARREL GOLD-PLATING ELECTROLYTE



Excellent Layer Thickness Distribution

AURUNA[®] 526 is a weakly acidic gold-cobalt electrolyte with very good throwing power and layer thickness distribution, especially on hollow parts.

This makes the electrolyte perfect for use of bulk material in barrel and vibration coating facilities. The interiors of cases or sockets often need to be gold-plated. The excellent throwing power therefore very positively influences the layer thickness distribution between the interior and exterior surfaces. This optimum distribution means gold can be saved.

The deposited layers have very good wear resistance, low contact resistance and impressive corrosion resistance.



Advantages

- Save gold due to optimal coverage of hollow parts
- Excellent throwing power
- Long-term stability in permanent operation
- Layers are classified in accordance with ASTM B-488-01: Type 1, Code C

Applications

- Bulk and barrel parts
- Pin, spring and plug contacts
- Contact sockets

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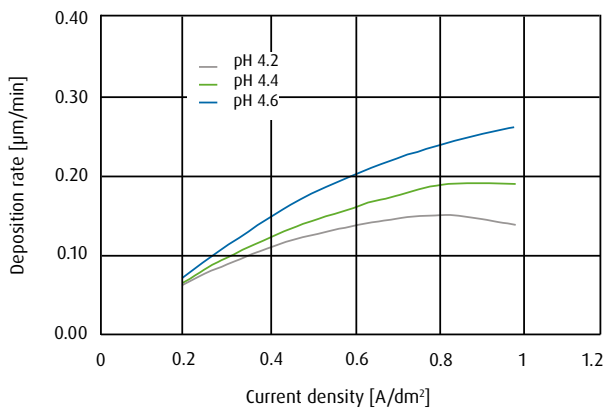


TECHNICAL SPECIFICATIONS

Electrolyte characteristics	
Electrolyte type	Weakly acid
Metal content	4 g/l (2 - 5 g/l)
pH value	4.4 (4.0 - 4.6)
Operating temperature	Room temperature (20 °C up to max. 30 °C)
Current density range	0.3 A/dm ² (0.3 - 1 A/dm ²) barrel
Plating speed	approx. 50 mg (Amin)
Anode material	approx. 0.08 µm/min

Coating characteristics	
Coating	Gold-cobalt (approx. 0.2 wt.% Co)
Hardness	approx. 160 HV 0.01
Abrasion resistance	Very good
Contact resistance	approx. 2 mΩ
Classification according to ASTM B 488-01	Type 1, Code C (equivalent to Type 1, Grade C in accordance with MIL-G-45204 C)

Deposition Rate in Relation to pH Value and Current Density



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