

Eliminate Cyanide silver strike tank and
plate directly to copper, copper alloy and
nickel with alkaline non cyanide silver

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Silver electroplating: applications

- ▶ Decorative: silverwares
- ▶ Electronics: switches, connectors

Silver Electroplating: Chemistry

- ▶ Cyanide silver Electroplating
- ▶ Non-Cyanide Silver Electroplating

Design non-cyanide silver plating chemistry

- ▶ Complex: environmental friendly chemicals, Ag ion easily to be precipitated out
- ▶ Stable bath chemistry
- ▶ Plate on nickel, as well as other copper alloys
- ▶ Excellent adhesion
- ▶ Uniform White deposit with no yellow hues

Breakthrough technology of non cyanide silver electroplating

- ▶ Plate directly on nickel, as well as copper alloys
- ▶ Stable solution chemistry
- ▶ Bright silver for electronic, industrial and decorative applications
- ▶ Cost effective: plate silver entirely from dissolving silver anodes
- ▶ Exceptional covering and throwing power
- ▶ Fine-grained, smooth, dense silver deposit with low porosity
- ▶ Brilliant white deposit and better anti-tarnishing properties than other non-cyanide silver processes
- ▶ Easy maintenance and room temperature plating

Plating Specifications

- ▶ Silver metal: 9.5-17 g/l
- ▶ pH: 9.5-10.5
- ▶ Temperature: 16-24 °C
- ▶ Cathode current density: 3-10 ASF
- ▶ Anode current density: 2-10 ASF

Plating Specifications (continuous)

- ▶ Silver anode: slab or popcorn anodes in polypropylene basket
- ▶ Filtration: continuous filtration with 1 micron filter
- ▶ Agitation: air agitation on the cathodes

Bath Make-Up

- ▶ Liquid silver concentrate 30% by volume
- ▶ Maintenance electrolyte 30% by volume
- ▶ Brightener 1% by volume
- ▶ Rest of DI water 39% by volume

Functions of solution components

- ▶ Liquid silver concentrate: provide initial silver ions
- ▶ Maintenance electrolytes: complex silver ions, dissolve silver anode, and ensure great adhesion between silver and metal substrates
- ▶ Brightener: refine silver grain and control crystal orientation

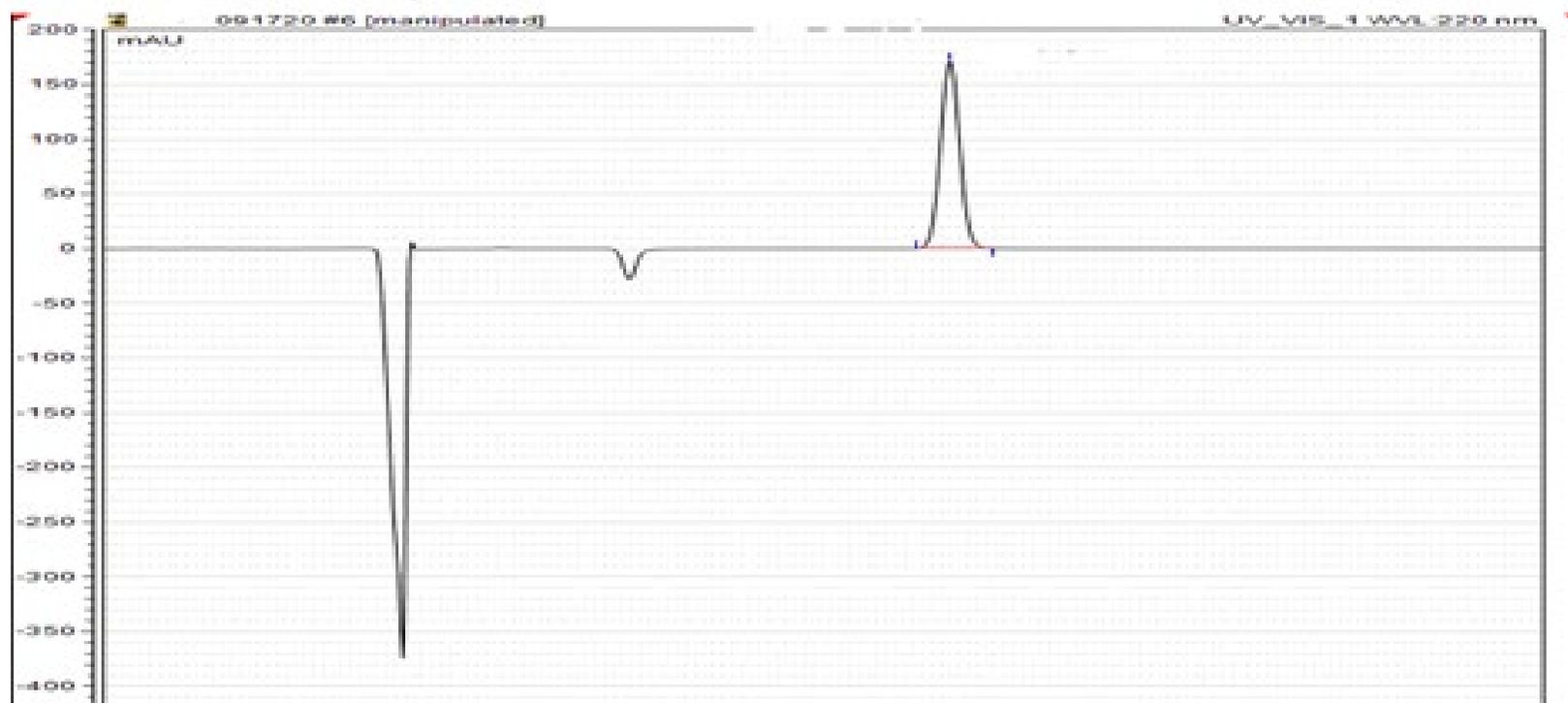
Maintenance of plating bath

- ▶ Silver metal: titration, entirely replenished by dissolving silver anode
- ▶ Maintenance electrolyte: Hull cell test for adhesion, HPLC analysis, consumed based on ampere hours
- ▶ Brightener: hull cell test and ICP analysis, consumed based on ampere hours

Maintenance of plating bath (continuous)

- ▶ pH: 9.5-10.5; lower pH with nitric acid, raise pH with 50% KOH
- ▶ Filtration: continuous filtration with 1 micron filter
- ▶ Agitation: air agitation on the cathodes

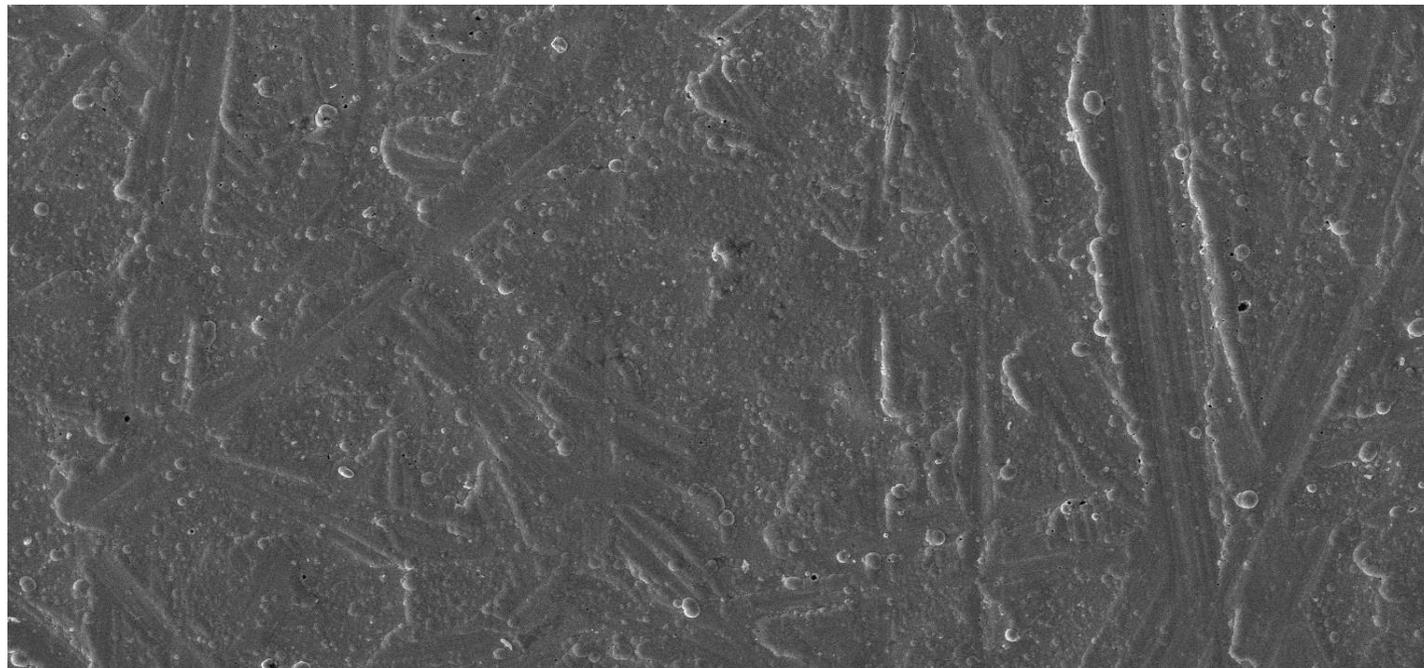
HPLC analysis of maintenance electrolyte



Plating speed of non cyanide silver

Cathode Current density (ASF)	2	5	10	15	20
Plating Rate micro-inches/min	6.4	15.4	26.2	33.3	40.3

SEM picture of silver deposit



SEM HV: 25.0 kV

Det: SE

VEGA3 TESCAN

View field: 758 μm

SEM MAG: 500 x

200 μm

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SEM picture of silver deposit over nickel (cross-section analysis)

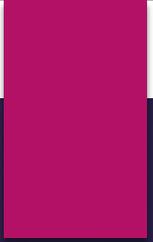


Properties of silver deposit

- ▶ Purities: over 99.9%
- ▶ Hardness: 150-200 KHN50 with a Knoop diamond indenter at a load of 50 grams
- ▶ Electrical resistance: 3.0-3.5 microhm-cm
- ▶ The wear resistance: better than cyanide silver deposit; the wear test performed by Taber Abrader is to abrade the silver deposit with the load of 250 grams.

Conclusion

- ▶ The silver deposit has a brilliant white color and shows a better anti-tarnishing properties than other non-cyanide silver processes.
- ▶ The new chemistry is very cost effective and it plates entirely out of silver anodes.
- ▶ The bath is extremely stable. The solution pH is buffered and remains stable during plating and when idle.
- ▶ It can plate non cyanide silver directly on nickel surfaces (meeting all three types of ASTM B-700) as well as plate directly on silver, brass, bronze and copper and does not require a separate silver strike on these substrates.
- ▶ The plating bath is an alkaline, cyanide free plating solution, which can plate bright silver for electronic, industrial and decorative uses.



Thanks