GF24 is a gold electrolyte intended for bath plating, which deposits a uniform, shiny layer in a 24 kt color. The color is that of pure gold as no other metals are used as an alloy in the deposit. GF24 is intended for decorative use therefore has been designed for flash plating permitting a deposition thickness of up to 0.2 micron. This yellow gold plating solution is Nickel, Lead, and Cadmium free, and despite being a traditional cyanide based alkaline bath, it is easily transported given the toxic level contained is below the limit established by international transportation laws.

### GENERAL INFORMATION

**Product form**
- Product’s pH: Alkaline
- Metal concentration: 0.8 g/l (Au)
- Solution form: Ready-to-use
- Solution form: Liquid
- Plating solution color: Transparent
- Storage time: 2 years
- Volume: 1 liter

**Deposit data**
- Solution appearance: Shiny
- Purity (%): 99.9
- Hardness [HV 0.01]: 90-100
- Density [g/cm³]: 19.0
- Plating solution color: 24 kt Gold Yellow
- Thickness range [µm]: 0.1 - 0.2

<table>
<thead>
<tr>
<th>Operating data</th>
<th>RANGE</th>
<th>OPTIMAL</th>
</tr>
</thead>
<tbody>
<tr>
<td>pH</td>
<td>10.00 - 10.50</td>
<td>10.3</td>
</tr>
<tr>
<td>Voltage [V]</td>
<td>3.5-5.5</td>
<td>4.5</td>
</tr>
<tr>
<td>Current density [A/dm²]</td>
<td>0.5 - 2.0</td>
<td>1.2</td>
</tr>
<tr>
<td>Working temperature [°C]</td>
<td>55-65</td>
<td>60</td>
</tr>
<tr>
<td>Exposure time (sec)</td>
<td>20 - 50</td>
<td>40.0</td>
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<tr>
<td>Cathode efficiency [mg/Amin]</td>
<td>8 - 14</td>
<td>10.0</td>
</tr>
<tr>
<td>Anode-cathode ratio</td>
<td>&gt;1:1</td>
<td></td>
</tr>
<tr>
<td>Anode type</td>
<td>Platinized titanium or stainless steel</td>
<td></td>
</tr>
<tr>
<td>Agitation</td>
<td>Moderate</td>
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</table>

<table>
<thead>
<tr>
<th>Metal concentration</th>
<th>METAL</th>
<th>RANGE (g/l)</th>
<th>OPTIMAL (g/l)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Gold</td>
<td></td>
<td>0.4 - 1.0</td>
<td>0.8</td>
</tr>
</tbody>
</table>

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GF24 is a ready-to-use plating bath at the concentration of 0.8 g/l of gold. No preparation is required while filling the working tank.

**EQUIPMENT**

Working vessel materials: Pyrex glass / PVC / polypropylene
Power supply: DC current rectifier with low residual AC (<5%)
Heating element
Anode type: Platinized titanium [1.5-2.5 µm] or stainless steel
For larger bath volumes:
Magnetic driven filter pumps with 5-15 µm cartridge (before use, boil and wash the cartridges with demineralized water for 3 hours to prevent organic contamination)
Amp/min counter

**PRE TREATMENT**

GF24 can be deposited directly onto Palladium, Nickel, and precious metal substrates. An intermediate deposit of Palladium or Nickle is required over Silver, and all alloys containing copper to prevent copper migration. An intermediate deposit or precious metal plating strike is necessary before depositing onto Tin, Lead, Zinc, Cadmium, Aluminum and Iron.

**POST TREATMENT**

Electrolyte should be removed from the surface as quick as possible. Rinse off the bath rests in a recovery rinse (still rinse). Rinse the parts in circulating deionized water and dry.

**WATER PURITY**

To prevent contamination of the bath both during its preparation and any subsequent replenishing operations, use demineralized water with a conductivity of less than 3 µS/cm (containing no traces of organic compounds, Chlorine, Silicon, or Boron).

**BATH MAINTENANCE**

This process is easy to maintain, but will initially requires frequent analytical controls in order to obtain a correct concentration level of all the metals present. Metal concentrations greatly influence the final deposited color; therefore, an incorrect management of these parameters shall inevitably lead to unwanted colors. Some general guidelines for maintenance are below described:
- Adding GF1AGR will lead the colour towards green-/pale hues.
- Adding GF1CUR will lead the colour towards red/pink hues.
- Adding GF10AUR will lead the colour towards yellow hues.
- Adding AUS683 is used to replenish the gold content
- Potassium cyanide concentration must be frequently controlled to be maintained at the correct working concentration

**SUPPLEMENTARY INFORMATION**

For maximum performance and in particular in terms of resulting color do not use an excessive agitation. A moderate agitation of the pieces to be plated will be sufficient. For larger volumes it is sufficient the use of a magnetic drive filter pump with a not too much high capacity.

**SAFETY INFORMATION**

Being an alkaline solution, the electrolyte is an irritant to the skin, eyes and mucous membranes. Caution should be exercised when using the product, avoiding contact with the eyes and skin. Use gloves and safety goggles. Keep away from acid based chemicals. For further information please refer to the relative MSDS.

**DISCLAIMER**

All recommendations and suggestions in this bulletin concerning the use of our products are based upon tests and data believed to be reliable. Since the actual use by others is beyond our control, no guarantee expressed or implied, is made by Legor Group, its subsidiaries of distributors, as to the effects of such use or results to be obtained, nor is any information to be construed as a recommendation to infringe any patent.
## RELATED PRODUCTS LIST

<table>
<thead>
<tr>
<th>Prodotto Complementari</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>AUS683</td>
<td>Gold (I) potassium cyanide 68.3%</td>
</tr>
</tbody>
</table>