


GENERAL INFORMATION

RU5DG-C is a ruthenium plating electrolyte in concentrated form. Simply add the 200 ml bottle to 800 ml of pure deionized water to prepare the ready to use solution. The electrolyte deposits an abrasion resistant layer of ruthenium metal in a dark gray color. The dark gray color produced is developed with extremely stable organic additives making this electrolyte easy to use and maintain. This acidic based compound is primarily used in decorative plating applications for a diverse dark color option in the case where corrosion resistance is also a requirement. The plating deposit is durable and can reach a maximum thickness of 0.2 micron. Due to the fact ruthenium has a lower conductivity than other precious metals, the electrolyte requires a greater metal concentration to function optimally.

Product form

Metal concentration	5 g/ 200 ml (Ru)
Product's pH	Acidic
Solution form	Concentrated
Plating solution color	Black
Storage time	2 years
Volume	1 liter

Deposit data

Solution appearance	Shiny
Purity (%)	99.9
Plating solution color	Grey


Operating data
RANGE
OPTIMAL

Anode type	Platonized titanium
Agitation	Strong

Metal concentration	METAL	RANGE (g/l)	OPTIMAL (g/l)
	Ruthenium	3-10	5.0

**PREPARATION**

RU5DG-C is a concentrated form. To prepare the ready to use solution, simply add the 200 ml bottle to 800 ml of pure deionized water.

EQUIPMENT

Working vessel: 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].

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

RU5DG-C can be deposited directly onto Palladium, Gold, Nickel and its alloys. An intermediate deposit or precious metal plating strike is necessary before depositing onto Tin, Lead, Zinc, Cadmium, Aluminum and Iron.

Copper and alloys containing copper provide the poorest layer for ruthenium adhesion and the metals together run a high risk metal diffusion which should be avoided. Separate the layers with intermediate deposits of white bronze or nickel when applicable and palladium.

POST TREATMENT

The electrolyte should be removed from the surface as quick as possible.

1. Wash off the bath residual in a recovery rinse (still rinse) followed by
2. Wash the article in hot distilled water (80°C).
3. Rinse the parts in circulating or running water.
4. Dry

In the case a problem is observed, replace step #2 with a 50% cold ammonia solution rinse for 5 minutes. This action should be performed under an exhaust hood.

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**Metallic additions**

For small-size ruthenium baths (up to 3 liters) we advise to use until the ruthenium solution is completely exhausted and dispose without incorporating replenishment. For larger-sized baths add **RU5R** which is a pre calibrated replenisher containing additional ruthenium in concentrate to restore the optimal ruthenium concentration. For perfect galvanic bath performance it is advisable to maintain the ruthenium concentration at a minimum of 20% of the initial concentration; for example, with a bath operating at a concentration of 5 g/l, additions should be made after a maximum consumption of 1 g/l of ruthenium. When introducing additional metal keep in mind that in optimum working conditions a bath working at 5 g/l normally deposits about 3 mg of ruthenium per Ampere/minute.

pH control

pH is a very important parameter especially when working on high thickness layers. The pH value must be frequently controlled and held under optimal values numerically described in the operating data table. In the case corrections are needed use Ammonium hydroxide to raise the pH, and **RU5S** conductive salts to lower it.

Density control

Solution density is not a critical parameter. In the case of heavy productions, it is advised to control the density periodically by chemical titration. As the density lowers in value, restore to its optimum working health using **RU5S** conductive salts. Adding 10 g/l of **RU5S** will raise the solution density of about 1° Bé.

**SAFETY INFORMATION**

Being an acidic solution, the electrolyte is corrosive therefore 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 cyanide based chemicals. For further information please refer to the relative MSDS.

DISCLAIMER

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