



KROMAXIMA



Chromium Plating Process

DESCRIPTION:

The Kromaxima process is a low concentration, high efficiency chromium plating process for decorative applications. The unique liquid catalysts provide exceptional activating power on nickel surfaces to give excellent covering power of the chromium deposit.

KEY PROPERTIES:

- Process with two liquid catalysts
- Excellent coverage at temperature around 35°C
- Optimal for plating of geometrically complex parts
- Good current efficiency even at low current densities

RECOMMENDED USE:

	Range	Optimum
Chromic Acid	200 ~ 300 g/L	225
Sulphate	0.8 ~ 1.2 g/L	0.9
Chrome : Sulphate Ratio	166-375	250
Kromaxima Part B	18 - 25 mL/L	21.5

Make-up:

Chromic Acid – 225 g/L

Kromaxima Additive KR-A – 25 mL/L

Kromaxima Additive KR-B – 25 mL/L

1. Fill $\frac{3}{4}$ of the tank with demineralised water and dissolve the required amount of chromic acid.
2. Add the liquid Kromaxima Additive KR-A & B.
3. Fill up to final volume with demineralised water.
4. Electrolyse the solution at 6 voltage for a few hours.

OPERATIONAL CONDITIONS:

Cathode current density	10 Amp/dm ² (5~20Amp/dm ²)
Tank voltage	6-15 volts
Temperature	30-40°C (optimum 35°C)

EQUIPMENT:

- Tanks

- Rectifier

- Extraction
- Tin-lead anodes
- Heating/cooling coils
- Supported PVC, lead-lined steel
- Ripple factor less than 5%
- Anodes
- Titanium, lead

SOLUTION CONTROL:

- The chromic acid content should be maintained at optimum level by adding Chromic Acid.
- Sulphate Catalyst Part A can be controlled under regular analysis. Excess Part A can be removed by barium carbonate.
- To increase 0.1 g/L of Sulphate = addition of 2.76 mL/L - KR-A
- Kromaxima Part B can be controlled by analysis

SAFE HANDLING & STORAGE CONDITIONS:

Before handling, the Safety Data Sheet (SDS) should be read and understood by all personnel in contact with this product. Chromic acid is a strong oxidising agent and can cause fires. Keep away from organic matter and reducing agents. In case of spillage, flush with cold, clean water. In case of injury consult a doctor.

IMPORTANT NOTICE! For Industrial Use Only

DISPOSAL:

Any disposal of this product should be in compliance with all federal, state, and local regulations. The hexavalent chrome must be reduced prior to neutralisation before dumping to sewer. Please refer to the Safety Data Sheet (SDS) for instructions regarding proper disposal of this product.

PRECAUTIONS:

KEEP OUT OF THE REACH OF CHILDREN.

Please refer to the label and Safety Data Sheet (SDS) for all warnings, recommendations for safety equipment, and other regulatory information. Copies of the SDS can be ordered by calling +61 3 9768 3860.

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