

riag Ni 122

Bright Nickel barrel plating process

The **riag Ni 122** barrel nickel electroplating process offers the following advantages:

Properties

- Excellent brightness
- Light coloured white deposits
- Excellent metal deposit thickness distribution
- Good ductility
- Excellent brightness throwing power
- Ideal for zinc die-casting plating

Make up

	Range	Optimum
Nickel sulphate (NiSO ₄ x 6 H ₂ O)	180 – 250 g/L	200 g/L
Nickel chloride (NiCl ₂ x 6 H ₂ O)	50 – 70 g/L	60 g/L
Boric acid (H ₃ BO ₃)	40 – 50 g/L	42 g/L
riag Ni 132 Make up	10 – 15 mL/L	12 mL/L
riag Ni 135 Carrier	3 – 6 mL/L	5 mL/L
riag Ni 122 Brightener	0.1 – 0.5 mL/L	0.3 mL/L
riag Ni 138 Tenside M * or	1 – 3 mL/L	2 mL/L
riag Ni 139 Tenside L *		
pH-value	3.8 – 4.5	4.2

* depending on customer-specific process requirements

Operating Values

Nickel (Ni ²⁺)	50 – 75 g/L	60 g/L
Chloride (Cl ⁻)	15 – 21 g/L	18 g/L
Boric acid (H ₃ BO ₃)	40 – 50 g/L	45 g/L

Make up

A separate tank is filled with deionised water to 2/3 of the final volume.

The water is then heated to at least 60 °C after which the chemicals are added and the tank is filled to final volume with deionised water. To remove contaminants 0.5 mL/L Hydrogen peroxide is added and the solution is stirred for at least one hour. This is followed by addition of 3 – 5 g/L **riag Carb SF** activated carbon and mixing for another 30 minutes. After settling, preferably overnight, the electrolyte needs to be transferred to the working tank by filtration. Finally, the correct undiluted volumes of **riag Ni 132 Make up**, **riag Ni 135 Carrier**, **riag Ni 122 Brightener** and **riag Ni 138 Tenside M / riag Ni 139 Tenside L** are added whilst stirring.

Operating Parameters

Temperature:	55 °C (50 – 60 °C)
pH-value:	4.2 (3.8 – 4.5)
Cathodic current density:	0.1 – 2.0 A/dm ²
Anodic current density:	< 3.0 A/dm ²
Current efficiency:	< 100 %
Deposition rate:	at 1 A/dm ² ca. 0.2 µm/min
Anodes :	Minimum purity 99.7 % Ni. We recommend polypropylene anode bags
Agitation:	Essential: Barrel rotation, filter pump
Tanks:	Plastic or lined steel
Filtration:	It is important to use continuous filtration and we recommend including activated carbon filtration as well. The filtration rate should be two to three times electrolyte volume per hour.
Heating:	Immersion heaters, but thermostatic control is essential
Cooling:	not required
Fume extraction:	Recommended
Maintenance:	Nickel sulphate, nickel chloride and boric acid should be analysed and corrected regularly. Additions of riag Ni 122 Brightener , riag Ni 133 Carrier and riag Ni 135 Carrier are made via ampere-hour consumption. As an alternative to riag Ni 133 Carrier , riag Ni 132 Make up can also be added.

Metallic contamination can be removed by frequent selective plating-out at 0.1 – 0.3 A/dm². The filter pump should be on with the filter outlet directed at the panels. This will ensure thorough electrolyte circulation and essential agitation at the same time.

pH-value adjustment: To lower the pH chem. pure Sulphuric acid (10 %) is added. To raise the pH only Nickel carbonate must be used. Ammonia or ammonia compounds must not be added. The brightener consumption will increase if the pH is above 4.5 while reduced levelling is noticed at a pH lower than 4.0.

Additive consumption: The additives are consumed during electrolytic reactions as well a drag-out losses and the use per 10 kWh can therefore vary.

riag Ni 122 Brightener	1.0 – 2.0 L/10 kWh
riag Ni 133 Carrier	0.3 – 0.7 L/10 kWh
riag Ni 135 Carrier	0.3 – 0.7 L/10 kWh
riag Ni Tenside M / L	0.1 – 0.3 L/10 kWh

Function of electrolyte components

riag Ni 122 Brightener

For uniform bright coatings it is essential to add the **riag Ni 122 Brightener** in small doses and according to the operating instructions. Smaller more frequent additions are important for optimal brightness and deposit quality. Regular pH-control and correction (4.2) reduce the **riag Ni 122 Brightener** consumption as well.

riag Ni 135 Carrier

The **riag Ni 135 Carrier** is responsible for uniform bright coatings over a wide current density range (especially for low current density) and can be determined analytically.

riag Ni 132 Make up / riag Ni 133 Carrier

The **riag Ni 132 Make up / riag Ni 133 Carrier** content can be determined analytically. To get ductile deposits, we recommend not going below the operating value. A lack of **riag Ni 132 Make up / riag Ni 133 Carrier** is indicated by shadows at medium to high current densities. In this case, 3 – 8 mL/L **riag Ni 132 Make up** have to be added.

riag Ni Tenside M / L

The consumption of **riag Ni 138 Tenside M / riag Ni 139 Tenside L** may vary. It reduces the surface tension and prevents pitting.

riag Ni 146 Support

The additive **riag Ni 146 Support** is used to remove dark plating in low current density areas that cannot be removed by selective plating-out. However, the maximum **riag Ni 146 Support** addition must be limited to 1 mL/L. Higher dosing reduces levelling and deposit brightness. **riag Ni 146 Support** can also be used to compensate for brightener overdosing (0.2 – 0.5 mL/L). To avoid overdosing of **riag Ni 146 Support** additions should be made in small volumes.

riag Ni 143 Purifier

Zinc-die casting processing in rack or barrel mode often leads to zinc and copper electrolyte contamination. This can be treated by additions of 0.03 – 0.1 mL/L **riag Ni 143 Purifier**. The volume **riag Ni 143 Purifier** to be added depends on contamination levels but overdosing results in loss of deposit brightness as well as levelling and must be avoided.

Activated Carbon

Continuous filtration over activated carbon is recommended. This can be done via a by-pass whereby the carbon will remove organic contaminants such as oils and breakdown products.

For this we recommend our **riag Carb SF** dust-free product which has an active surface area of 1500 m²/g. The additional brightener consumption should not exceed 5 %.

A significant contamination of the electrolyte can be removed by filtration in the bypass (filter pump with a filled sack of **riag Carb GR**). **riag Carb GR** is ideally suited for this purpose, as such treatment may be performed during the plating process. **riag** can provide such filter system.

riag Ni 147 Oxidant

Iron contamination (pitting) can be removed effectively by additions of **riag Ni 147 Oxidant**. The maximum concentration of 0.5 g/L should not be exceeded. The salt is first dissolved in hot water and the iron is removed via the filter.

Environmental considerations and product safety

All concentrates, rinse waters and waste solution must be treated and discharged in accordance with local effluent control regulations. Information can be gleaned from the material safety data sheets. Chemicals shall not be stored below 10 °C.

Liability

This instruction manual was compiled with reference to the state of the art and all current standards, and is based on the long-term knowledge and experience of riag. However, riag cannot monitor compliance with this instruction manual and the methods described herein at the customer/end-user's premises. Work carried out with riag products must be adapted accordingly to meet local conditions. In particular, riag cannot accept liability for damage, loss or cost incurred due to a failure to adhere to this instruction manual, improper application of the methods, unauthorised technical modifications, insufficient maintenance or the absence of maintenance in respect of the requisite technical hardware or equipment, or in the event of use by unqualified personnel. riag is not liable for damage or loss caused by riag or its employees except where intention or gross negligence can be proved. riag furthermore reserves the right to make changes in relation to products, methods and the instruction manual without prior notice.

Our goods and services are subject to the General Terms and Conditions for Delivery of the Association of Surface Technology Suppliers (VLO), which can be viewed at www.riag.ch (link "terms and conditions" , document "General Terms and Conditions for Delivery", version 3/2018), which we gladly send you on request.

This transaction is governed by material Swiss law (Law of Obligations), excluding private international law (conflict of laws) and intergovernmental treaties, specifically the CISG.

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Analysis (Analytical Methods)

Sample preparation:

The sample must be taken from a well-mixed point and allowed to cool down to 25°C.

Boric acid

Reagents:	Sodium hydroxide solution 0.1 mol/L Bromcresol purple (1 % in Ethanol) Mannitol														
Procedure:	<table> <tr> <td>10 mL</td> <td>electrolyte are transferred via pipette into a 100 mL measuring flask and filled up to the mark with deionised water followed by mixing well.</td> </tr> <tr> <td>10 mL</td> <td>of this mixture is given into a</td> </tr> <tr> <td>250 mL</td> <td>beaker via pipette followed by</td> </tr> <tr> <td>100 mL</td> <td>deionised water addition.</td> </tr> <tr> <td>2 – 3 g</td> <td>Mannitol is added followed by addition of 10 drops Bromcresol purple.</td> </tr> <tr> <td></td> <td>Titration with</td> </tr> <tr> <td>0.1 mol/L</td> <td>Sodium hydroxide from yellow to green, to dark green and finally to blue-violet.</td> </tr> </table>	10 mL	electrolyte are transferred via pipette into a 100 mL measuring flask and filled up to the mark with deionised water followed by mixing well.	10 mL	of this mixture is given into a	250 mL	beaker via pipette followed by	100 mL	deionised water addition.	2 – 3 g	Mannitol is added followed by addition of 10 drops Bromcresol purple.		Titration with	0.1 mol/L	Sodium hydroxide from yellow to green, to dark green and finally to blue-violet.
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0.1 mol/L	Sodium hydroxide from yellow to green, to dark green and finally to blue-violet.														
Calculation:	Boric acid (g/L) = consumption of mL NaOH x 6.18														

Nickel chloride hexahydrate

Reagents:	Silver nitrate solution 0.1 mol/L Potassium dichromate solution 5 %										
Procedure:	<table> <tr> <td>5 mL</td> <td>electrolyte are transferred into a</td> </tr> <tr> <td>250 mL</td> <td>glass beaker and diluted with</td> </tr> <tr> <td>50 mL</td> <td>deionised water.</td> </tr> <tr> <td>10 drops</td> <td>of Potassium dichromate solution are added.</td> </tr> <tr> <td></td> <td>Titration with 0.1 mol/L Silver nitrate solution from white yellow to a light brown end point.</td> </tr> </table>	5 mL	electrolyte are transferred into a	250 mL	glass beaker and diluted with	50 mL	deionised water.	10 drops	of Potassium dichromate solution are added.		Titration with 0.1 mol/L Silver nitrate solution from white yellow to a light brown end point.
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10 drops	of Potassium dichromate solution are added.										
	Titration with 0.1 mol/L Silver nitrate solution from white yellow to a light brown end point.										
Calculation:	Nickel chloride hexahydrate (g/L) = consumption of mL AgNO ₃ x 2.380										
	Chloride (g/L) = consumption of mL AgNO ₃ x 0.709										

Nickel

Reagents: Buffer solution pH 10
 Na₂EDTA 0.1 mol/L
 Murexide (Sodium chloride 1: 100)

Procedure: 10 mL electrolyte are transferred via pipette into a
 100 mL measuring flask and filled- up to the mark with deionised
 water and mixed well
 10 mL of this mixture is given into a 250 mL glass beaker by
 pipette followed by
 15 mL Buffer solution addition
 100 mL deionised water and
 1 spatula tip of Murexide are added The sample colour should then be
 deep yellow
 Titrate immediately with Na₂EDTA 0.1 mol/L to a blue-
 end- point

Calculation: Nickel (g/L) = consumption of mL Na₂EDTA 0.1 mol/L x 5.869

Nickel sulphate hexahydrate (g/L) = [A – (B x 0.247)] x 4.48

A = Nickel concentration in g/L

B = Nickel chloride conc. in g/L

riag Ni 138 Tenside M

Reagents: Glycerine
 Butyl phosphate solution:
 Mix 5 mL Tri-n-Butyl phosphate
 500 mL Methanol
 500 mL water DI

Procedure: 25 mL electrolyte are transferred via pipette into a 300 mL
 Erlenmeyer flask, add
 3 drops glycerine, shake well, to form a foam cover. Add in steps
 of
 0.5 mL butyl phosphate solution,
 shake well after each addition, until the foam cover
 disappears within 10 seconds

Calculation: consumption in mL = mL/L **riag Ni 138 Tenside M**