

21.12.2021

riag Sn 865S

Satin tin process based on sulphuric acid

The **riag Sn 865S** process can be used in both barrel and rack applications as well as in vibration systems. Applications include both decorative and technical purposes.

Properties

- satin mat deposits across a wide current density range
- excellent coat thickness distribution
- excellent solderability of coats
- rack -and barrel application
- technical and decorative application

Make up

	Range				Optimum
Tin(II)-sulphate	40	–	70	g/L	55 g/L
*Sulphuric acid conc.	55	–	135	g/L	97 g/L
riag Sn 865 Tenside	40	–	80	mL/L	50 mL/L
riag Sn 865 Additive	3.5	–	7	mL/L	5 mL/L
riag Sn 860 Antiox	1	–	2	g/L	1.5 g/L

*Sulphuric acid: figures are based on 96 % acid, for safety reasons the use of pre-diluted acid is recommended, of course the figures must then be adjusted.

Make up

The tank is filled with deionised water to 80 % of the final volume. Then add sulphuric acid (it is advantageous to use a pre-diluted solution) and tin(II) sulphate carefully while stirring well (be careful, the solution gets warm). Stir until everything is dissolved. As soon as the temperature of the electrolytes has cooled down to 25° C, while stirring you add the required amount **riag Sn 865 Tenside**, **riag Sn 865 Additive** and **riag Sn 860 Antiox** (predissolved). The electrolyte is filled up with water to the final volume. First some dummy parts are coated to work in the process.

Operating values

	Range	Optimum
Tin(II)	22 – 39 g/L	30 g/L
*Sulphuric acid conc.	55 – 135 g/L	97 g/L

Operating parameters

Temperature:	20 °C (14 – 25 °C)
Cathodic current density:	0.5 – 5.0 A/dm ² in rack applications 0.1 – 1.0 A/dm ² in barrel applications
Anodic current density:	1.0 A/dm ² (0.5 – 3.0 A/dm ²)
Current efficiency:	< 100 %
Deposit rate:	at 2 A/dm ² approx. 1 µm/min.
Anodes:	The purity of the tin anodes should at least be 99.99 %. We recommend the use of polypropylene anode bags.
Agitation:	Electrolyte agitation by using goods movement at 2 – 5 m/min. required. The filter pump supports the movement and agitation of the electrolyte.
Tanks:	Plastic or lined steel
Filtration:	For high performance electrolytes constant filtration is necessary. The electrolyte should be circulated two to three times per hour. Especially important in barrel applications in order to ensure the circulation of the electrolyte.
Heating:	Thermostatic controlled temperature regulation is essential
Cooling:	Usually required, cooling coils of acid resistant plastic or plastic coated steel- or copper tubing, respectively PTFE
Fume extraction:	Recommended
Preparation of new tanks:	New tanks should be treated with sulphuric acid ca. 5 % and riag Sn 865 Tenside for 24 hours. When a conversion of the tank from a lead containing electrolyte takes place, an alkaline primary cleaning is recommended. Our sales staff will gladly advise you.
Maintenance:	Analyse and adjust tin(II) sulphate and sulphuric acid as well as riag Sn 860 Antiox regularly. To increase the tin content in the electrolyte by 1 g/L, 1.8 g/L tin(II) sulphate (contains 55 % tin) is required. Dosage of riag Sn 865 Additive and riag Sn 865 Tenside are determined by ampère hours.

Usage: The additives are used up by drag out as well as electrochemical, that is by anodic or cathodic processes. Therefore the usage may vary process-related.

riag Sn 865 Tenside 2.5 – 5.0 L/10 kWh

riag Sn 865 Additive 3.0 – 5.0 L/10 kWh

General: In particular the drag-in of chloride into the tin electrolyte has to be avoided. Therefore the parts are activated with sulphuric acid (approx. 5 % V) instead of hydrochloric acid. Brass and other zinc containing alloys must not at all tin-plated directly since zinc diffuses into the tin coat. In this case a barrier coat of copper or nickel is required. **riag Sn 860 Antiox** prevents the formation of Sn (IV) and the following clouding of the electrolyte.

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.

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Analysis (Analytical Methods)

Sample preparation:

The sample must be taken from a well-mixed point.

Tin (II)

Reagents: Iodine 0.05 mol/L
Hydrochloric acid 37 %
Starch solution 1 %
Calcium carbonate p.a.

Procedure: 5 mL electrolyte are transferred via pipette into a
250 mL beaker, add
50 mL deion. water, add
40 mL hydrochloric acid 37 %, add
approx. 2 g calcium carbonate, add
approx. 2 mL starch solution
Titrate with iodine 0.05 mol/L from colourless to dark blue. The dark blue colour has to stay for 30 s

Calculation: Use in mL x 1.186 = g/L Tin(II)

Sulphuric acid

Reagents: Sodium hydroxide solution 1 mol/L
Methyl red 0.2 % in ethanol

Procedure: 5 mL electrolyte are transferred via pipette into a
100 mL beaker, add
ca. 50 mL deion. water
ca. 3 drops methyl red
Titrate with sodium hydroxide from orange-red to yellow

Calculation: Sulphuric acid 96 % (mL/L) = Consumption in mL x 5.55
Sulphuric acid 96 % (g/L) = Consumption in mL x 10.2