

Technical Data Sheet

PD-Activator EB-10

PD-Activator is an acid activator consisting of specially prepared hydrosols of catalytic palladium which insures the operability of such sols in activating suitably treated nonconductive substrate surfaces for chemical plating particularly ABS plastic plating.

Make-Up Method-

- Firstly clean tank thoroughly (PP/PVC Tank recommended)
- Fill tank 2/3rd with RO/Line water.
- Add PD-Activator 10ml/ltr and mix well.
- After addition maintain required level of solution.

Operating Parameters:-

Appearance : Blackish Liquid
Temperature : Ambient
Residence time : 2-5minutes
Agitation : Mechanical
Filtration : Acid resistant 5 micron cartridge filter.

Process Flow:-

- 1) Degreasing Cleaner
- 2) Water Rinse 2X
- 3) Chrome etching
- 4) Water Rinse 4X
- 5) HCL Dip 0.5%
- 6) Water Rinse
- 7) PD Activator EB-10
- 8) Water Rinse 3X
- 9) Sulfuric Acid Dip 10% (By volume)
- 10) Water Rinse 2X
- 11) Electro less Nickel
- 12) DI Water Rinse 2X
- 13) Bright Acid Copper Plating

Analysis Method:-

The solution must be maintained at its original strength by the addition of activator concentrate day to day maintenance of the PD-Activator can be done with the colour standard method below.

The bath should be corrected each morning and stirred well, the movement of the work jigs providing enough agitation to circulate the solution during the working .

Apparatus:

One pair of 100ml Nessler Tubes, 10ml burette, 20ml pipette, 2 ml pipette

Method:

First ensure that the bath is at the correct volume and well mixed. Into one Nessler tube pipette 20ml of bath solution. In the other tube put 18ml of a 10% AR grade hydrochloric acid solution.

Fill the burette PD Activator EB-10 concentrate and add drop wise to the dilute hydrochloride acid until the colours match when two tubes are viewed from the side against a piece of white paper.

Calculation:

Volume in ml of PD Activator EB-10 concentrate X 50 = ml/L. of PD activator concentration in the bath.
The bath should be maintained at 5 – 10 ml/L

Cautions:

- Must Wear PPE's Rubber Gloves, Long shoes and apron during chemicals mixing.
- Care should be taken while adding concentrated acid or diluted acid's at elevated temperature as fuming or foaming may occur.

Waste Treatment:

- PD-activator bath is acidic and should be neutralize with alkali prior to discharge into sewerage line.



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