



7696 Route 31  
Lyons NY 14489  
Voice: 315.946.1213 Fax: 315.946.4456  
www.caswellplating.com

## CASWELL REPROCHROME® PLATING INSTRUCTIONS

Caswell REPROCHROME® is a unique Cobalt/Tungsten plating solution that provides a bright, chrome-like plate onto copper, brass, nickel, steel and most other ferrous and non-ferrous metals. For best corrosion resistance and shine, we recommend plating in copper, then nickel before REPROCHROME® plating.

REPROCHROME® comes pre-mixed and ready for use. Just add REPROCHROME® brightener at the rate of 3ml per 1000ml (0.40 fl oz per 1 Gal) of REPROCHROME® Starter (but don't add it yet)

### Operating Instructions:

1. Use HDPE or PVC plastic tank. Clean and rinse thoroughly with DISTILLED WATER before use.
2. Install stainless steel anodes and maintain at least a 1:1 ratio of anode surface area to part surface area.
3. Install pump agitation to keep solution moving.
4. Pour REPROCHROME® starter into tank to required level.
5. Heat bath to 140 deg F with a stainless steel or titanium heater plus thermostat.
6. Plate a cleaned dummy part (scrap metal as big as you can find that will fit in the tank) at 5V DC for 5-15 mins.
7. Remove dummy and add REPROCHROME® brightener at the rate of 3ml per 1000ml (0.40 fl oz per 1 Gal) – no point using your brightener on the dummy part.
8. Install part to be plated.
9. Plate at 0.07 amps per square inch of part surface area at approx 5 volts.
10. Plate for 1-2 minutes

Some shadowing and discoloration is normal in a brand new bath. Plate dummy parts until an even color is achieved. This might also occur if bath is not used for periods of time.

Solution pH is 9.9-10.2. Read pH at 140F with pump agitation.

### Troubleshooting:

<b>Problem</b>	<b>Solution</b>
<b>No plating in low areas or patchy plating</b>	Add REPROCHROME® Starter to replenish. Increase current.
<b>Dark Deposit</b>	Add REPROCHROME® Starter or adjust pH
<b>Light Deposit</b>	Increase temperature and/or current
<b>Milky Solution with plating defects</b>	pH out of range or replenisher additions too large. Add water or replace solution.

Theoretical bath life is 50 sq ft per 1 gallon of REPROCHROME® bath.