

CASWELL

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STAINLESS STEEL ACTIVATOR FOR GOLD

1. Fill a one quart or 1000 ml beaker nearly full with Activator-SS.
2. Check solution temperature to assure it is between 80-100 degrees Fahrenheit.
3. Check connections from power supply to anode and work to be sure the negative (-) and positive (+) wires are connected properly.
 - The work should be charged negative (-), and the anode positive (+).
 - Use a Stainless Steel Anode
4. Turn rectifier on.
5. Activate at 6-8 volts for 45-60 seconds depending on size of part. Part should be completely clean prior to further plating.
6. Larger parts require slightly higher voltage, while smaller parts require lower voltage. If part shows any burning such as dark or gray deposits around the edges, you are burning the part and must lower the voltage. If part is not cleaning after two minutes, voltage is too low, therefore, increase voltage slightly.
7. After Activating, rinse part thoroughly in water and continue the plating process with Fastgold brush plating or Caswell Tank Plating Gold at 140 degrees Fahrenheit. Plate 15-30 seconds longer than normal.
8. If you are not going to continue the plating process immediately, then dry the part thoroughly. When you continue the plating process, re-activate the part in Activator~SS to assure better adhesion.
9. Change solution when Activator-55 becomes inactive, reaches a pH higher than 2, or noticeably dirty.

Discard & Replace:

Activator-SSTM is a rugged solution and is designed to help assure long life. .
If, however, a problem should arise that cannot be solved by any of the above recommendations, or recommendations by us, the bath may need to be replaced: Transfer to a D.O. T. approved container.