

Typical Zinc Die cast EN Plating Cycles

Chemical Milling and De-smutting

1. Soak Clean, **Technic TSC-1508**¹, 8 oz/gal, 150⁰ F, 2 – 4 minutes.
2. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
3. Anodic Electro-clean, **Techni TEC-1016**², 4% v/v, 150⁰ F, 3 – 4 volts DC, 30 – 60 seconds.
4. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
5. Chemical Mill, **Technic's Zamak Concentrate**, full strength, 75⁰ F, 3 min.
6. Warm Water Rinse, Warm Water Rinse, 90⁰ F, 2 – 4 minutes.
7. Die Cast Conditioner, **Technic's Die cast Cond.-LC**, 22% v/v, plus 1 oz/gal NaCN, 75⁰ F, 1 minute.
8. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
9. Cyanide Copper Strike, **Techni Copper C**, 130⁰ F, 15 – 25 ASF, 30 – 120 seconds.
10. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
11. Acid Activate, **Technic TAS-4**, 4 – 8 oz/gal, 80⁰ F, 1 – 2 minutes
12. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
13. Electroless Nickel Plate, **Techni EN 2600/3500/5700**, 190⁰ F, pH 5.1, to spec.
14. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
15. Hot DI Water Rinse, 140⁰ F, 2 – 4 minutes.
16. Dry.

Notes:

¹ Techni TSC-1501, 2% v/v, 160⁰ F, 3 minutes may be used as substitutes.

² Techni TEC-1002, Techni TEC-1005 may be used as substitutes.

Typical Zinc Die cast EN Plating Cycles

General Plating of Zinc Die casts

1. Soak Clean, **Technic TSC-1508**¹, 8 oz/gal, 150⁰ F, 2 – 4 minutes.
2. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
3. Anodic Electro-clean, **Techni TEC-1016**², 4% v/v, 150⁰ F, 3 – 4 volts DC, 30 – 60 seconds.
4. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
5. Acid Deoxidize, **Technic TAS-3Z**, 12 oz/gal, 80⁰ F, 20 seconds.
6. Warm Water Rinse, Warm Water Rinse, 90⁰ F, 2 – 4 minutes.
7. Die Cast Conditioner, **Technic's Die cast Cond.-LC**, 22% v/v, plus 1 oz/gal NaCN, 75⁰ F, 1 minute.
8. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
9. Cyanide Copper Strike, **Techni Copper C**, 130⁰ F, 15 – 25 ASF, 30 – 120 seconds.
10. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
11. Acid Activate, **Technic TAS-4**, 4 – 8 oz/gal, 80⁰ F, 1 – 2 minutes
12. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
13. Electroless Nickel Plate, **Techni EN 2600/3500/5700**, 190⁰ F, pH 5.1, to spec.
14. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
15. Hot DI Water Rinse, 140⁰ F, 2 – 4 minutes.
16. Dry.

Notes:

¹ Techni TSC-1501, 2% v/v, 160⁰ F, 3 minutes may be used as substitutes.

² Techni TEC-1002, Techni TEC-1005 may be used as substitutes.