

Typical Copper, Brass or Bronze Alloy EN Plating Cycles

Copper, Brass or Bronze (Unleaded) for Normal Service

1. Soak Clean, **Technic TSC-1501**¹, 8 oz/gal, 160⁰ F, 3 – 5 minutes.
2. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
3. Acid Activate, **Technic TAS-1**, ¾ lb/gal, 100⁰ F, 30 – 60 seconds.
4. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
5. Nickel Strike, Woods Nickel Strike, 80⁰ F, 20 – 50 ASF, 30 – 120 seconds.
6. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
7. Electroless Nickel Plate, **Techni EN 2600/3500/5700**, 190⁰ F, pH 5.1, to spec.
8. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
9. Hot DI Water Rinse, 140⁰ F, 2 – 4 minutes.
10. Dry.

Copper, Brass or Bronze (Unleaded) for High Luster Appearance

1. Soak Clean, **Technic TSC-1501**¹, 8 oz/gal, 160⁰ F, 3 – 5 minutes.
2. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
3. Acid Activate, **Technic TAS-1**, ¾ lb/gal, 100⁰ F, 30 – 60 seconds.
4. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
5. Bright Dip (Generic Type), 80⁰ F, 30 seconds
6. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
7. Nickel Strike, Woods Nickel Strike, 80⁰ F, 20 – 50 ASF, 30 – 120 seconds.
8. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
9. Electroless Nickel Plate, **Techni EN 2600/3500/5700**, 190⁰ F, pH 5.1, to spec.
10. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
11. Hot DI Water Rinse, 140⁰ F, 2 – 4 minutes.
12. Dry.

¹ Techni TSC-1509 or Techni TSC-1501 may be used as substitutes.

Brass or Bronze, Containing more than ½% Lead

1. Soak Clean, **Technic TSC-1501**¹, 8 oz/gal, 160⁰ F, 3 – 5 minutes.
2. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
3. Acid Activate, Fluoboric Acid, 10% v/v, 80⁰ F, 30 – 60 seconds.
4. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
5. Nickel Strike, Woods Nickel Strike, 80⁰ F, 20 – 50 ASF, 30 – 120 seconds.
6. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
7. Electroless Nickel Plate, **Techni EN 2600/3500/5700**, 190⁰ F, pH 5.1, to spec.
8. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
9. Hot DI Water Rinse, 140⁰ F, 2 – 4 minutes.
10. Dry.

Beryllium Copper

1. Soak Clean, **Technic TSC-1501**¹, 8 oz/gal, 160⁰ F, 3 – 5 minutes.
2. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
3. Acid Activate, **Technic TAS-3Z**, 2 lbs/gal, 75⁰ F, 2 minutes.
4. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
5. Nickel Strike, Woods Nickel Strike, 80⁰ F, 20 – 50 ASF, 30 – 120 seconds.
6. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
7. Electroless Nickel Plate, **Techni EN 2600/3500/5700**, 190⁰ F, pH 5.1, to spec.
8. Cold Water Rinse, Cold Water Rinse, 80⁰ F, 2 – 4 minutes.
9. Hot DI Water Rinse, 140⁰ F, 2 – 4 minutes.
10. Dry.

¹ Techni TSC-1509 or Techni TSC-1508L may be used as substitutes.