



Product Code	307-207.R
Color	Transparent
Preparation	Ready-to-use
Tank Material	Polypropylene or Glass
Anot	Platinum-Plated Titanium or MMO
Heater	Porcelain
Agitation	Gentle solution and rack movement

USAGE: Heat the ready-to-use solution to **50°C (122°F)**. Immerse a **platinum-plated titanium (+) anode** into the solution. Suspend the workpiece to be coated using a conductive **(-) rack (Platinex rack recommended)** and immerse it in the bath. Apply **1 Volt** and move the workpiece gently for **5 minutes** during the coating process.

IMPORTANT NOTE: Nano lacquer platings form an ultra-thin protective film of approximately **0.1 micron** on silver and gold surfaces. This film is absorbed onto the metal surface, providing long-lasting protection against oxidation and discoloration.



WORKING CONDITIONS

Temperature:	50°C
Voltage:	1 Volt
Plating Time:	5 Minutes



BATH MAINTENANCE

Requirements for Bath Maintenance

It is recommended to replace the bath solution after every **5–6 kg of coated products** or at least every **6 months**, depending on usage.



BATH EQUIPMENT

1. TANKS

The tank should be made of polypropylene or glass. Polypropylene tanks must withstand temperatures up to **70°C**. Before use, the tank should be conditioned by filling it with a **5% sodium hydroxide solution at 60°C** and leaving it for **24 hours**. Afterwards, rinse thoroughly **3–4 times with deionized water**.

2. HEATERS

The heating element should be made of porcelain or stainless steel and equipped with a thermostat to control bath temperature. The operating temperature of the bath should be maintained at **50°C**.

3. FILTRATION

The solution should be continuously filtered. All filtration system components must be manufactured from alkali-resistant materials capable of withstanding temperatures of **60–70°C**.

Filter cartridges should be washed with **2% sodium hydroxide solution** before use.

The entire bath volume should be filtered at least **twice per hour**, and the filtration system should retain particles of **10 microns or smaller**.

4. AGITATION

Mechanical agitation is required. The solution should be continuously agitated during the Nano Lacquer process.

5. ANODES

Use a **Platinum-Coated Titanium Anode** or **MMO Anode**.



PROCESS SEQUENCE

NOTE: Parts to be lacquer-coated should be processed in the following order:

1-Ultrasonic Cleaning, 60–70°C, 1–2 min

2-Cold Rinse, 1 min

3-Electrocleaning (Degreasing), 50°C, 6V, 1–2 min

4- Cold Rinse



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Instructions for Use

- 5- Acid Dip, 30°C, 30 sec
- 6- Cold Rinse
- 7- Rinse with Cold Deionized Water, 1 min
- 8- Silver or Gold Plating
- 9- Cold Rinse
- 10- Acid Dip, 30°C, 30 sec
- 11- Cold Rinse
- 12- Rinse with Cold Deionized Water
- 13- Nano Lacquer Plating, 50°C, 5 min, 1V
- 14- Dragout
- 15- Cold Rinse
- 16- Rinse with Deionized Water
- 17- Hot Air Drying, 50°C, 10 min