

ITALFIMET	Technical specification for galvanic plating	Specification Number: 1000989 Date: 03/07/2020 State: Definitive Release: 0 Compiled by: Consulting Department Mail adress: consulting@italfimet.it
DEA		
Division: LEATHER	Name: RUTHENIUM MAT	Code: N.A.
Process in compliance with REACH and Proposal 65		
Base material	BRASS/ZAMAK	
Galvanic	STATIC/ROTOBARREL	
Process	NICKEL FREE	

NOTE: It may be cases that some articles has special application, can't be treated respecting this technical specification. These situations must be evaluatend each time. The galvanic process can be start only if the base material is free from defects about molding, roughing and polishing. This galavanic process must satisfy the technical performance established by the Brand.

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<h2>Preparation</h2>	The metallic accessories must be arrive to the galvanic industry without defects. Flat accessories will be prepeare with shiny mechanical polishing, the others will be treat in vibrators with ceramic materials and liquid soap to polish the surface.		
<h2>Galvanic</h2>	PROCESS	STATIC	ROTOBARREL*
	1° NPT.: Alkaline Copper RAMAL ITALFIMET (for zamak and brass if necessary)	8 - 10 µm	3 - 4 µm
	2° NPT.: Acid Copper CUPPER 350 ITALFIMET	8 - 10 µm	2 - 3 µm
	3° NPT.: Mat Copper CUPPER SATIN ITALFIMET	UNTIL MASTER	
	4° NPT: Vibrate process (see the specific section)	N.A.	N.A.
	5° NPT: White Bronze BRINOX 6,1 ITALFIMET	2 - 3 µm	2 - 3 µm
	6° NPT: N.A.		
	1° PT: PALLADIUM ITALFIMET P4600 0,40 µm		
	2° PT: RUTHENIUM RUTENET 10-05 ITALFIMET 0,05 µm		
	3° PT: RUTHENIUM RUTENIO 5011 ULTRA BLACK ITALFIMET 0,05 µm		
	4° PT: N.A.		
	5° PT: N.A.		
<h2>Finishing process</h2>	Satin: N.A.		
	Vibrate: Vibrate process VIB.09G until master		
	Finishing: Sawdust V20/01 and clean sawdust V20		
<h2>Varnish</h2>	N.A.		

***OR ITEMS TREATED IN STATIC PROCESS WITH MECHANICAL APPLICATION**

<h2>Range of color</h2>	L= 54 - 56 ; a= < 3 ; b= < 3 This range of colour it must be respect on shiny tickness of Rutenio 5011 Ultra Black
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NPT = Not Precious Tickness - PT= Precious Tickness - N.A.= Not Applicable

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<h2>NOTE</h2>	<ol style="list-style-type: none"> 1. The precious metal thicknesses are always medium in the surface. 2. It may be cases that some articles has special application, can't be treated respecting this technical specification. These situations must be evaluatend each time with DEA 3. N.A. 4. N.A.
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<h2>QC Process</h2>	<ol style="list-style-type: none"> 1. Adhesion test (UNI ISO 4524-5 1988 on galvanic thickness or UNI ISO 2409:2013 on varnish) on each production lot 2. Bending test (EN ISO 4524-5-5) on each production lot when it's required 3. N.A.
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<h2>Release</h2>	Release 0 03/07/2020: New specification Release 1 : Release 2 : Release 3 :
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