

ITALFIMET	Technical specification for galvanic plating	Specification Number: 1000988 Date: 03/07/2020 State: Definitive Release: 0 Compiled by: Consulting Department Mail adress: consulting@italfimet.it
DEA		
Division: LEATHER	Name: RUTHENIUM	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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Preparation

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.

Galvanic

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.: White Bronze BRINDOX 6,1 ITALFIMET	2 - 3 µm	2 - 3 µm
4° NPT: N.A.		
5° NPT: N.A.		
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.		

Finishing process

Satin: N.A.
 Vibrate: N.A.
 Finishing: N.A.

Varnish

N.A.

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

Range of color

L= 54 - 56 ; a= < 3 ; b= < 3

NPT = Not Precious Tickness - PT= Precious Tickness - N.A.= Not Applicable

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NOTE	<p>1. The precious metal thicknesses are always medium in the surface.</p> <p>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</p> <p>3. N.A.</p> <p>4. N.A.</p>
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QC Process	<p>1. Adhesion test (UNI ISO 4524-5 1988 on galvanic thickness or UNI ISO 2409:2013 on varnish) on each production lot</p> <p>2. Bending test (EN ISO 4524-5-5) on each production lot when it's required</p> <p>3. N.A.</p> <p> </p> <p> </p> <p> </p> <p> </p> <p> </p> <p> </p>
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Release	<p>Release 0 03/07/2020: New specification</p> <p>Release 1 :</p> <p>Release 2 :</p> <p>Release 3 :</p>
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