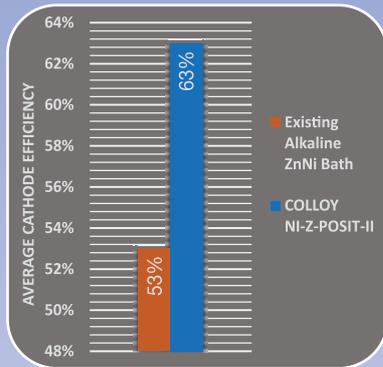


COLLOY[®] NI-Z POSIT-II

Process For Alkaline Zinc-Nickel Plating
Provides Benefits You Can't Afford To Ignore



Increased Plating Speed

Upto 10% increased cathode efficiency. Increased plating speeds drive throughput and reduces related energy expense.

Excellent Ductility

Deposits contain 12-15% Ni content and can still withstand bending or crimping operations post-plating without cracks.



Mandrel Bend Test



Brightness without Deposit Stress

Produces a Bright deposit without adding deposit stress, reducing blistering and improving final passivation appearance.

Scan for Interactive
OEM Approvals Table:



Columbia Chemical has been granted Zinc-Nickel chemistry approvals from several OEM's including GM for fasteners per GMW Type B Code G Clear, GMW Type B Code G Black, and GMW 16730



**Consolidated
Metal Finishing
Private Limited**

104 (NP), Industrial Estate, Ambattur, Chennai - 600 098. T.N. India.

Phone: +91 44 2625 3976 / +91 86 8087 0614

Email: info@cmf-india.com | Web: www.cmf-india.com

In association with

COLUMBIA[®]



CHEMICAL

Simplifying Surface Finishing[®]

www.columbiachemical.com

FEATURES AND BENEFITS

CONSOL - COLLOY NI-Z POSIT- II

ZINC/NICKEL ALLOY PLATING PROCESS FROM AN ALKALINE CYANIDE-FREE BATH

Brought to India in association with Columbia Chemical Corpn.,-U.S.A., World leaders in Zinc Plating Technologies.

- ◆ Developed to provide a Deep Bright deposit containing 12-15% nickel in the deposit.
- ◆ Process has a wide operating window, with zinc concentration of 6 - 11.25 g/L.
- ◆ Process does not require separate rectifiers or anodes for replenishment of Nickel in the plating solution.
- ◆ The deposition is speedy, has superior chromate acceptability and is well suited for both Rack & Barrel plating process.
- ◆ Unique Process that can be operated with either NaOH or KOH which helps to increase efficiency.
- ◆ Alloy deposits produced have increased levels of hardness and high temperature resistance, giving superior corrosion protection.

OPERATING PARAMETERS

	Range	Optimum
Zinc Metal	6 – 11.25 g/L	7.5 g/L
Caustic Soda	75 - 135 g/L	112 g/L
Nickel Metal	1200 - 1800 ppm	1500 ppm
Operating Temp	21° - 34°C	26°C
CONSOL - Colloy NI-Z-POSIT-II MAKEUP 510*	8% - 12% by volume	10% by volume
CONSOL - Colloy NI-Z-POSIT-II REPLENISHER 520*	0.9% - 1.4% by volume	1.2% by volume
CONSOL - Colloy NI-Z-POSIT-II BRIGHTENER 531	0.2% - 0.4% by volume	0.25% by volume
CONSOL - Colloy NI-Z-POSIT-II BOOSTER 541	0.05% - 0.4% by volume	0.10% by volume
Filtration	Continuous	2 - 4 tank turn-overs/Hr
Agitation	Mechanical	Barrel: 4-6 RPM
Cathode Current Density	Barrel: 5 - 10 ASF (0.5 - 1.0 ASD) Rack: 10 - 30 ASF (1.0 - 3.0 ASD)	

***Note: The CONSOL NI-Z-POSIT-II REPLENISHER 520 must be mixed with the CONSOL NI-Z-POSIT-II MAKEUP 510 prior to adding to the tank. Make a pre-mix solution containing 1 part CONSOL NI-Z-POSIT- II MAKEUP 510 and 1 part CONSOL NI-Z-POSIT-II REPLENISHER 520. Mix well. Use this solution to add back to the plating tank when Nickel needs to be replenished. After the pre-mix is made a 0.16% v/v add-back to the plating tank will replenish approximately 100 ppm Ni to the plating solution.**

Attention: This sheet is only meant to provide Features and Benefits of the process mentioned. For detailed Usage, Please refer the product Technical Data Sheet. For Safety, handling and Chemical information please refer the Safety Data Sheet. These can be provided through a Consolidated Metal Finishing Pvt. Ltd. representatives or requesting us for the same by email.