

NATIONAL RADIO ASTRONOMY OBSERVATORY  
Charlottesville, Virginia

## NRAO CHEMICAL LAB REPORT NO. 9

TITLE: Chemical Lab Procedures, 1990

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### I. METAL CLEANING AND PREPARATION

Generally speaking, oils, greases, abrasives, oxide films, metal chips and the like need to be removed before a piece can be plated. For most work we ultrasound clean using an alkaline soap mixture, pH 11.35, (125 g.  $\text{Na}_2\text{CO}_3 \cdot \text{H}_2\text{O}$  plus 50 g. sodium lauryl sulfate per gallon). Then, a mixture of 2-1/2% Olin's Polytergent B-300, 2-1/2% sulfamic acid, 22% butyl cellosolve, and 10% acetic acid, in water, pH 1.85 max., (hereafter called general metal cleaner) is used.<sup>1</sup>

Thus COPPER, BRASS, TELLURIUM COPPER, BERYLLIUM COPPER, PHOSPHOR BRONZE, MILD STEEL and SILVER, with or without SOLDER<sup>2</sup> or BRAZING, are cleaned using this procedure.

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<sup>1</sup> If bath that piece is to be immersed in is alkaline in pH, a quick dip in alkaline soap mixture is performed and a final water rinse before plating to avoid surface pH incompatibility.

<sup>2</sup>Solder darkens, presenting a bad appearance, but is ideally suited for ensuing plating.

Copper electroforms wherein some of the copper but not all has been grown should, if removed from the electroforming bath for processing, be anodically electro-cleaned, producing vigorous bubbling, in phosphoric acid without rinsing afterwards. Reentering with adherent phosphoric acid prevents lamination of the copper otherwise produced.

ALUMINUM MANDRELS used in electroforming are cleaned in a different way to be considered in the section on electroforming.

## II. BATH FORMULATIONS, MAINTENANCE, QUANTITATIVE ANALYSIS, AND OPERATIONAL PARAMETERS

### Sel-Rex CuBath #1 Acid Copper Sulfate Electroforming Bath

Discussion: This is a self-leveling, proprietary copper sulfate-sulfuric acid electroforming/electroplating bath with brighteners, levelers, etc. called "hy", "lo", and "D." The anodes used are phosphorized copper, the pH is in the vicinity of 0.45, agitation is vigorous, filtration is by a pump with a polyester wound cartridge, operational temperature is room temperature. Currently at NRAO, two of these baths are used containing about 55 gallons each, using four, triple-bagged, 18" long hexagonal cross-section anodes of one square foot surface area. These baths are housed in 24" x 24" x 24" PVC-lined steel cubical tanks, as in Figure 1. Note: Nylon should not be used in connection with these baths, as it is attacked by the bath, producing an oily scum.

Deviations from Sel-Rex specifications have been adopted<sup>3</sup> to suit the baths better to NRAO electroforming requirements. Typical Sel-Rex specifications are as follows:

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<sup>3</sup> Except for the internal plating of small stainless steel waveguides which calls for the Sel-Rex Cubath #1 to be used according to the manufacturer's specs.

NOTE: Filter-Pump  
Not Illustrated

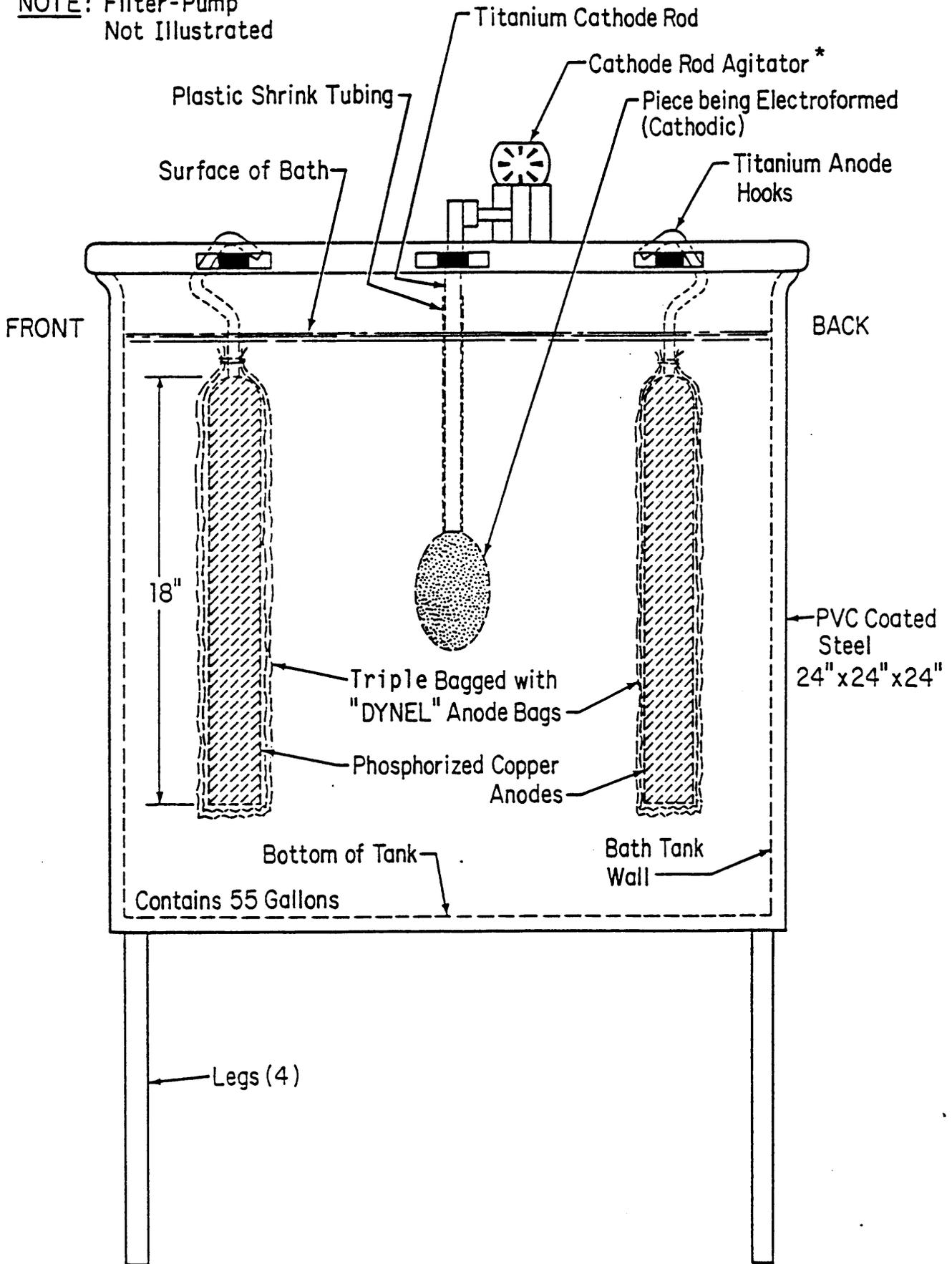


Fig. 1. Large cubath #1 acid-copper-sulfate electroforming bath.

\*Motor is brushless: Dayton shaded-pole gear motor, Model 3M137B.

CuSO<sub>4</sub> ----- 9 ounces/gallon optimum  
H<sub>2</sub>SO<sub>4</sub> ----- 23 ounces/gallon optimum  
chloride ----- 30 milligrams/liter optimum  
copper as metal ----- 2-1/4 ounces/gallon optimum  
sulfuric acid to copper metal ratio ----- about 7/1

Adopted NRAO specifications are as follows:

CuSO<sub>4</sub> ----- 16.4 ounces/gallon  
H<sub>2</sub>SO<sub>4</sub> ----- 18.0 ounces/gallon  
chloride ----- 30 milligrams/liter  
sulfuric acid to copper metal ratio ----- about 4-1/2 to 1

Maintenance of Cubath #1: Hull cell tests are performed to determine changes necessary in brightener levels, chloride ion level (adjusted by adding very small amounts of hydrochloric acid), sulfuric acid (usually unnecessary), phosphoric acid (aids in smoothing deposit and improves performance of bath), copper sulfate, and agitation. Usually small additions of H<sub>3</sub>PO<sub>4</sub> and "hy" are called for, about 1:1 by volume. The 267 ml. Hull cell is used, at 2 amps per panel for 5 minute intervals, on highly polished, commercially-available<sup>4</sup> brass panels using a corrugated copper anode.

Occasionally major adjustments or checks are necessary in order to keep the cubath operating at its best. Then quantitative analysis by wet-test methods is used. The following procedures apply to determine copper-metal concentration, sulfuric acid concentration, and - very rarely - chloride-ion concentration:

1. COPPER METAL CONCENTRATION: Carefully pipette a 5.0 ml. sample of the bath into a 500 ml. Erlenmeyer flask and add 100 mls. distilled water. Add ammonium

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<sup>4</sup>McGean-Rohco, 2910 Harvard Ave., Cleveland, OH 44109.

hydroxide (approximately 2-5 mls.) until solution turns a deep blue. Gently boil until the deep color disappears, using a few boil-ezers, since foaming tends to be vigorous. Add glacial acetic acid until the solution turns acid (5-10 mls., as determined by pH paper test of vapor boiling off). Add 2 mls. more glacial acetic acid. Boil an additional 2 minutes, then cool and add 4 grams potassium iodide (amount not critical as it is used as an indicator). Titrate with 0.1 N sodium thiosulfate solution until the solution turns a pale yellow color. Add 2 mls. starch solution (not critical) and titrate to a white endpoint. The ounces per gallon of copper equals 0.17 times the number of mls. of thiosulfate.

2. SULFURIC ACID CONCENTRATION: Carefully pipette a 10.0 ml. sample of the bath into a 500 ml. Erlenmeyer and add 150 mls. distilled water. Titrate with a 1.0 N sodium hydroxide solution with rapid mechanical stirring until the first faint sign of a permanent turbidity appears. The ounces-per-gallon of sulfuric acid equals 0.426 times the number of mls. of sodium hydroxide solution.

3. CHLORIDE ION CONCENTRATION<sup>5</sup>: (gravimetric determination) Pipette accurately a 100 ml. sample of the bath into a 250 ml. beaker. Add 10 mls. nitric acid and 5 mls. 10% silver nitrate. Boil and stir until the silver chloride is coagulated. Carefully filter through a fine sintered-glass weighing crucible, and thoroughly dry at about 120°C for two hours. Cool and determine the weight by subtracting the tare weight. Mg/L Cl equals wt. AgCl times 0.2474 times 4000.

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<sup>5</sup>This test is only necessary if obvious anode polarization is taking place, resulting in no current flow. Generally, chloride is provided by replacing evaporated water with tap, not distilled water. Excessive chloride ion deactivates the anodes, sending current flow to zero and voltage reading to maximum on power supply.

### Modified ASTM Rochelle Copper Cyanide Flash Bath

Composition and Formulation: 8 liters distilled water  
add 1194 grams potassium cyanide  
slowly with stirring add 756 grams CuCN  
add 1080 grams Rochelle Salts (Na-K Tartrate)  
add water to make 18 liters  
adjust free cyanide to 0.50 ounces/gallon  
(NaCN raises, CuCN lowers)  
adjust pH to 9.5-10.0 with NaHCO<sub>3</sub>

Operational Parameters: This depends upon the particular use to which the bath is going to be put. For flashing zincated aluminum, individual current densities and times depend upon the aluminum's geometrical configurations, but the norm is 24 ASF for 45 seconds or more where appropriate and "burning" of sharp projections is not a factor, requiring a lower current or a shorter time period. If current, on the other hand, is too low, adhesion suffers, producing blistering that may not be noticed until the piece is then put in a warmer bath. Unequal thermal expansions produce this effect. For thin coatings over silver, brass, etc., a lower current density may be used.

Other operational parameters remain constant, regardless of the use to which the bath is put. These are as follows:

Temperature: room temperature (40°C if critical)  
Agitation: magnetic stirring  
Filtration: wound polyester cartridge  
Anodes: 6 (9" x 0.5" diameter) OFHC anodes evenly spaced around inside perimeter of glass beaker

### Quantitative Analysis:

1. Free Cyanide: Pipette a 10.0 ml. sample into a 250 ml. Erlenmeyer flask. Add 90 mls. distilled water, also 5 mls. 10% KI solution. Titrate with 0.10 N  $\text{AgNO}_3$  solution until a faint yellow turbidity persists. NaCN in ounces/gallon equals 0.131 times number of mls. silver nitrate solution. Normal bath color is a pale, straw yellow. If the bath persists in a blue color, then the free cyanide is about zero. Adjust it!

2. Rochelle Salts: This test is not usually required as it is more practical to decompose and dispose of the bath than to use the time testing and adjusting Rochelle Salts. However, if desired, there is a satisfactory procedure in *Metal Finishing Guidebook and Directory*.

3. Carbonates: The same as is the case with Rochelle Salts. It should be noted that carbonate comes from electrolytic oxidation of cyanide. Carbonate concentration has a lot to do with plate quality. If plate quality becomes poor and pH adjustment or free cyanide adjustment doesn't improve matters much, it is likely the case that carbonate contamination has ruined the bath. Freezing out the carbonates, perhaps using liquid nitrogen, and then removal may restore the bath.

### Sel-Rex BDT 200 Sulfite Gold Plating Bath

Discussion: This is an excellent gold plating bath, much superior for most purposes in the electronics field (excepting wire-bonding use or whisker posts and related applications which tend to suffer from galling) to the cyanide gold baths. It can also be a very annoying bath if not properly understood and carefully maintained! It is self-levelling and produces a very bright, pure, amorphous, yellow gold (99.9%) plate of moderate hardness (knoop hardness 130 to 190). It should be noted that due to the bath's alkalinity, glass is gradually dissolved. Because of this and gradual contamination, the bath should be totally replaced every couple of

years. Please note that the fresh bath is water white. Bath brightener contains compound arsenic.

Some of the problems that can arise: peeling and blistering<sup>6</sup> of gold off base metal, patches of black, pink appearance on high current areas, organic cellophane-like pieces floating in bath, etc. Below is a trouble-shooting chart to demonstrate what to do to treat a symptom and what causes the symptom:

<u>PROBLEM</u>	<u>PROBABLE CAUSE</u>	<u>PROBABLE SOLUTION</u>
peeling or blistering of gold	lack of compatibility with underlying layer; or immersion layer formed before current flow commenced	plate a layer of metal in between from a bath that is compatible with both; enter bath electrically hot
patches of black	incomplete cleaning or too low a pH	adjust pH to 9.5 to 10.0 and/or clean part a little better
pink appearance on high current areas	gold level in bath is too low or current is too high or insufficient brightener	recalculate current. If current is okay, analyze gold content and make necessary additions.
lint and particles	gradual buildup with time	filter bath using pleated papers or, if vacuum filtering, using

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<sup>6</sup>When attempting to use BDT-200 over a layer of copper from the CuBath solutions, blistering may result, perhaps caused by surface brighteners, pH effects and/or physical surface effects. Use an intermediate layer of Pur-A-Gold 125.

		glass fiber filter disc.
cellophane-like pieces floating in bath	probably electrolytic oxidation-reduction reaction of organics in bath and/or salt buildup; dissolved glass reprecipitating	filter bath, probably need to use up gold and then replace bath.
generally poorer than normal performance	check Baume level -- may be too high	use up gold or reclaim gold, then purchase new bath.
yellow color of bath	pH too low or copper contamination	adjust bath w. 20% NaOH. If contaminated, reclaim gold and replace bath.
gassing or brown powdery deposits	current is too high	reduce current.

Operational Parameters: See the chart below. The temperature recommended by the Sel-Rex people is 35-55°C. We use 40°.

Gold content-----0.7 to 2.0 recommended oz./gal. If less than 0.5, problems begin to manifest themselves, e.g., pink in high current area.

pH-----9.5 (adjust up w. 20% NaOH, down ONLY IF ABSOLUTELY NECESSARY w. 5% H<sub>2</sub>SO<sub>4</sub> very carefully, as gold tends to precipitate out due to some sulfite-forming sulfurous acid, which reduces some gold ions to the metallic state.

Filtration-----batch vacuum filtered through glass-fiber filter.

Specific gravity----8°-35° Baume (preferably lower end).

Anode-----Platinized Niobium.

Current density-----3 ASF, straight DC, entering bath electrically "hot"  
using voltage regulation according to Figure 2.

Plating rate-----0.0001" in 14 minutes @ 3 ASF or 1 troy ounce Au in  
250 amp minutes.

Quantitative Analysis of BDT 200 Bath: This consists of a gold metal determination, modifying the procedure used for gold metal determination of a cyanide-gold bath.

The modified procedure is as follows:

1. Accurately pipette 10.0 mls. gold bath into a 500 ml. Erlenmeyer. In a hood, add 15 mls. conc. HCl, and evaporate with stirring to a syrup (DON'T ALLOW TO BOIL DRY). Since some sulfurous acid is generated, some of the gold will come out as finely divided metal. Add 5 mls. HNO<sub>3</sub> to the syrup and 15 mls. HCl. Boil to a syrup again. Add another 15 mls. HCl, boil to a syrup again. Repeat one more time. This drives off nitrogenous compounds. Add 150 mls. distilled to final syrup. Add 25 mls. of 20% KI and 2 mls. 1% starch indicator solution. Titrate w. 0.01 N sodium thiosulfate to colorless endpoint, using good lab procedure. Record number of milliliters thiosulfate used.

2. Now, to standardize the thiosulfate solution used, weigh out 0.0500 grams fine gold wire. Dissolve in minimum aqua regia necessary, then go through a boiling down and three HCl additions with boiling down, as above. Titrate and record this number. Then, the gold in the bath can be calculated thusly:

troy oz. Au/gallon of bath =

(0.608/mls. thiosulfate for 0.0500 g. Au) x mls. for sample

CHARACTERISTICS BDT -200 GOLD BATH CURRENT VS VOLTAGE  
 DC 3 ASF, 40°C, BAUME 30, pH 9.5, ~2 OZ AU/CAL

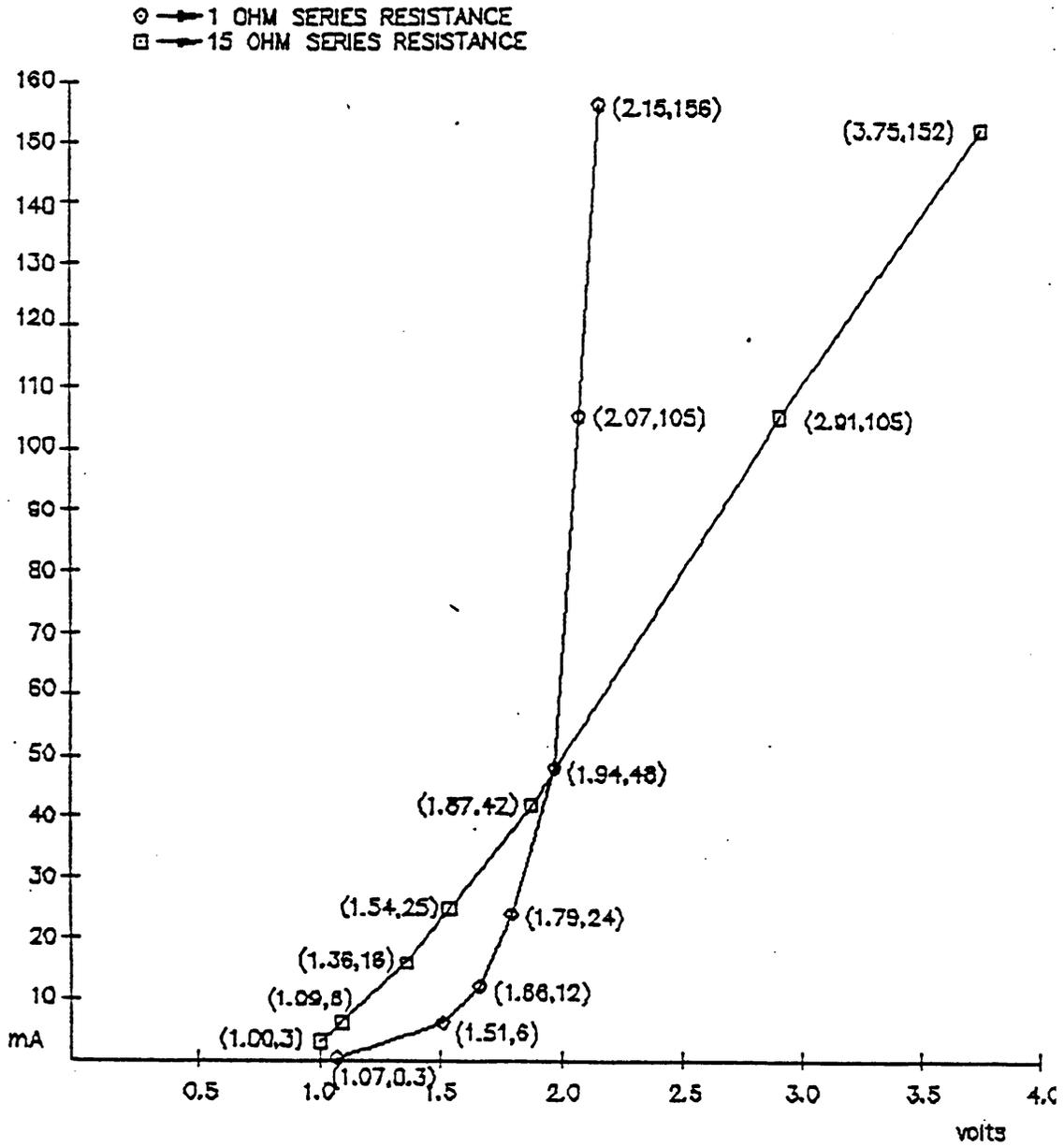


Fig. 2

For example, if titration of bath took 48 mls. thiosulfate and standardizing took 37 mls. for the 0.0500 grams wire, then

$$\text{tr. oz./gal. Au} = (0.608/37) \times 48 = 0.79$$

Pur-A-Gold 125 Cyanide Gold Plating Bath

Discussion: This is a very soft (Knoop 50-80) high purity (99.99%) gold bath producing crystalline deposits suitable for wirebonding and in the manufacture of coil stock (which undergoes considerable twisting and flexing). It is NOT self-levelling and is not as suitable as the BDT-200 bath for most purposes. It is, however, a somewhat "forgiving" bath as far as part cleanness goes.

It has a phosphate-citrate base and, hence, pH can be adjusted as for the Aurobond TC bath.

Operational Parameters:

Gold content-----0.7 - 2.0 troy oz./gal.  
pH-----5.75 (Na<sub>3</sub>PO<sub>4</sub> ↑, citric acid ↓)  
Temperature-----60°C (important for best results)  
Anode-----platinized niobium  
Current density-----3 ASF<sup>7</sup> straight DC  
Plating rate-----50 microinches/6 minutes

NRAO Bright Nickel Bath

Composition:

999 g. NiSO<sub>4</sub>·6H<sub>2</sub>O  
120 g. H<sub>3</sub>BO<sub>3</sub>  
28 g. sodium paraphenolsulfonate

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<sup>7</sup> When plating thick layers where edge buildup is a problem, reduce current density slightly.

132 mls. 40% formaldehyde  
to 4 liters -- adjust pH to 4.0  
with H<sub>2</sub>SO<sub>4</sub> or NaHCO<sub>3</sub>

Use: Bright nickel is for corrosion resistance and physical appearance. It usually requires some gentle polishing with a cream and polishing rag. It can be plated right on copper or zincated aluminum. Caution must be used to insure that plating times aren't too long and current densities not too high. Parameters: 50°C, pH 4.0, 32-1/2 ASF, nickel anode, 7 minutes maximum, vigorous agitation and uniform exposure of surfaces approximating "conforming anode" (due to poor throwing power).

#### NRAO Electroless Copper Composition

##### Composition:

###### Part A (one) -

In one liter volumetric in 300 mls. water  
dissolve 13.3 g. copper lactate, then dissolve  
18 g. EDTA·2Na, bring to one liter

###### Part B (two) -

Per 100 mls. Part A,  
add, only upon using,  
2 grams paraformaldehyde  
flakes, then  
concentrated KOH  
solution and adjust pH  
to 12.5

Use: Quartz windows (washer-shaped) get their inner and outer surfaces plated with copper for soldering them into place as vacuum-tight windows for microwave radiation. For adhesion of the initial electroless copper (which is prerequisite to electrolytic copper deposition), the surface of the quartz must be roughened. This substrate (already roughened by manufacturer) is then pretreated as follows:

- 1) 5 minute soaking in activator consisting of 20 g. SnCl<sub>2</sub> in 500 mls. water adjusted by HCl or KOH to pH 1.25.
- 2) GENTLE water rinse.
- 3) 5 minute soaking in catalyst consisting of 1 g. PdCl<sub>2</sub>/500 mls. water adjusted to pH 4.0 with KOH (not NH<sub>4</sub>OH) or HCl.
- 4) GENTLE water rinse.

Then immerse the part(s) immediately in the freshly prepared electroless copper until it is pretty much "spent." Rinse thoroughly with water and proceed to next step.

#### Hard Anodizing Bath (for Aluminum)

Composition: This bath consists of 15% concentrated sulfuric acid by volume in distilled water.

Use: Keeping bath at 0°C sharp, reverse polarity (making the piece the anode) is used at 12-1/2 ASF. The piece is anodized when it has gone from an initial 25 volts to 50V (that is when piece is approaching nonconductivity). The piece when properly done will be a charcoal color.

#### Stainless Steel Activation Nickel

Composition:

8 oz./qt. NiCl<sub>2</sub>·6H<sub>2</sub>O

4 liq. oz./qt. HCl (conc.)

Use: Cleaned stainless is plated for three minutes @ 100 ASF at room temperature.

Please note that this bath has been largely discontinued in favor of other procedures.<sup>8</sup>

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<sup>8</sup> See Section VI, Miscellaneous Information, #7, at end of this paper for exception.

### Miscellaneous Baths for Possible Occasional Future Use

1. Electroless nickel:

Composition: 30 g.  $\text{NiCl}_2 \cdot 6\text{H}_2\text{O}$   
(per liter) 11.9 g. potassium citrate  
10.0 g. sodium hypophosphite

Use: Using same procedure as for electroless copper activating-catalyzing

pH 5.85

temperature 85°C sharp

growth rate estimated 0.2 mils/hr.

### III. GENERAL PLATING PROCEDURES

Most often, pieces which are received in the plating lab consist of the following metals: copper, leaded brass, phosphor-bronze, tellurium-copper, silver, beryllium-copper, oxygen-free-high-conductivity (OFHC) copper and extra-tough pitch (ETP) copper. These metals are generally plated in the same manner, using the same bath combinations. General plating procedure is as follows:

1. Ultra-sound clean in alkaline soap cleaner/water rinse
2. Ultra-sound clean in general metal cleaner/rinse
3. Copper cyanide strike 10 seconds @ 12 ASF (if not pure copper)/water rinse (this step eliminates corrosion of non-copper metals, e.g., zinc through pores in the gold electroplate). USE THIS STEP ONLY WHEN ESSENTIAL.
4. Gold plate to desired microinches (usually 75 minimum; however, less if dimensions are critical, or 100 or more if high durability or good heat properties required - 250 or more of cyanide gold for wirebonding)

5. Water-rinse, air-dry

#### IV. SPECIAL PLATING PROCEDURES (INCLUDES ELECTROFORMING)

A number of different, special plating procedures are called for. A number of these are listed below:

1. Copper plating stainless steel and Kovar
2. Preparation for electroforming on aluminum types 7075, 2024, and 6061
3. Nickel electroforming

These will be considered one at a time below:

1. Copper plating stainless steel: A significant improvement has been made in this particular area. Nascent hydrogen is plated onto the stainless steel piece using 30% H<sub>2</sub>SO<sub>4</sub>, a platinized-niobium anode and a current density of 125 ASF for four minutes. Then the steel is IMMEDIATELY immersed in Cubath #1 and plated. Five to ten minutes @ 30 ASF in the Cubath #1 is the prescribed treatment for preparing stainless steel for soldering (approximately 100 to 200 μinches).

2. Preparation for electroforming on aluminum types 7075, 2024, and 6061: Zincating solutions are currently used to prepare aluminum for copper plating. Here is the general procedure:

1. Immerse with swirling into an alkaline cleaning dip consisting of 44 grams Na<sub>2</sub>CO<sub>3</sub> + 44 grams Na<sub>3</sub>PO<sub>4</sub> per 1/2 gallon solution pH 11.9 for 6-15 minutes at room temperature. Should appear blue like steel.
2. Water rinse.
3. Amchem nitric deoxidizer #4<sup>9</sup> dip with swirling 10 seconds.

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<sup>9</sup> Amchem Nitric Deoxidizer #4 is manufactured by Amchem Products, Inc., Ambler, PA 19002.

4. Carefully and thoroughly water rinse.
5. Zincate, as will be described below under each specific aluminum type.
6. Quickly but thoroughly water rinse.
7. Copper cyanide flash<sup>10</sup>.
8. Acid-copper-sulfate plate 1-5 minutes @ 20 ASF
9. Water rinse.
10. Pur-A-Gold 125 one to two minutes.
11. BDT 200 plate (generally 300 to 500 microinches).
12. Water rinse.
13. Pur-A-Gold 125 again, as above.
14. Water rinse.
15. Electroform<sup>11</sup> in acid-sulfate-copper @ 10 to 20 ASF for first 24-48 hours, then up to 20-30 ASF thereafter, OR electroform in acid nickel sulfamate (Sel-Rex "Sulfamex" bath) @ 30 ASF -- other current densities only if compressive or tensile stress desirable.

The zincating solution and procedure are listed below:

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<sup>10</sup>We have the bath short-circuited with proper current on just prior to flashing for quick response time. Otherwise, the zincate layer partially deteriorates, resulting in blistering between aluminum and copper when the mandrel is placed in hot gold baths (differing thermal expansions).

<sup>11</sup> For some electroform geometries, cleavage planes and grooves are a serious problem. This usually can be handled by (1) machining a layer off after partial growth (smearing the cleavage line with copper in the process), (2) solder filleting using a solder pot (not a torch), copper cyanide striking and reentry into the Cubath, or (3) filleting with silver conductive epoxy. In the latter two cases, a copper cyanide flash is necessary before reentry into the Cubath.

Zincate Solution Composition

525 g. NaOH + 100 g. ZnO  
+ 10 g. Rochelle salts  
+ FeCl<sub>3</sub>·6H<sub>2</sub>O, 1 g. per  
liter solution.

Technique

Zincate only once for 5-10 seconds.  
Rinse quickly. Plate in cyanide  
copper @ 24 ASF seconds or more,  
depending on whether there are  
projections, deep recesses, etc.

3. Nickel Electroforming: Currently only one nickel electroforming bath is used - a Sel-Rex "Sufamex" acid sulfamate bath (with a small fraction of 1% sodium lauryl sulfate added). To quote the specs supplied, it "produces dull, pure, ductile, fine-grain, low-stress nickel deposits."

To the bath, as provided by the manufacturer, after dummied for 24 hours, is added 0.1 g/liter of sodium lauryl sulfate, to eliminate hydrogen pitting and increase bath efficiency.

Parameters for use are as follows:

Temperature-----50°C; varied if stresses and other property  
changes desired  
Current Density-----30 ASF; more or less if various stresses desirable  
Agitation-----very vigorous  
Filtration-----batch  
pH-----3.25 adjusted with sulfamic acid ↓ or nickel  
carbonate ↑. If nickel carbonate is needed, add to  
a portion of bath, making a slurry and then  
gradually add back to bath.  
Current-----Straight DC (at present)  
Addition Agents-----Sufamex Anode Activator

The electroforming is done after preparing the aluminum according to standard procedure involving alkaline cleaner, Amchem deoxidizer, copper striking, copper sulfate plating and gold plating. 10% sodium hydroxide is used to dissolve out the aluminum after electroforming and machining. The standard flash dissolver is then used, followed by gold plating.

## V. WASTE DISPOSAL

Proper waste disposal is best effected by turning wastes over to an approved waste-disposal company. NRAO uses the Special Materials Handling Facility at the University of Virginia.

## VI. MISCELLANEOUS INFORMATION

1. Gold recovery: Gold should be recovered from BDT-200 bath by careful addition of  $H_2SO_4$  (in a HOOD! due to evolution of sulfur oxides) to pH 1.0 filtration and heating filtrate to 2100°F to melt.

2. Aluminum mandrel removal: For copper electroforms, 50:50 conc. HCl:H<sub>2</sub>O seems to work the best overall. The aluminum should be dissolved out at room temperature. Where small openings are involved using 2024 aluminum, ultrasound should be employed. Excess copper as noticed by dark yellow color causes immersion plating of copper on dissolving aluminum surfaces, slowing or stopping dissolution of remaining aluminum and thinly covering outside gold-plated surfaces. This comes from copper off piece and from copper released from alloyed aluminum and may even involve a "battery" effect. Also it should be noted that three molecules of HCl are consumed for each Al atom dissolved! In addition, conc. hydrochloric acid is only 35% hydrogen chloride to start with! So don't try to get by using too little acid;

it won't work. Dissolving of additional aluminum slows when saturation of solution with  $Al^{+3}$  approaches.

3. Copper flash removal: A solution consisting of 15%  $HNO_3$  and 55% glacial acetic acid appears to work quite well for dissolving copper flash out of and off of electroform after aluminum has been removed.

Ten percent (10%) sodium hydroxide is used to dissolve the aluminum out of nickel electroforms.

4. Gold-stripper: A suitable gold stripping composition consists of 30 g. sodium metanitrobenzenesulfonate plus 120 g. sodium cyanide in 1 liter of solution. It dissolves gold and copper off aluminum or Kovar at room temperature. For best results, don't heat unless absolutely necessary.

5. Scale buildup: The water distillation apparatus should occasionally be cleaned of scale by dismantling, soaking in concentrated HCl and scraping with wires and brushes until it is all removed.

6. Mild Steel: This is routinely cleaned, then CuCN flashed at 24 ASF for 30 seconds to one minute and Cubath plated.

7. Music wire and the steel of drill bits need to be plated with gold on occasion. Anodic cleaning at 1,500 ASF for one minute in conc.  $H_3PO_4$ , followed by a one-minute nickel flash (bath used described in Section II, page 16), and one-minute Cubath #1 plating precedes gold plating.

8. Aluminum can be bright-dipped by immersion for exactly one minute in a 2:15° sharp mixture of 84 mls. phosphoric acid to 3.3 mls. nitric acid to 12.7 mls. glacial acetic acid. Results are excellent. Surfaces are brighter and cleaner than possible by machining.

9. Small gold pads of the thickness order of less than a mil for soldering to SIS junctions, can be formed by the following procedure:

- (1) Form a cured resist-pattern (American Hoechst Corp. AZ5413) soluble in organic solvent.
- (2) Don't clean the bare aluminum.
- (3) Plate one minute at 30 ASF in Aurobond TC.
- (4) Rinse.
- (5) Plate in BDT-200 at 1 or 2 ASF to required thickness.
- (6) Rinse.
- (7) Carefully flake off loosely adhering pads.

10. Copper electroforms that have been removed midstream and that are found to have perhaps one or two little pits in the copper can be "patched" for further copper growth by filling with indium and sanding flush. Then a cyanide copper strike before reentry is sufficient for fine results.

11. Gold stripping off copper-flashed, zincated aluminum mandrels can be nicely accomplished using the following:

Potassium Ferrocyanide	50.3 g/L	49°C
Potassium Cyanide	15.0 g/L	6 volts
Potassium Carbonate	9.8 g/L	piece anodic
		pH 9.0

Adjust pH with monobasic potassium phosphate.

Frequent additions of cyanide and pH adjuster are commonly necessary.

12. Stainless steel electropolishing is performed with the following:

330 mls/L	85% Lactic Acid	85° C
400 mls/L	85% Phosphoric Acid (mixed)	300 ASF
135 mls/L	Conc. Sulfuric Acid	piece anodic

This dissolves approximately 0.1 mils/side/min. of stainless steel.