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# Midas® Bath-Plating Unit

The Midas® stainless steel bath-plating unit is an ideal system for electro-plating and electro-forming processes.

The Midas® Plating Station (#331-961)

The Midas® Plating Station with 3-amp Rectifier (#331-962)

The Midas® Plating Station with 5-amp Rectifier (#331-963)

1. Unpack the unit and place on a flat surface.
2. Ensure that the following are included:
  - a. Stainless steel lid
  - b. Third-hand assemblies (2)
  - c. Red lead with banana jacks on both ends (1)
  - d. Red leads with banana jack and alligator clip (2)
  - e. 1000mL beakers (6)
  - f. Magnetic stirring pellets (2)
  - g. Power cord
  - h. Thermometer
  - i. 3-amp rectifier (optional) #331-962
  - j. 5-amp rectifier (optional) #331-963
3. Assemble the Third-hands by screwing the rods together, sliding the clips over the rod and tightening with the thumb screw. Position each rod into the bracket mounted on the back of the unit.
4. Position a beaker in each of the unit's six beaker receptacles.



Item 331-963 shown

## Our recommended set-up

**Station One**—Electrocleaner (#335-076) and stainless steel anode (#335-042).

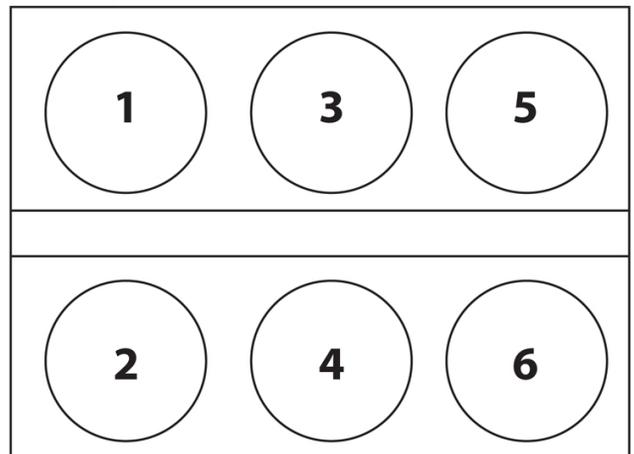
**Station Two**—Deionized water or distilled water rinse.

**Station Three**—Acid dip (#335-075). **Please Note:** There is no power or heat on station three. The acid dip is included because it is extremely important—to assure a good plating bond, we strongly recommend that you do not skip this station.

**Station Four**—Deionized water or distilled water rinse.

**Station Five**—Plating solution and appropriate anode (this is dependent on your selected solution; see the *Midas® Plating Guide* for information on selecting plating solutions and anodes).

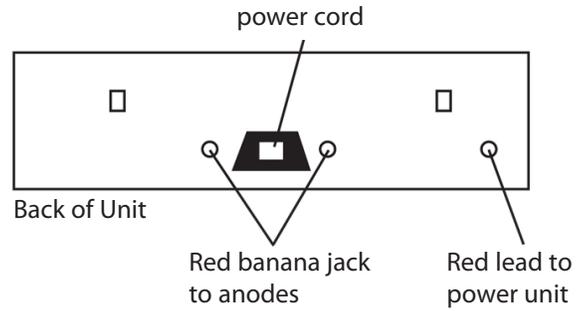
**Station Six**—Deionized water or distilled water rinse.



This drawing represents each position as a station; the numbering sequence represents the steps taken in a normal plating operation.

## Our recommended set-up (continued)

1. Add the appropriate solutions to each of the six stations.
2. Place the appropriate anode and magnetic pellet in station one and station five.
3. Plug the red leads into the banana jacks on the back of the unit and connect to each anode with the alligator clip.
4. Plug the remaining red lead into the banana jack at the back of the unit and the other end into the positive jack on the rectifier.
5. Plug the plating unit into a grounded 120-volt outlet.
6. Suspend the thermometer in the solution using the third-hand.
  - a. The thermometer is used to calibrate the correct solution temperatures in stations one and five. For example, the electrocleaner solution in station one operates best at 150°F (65.5°C). See the *Midas® Plating Guide* for more information regarding solutions and temperatures.



## Using the unit

Stations one and five are equipped with an on/off switch, heater control and agitation control.

1. Turn on station one.
2. Set the heater control to the appropriate position to reach the desired temperature.
3. Turn on the magnetic stirrer. Please Note: We have found that setting the magnetic stirrer on a minimum position optimizes plating performance.
4. Repeat for station five.

Attach the workpiece to the negative lead (black) from the rectifier via a handling wire. Please refer to the *Midas® Plating Guide* for proper plating settings and to the rectifier instructions for rectifier operation.

When finished, turn off both stations one and five. Place the lid on top of the beakers to avoid contamination.

Do not place the lid on the beakers if heaters and/or magnetic stirrers are on.

**Please Note:** The solution level in the beakers will decrease due to evaporation and drag out. Make sure beakers are at least half-full to avoid unit damage.

