

**LEKEM OF INDIANA, INC.**  
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## **AEN 100 S**

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LeKem of Indiana, Inc., AEN 100 Alkaline Electroless Nickel Process is a new system specially designed to provide a nickel strike on zincated aluminum prior to plating in an acid Electroless Nickel bath. AEN 100 Alkaline Electroless Nickel Strike will plate a pore-free, adherent deposit directly on zincated aluminum without the problems encountered with the use of conventional acid Electroless Nickel formulations. This deposit can then be overplated with a conventional acid Electroless Nickel to the desired thickness. Additionally, its high tolerance for zinc makes AEN 100 Electroless Nickel long lived and economical.

### **Benefits:**

- Alkaline Formulation
- Maximum Stability
- Long Bath Life
- Can Be Used For Barrel Plating
- High Tolerance to Impurities
- Additions can be Made at Operating Temperatures

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**LEN 100 A S**

**Make-up and Operating Conditions:**

Lekem, AEN 100 S Alkaline Electroless Nickel is supplied as three concentrates, they are:

<u>Constituent</u>	<u>% By Volume</u>	<u>For 50 Gallon</u>	<u>For 100 Gallon</u>
D.I. or Distilled Water	80%	40 gallons	80 gallon
AEN 100 S	20%	10 gallons	20 gallon
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**Operating Conditions:**

	<u>Range</u>	<u>Optimum</u>
Temperature	70-110° F	80° F*
pH	9.5-11.0	10.0
Ni Metal Concentration	0.65-0.85 oz/gal.	0.80 oz/gal.
Sodium Hypophosphite Conc.	38-45g/L.	40g/L
Optimum Tank Loading	0.25-0.75 ft. <sup>2</sup> /gal.	0.50 ft. <sup>2</sup> /gal.
Agitation, Mechanical or Gentle Air Preferred		
Filtration, Continuous Preferred		
Immersion Time	5-15 min.**	

\* As bath ages, increasing bath temperature is recommended.

\*\* Dependent upon temperature, pH, solution concentration, and age of bath.

**Equipment:**

Tanks:	Polypropylene, PVC, high density polyethylene, polyethylene lined stainless steel or glass
Heaters:	316 stainless steel, Teflon, titanium or quartz. Use a low watt-density or derated unit
Filters:	CPVC pumps and plumbing, polypropylene bags or tubes
Air Agitation:	Oil-free such as supplied by low-pressure blower, or an "oil-less" compressor