

9-17-2024,150, tank 5th (part 1)

| Unnamed: 0 | Unnamed : 1 | Unnamed : 2 | Unnamed : 3 | Unnamed : 4 | Unnamed : 5 | Unnamed : 6 | Unnamed : 7 | Unnamed : 8 | Unnamed : 9 | Titration results | Unnamed : 11 | Unnamed : 12 | Unnamed: 13 |
|---------------------|----------------------------|----------------|--------------|-------------|-----------------------|--|-------------|-----------------|-------------|------------------------------------|-----------------|----------------------------------|--|
| Date | Part name/task explanation | Temperature, C | Current, Amp | Time, min | Coating thickness, um | Total Bath Ampxhour after plating part in line | pH Preplate | Surface Tension | Pickle %HCL | Nickel Sulfamate Tetrahydrate, g/L | Boric acid, g/L | Nickel Chloride Hexahydrate, g/L | Notes |
| 2024-11-15 00:00:00 | chemical add | 70 | 9 | | | 274.5 | | | | | | | added 11.5 L of Liquid Nickel Sulfate |
| 2024-11-15 00:00:00 | 125407 roll | 70 | 9 | 80 | 35 | 286.5 | 4 | | 30 | 575 | 19 | 14 | |
| 2024-11-18 00:00:00 | Start of day sample | 70 | | | | 286.5 | 4.1 | | 30 | 570 | 17 | 14 | filter cleaned and all filter pads changed to carbon filter pads |
| 2024-11-18 00:00:00 | 125408 roll | 70 | 9 | 80 | 35 | 298.5 | 4 | | | | | | |
| 2024-11-18 00:00:00 | 125409 roll | 70 | 9 | 80 | 35 | 310.5 | 4.2 | | | | | | |
| 2024-11-19 00:00:00 | Start of day analysis | | | | | 310.5 | | 48.8 | 28 | 575 | 17 | 13 | Surface tension was high, it should be less than 45. Sodium lauryl sulfate (SLS) needs to be added |
| 2024-11-19 00:00:00 | Chemical add | | | | | | | | | | | | Added 60 ml of wetter |
| 2024-11-19 00:00:00 | 125410 roll | 70 | 9 | 80 | 35 | 322.5 | 4.5 | | | | | | |
| 2024-11-19 00:00:00 | 125411 roll | 70 | 9 | 80 | 35 | 334.5 | 4 | | | | | | |
| 2024-11-19 00:00:00 | 125412 roll | 70 | 9 | 80 | 35 | 346.5 | 4 | | | | | | |

| Unnamed: 0 | Unnamed : 1 | Unnamed : 2 | Unnamed : 3 | Unnamed : 4 | Unnamed : 5 | Unnamed : 6 | Unnamed : 7 | Unnamed : 8 | Unnamed : 9 | Titration results | Unnamed : 11 | Unnamed : 12 | Unnamed: 13 |
|---------------------|-------------------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------------|--------------|--------------|---|
| 2024-11-20 00:00:00 | Start of day analytical | | | | | | | 44 | 0.25 | 575 | 17 | 13 | %HCl in pickle was low. It should be around 30%. HCl needs to be added to pickle. |
| 2024-11-20 00:00:00 | Chemical add | | | | | | | | | | | | 3 gallons HCl was added to pickle |
| 2024-11-20 00:00:00 | 125413 roll | 70 | 9 | 80 | 35 | 358.5 | 4 | | | | | | |
| 2024-11-20 00:00:00 | 125414 roll | 70 | 9 | 80 | 35 | 370.5 | 4 | | | | | | |
| 2024-11-20 00:00:00 | 125415 roll | 70 | 9 | 80 | 35 | 382.5 | 4 | | | | | | |
| 2024-11-20 00:00:00 | 125416 roll | 70 | 9 | 80 | 35 | 394.5 | 4 | | | | | | Cracked deposit. Based on the AA analysis, there is chrome contamination. |