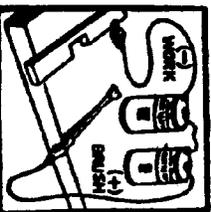


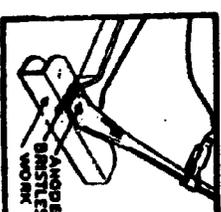
DIRECTIONS



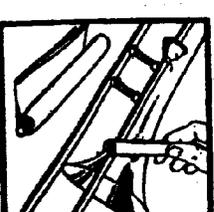
DIRECT CURRENT FOR PLATING—is obtained from two No. 6 dry batteries connected in series (3 volts) as shown at left, for general plating work. Three batteries in series (4½ volts) can be used to speed up plating on surfaces larger than 4 square inches, but requires more careful brushing. **CONNECT BRUSH TO POSITIVE (+) AND WORK TO NEGATIVE (-)**, when ready to plate.



POLISH BEFORE PLATING—Plating by any method can only be as good as the surface on which applied. (a) **FOR FLAT FINISHES**, polish thoroughly with 3/0 emery cloth or other fine abrasive. (b) **FOR SATIN FINISHES**, polish with same abrasive as for flat finishes, using fairly heavy pressure and straight parallel strokes. (c) **FOR BRIGHT FINISHES**, polish to desired brightness with metal polish (brand polishing methods shown on this and reverse side), or with a polishing motor if available.



HOW TO PLATE—(1) Connect plating current and under side of anode are well covered with it. (3) Start plating. Use a **SHORT CIRCULAR MOTION** with anode always pressing bristles lightly against the work. Keep brush in motion while plating. (4) Dip brush in compound at intervals to renew supply of metal. Plate each square inch or smaller surface at least 30 seconds for light platings and more for heavier coatings. All white metals, except light coatings of nickel, plate on with a dull or foggy finish. Immediately after plating, wash compound off with water or wipe off with a wet cloth, and wipe the plating dry.



POLISHING AFTER PLATING—Flat finish protective coatings do not require polishing after plating. Scrub finishes can be polished lightly in same direction as before plating, with fine abrasive such as crocus cloth, emery polishing paper, etc. Bright finishes can be polished with metal polish (as at left) or with a buffing wheel. Polishing after plating should be done carefully to avoid excessive wear on platings.



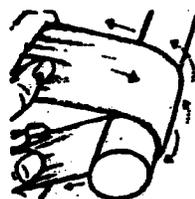
CARE OF BRUSHES AND COMPOUNDS—After using or before changing compounds, wash brushes clean with a bristle brush and water, making sure under side of anode is clean. If compounds dry out they can be reconditioned by adding small amount of water and stirring with wooden stick. Use care to avoid contaminating one compound with another. **CAUTION**—Plating compounds are poisonous if taken internally. Keep out of reach of small children.

PLATING FAILURES—may be caused by (1) reversed current (clean brush if this happens), (2) broken wires or bad connections, (3) insufficient compound on brush, (4) batteries run down, (5) lacquer or other transparent coating on the work, or (6) dropping silver compound on the work before plating.

HAND POLISHING METHODS AND ART WORK, ETC.



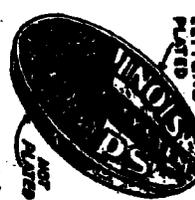
Method of polishing small parts, screw heads, nuts, etc.



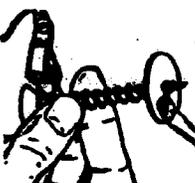
Polishing rounded parts, small nuts, washers, etc.



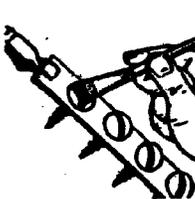
Polishing defects in reflectors and similar articles.



Method used to make letters more legible by plating letters.



Method of holding brush and smaller parts.



Holder for plating screw heads in quantities.



Method of plating parts which cannot be removed.

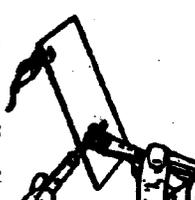


Plate small wires, pins, etc., against a piece of steel.



DESIGN PLATING—nickel plating is unequaled for plating designs, highlighting art work, simulating inlay work, etc., on copper, brass and bronze articles. An endless number of artistic and interesting designs can be plated with the aid of ordinary painters' masking tape. Bright or satin finish stripes, etc., can be plated after the tape or stencil has been firmly pressed areas to be plated after the tape or stencil is removed. Bright finish stripes can be polished with the end of a polishing stick. Polishing after plating should also be done before the tape or stencil is removed.

LACQUERING—Clear lacquer (obtainable at paint stores) can be applied over decorative platings to prevent tarnishing, as is done on commercially plated work.

REPLACING WORN SPOTS—Worn spots in old plating should be replaced while still small and easy to repair. Plating over zinc or zinc die castings, aluminum or chromium cannot be done satisfactorily, but worn spots in chromium platings can be replated as explained below.

LARGE ARTICLES—Brush plating, of any kind, is not suited for overall plating or replating of articles such as coffee pots, toasters, auto bumpers, etc. These articles cannot be prepared for overall plating by hand polishing methods or even with small polishing motors. This kind of work requires special polishing and buffing equipment that is usually found only in commercial plating plants.

CHROMIUM PLATING—cannot be done in a practical manner with brush plating. Cadmium is recommended for touching up small worn spots in chromium plating on iron and steel parts. Nickel can be used for repairing chromium on copper, brass or bronze articles such as faucets, where a slight difference in color is not objectionable.

INSTRUCTIONS

1. CURRENT: This plater is made to be used with two No. 6-1½ volt dry batteries, connected in series. To connect batteries in series, connect the negative post (outside) of one battery to the positive post of the other battery. The unused negative post is connected to the wire leading to the work. The unused positive post is connected to the plating brush. Three batteries may be connected in series to speed up work and insure enough current and better results. Always be sure batteries are fresh. Weak batteries can result in a poor plate. Use a piece of scrap steel for the first time. A little practice will enable you to do an expert job on later work. It is more economical in the long run to use a battery charger or battery eliminator of the proper D.C. voltage for plating. Depending on the composition of the metal to be plated, it may sometimes be useful to use a higher voltage -- up to six or eight volts.

2. POLISH: For a flat, dull finish, polish with a fine abrasive cloth, using light forward and backward strokes. For a bright, shining finish, polish to desired brightness with metal polish. A cloth wheel charged with fine abrasive powder will pay for itself quickly, usually on the first job. Be sure all old blue, rust, and foreign materials are removed. If there is anything on the steel, the plate will not bond.

3. CLEAN AND DE-GREASE: Be sure all oil and grease are removed. This can be accomplished by boiling in water, or rinsing in gasoline or carbon tetrachloride. After de-greasing, wash with water and a stiff bristle brush, and polish with a fine cloth, paying special attention to corners such as sight bases, hammer checkering, and hard to reach places. The work you do depends 75% on the surface you plate. Be sure it is clean. If there are any pits that cannot be polished out, be sure they are clean. If you plate over dirt, rust, or old blue, the plated finish will look old and tarnished.

Do not be discouraged by our concern over the surface. It is easy to prepare steel for a beautiful genuine 24 karat gold or rich silver plate. We want you to be pleased with this plater. Thousands of individuals and institutions have praised them. You will too. Thousands of radar and radio parts were plated with our platers during the war. Many gun and antique restoring firms in the U.S., Canada and Mexico have used them daily for many years. Many electro-plating firms use our platers for small "hurry-up" jobs. We want you to order supplies from us and believe the best way to receive refill orders is to give you your money's worth and be sure you do fine work. 90% of our business is in refill orders for compounds.

4. PLATING: To plate gold or silver over steel, it is necessary to use a copper undercoat. Connect the plating current, negative clip to work (prepared according to instructions) and positive clip to brush. Dip the plating brush into compound, being sure under side of anode (this is the metal plate above brush) and bristles are well coated with compound. Start plating, using straight strokes, being sure anode is always lightly pressing bristles against work. Dip brush in compound as needed. Plate each square inch or smaller area at least thirty seconds, longer for a heavier coat. Gold and silver have a foggy appearance when fresh. Polishing with a fine cloth, using light strokes, will result in the desired brightness. Do not use chemicals or abrasives after plating. After plating each part, rinse off all extra compounds with water or a wet cloth. Wash brush clean in water after each compound is used, being sure brush is clean.

Be sure you do not, in any way, mix different compounds. If you drop silver compound on a steel surface, the undercoat will not bond, and the surface must be polished again. Be sure current is not reversed. If this happens, wash out brush.

The plate is rust-resistant, but it is an excellent idea to coat the plate with wax or clear lacquer, pure gold and silver are soft and wear quickly. Plating compounds are poisonous if taken internally and should always be kept out of the reach of children, and away from the eyes and open wounds.

Commercial plating on an average sized handgun costs from \$45.00 to \$75.00 to silver plate, and from \$80.00 to \$150.00 to gold plate. You can plate them at the smallest fraction of the "going prices," and you will usually get a better plate, because you are plating your own guns. The secret of the lower cost is that you do not have to mix gallons of compounds to "dip-plate," and the labor is your own.