



Vault Collection – Gold Plating

## Decoplate® Rose Gold Series

### 1.0 Description/ ID

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#### LLROS - Decoplate® Rose Gold Series

With a unique red-pink hue, Decoplate® Rose Gold forms the perfect balance between the modernity of white gold and the timelessness of yellow gold. A subtle shade, its refined appearance exudes a calming style. With a soft tone, it is the definition of unrestrained elegance and luxury.

Rose Gold complements muted shades such as teals and gentle greys, whilst combining to create a warm and inviting appearance when paired with earth-toned interiors, beautifully setting off cherry and teak woods.

### 2.0 Applications and Sectors

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Designed primarily for decorative applications, there are many sectors where the Decoplate® Rose Gold can be found in, including:

#### Decorative:

- Aerospace (Aircraft Interiors)
- Automotive (Vehicle Interiors)
- Maritime (Yacht Interiors)
- Architectural (Interior Fixture and Fittings)
- Art and Interior Design (Artwork)
- Model Making/ Prototyping

Please read this document carefully, we reserve the right to make any technical changes, as necessary.

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Address: Watford West Works, 85a Hagden Lane. Watford. Hertfordshire. WD18 7UA. United Kingdom.

Company Registration Number (CRN): 00968050 VAT Registration Number (VRN): 196856107





### 3.0 Features

- **Coating Type:** - Electrodeposition of Au/Gold (Not imitation, genuine)
- **Colour/ Appearance:** - Reddish-Pink, Gold
- **Karat:** - 20
- **Odour:** - Odourless
- **Hardness:** - No Data
- **Corrosion Resistance:**\* - Excellent
- **Adhesion Strength:**\* - Excellent
- **Solvent Resistance:**\* - Not Applicable
- **Fire/ Smoke/ Toxicity/ Heat Release:**\* - Not Applicable
- **Scratch/ Wear Resistance:**\* - Moderate/ Poor
- **UV Resistance:**\* - Not Applicable
- **Sanitiser Resistance:**\* - No Data
- **Rack/ Barrel:** - Rack
- **RoHS compliant:** - Compliant
- **REACH compliant:** - Compliant

\* Refer below to section **12.0 - Standards** for more information on the types of testing typically conducted in accordance with international standards.

It is advisable to conduct external testing that is relevant to the qualification requirements of the application/ programme, ensuring it conforms to the necessary criteria. Test results may vary depending on the selected finish code/ specification and substrate type and grade to be treated. Refer below to section **5.0 – Finishes** for the relevant finish code/ specification.

### 4.0 Substrate Materials

Typical substrate materials that can be processed, but are not limited to are;

- **Metallic (Ferrous)**
  - Mild/Carbon Steel Alloys\*
  - Stainless Steel Alloys\*
- **Metallic (Non-Ferrous)**
  - Aluminium Alloys\*
  - Nickel Alloys\*
  - Copper Alloys\*
  - Magnesium (Diecast) Alloys\*
  - Zinc (Diecast) Alloys\*
- **Non-Metallic**
  - Composite Materials\*
  - Plastic Resin Polymers\*

\* may require multiple electrodeposited underlying/ intermediate layers

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## 5.0 Finishes

When ordering please use the following description or code:

Plating	Finish	Protection	ID Code
Decoplate® Rose Gold	Polished	-	LLROS-P
Decoplate® Rose Gold	Polished	Clear Protection Inhibitor	LLROS-P(CPI/M)
Decoplate® Rose Gold	Polished	Gloss Clear Coat Lacquer*	LLROS-P-(G-CC/#####)
Decoplate® Rose Gold	Satin	-	LLROS-S
Decoplate® Rose Gold	Satin	Clear Protection Inhibitor	LLROS-S(CPI/M)
Decoplate® Rose Gold	Satin	Gloss Clear Coat Lacquer*	LLROS-S-(G-CC/#####)
Decoplate® Rose Gold	Satin	Semi Clear Coat Lacquer*	LLROS-S-(S-CC/#####)
Decoplate® Rose Gold	Satin	Matt Clear Coat Lacquer*	LLROS-S-(M-CC/#####)
Decoplate® Rose Gold	Matt	-	LLROS-M
Decoplate® Rose Gold	Matt	Gloss Clear Coat Lacquer*	LLROS-M-(G-CC/#####)
Decoplate® Rose Gold	Matt	Semi Clear Coat Lacquer*	LLROS-M-(S-CC/#####)
Decoplate® Rose Gold	Matt	Matt Clear Coat Lacquer*	LLROS-M-(M-CC/#####)
Decoplate® Rose Gold	Technical Application	-	LLROS-TA

\* Lacquer type can be identified within the ID code. For example (G-CC/460-16) or (G-CC/12182). Refer to separate Clear Coat Lacquer Series data sheets for more information.

**Deposit Thickness Range: 0.045 - 0.15µm (micron or micrometre)**

### Finish descriptions;

- |                                    |           |  |
|------------------------------------|-----------|--|
| ▪ <b>Polished</b>                  | <b>P</b>  | A smooth, mirror-like, opulent finish that reflects light.                         |
| ▪ <b>Satin**</b>                   | <b>S</b>  | A contemporary hand-brushed finish (grained); standard lineal, or non-directional. |
| ▪ <b>Matt***</b>                   | <b>M</b>  | A nacreous frosted, verglas-like, textured effect.                                 |
| ▪ <b>Technical Application****</b> | <b>TA</b> | Unfinished; no definitive surface finish selected or required.                     |

\*\* When considering Satin finishes, which is a contemporary hand-brushed (grained) finish, please consider that discrepancies between two separately processed articles may occur. Whilst we strive for continuity, due to the nature of the hand applied process, no two components may ever be the same. Adjoining parts may have visual differences, with satin lines differing in intensity and positioning due to the pressure applied.

\*\*\* When considering Matt finishes (which are bead-blasted in order to achieve the desired textured effects) please consider that discrepancies between two separately bead-blasted articles may occur. The final textured effect from the bead-blasted surface is dependent on several variables (i.e. nozzle pressure, spray distance etc.); fluctuations in the final appearance may be detectable by eye.

\*\*\*\* When selecting Technical Application, please consider that no type of finish will be applied. Typically, this is required when articles are not of aesthetic importance, or the customer has taken the full responsibility of supplying the finish that is required. The surface quality of the article (i.e., any present defects) originally submitted for processing will be at the customers full responsibility.

## 6.0 Properties

- **Issue Number:** - 3
- **Formula:** - Au; Cu; Ni; Ag / Gold-Copper-Nickel-Silver
- **Deposit Thickness Range:** - **Minimum** - 0.045µm (micron or micrometre) [Thinnest deposit]\*  
 - **Maximum** - 0.15µm (micron or micrometre) [Thickest deposit]\*
- **Deposit Thickness Recommended:** - >0.045 microns
- **Colour Values:** - CIE Lab colour measurement ( $\Delta L^*$ ;  $a^*$ ;  $b^*$  - D65/10 SPIN)\*\*  
 Master Vault Collection Plaque; **A220164**  
*Polished (Gloss Clear Coat Lacquer):* -  
 -  $\Delta L^*$  - 80.67 ( $\pm 1.40$ )  
 -  $a^*$  - 11.67 ( $\pm 1.50$ )  
 -  $b^*$  - 19.60 ( $\pm 1.50$ )

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- **Substrate Dimensions (Maximum):** *Permanent Tank(s):-*  
**E Line; Tank 9 (E9)**
  - Internal tank dimensions - **Length** = 3000mm x **Width** = 325mm x **Height** = 955mm<sup>\*\*\*</sup>
  - Working envelope - **Length** = 2900mm x **Width** = 225mm x **Height** = 793mm<sup>\*\*\*</sup>

\* Lacquered finishes typically only require the minimum deposit of Decoplate® Rose Gold as the wear resistance is being provided by the protective Lacquer coating.

\*\* An exact colour comparison is only possible between metal plated articles that share the exact same equal geometry (i.e., shape and structure of the surface). Refer above to section **5.0 - Finishes - Finish descriptions** for an explanation into why there may also be possible discrepancies between two separately finished articles. Please note that colour deviations may be expected with this very sensitive electrolyte process; in some cases, exceeding the permitted colour measurement tolerance ranges (±) on complex articles. Every effort is put into place to help minimise colour deviations on highly/ partially visible surfaces; ensuring that the articles are metal plated under the best possible conditions and that tolerances ranges (±) are not too far exceeded beyond their set colour limitations. Written consent may be requested on an individual basis.

\*\*\* An array of different sized tanks are normally kept ready to accommodate larger parts. Spare auxiliary tanks are also on-hand for parts with unusual dimensions, please contact us for more information.

## 7.0 Protection

An additional option of a top coat process can be applied to help protect the surface from either finger-print marks, perspiration, minor abrasion marks, oxidising, mineral deposits or corrosion. Please refer to separate Product Data Sheets.

**Note:** Caution is highly recommended when specifying Decoplate® Rose Gold for high traffic areas that may be vulnerable to significant impact damage, e.g., button assemblies. The top coat lacquer process that must be applied provides protection and durability against general wear and tear usage, however, if significantly impacted/ penetrated, this may cause exposure of the plating beneath which could result in visual impairment, i.e. tarnishing or oxidation.

### Protection descriptions;

- **Clear Coat Lacquer Series:**
  - **(G-CC/#####)** - Gloss Clear Coat Lacquer\*  
A highly transparent, reflective, almost wet-looking appearance. Slightly darkens the colour of the final finish.
  - **(S-CC/#####)** - Semi Clear Coat Lacquer\*  
A slightly cloudy/ foggy finish. Slightly reflective yet semi-opaque and slightly lightens the colour of the final finish.
  - **(M-CC/#####)** - Matt Clear Coat Lacquer\*  
A dim, frosty, unreflective finish. Largest degree of lightening and clouding in the colour of the final finish that is on offer.
- **Clear Protection Inhibitor:** **(CPI/M)**  
An ultra-thin, transparent coating. Very discreet (almost undetectable) on the colour of the final finish.
- **Clear Protection Sealant:** **(CPS/M)**  
A thin, transparent coating. Very discreet on the colour of the final finish.
- **Clear Coat Wax:** **(WX)**  
A thin, transparent, slightly greasy feel, reflective coating. Quite discreet on the colour of the final finish.

\* Lacquer type can be identified within the ID code. For example **(G-CC/460-16)** or **(G-CC/12182)**. Refer to separate Clear Coat Lacquer Series data sheets for more information.

## 8.0 Maintenance Care

Please refer to the separate product data sheet **Aftercare Maintenance**

## 9.0 Product Range

The latest up-to-date version can be downloaded from our website; [www.lambertslondon.com](http://www.lambertslondon.com)

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## 10.0 Levelling Type Deposits – Underlying/ Intermediate Layers

Depending on the substrate material, grade, batch or machine quality, this can influence the overall electrodeposit thickness that may be required in order to achieve the high standard that is expected aesthetically. Typically, the article will undergo primary and secondary stages of both Linishing and Polishing that would in essence remove some of the substrate and underlying plated material.

Additional levelling type layers may have to be introduced and deposit thicknesses adjusted accordingly that are specific to the functionality of the article. Electrodeposited coatings are susceptible to uneven distribution of the deposit. The thickness of a plated deposit is dependent upon the current density and the plating time. With the majority of articles the current density will vary over the surface, being higher at the edges and points than in recessed areas. The more complex the shape of the article, the greater are these variations likely to be.

In addition to allowing for variations in current density over the surface of the article being plated, it is also necessary to allow for variations between different parts of the jig and between jig positions in the plating tank.

Every effort is put into place to help minimise the aforementioned factors; ensuring that the work is plated under the best conditions and tolerances are carefully controlled. This applies on any given part that is non-critical and for aesthetic/ decorative uses only.

## 11.0 Supplier

<b>Address:</b>	Lamberts London Limited Watford West Works 85a Hagden Lane Watford Hertfordshire WD18 7UA UNITED KINGDOM
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<b>Website:</b>	<a href="http://www.lambertslondon.com">www.lambertslondon.com</a>
<b>CRN:</b>	00968050 England and Wales <i>(Incorporated as a Limited company on the 11<sup>th</sup> December 1969).</i>
<b>VRN:</b>	196 8561 07
<b>Certifications:</b>	BS EN 9100:2018 Quality management system (Aviation, Space and Defence Organizations) BS EN ISO 9001:2015 Quality management system BS EN ISO 14001:2015 Environmental management system (EMS) BS ISO 45001:2018 Occupational Health and Safety (OH&S) management system

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## 12.0 Standards

### International Standards

Representative Vault Collection Test Plates\* can be tested for compliancy against well-known international quality standards if required.

**Note:** It is highly recommended and general commercial practice for customers to conduct pre-production samples and articles as part of their own qualification testing requirements for the Preliminary Design Review (PDR), Critical Design Review (CDR) and First Article Inspection (FAI) stage(s); ensuring certification or conformity to the necessary/ required standards, directives, or restrictions applicable to their application/ programme.

- 12.1 ISO 8654:2018 - Colours of gold alloys - Definition, range of colours and designation
- 12.2 ASTM B571-18 - Standard Practice for Qualitative Adhesion Testing of Metallic Coatings
- 12.3 BS EN ISO 2819:2017 - Metallic coatings on metallic substrates. Electrodeposited and chemically deposited coatings. Review of methods available for testing adhesion
- 12.4 ASTM D3363-20 - Standard Test Method for Film Hardness by Pencil Test
- 12.5 BS EN ISO 15184:2020 - Paints and varnishes. Determination of film hardness by pencil test
- 12.6 ASTM B117-19 - Standard Practice for Operating Salt Spray (Fog) Apparatus
- 12.7 BS EN ISO 9227:2017 - Corrosion tests in artificial atmospheres. Salt spray tests
- 12.8 BS EN ISO 2409:2020 - Paints and varnishes. Cross-cut test
- 12.9 BS EN ISO 6272-1:2011 - Paints and varnishes. Rapid-deformation (impact resistance) tests. Falling-weight test, large-area indenter
- 12.10 ASTM D5402-19 - Standard Practice for Assessing the Solvent Resistance of Organic Coatings Using Solvent Rubs
- 12.11 ASTM B568-98(2021) - Standard Test Method for Measurement of Coating Thickness by X-Ray Spectrometry
- 12.12 BS EN ISO 3497:2001 - Metallic coatings. Measurement of coating thickness. X-ray spectrometric methods
- 12.13 FAR/JAR/CS (§ 25.853 (a) and App. F, Part I § (a) (1) (I)) - Flammability\*\*
- 12.14 FAR/JAR/CS (§ 25.853 (d) and App. F, Part V § (b)) - Smoke Gas Density\*\*
- 12.15 ABD 0031 and AITM 3.0005 - Toxicity\*\*
- 12.16 FAR/JAR/CS (§ 25.853 (d) and App. F, Part IV § (h)) - Heat Release\*\*
- 12.17 ISO 1518-1:2019 - Paints and varnishes — Determination of scratch resistance — Part 1: Constant-loading method
- 12.18 ASTM D2197-16 - Standard Test Method for Adhesion of Organic Coatings by Scrape Adhesion
- 12.19 ASTM G154-16 - Standard Practice for Operating Fluorescent Light Apparatus for UV Exposure of Nonmetallic Materials\*\*\*
- 12.20 RTCA/DO-160G – Environmental Conditions and Test Procedures for Airborne Equipment — Section 11: Fluids Susceptibility

### Quality Management Framework (QMF)

Vault Collection Test Plates\*, Hull Cell Test Panels\*, Vault Collection Plaques, pre-production samples and actual production articles are treated and processed in accordance with the aerospace standard; AS9100 (EN 9100/ ISO 9001) certification, and unless otherwise stated, conform and adhere to the quality requirements of the following Lamberts London Quality Management Framework (QMF) documents;

- 12.21 QMF 20 - Quality Inspection Process Control and the Control of Finish Control Sample Plaques
- 12.22 QMF 25 - Finishes and Specifications; Processes and Treatments

\* Coatings can be tested on either 103mm x 50mm x 1mm (QMF 20: 7.0) - Vault Collection Test Plate made from Aluminium Alloy 5251 or 100mm x 75mm x 0.3mm - Hull Cell Test Panel made from Brass Alloy Cu Zn37.

\*\* Fire, Smoke and Toxicity Retardant Materials (FST) compliancy provided by the manufacturer.

\*\*\* UV Exposure compliancy provided by the manufacturer.





13.0 Version

Decoplate® Rose Gold Series - Technical Data Sheet (QMF 10)					
Document Number	Page Number	Issue	Date	Description of Change	Authorisation
All	All	001	25/01/2016	First Issue	Jamie Lambert
9.0	4	002	31/03/2016	Finish descriptions added	Jamie Lambert
10.0	4	003	28/09/2016	Protection descriptions added	Jamie Lambert
5.0	2	004	26/01/2017	Permanent Tanks; C19a and C19b withdrawn and replaced with E7; a new tank installation ( <i>increased capacity</i> ).	Jamie Lambert
2.0	1	005	01/10/2017	Removed Brass Musical Instruments	Jamie Lambert
3.0	1	005	01/10/2017	Added * to reference 12.0 - Standards	Jamie Lambert
12.0	4	005	01/10/2017	International Standards paragraph amended and Quality Management Framework (QMF) paragraph added	Jamie Lambert
5.0	2	006	06/04/2018	Colour deviation paragraph ** added under Colour Values	Jamie Lambert
2.0	1	006	06/04/2018	Removed Jewellery	Jamie Lambert
9.0	3	007	29/06/2019	Removed Satin Antique references	Jamie Lambert
1.0	1	008	08/07/2019	Added ID reference number	Jamie Lambert
13.0, 14.0	6, 7	008	08/07/2019	Added new Supplier section 13.0 and renumbered Version section to 14.0.	Jamie Lambert
3.0, 10	1, 5	009	22/10/2019	Added UV Resistance and new standard 10.19 (ASTM G 154 – 16)	Jamie Lambert
10.0	5	009	22/10/2019	Amended QMF 20 from 10.19 to 10.20 and QMF 25 from 10.20 to 10.21 under Quality Management Framework (QMF)	Jamie Lambert
3.0	1	009	22/10/2019	Added individual product codes to section 3.0 for Hardness, Corrosion Resistance, Adhesion Strength, Solvent Resistance, Fire/ Smoke/ Toxicity/ Heat Release, Scratch/ Wear Resistance and UV Resistance	Jamie Lambert
5.0	2	010	16/04/2020	Added internal tank dimensions and changed working envelope dimensions from imperial to metric measurements under Substrate Dimensions (Maximum).	Jamie Lambert
All	All	011	12/03/2021	Updated with new company branding and changed the layout.	Dominika Szejgiec
All	All	012	22/09/2021	Standard Revision Number updated with latest revision.	Vipul Patel
3.0, 12.0	1, 6	013	04/01/2022	Added Fluids Susceptibility and new standard 12.20 (RTCA/DO-160G)	Jamie Lambert
12.0	6	013	04/01/2022	Amended QMF 20 from 12.20 to 12.21 and QMF 25 from 12.21 to 12.22 under Quality Management Framework (QMF)	Jamie Lambert
6.0	4	014	16/06/2022	6.0 Properties: $\Delta L^*$ ; a*; b* colour values changed	Vipul Patel
6.0	4	015	03/02/2023	6.0 Properties: $\pm$ tolerance variance limits changed	Jamie Lambert

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