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Electroless Nickel Immersion Gold Process

#	PROCESS STEP	TEMPERATURE	DWELL TIME
1	PC5012 Cleaner Alternately: CK300 Cleaner	90 – 120°F (120) 32 – 49°C (49)	3 – 5 min (4)
2	DI water rinses 2x counterflow	Room temp.	1 - 2 min in each
3	Micro etch: CirEtch 130	70 – 90°F (80) 21 – 32°C (26)	1 – 2 min (2)
4	DI water rinses 2x counterflow	Room temp.	1 - 2 min in each
5	Pre-dip, sulfuric acid	Room temp.	2 min
6	ENIG CT300 Catalyst	70 – 90°F (80) 21 – 32°C (26)	1 - 3 min (2)
7	DI water rinse	Room temp.	1 - 2 min
8	Post-dip, sulfuric acid	Room temp.	2 min
9	DI water rinse	Room temp.	1 - 2 min
10	EN300 Electroless Nickel	175 - 180°F (175) 79 – 82°C (79)	Set for thickness
11	DI water, Nickel drag-out	Room temp.	10 – 15 sec
12	DI water rinse	Room temp.	45 sec
13	IG300 Immersion Gold	160 – 175°F (170) 71 – 79°C (76)	10 – 20 min (15)
14	DI water rinses 2x counterflow	Room temp.	1 - 2 min in each
15	Hot DI water rinse	90 – 100°F (95) 32 – 38°C (35)	2 – 3 min
16	Hot, forced air dryer	>120°F >48°C	Until completely dry

Note: nominal values are listed in parentheses ().