



Mitee-Grip Tape for holding small and thin components

Multi-Clamping Systems

1. Place the grip tape sheet on a subplate leaving a 6mm border on all sides.

2. We recommend the part being lightly clamped to prevent movement.
NOTE: For very thin workpieces use a top plate for even pressure.

3. The ideal application temperature is 100°C, when the adhesive is fully liquid. 80°C is the melting temperature of the adhesive and is therefore the minimum temperature for application. Some customers use an oven and record time and temperature to determine best application. A hot plate may also be used at higher temps if monitored carefully. Most parts will 'float' when the grip tape has liquefied.

4. Use air or water to cool adhesives, being careful to prevent water from going between subplate and workpiece whilst hot.

5. Cooled part is ready for machining. We recommend the use of a coolant to keep the part cool. To release the component, re-heat the adhesive. The component will require cleaning to remove wax residue - we have found an ultrasonic cleaner or warm alcohol-based wipe is effective.



10784

MULTI-CLAMPING SYSTEMS

Material

A heat activated, wax-based compound embedded in precision paper. Coated on a nylon mesh or in a stick form.

Technical Notes

Maintains parallelism on precision parts. Very useful for thin parts, micro-machining, optical and quartz components as well as jewellery related items.

Tips

Approx. clamping force is 40 PSI.

Important Notes

1. Place the Mitee-Grip sheet on the subplate leaving a 6mm border on all sides. Melt the wax stick onto the wax subplate.
2. In some cases the part should be lightly clamped to prevent movement. Over thin workpieces, use a top plate for even pressure.
3. Heat parts to between +85°C and +90°C. Heating from the bottom is best.
4. Use air or water to cool, being careful to

prevent water going between subplate and workpiece whilst hot.

5. The part is now ready to machine. Use a coolant to keep it cool. To remove the part, re-heat to between +80°C and +90°C.

Order No.	Description	Size
10784.W0230	Compound	1 Stick
10784.W0235	Compound	3 Sticks
10784.W0245	Paper Roll	305x7620
10784.W0250	Mesh Roll	254x1524
10784.W0252	Mesh Roll	254x7620