



Mitee-Grip Tape

for holding small and thin components

Multi-Clamping Systems

- Place the grip tape sheet on a subplate leaving a 6mm border on all sides.
- We recommend the part being lightly clamped to prevent movement.
NOTE: For very thin workpieces use a top plate for even pressure.
- 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.
- Use air or water to cool adhesives, being careful to prevent water from going between subplate and workpiece whilst hot.
- 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

- Place the Mitee-Grip sheet on the subplate leaving a 6mm border on all sides. Melt the wax stick onto the wax subplate.
- In some cases the part should be lightly clamped to prevent movement. Over thin workpieces, use a top plate for even pressure.
- Heat parts to between +85°C and +90°C. Heating from the bottom is best.
- 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.W0240	Paper Roll	305x1524
10784.W0245	Paper Roll	305x7620
10784.W0250	Mesh Roll	254x1524
10784.W0252	Mesh Roll	254x7620