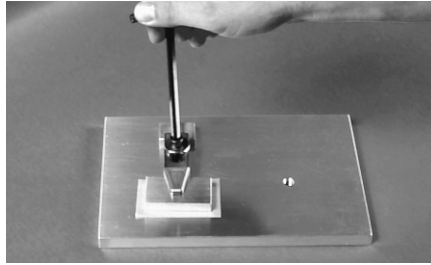
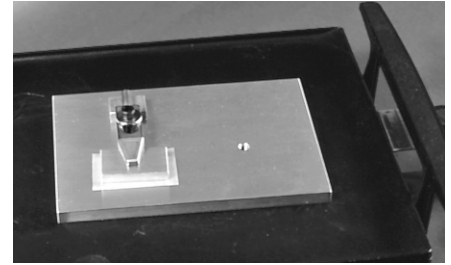


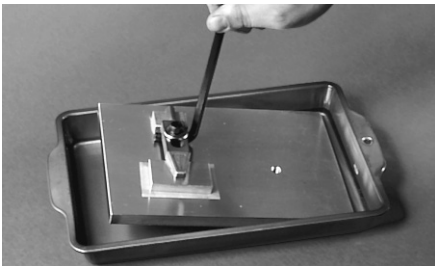
1 Place the Mitee-Grip paper on the subplate leaving a 1/4" border on all sides of the part



2 In some instances a weight or clamp with light pressure may be used to locate part.
NOTE: Over large thin workpieces use a top plate for even pressure.

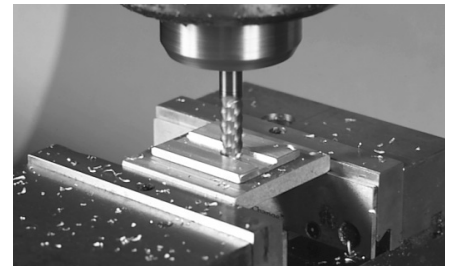


3 Heat parts to between 180° and 200°F. An electric griddle or hot plate is preferred, so heat comes from bottom.



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

5 Part is ready to machine with approximately 40 PSI of holding force. Reheat to remove part.



Mesh - The mesh product captures additional wax material in the web and aides in holding irregular shape parts. Typically additional holding force can be attained with this material.



Stick - The stick form material can be used in shallow cavities for holding concave and convex pieces. It will also stabilize delicate parts during machining.



SUGGESTIONS

- Use maximum surface area until last machining operations. The greater the surface area the greater the bond.
- Multiple thin parts, such as brass shim stock, can be layered with Mitee-Grip before heating to machine more than one piece at a time.
- Works well in water based EDM machines.
- Practice using Mitee-Grip to become familiar with its properties.
- Keep chips from between subplate and workpiece to maintain flatness and gripping force.

CAUTIONS

- Do not use heavy roughing cuts without additional clamps.
- Avoid hi-helix tools or anything that would tend to lift the part.
- Always use water based coolant to prevent heat from affecting bond.

Removal of compound residue can be accomplished by dipping the parts in a very hot soapy water or by wiping the parts, while still warm, with a rag wetted with isopropyl, alcohol, or mineral spirits (Naphtha).

**Three
Styles
Available**

| PART# | DESCRIPTION |
|-------|----------------------|
| 10240 | 12" x 5' Paper Roll |
| 10245 | 12" x 25' Paper Roll |
| 10250 | 10" x 5' Mesh Roll |
| 10252 | 10" x 25' Mesh Roll |
| 10230 | Compound - 1 stick |
| 10235 | Compound - 3 sticks |

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