

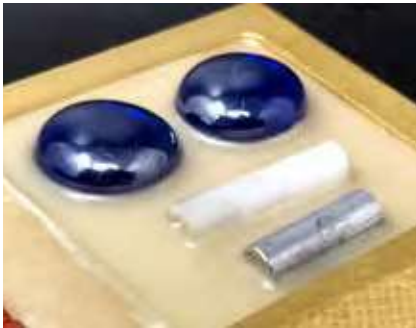


How to Hold a Workpiece When You Can't Use a Clamp

Mitee-Grip™ is a heat activated wax based compound embedded in precision paper, coated on nylon mesh or in a stick form. This



holding media maintains parallelism on precision parts. It is very useful for thin parts, micro machining, optical and quartz components, and jewelry related items. Approximate holding force 40 PSI.



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



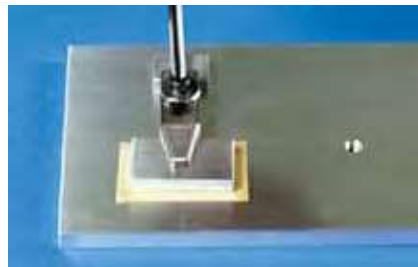
The mesh product captures additional wax material in the web and aids in holding irregular shape parts. Typically additional holding force can be attained with this material.



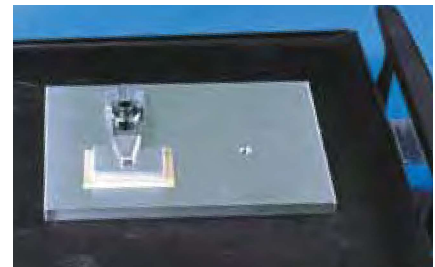
The original paper product is excellent for holding smooth flat parts and maintaining parallelism.



1 Place the Mitee-Grip™ sheet on the subplate leaving a 1/4" (6mm) border on all sides, or melt stick on warm subplate



2 In some cases the part should be lightly clamped to prevent movement. NOTE: Over thin workpieces use a top plate for even pressure.



3 225°F (107°C) is application temperature and fully liquid, 186°F (85°C) is solid and becoming liquid. Some customers use an oven and record time and temp once determined by experimentation. A hot plate may also be used at higher temps if monitored. Most parts will "float" when the Mitee-Grip™ has liquefied.



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



5 Part is ready, use coolant while machining. Reheat to remove. We have found an ultrasonic cleaner is best to remove wax residue or simply wipe part while warm using alcohol based cleaner.



Part No.	Desc.	Size (Metric)
10240	Paper Roll	12"x5' (305x1524)
10245	Paper Roll	12"x25' (305x7620)
10250	Mesh Roll	10"x5' (254x1524)
10252	Mesh Roll	10"x25' (254x7620)
10230	Compound	1 Stick
10235	Compound	3 Sticks