



**TOLBER DIVISION**  
PYRAMID PLASTICS, INC.



# Technical Information Data

## MICCRO XP-410 VOC FREE STOP-OFF LACQUER

**MICCRO XP-410 IS SUITABLE FOR USE IN THE FOLLOWING CYCLES:**

Electroless Nickel      Hard Coat Anodizing      Chemical Milling      Acid Solutions in General

### APPLICATION PROCEDURE

***\*XP-410 SHOULD BE STIRRED PRIOR TO USAGE\****

1. Chemically and/or mechanically clean the area of the part to be masked. The area to be masked must be free of all dirt, grease, or other contaminants. **NOTE:** Cleaning is the most critical aspect of the masking procedure.
2. Apply XP-410 to the area to be masked by dipping, brushing or spraying. For reducing XP-410, use the XP-410 REDUCER only.
3. Two or Three coats are recommended depending upon the type of plating/chemical solution and/or length of processing time in solution. Allow at least a one-hour dry time between coats. A longer dry time between coats will improve the performance of the product. This factor is highly dependent on the severity of the plating cycle. Faster drying of XP-410 can be accomplished by force drying for 15 minutes in an oven. Temperatures must not exceed 140 ° F. and times over 15 minutes. Dry time will vary according to relative humidity. **NOTE:** Make sure XP-410 has lost all solvent odor before force drying or applying additional coats.
4. If area to be masked is highly polished, refer to the "Masking Polished or Smooth Surfaces" technical data page for improved adhesion.
5. XP-410 can normally be peeled from the part after processing. For mass stripping or removal from recessed areas, use XP-410 REDUCER MICCROSTRIP A

### CHARACTERISTICS

Color:	Orange	Wt./Gal:	10.96 lbs/gal
Viscosity:	5000-6000 cps	Flash Point:	109° F. TCC
Coverage Rate:	Approximately 130 ft. <sup>2</sup> (12m <sup>2</sup> ) per gallon	Dry film:	1 mil

\*\*\*\*\*XP-410 is available in 1 gallon, 5 gallon, and 55 gallon containers.\*\*\*\*\*

**REFER TO REVERSE SIDE FOR PRECAUTIONARY INFORMATION AND WARRANTY**



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