



TOLBER DIVISION
PYRAMID PLASTICS, INC.



Technical Information Data

MICCROWAX 565-HT

MICCROWAX is a single-material wax for selective stop-off that is especially suited for masking on complicated parts and sharp edges.

MICCROWAX will not crack, and may be readily melted for use by any common heating medium.

MICCROWAX shows a remarkable degree of adhesion, even when on flat surfaces. It requires no prime coat before application which means only one wax dip tank is necessary for the complete operation.

MICCROWAX hardens immediately after the part is dipped, thereby minimizing preparation time and speeding production of parts before plating.

MICCROWAX can be reused without loss of its efficiency.

MICCROWAX may be used in most plating cycles as long as cycle temperatures do not exceed the melting point of the wax.

MICCROWAX may be used in the following types of plating:

Hard Chrome

Indium

Copper Acid

Lead

Copper Pyro

Silver

APPLICATION AND REMOVAL PROCEDURES

MICCROWAX 565-HT should be held at temperatures between 210°F and 230°F to attain a maximum thickness of coating for use in selective hard chromium plating. The parts to be stopped-off should be cleaned of all dirt, grease, etc. Immerse in MICCROWAX 565-HT a few moments to raise the temperature of the part and withdraw. Two or three successive, fast dips will provide a heavy coating that will withstand any hard chrome cycle. The portion to be plated can be bared with a knife and the surface cleaned with naphtha before plating.

Since reclaimed wax contains acid, air will only encourage degradation. The bath should be stirred frequently and new wax added when needed.

Remember, recycled wax degrades with time, which decreases pliability. When a wax begins to darken and become brittle due to acid attack, a base such as morpholine, ammonia, or KOH can be added to the wax to neutralize the effects. The wax will lighten as it is neutralized. However, the addition of aqueous base will increase the water contamination of the wax.

Increasing the temperature of the bath above 250°F until the wax is dried out can eliminate water contamination. Since bumping can occur while the wax is drying, extreme care must be taken to protect operations during this procedure.

When dipping large parts in wax, the metal acts as a heat sink and absorbs the energy of the liquid wax, causing it to rapidly solidify. This can result in a thick wax coating with poor adhesion to the metal. Preheating of the part will help to alleviate this problem. Another way to alleviate this problem is to increase the wax bath temperature, although this may accelerate degradation.

MICCROWAX 565-HT can be removed easily by placing part in boiling water to melt the coating.

MICCRO SAFE-STRIP "D" can be used to remove the last residues of the wax after boiling water rather than use vapor degreasers or hazardous solvents.

NOTE: MICCROWAX 565-HT is packaged six slabs (6) per carton. Approximate weight is 65.5 pounds per carton.

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