

MICCRO[®] PRODUCTS

TECHNICAL INFORMATION DATA

ST-210

VOC FREE STOP-OFF LACQUER



SUITABLE FOR USE IN THE FOLLOWING CYCLES:

BLACK OXIDE • CADMIUM • CHROME-BRIGHT • CHROME-DECORATIVE
COPPER CYANIDE • COPPER PYRO • DICHROMATE • GOLD ALKALINE
GOLD ON SILVER • INDUSTRIAL CHROME • LEAD • NI-CAD DIFFUSED
NICKEL-BRIGHT • NICKEL-GRAY • NICKEL-SULFAMATE • PHOSPHATING
SILVER • SILVER ON GOLD TIN-ACID • TIN-ALKALINE • ZINC

APPLICATION PROCEDURE

MICCRO[®] ST-210 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 MICCRO[®] ST-210 to the area to be masked by dipping, brushing or spraying. For reducing MICCRO[®] ST-210, use the MICCRO[®] ST-210 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 MICCRO[®] ST-210 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 MICCRO[®] ST-210 has lost all solvent odor before force drying or applying additional coats.
4. For extra long cycles, three coats are recommended. If area to be masked is polished or smooth, refer to the "Masking Polished or Highly Smooth Surfaces" technical data page for improved adhesion.
5. MICCRO[®] ST-210 can be removed using MICCRO[®] ST-210 REDUCER, MICCROSTRIP[®] A, MICCRO SAFE-STRIP[®] C

CHARACTERISTICS

Color: Red **Wt./Gal:** 7.49 lbs/gal **Dry Film:** 1 mil
Viscosity: 32-37 sec (#2 Zahn) **Flash Point:** 24°F TCC
Coverage Rate: Approximately 500 ft. 2 (46m²) per gallon

Available in 1 gallon, 5 gallon and 55 gallon containers



220 WEST 5TH STREET, HOPE, ARKANSAS 71801

PH: (870) 777-3251 • FAX: (870) 777-8056 • www.TOLBER.com

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MASKING POLISHED OR HIGHLY SMOOTH SURFACES

After final polishing and cleaning (no water constrictions, etc.), the following process is suggested:

1. Dilute the TOLBER[®] Stop-Off Lacquer with the appropriate reducer from 10% to no more than 50%.
2. Apply the “thinned” TOLBER[®] Stop-Off Lacquer to all areas of the part being protected.
3. Air dry part with the “thinned” lacquer until the solvent odor is gone.
4. At this point, the part can be baked in a circulating oven not to exceed 150°F for 10-15 minutes. This step is optional and not required.
5. Cool part to room temperature.
6. Apply 2nd coat of the TOLBER[®] Stop-Off Lacquer at normal viscosity on top of the areas where the “thinned” primer has been applied.
7. Let the part air dry for 30-45 minutes or until the solvent odor is gone and the surface is tact free.
8. Subsequent coats may be applied if necessary. (Refer to step #6)
9. Bake part in a circulating oven if necessary.
10. Cool part and begin plating procedure.

†These step are what is recommended for TOLBER[®] Products only. Before using the procedures above, please consult the products data sheet or TOLBER[®] for appropriate reducing agent or any other questions that may arise.