

# MICCRO<sup>®</sup> PRODUCTS

## TECHNICAL INFORMATION DATA

# XP-410

## VOC FREE STOP-OFF LACQUER



### SUITABLE FOR USE IN THE FOLLOWING CYCLES:

ACID ETCHING • ANODIZING • LEAD  
NICKEL-ELECTROLESS

### APPLICATION PROCEDURE

MICCRO<sup>®</sup> 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 MICCRO<sup>®</sup> XP-410 to the area to be masked by dipping, brushing or spraying. For reducing MICCRO<sup>®</sup> XP-410, use the MICCRO<sup>®</sup> 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 MICCRO<sup>®</sup> 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 MICCRO<sup>®</sup> XP-410 has lost all solvent odor before force drying or applying additional coats.
4. If area to be masked is polished, refer to the “Masking Polished or Highly Smooth Surfaces” technical data page for improved adhesion.
5. MICCRO<sup>®</sup> XP-410 can normally be peeled from the part after processing. For mass stripping or removal from recessed areas, use XP-410 REDUCER, MICCROSTRIP<sup>®</sup> A, or MICCRO SAFE-STRIP<sup>®</sup> C.

### CHARACTERISTICS

**Color:** Orange    **Wt./Gal:** 10.96 lbs/gal    **Viscosity:** 5000-6000 cps    **Dry Film:** 1 mil  
**Flash Point:** 109°F TCC    **Coverage Rate:** Approximately 130 ft.2 (12m2) per gallon

*Available in 1 gallon, 5 gallon and 55 gallon containers*



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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<sup>®</sup> Stop-Off Lacquer with the appropriate reducer from 10% to no more than 50%.
2. Apply the “thinned” TOLBER<sup>®</sup> 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<sup>®</sup> 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<sup>®</sup> Products only. Before using the procedures above, please consult the products data sheet or TOLBER<sup>®</sup> for appropriate reducing agent or any other questions that may arise.