



BR1301 and BR1302 DIP STRIP OPERATING INSTRUCTIONS

! DANGER !

Dip Strip contains caustic soda. Do not take internally. Avoid direct contact with skin and clothing. Do not inhale dust or allow contact with eyes. If accidental contact does occur, flush freely with water and obtain medical attention. See Safety Data Sheet (SDS) for more information.

! WARNING: USE APPROPRIATE PPE !

Due to the caustic properties and high operating temperatures of Dip Strip, the following Personal Protective Equipment (PPE) and clothing must be worn/used at a minimum when using, handling or cleaning Dip Strip:

Eye Protection: Face shield and chemical splash goggles when handling or using Dip Strip in any form.

Hand Protection: Impervious gloves, such as heat resistant gloves or gauntlets.

Other Protective Clothing/Equipment: Long sleeve shirts, long trousers, work shoes, and aprons. Pliers or hemostats are recommended to retain wire(s) during immersion.

Respiratory Protection: NIOSH approved respirator for dusts in absence of environmental controls. In use, NIOSH approved respirator for mists and/or nitrogen oxide gases may be required.

Ventilation: Normal industrial. Mechanical exhaust with components coated with chemically impervious material. Due to fumes emitted during the wire stripping process when material is in a molten state, suitable ventilation such as a fume hood should be employed during use.

! WATER SHOULD NEVER BE INTRODUCED TO THE DIP STRIP POT OR MEDIUM !

The only exception is during the cleaning of the Dip Strip Pot (DSP). See the MAINTENANCE section of the DSP Operating Manual.

INTENDED USE: Industrial use only. Not intended for any other use or application. The Dip Strip medium is designed to be used exclusively in Eraser manufactured Dip Strip Pots and is not intended to be used with any other equipment or materials.

IMPORTANT: NO LIABILITY WILL BE INCURRED BY THE ERASER CO. FOR INJURY, DEATH, OR PROPERTY DAMAGE CAUSED BY A PRODUCT WHICH HAS BEEN SET UP, OPERATED, AND/OR INSTALLED CONTRARY TO ERASER'S WRITTEN

INSTRUCTION MANUAL, OR WHICH HAS BEEN SUBJECTED TO MISUSE, NEGLIGENCE, OR ACCIDENT, OR WHICH HAS BEEN REPAIRED OR ALTERED BY ANYONE OTHER THAN ERASER, OR WHICH HAS BEEN USED IN A MANNER OR FOR A PURPOSE FOR WHICH THE PRODUCT WAS NOT DESIGNED.

SET UP:

! WARNING ! Prior to set up and/or operation of Dip Strip process, refer to the PPE section above, for proper clothing and equipment (PPE) to be worn/used at all times during set up and/or operation of Dip Strip and DSP.

1. Mix bag of Dip Strip before pouring into a cold (room temperature) Dip Strip Pot (DSP).
2. The DSP has a temperature control, which is adjustable from approximately 100°F to 900°F (38°C to 482°C).
3. [Set DSP to 500°F]. The Dip Strip will melt at or about 500°F (260°C). When bubbling has ceased, and any cloudiness disappears, it means that entrapped air and/or moisture has been driven out.
4. Increase temperature to desired setting.

NOTE: For most materials there will be little or no advantage in exceeding 730°F (388°C). Dip Strip will be subject to deterioration, with breakdown occurring at about 900°F (482°C).

OPERATION:

1. Immerse the item to be stripped into the melted Dip Strip to the level/distance of desired strip. As the Dip Strip reacts with the insulation, a bubbling action will occur. Complete removal of the insulation is indicated when the bubbling ceases. At this time remove the item from the Dip Strip.
2. Remove with water any Dip Strip that has been applied to the stripped item. In the case of copper (where oxidation may occur), it is recommended that Dip Clean 2 metal cleaner be used after the water rinse, followed by a final water rinse.
! WARNING ! If it appears that the item was prematurely removed from the Dip Strip, **be sure it is dry** before returning it to the Dip Strip bath. **This will avoid dangerous boiling and spattering. NEVER DIP A WET WORK PIECE INTO DIP STRIP.**
3. In most cases the best results will be obtained by leaving the Dip Strip Pot on at a reduced setting of approximately 250°F (121°C) when not in use. This will prevent the entrapment of moisture and reduce set up time.
4. When the Dip Strip has lost its stripping ability, either

by depletion or through inadvertent overheating, it must be replaced.

Dip Strip may be readily incorporated as another station on automatic processing equipment. Because it is a liquid at operating temperature, Dip Strip will readily flow around and between conductors facilitating the removal of insulation from otherwise inaccessible locations. Groups of wires, pre-twisted or attached to terminals, may be stripped, cleaned, fluxed and soldered all by automatic equipment. Even where automated production lines are not justified, Dip Strip may be used to significantly improve operator efficiency.

Partial Listing of Insulation Types Dip Strip Will Remove:

- Thermosetting terephthalic polyester and amide type imide overcoat and thermoplastic polyester cement.
- Triple polyvinyl acetyl resin and butyral adhesive overcoat.
- Polyurethane and 6/6 nylon and butyral adhesive.
- Heavy polyimide.
- Polyurethane and 6/6 nylon overcoat.
- Hermetic polyvinyl formal acetate resin.
- Nylon/Polyester.
- Polyimide/Polyester.
- Esterimide.

TECHNICAL DATA:

Melting temperature = 500°F (260°C)
Normal use temp. = 700°F-750°F (371°C-399°C)
Maximum operating temperature = 820°F (438°C)

APPLICATION:

Dip Strip is especially formulated to remove modern film insulations, such as Polyimide and Polyamide-imide. It is equally suitable for removing virtually all film insulations currently available.

Dip Strip removes insulation with a chemical action that attacks the bonds of the organic insulation without being corrosive to the metallic conductor. Therefore, this chemical action is suitable for use even on very fine wires and those with an outer coating (such as copper-clad aluminum). Dip Strip is readily neutralized by the Dip Clean 2 metal cleaner used to remove the oxide layer that forms at operating temperature.

ROUTINE MAINTENANCE:

When the Dip Strip has lost its stripping ability, either by depletion or through overheating, it must be replaced.

! DO NOT POUR FROM THE POT IN ITS LIQUID STATE ! Dip Strip may splatter or re-solidify upon striking a cold surface.

Cleaning & Removal of Dip Strip medium from Dip Strip Pot

Refer to the MAINTENANCE section of the Dip Strip Pot (DSP) Operating Manual for proper removal of Dip Strip and cleaning of the DSP. Regular cleaning of the DSP prevents excessive residual buildup of Dip Strip on the vessel's interior.

Disposal

See Safety Data Sheet (SDS) for disposal instructions.

SHELF LIFE:

Dip Strip has an indefinite shelf life provided that the following conditions are observed:

1. Dip Strip should be stored in a cool, dry place.
2. Bags of Dip Strip should remain sealed and airtight during storage. Dip Strip will absorb moisture from the air and thus deplete its stripping capabilities. To reduce/prevent this condition, storing sealed bags in an airtight container is recommended.