



## 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 Material Safety Data Sheet for more information.

#### **SET UP:**

Mix bag of Dip Strip before pouring into a cold melting pot. The melting pot should have an adjustable temperature control from 500° to 900° F (260° to 482°C). The Dip Strip should 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. Now increase temperature to desired setting. 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 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 carried out on the stripped item. In the case of copper, (where a slight amount of oxidation may occur) it is recommended that Dip Clean 2 metal cleaner be used after the water rinse, this should then be followed with a final water rinse. If it appears that the item was prematurely removed from the Dip Strip, be sure it is dry before returning it to the pot. 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 stripping pot on at all times (but a reduced setting of approximately 250°F when not in use). This will prevent the entrapment of moisture and thereby reduce the set-up time.
4. When the Strip bath 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 it 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°-750°F (371°-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.

### **MECHANISM:**

Dip Strip removes insulation by 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). When used with copper it is readily neutralized by the Dip Clean 2 metal cleaner used to remove the oxide layer that forms at the operating temperature.

### **ROUTINE MAINTENANCE:**

When the Strip bath 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.** It may splatter upon striking a cold surface or it could re-solidify, causing a blockage of drains, etc. Dip Strip may be disposed of by turning off the melting pot and allowing it to return to ambient (room) temperature; the solidified Dip Strip may then be neutralized and disposed of. See Material Safety Data Sheet for disposal instructions. Refer to pot instructions for use of removal tool to remove solidified Dip Strip. Electric pots should be disconnected from the power source before washing. Before reusing the pot make sure all parts of the pot are completely dry. Regularly clean the stripping pot to prevent build up on the casing. **CLEAN POT ONLY WHEN ELECTRICAL SUPPLY IS DISCONNECTED AND POT IS COLD.**

### **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 when storing. Dip Strip will absorb moisture from the air and thus deplete its stripping capabilities. To ensure that moisture is kept from Dip Strip, we recommend storing sealed bags in an airtight container.

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