

LUBRICANT

LMW BACK UP, LMW25

A new type of composite drill backing board. The main features are drill bit cooling, lubricating and drill bit cleaning, guaranteed by a unique and patented engineered surface resin system.

The unique resin system offers low melting point lubricating characteristics, minimizes drill bit temperature rise and maximizes drill life. The resin system is water-soluble and easily removed during subsequent wet processing.

GENERAL INFORMATION

- Reduced Drill Temperature - lubrication Back's unique lubricated resin layer significantly reduces drill temperature, minimizing drill wear and thus minimizing heat related hole defects.
- Improved Hole Wall Quality - the lubrication of the drill, provided by the unique resin layer, significantly reduces hole wall roughness and extends drill life.

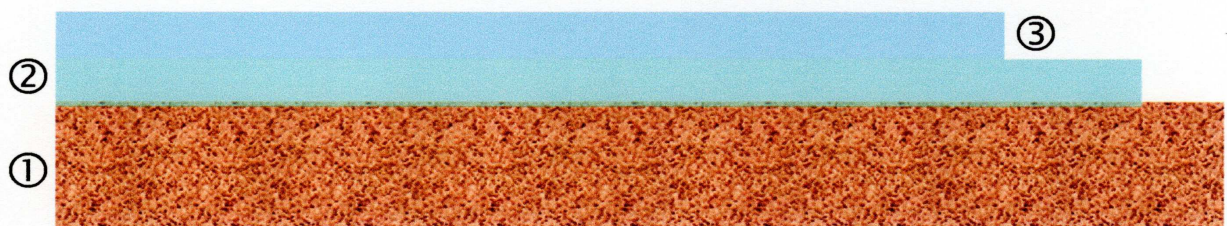
LUBRICANT LMW-BACK UP		
Composition	High Quality HDF	89%
	Paper	5%
	Lubricated Resin Layer	5%
	Unsaturated Polyester Resin	1%

SPECIFICATION

Specification	Data		Unit	Notes
Thickness	2.50		mm	/
Thickness Tolerance	± 10%		mm	/
Density	≥ 880		Kg/m ³	/
Surface Hardness	≥ 72		Shore D	/
Warp	≤ 0.9		%	/
Size & Tolerance	940x1245	+4	mm	37"x49"
	1041x1245	-0		41"x49"
	1092x1245			43"x49"
	510x610	± 2		/
Storage	1. Keep dry & flat at room temperature, use moisture-proof packing and keep away from heat & water sources. Stack, maximum 3 pallets high. 2. Keep away from direct sunlight. Keep temperature 5~40°C & humidity 40~65%RH 3. Shelf life: 1 year from delivery date (when stored in sealed original packaging)			

Sheets can be cut to customer required panel size.

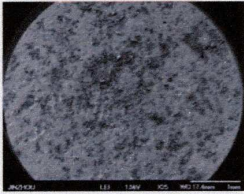
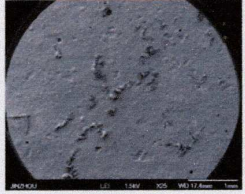
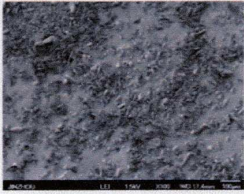

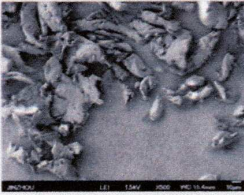
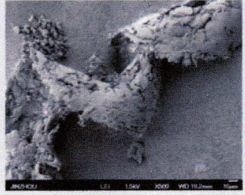
CONSTRUCTION



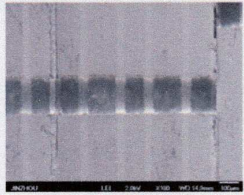
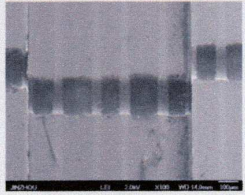
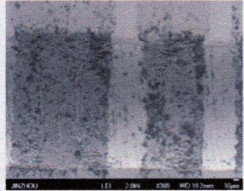
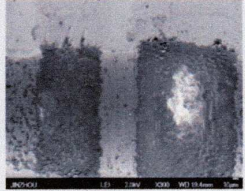
Item	Material	Thickness (mm)	Function
1	Premium HDF	2.40	Core material & supporting
2	Water soluble & lubricated Resin Layer	0.025-0.03	Cooling & Cleaning
3	Enhanced resin layer, maximizing surface hardness	0.05-0.075	Increased surface hardness, significantly reducing drill burrs

COMPARATIVE DATA

Chipping Debris


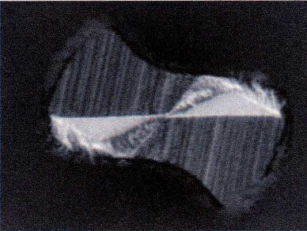

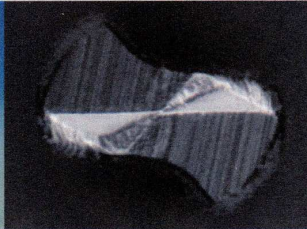
	Normal Backup board	Lubrication backup board
25 X		
100 X		
500 X		

Hole Wall Quality

	Normal Backup board	Lubrication backup board
100 X		
300 X		

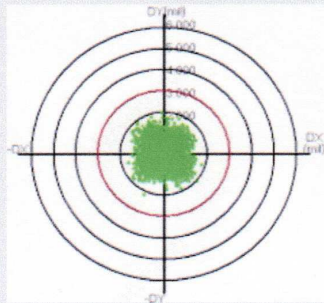
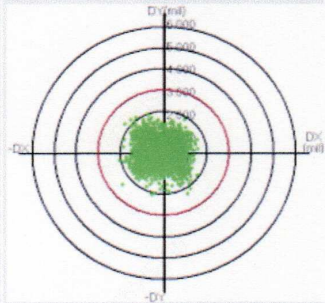
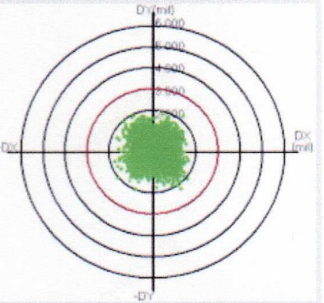
DATASHEET /

Drill Wear

Backer	Drill Wear		Remarks
Lubrication backup board			<ul style="list-style-type: none"> • Reduced drill wear • No drill residue remaining in flute • Lubricant non-tacky
Normal Backup board			<ul style="list-style-type: none"> • Larger drill wear • Drilling residue remaining in flute

Drilling - Material Comparison

Item	Specification
Drill Bit	Toshiba 0.3mm
Parameter	S135 F1.4 R18
Entry Board	Solid Aluminum Entry Sheet
CCL/PCB Type	High Tg
Backup Board	

	Lubrication backup board	Melamine Board	Normal Backup board
CPK			
	1.963	1.956	1.909

SUMMARY

Lurication LMW25 back up, offers a cost effective solution to todays 'high accuracy' drilling challenges

- Reduced drill temperature and drill wear.
- Increased hit counts, reducing cost per hole drilled.
- Increased stack heights.
- Excellent drill cleaning and chip formation.
- Improved hole-wall quality.
- Reduced costs.

All information given here is based on currently available facts and on the results of experiments performed with all due care in our laboratories. It does not in any way reduce the responsibility of the user for carrying out further tests in order to ensure successful processing and use in specific applications.