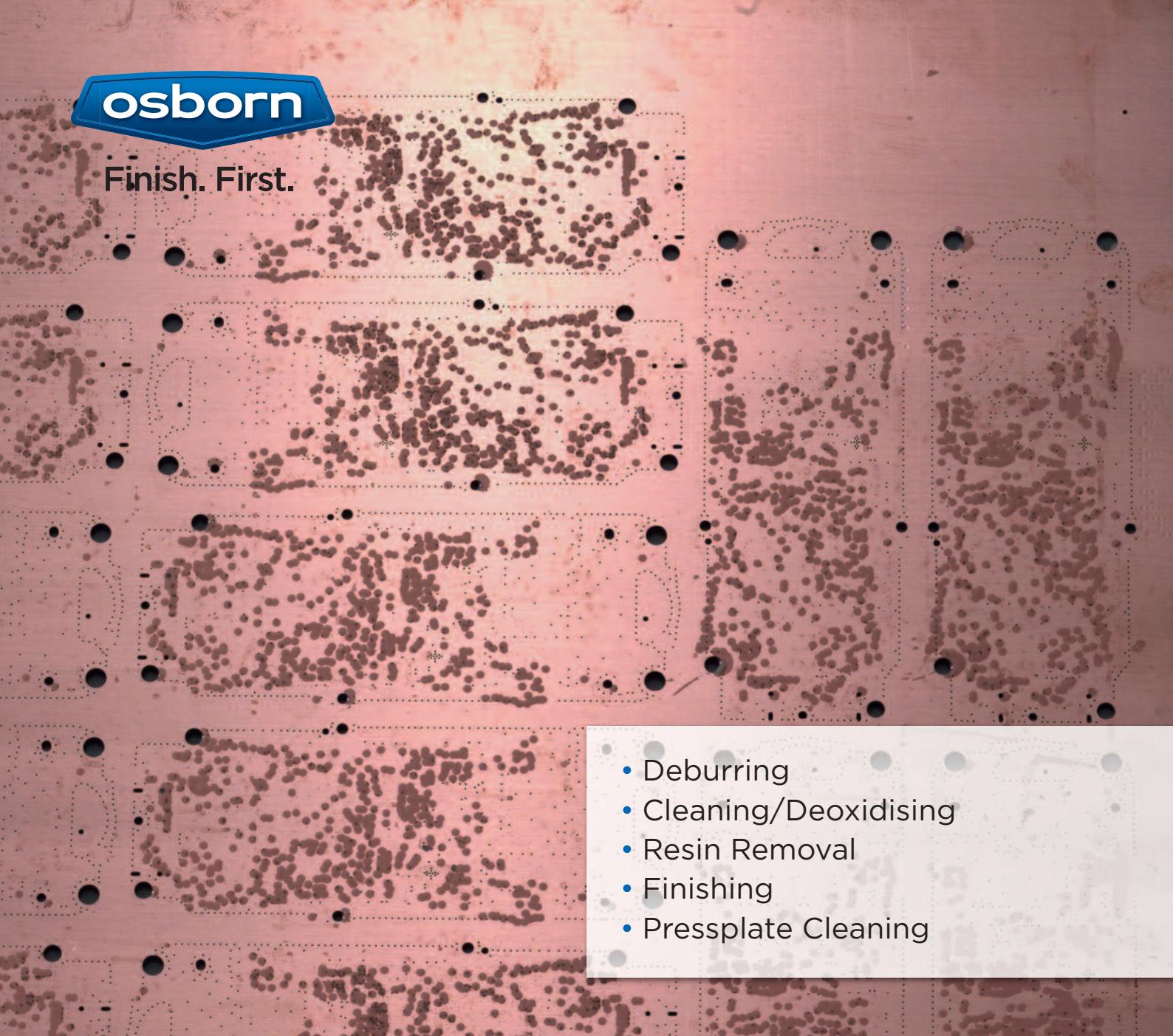




osborn

Finish. First.



- Deburring
- Cleaning/Deoxidising
- Resin Removal
- Finishing
- Pressplate Cleaning



Innovative Solutions
for Printed Circuit Board Processing

Operations in
14
Countries

Brazil
China
France
Germany
India
Mexico
Portugal
Romania
Singapore
Spain
Sweden
Taiwan
United Kingdom
United States

Offers access to new ideas, economies of scale, and new techniques to master your surface treatment and finishing needs.



Sales offices in

23
Countries

2,000

Employees worldwide

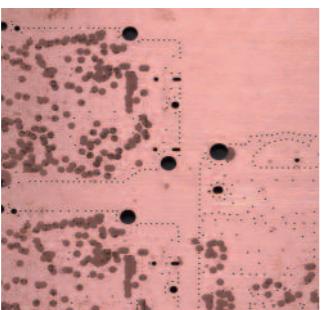
Servicing more than

120

Countries

through numerous agencies and strong distribution networks. Providing insight into the customs and best practices necessary to succeed anywhere in the world.

PRINCIPLES IN MANUFACTURING AND DEVELOPING SURFACE FINISHING ROLLERS



Printed Circuit Board manufacturing has changed dramatically in recent years and production processes can no longer be simply described as: deburring, cleaning or finishing.

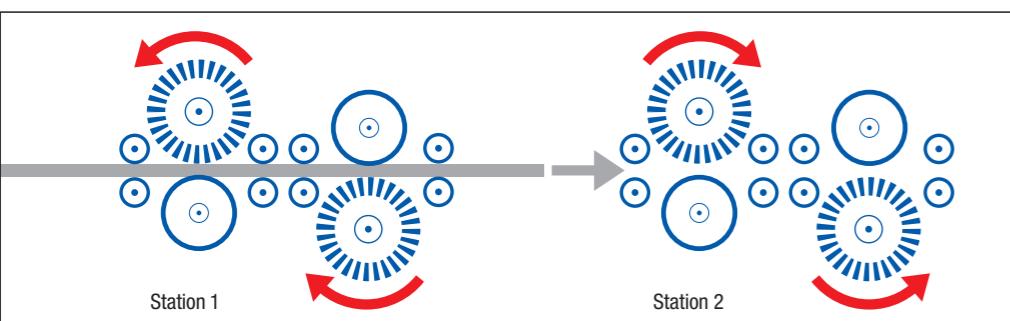
We have not only had to broaden our vocabulary but also extend and develop the range of brushing rollers used for mechanical surface processing.

Highly competitive global markets dictate that only the fittest survive hence high reliability, stability and long durability have become a necessity.

We have a range of brushing rollers to meet these goals, all producing the same uniform performance, throughout a long service life. High quality materials tightly packed to maximum density offering the necessary "bite". The three dimensional open web construction ensures a "self-cleaning action", it prevents loading of contamination and the generation of excessive heat or "baking".

New abrasive particles are continually exposed to produce a consistent and uniform finish. Special treatments ensure that, even when wet, the rollers remain hard and resilient.

To the proven range of LIPPROX® Clean Deburring Rollers, there have been added the LIPPRITE® Super Cut Rollers, LIPPRITE® High Resolution Finishing Rollers and LIPPRITE® Soldermask Finishing Rollers. The LIPPRITE® Pressplate Cleaning Rollers complete this range.



A brushing machine with **4 heads** is highly recommended for all brushing operations!

The alternating direction of rotation is the distinct advantage of this set-up. Drilled holes are consistently deburred in the brushing direction. This set-up permits a considerable increase in feed rate. Brushing against feed direction on station 2 ensures that copper particles and brush debris are thrown behind the board.

Operating Parameters

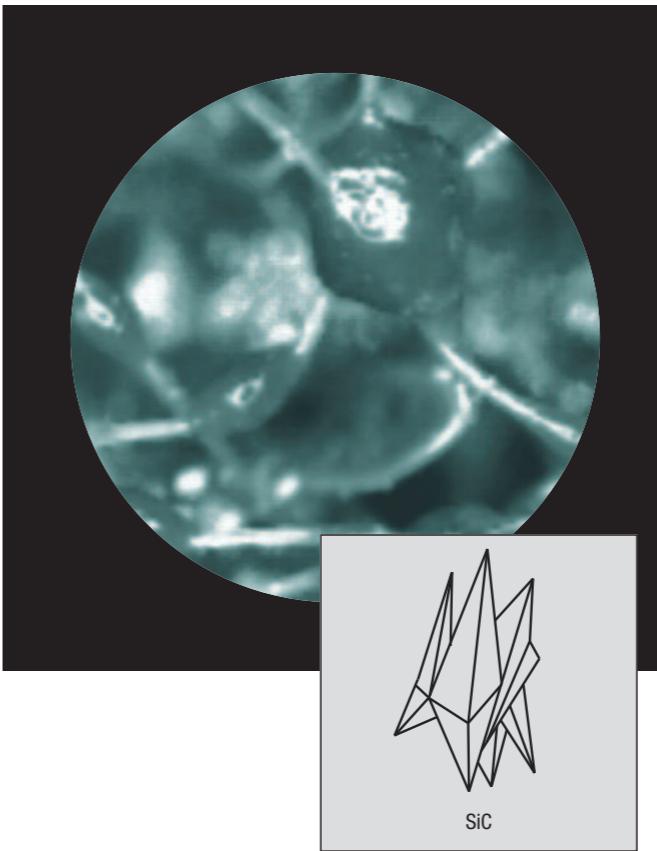
Cutting speed:	12 – 18	[m/s]	Brush speed is generally determined by the machine manufacturer
Feed rate:	1.5 – 2.5	[m/min]	
Pressure:	1.0 – 1.5 40 %	[kW] [load]	
Oscillation frequency:	240 – 500	[strokes/min]	
Oscillation path:	3 – 10	[mm]	
Coolant:	wet	[water]	
Rinsing on PCB:	up to 100	[bar]	
Rinsing on brush:	max. possible	[bar]	i.e. full flow as determined by machine
No. of brushes:	4 – 8		2 top / 2 bottom or 4 top / 4 bottom

Station 1:

Top roller rotates with the board.
Bottom roller rotates with the board.

Station 2:

Top roller is counter rotating.
Bottom roller is counter rotating.



Available grit sizes

LIPPERT-UNIPOL specification	Quality (FEPA)	International specification	Cu		St. 1.4542	
			Rz [µm]	Ra [µm]	Rz [µm]	Ra [µm]
S4	SiC 120	MEDIUM S	5.0 – 7.0	1.20 – 2.50		
S6	SiC 180 / 240	FINE S	3.0 – 5.0	0.70 – 1.20		
S7	SiC 320	VERY FINE S	2.0 – 3.0	0.30 – 0.45		
S8	SiC 500	SUPER FINE S	1.5 – 2.5	0.25 – 0.35		
S9	SiC 600 / 800	ULTRA FINE S	1.0 – 2.0	0.15 – 0.25		
S10	SiC 1000 / 1200	MICRO FINE S	0.7 – 1.2	0.10 – 0.15		
A4	Al ₂ O ₃ 120	MEDIUM A			1.60 – 2.50	0.15 – 0.30
A5	Al ₂ O ₃ 150 / 180				1.20 – 2.00	0.14 – 0.25
A6	Al ₂ O ₃ 240	FINE A			1.00 – 1.60	0.13 – 0.15
A7	Al ₂ O ₃ 320	VERY FINE A			0.60 – 1.20	0.08 – 0.14

Surface Roughness Measurements

Rz	Results (measured values) are calculated as mean values from 5 consecutive measurements
Ra	The arithmetic average of the absolute values of the roughness profile ordinates
Rt	Maximum roughness, the distance between the highest peak and the lowest valley within the evaluation length



Roller Construction

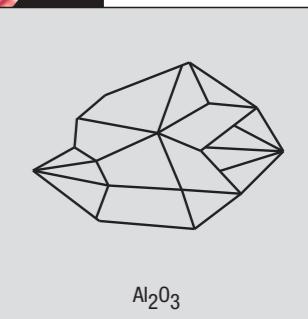
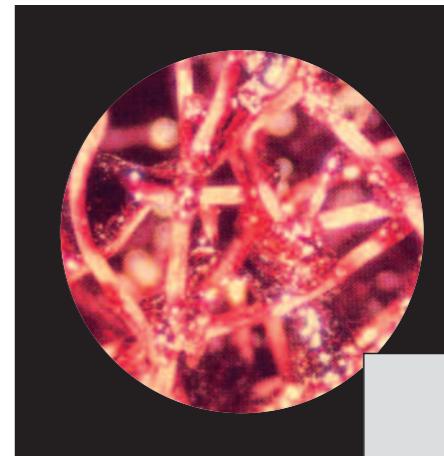
Important:

Every LIPPROX® Roller is clearly marked with a directional arrow, rollers must rotate in the direction shown.

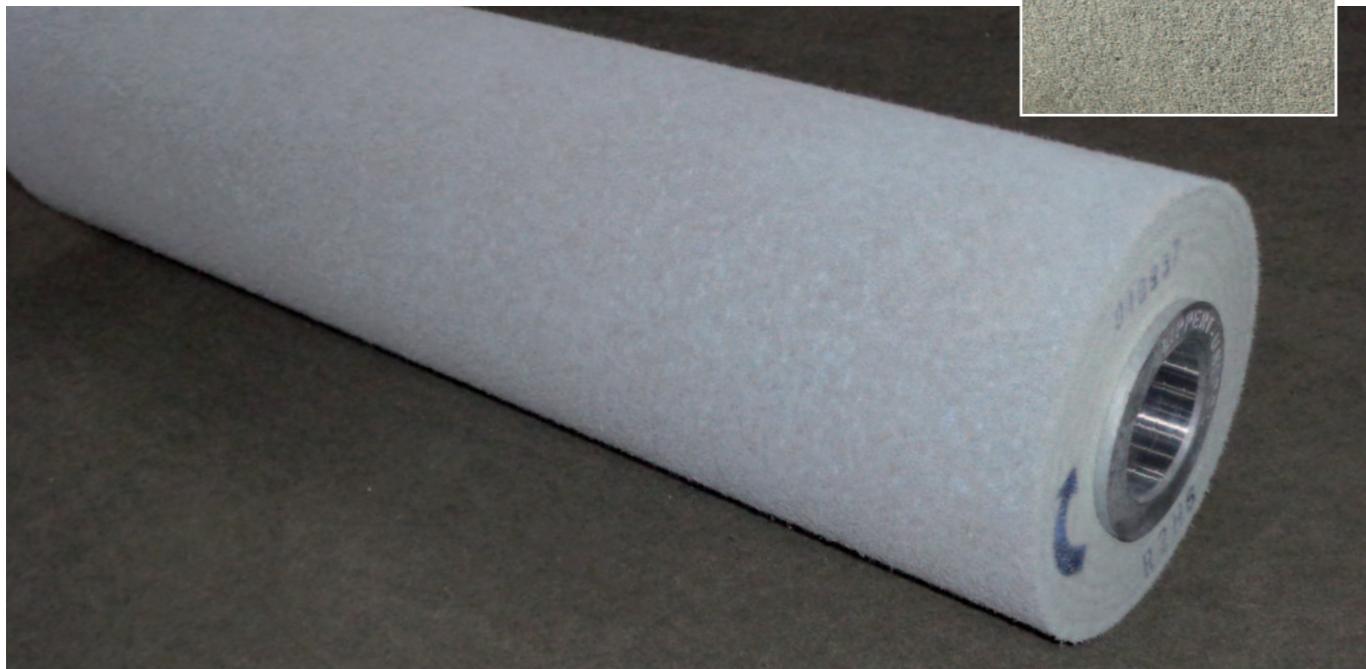


Flap Construction

Abrasive non-woven flaps are bonded radially to a phenolic core. Treatment with synthetic resin stiffens the LIPPRITE® Roller improving performance and extending its suitability for a range of applications.



LIPPROX® CDR CLEAN DEBURRING ROLLER



LIPPROX®

A convolute non-woven roller. Non-woven material is wound around a tube and polymerised.

LIPPROX® rollers are ideal for deburring since they offer considerably longer life and higher performance than comparable flap rollers.

LIPPROX® – burr removal prior to plating

Despite the introduction of high speed drills, an entirely burr free hole is rarely possible. To avoid subsequent errors, shorts or missing connections, it is necessary to ensure that the geometry of the hole edges is as precise as possible. Especially for this process, LIPPERT has developed the roller type LIPPROX®, already proven throughout the world.

Your advantages:

- uniform surface quality
- intense cleaning performance
- perfect preparation for electroplated copper coating
- minimal radiusing of the edges
- minimal brush debris
- drilled holes are not blocked by contamination from the boards or rollers
- no damage to the edges of the bore
- no clogging of brush surface
- extremely long life
- regular hardness and abrasion throughout the entire service life
- dynamic balancing available
- metal flanges for a perfect fit (no tolerance problems) and concentric run



PCB made of Teflon base material.

Deburred with LIPPROX® and perfectly metallized.



Cross-section of a bore of 0.30 mm – enlarged 500:1.
Base copper only 5–9 µm.

Deburred with LIPPROX® and perfectly metallized.



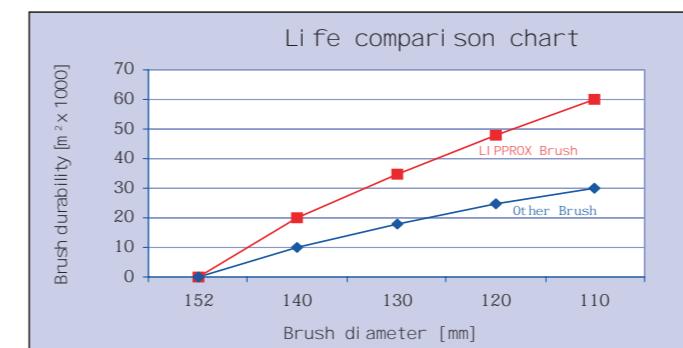
Cross-section of a bore of 0.50 mm – enlarged 100:1.

Base copper only 18 µm.

Deburred with LIPPROX® and perfectly metallized.

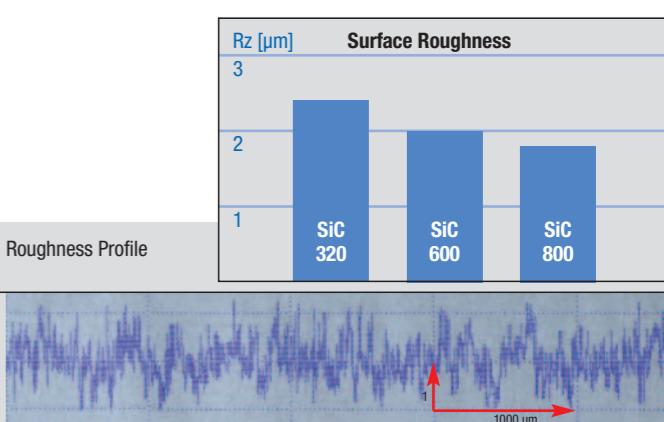
Durability

LIPPROX® Clean Deburring Roller is enhanced by the special LIPPERT bonding system that ensures a high service life of over 50,000 m² panel surface.



Surface Roughness

Brushing Roller Type	Expected surface roughness Rz (µm)	Roughness Profile
LIPPROX® CDR S8 H7 (super fine SiC 500/600)	2.0	



Product Recommendation

LIPPROX® Clean Deburring Roller	S8* C2 H6	super fine SiC 500/600 med. density	Rz = 2.0 µm
LIPPROX® Clean Deburring Roller	S8* C3 H7	super fine SiC 500/600 high density	Rz = 2.0 µm

*also available in S7 SiC 320/400 and S9 SiC 800/1000

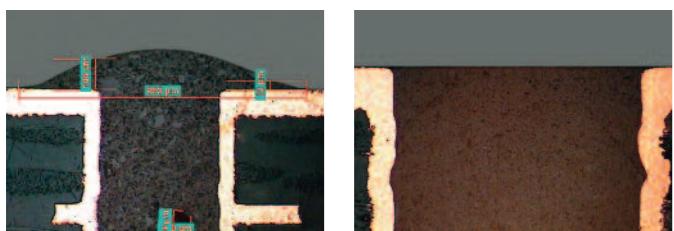
LIPPRITE® SCR SUPER CUT ROLLER



LIPPRITE® SCR

- Removing residual copper "nODULES" after plating (surface preparation prior to lamination)

After the panel plating process there may be copper "nODULES" sticking to the surface. LIPPRITE® Super Cut Roller will reduce nODULES to a minimum and smooth the gritty appearance.



- Removal of built-up resin ink spots in SBU process

To protect through plated holes from etchant used in the subsequent etching process, holes are filled with ink resin (UV-hardened or heat hardened). Intensive scrubbing power is required to remove mushrooms of resin from the boards. LIPPRITE® Super Cut Rollers produce a uniform, smooth and flat surface structure.

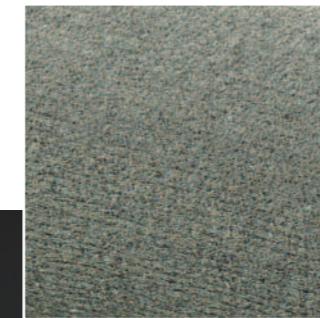


- Finishing for BGA process

This process demands the removal of excessive ink resin, either conductive or insulative, whilst increasing micro roughness for perfect adhesion of laminate.

Your advantages:

- uniform surface quality
- intense cleaning performance
- increased micro roughness
- increased adhesion of ink resist
- remains hard under wet conditions
- low risk of hole blockage
- no damage to the bore edges
- no clogging of brush surface
- dynamic balancing available
- metal flanges for a perfect fit (no tolerance problems) and concentric run



Direction of brush rotation

Station 1 (and 3):

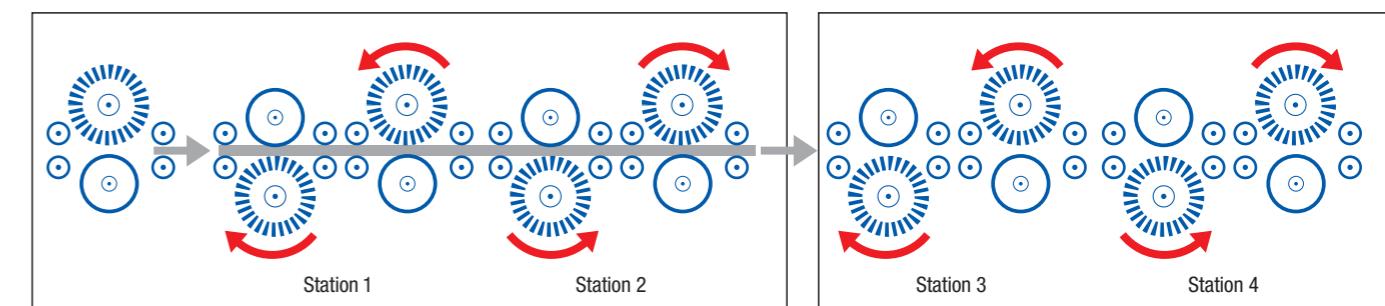
Top roller must rotate with the board.
Bottom roller must rotate with the board.

Station 2 (and 4):

Top roller must counter rotate.
Bottom roller must counter rotate.

Machine set-up for:

- Removing built-up resin ink spots
- Finishing for BGA process

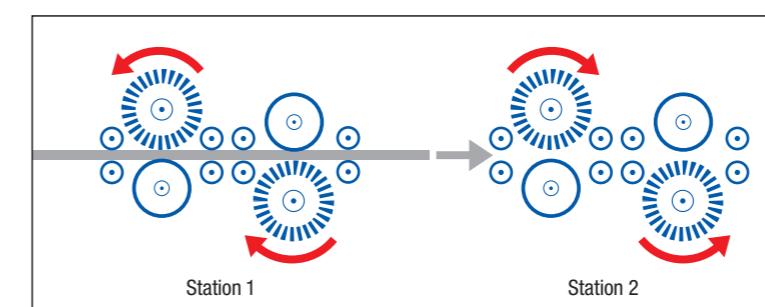


Process/Product Recommendation

Surface levelling:	Ceramic roller			
Station 1:	Ceramic roller			
Station 2:	LIPPRITE® Super Cut Roller	S7 D109 I22	VFN (SiC 320)	Rz = 2.5 µm
Station 3:	LIPPRITE® Super Cut Roller	S8 D109 I22	SFN (SiC 600)	Rz = 2.0 µm
Station 4:	LIPPRITE® Super Cut Roller	S9 D109 I22	UFN (SiC 800)	Rz = 1.5 µm

Machine set-up for:

- Removing residual copper "nODULES" after plating (surface preparation prior to lamination)
- Removing black oxide from IVH and BVH process



A brushing machine with **4 heads** is highly recommended!

Process/Product Recommendation

Station 1:	LIPPRITE® Super Cut Roller	S8 D109 I22	SFN (SiC 600)	Rz = 2.0 µm
Station 2:	LIPPRITE® Super Cut Roller	S9 D109 I22	UFN (SiC 800)	Rz = 1.5 µm

LIPPRITE® HFR HIGH RESOLUTION FINISHING ROLLER



LIPPRITE® HFR

With finer circuitry, the dry film lamination process has become very common. Dry film must adhere perfectly to the copper surface of the laminate to ensure that there is neither contact failure nor under-etching during the subsequent etching process.

Prerequisites include a clean, matt surface with no oxidation and minimal reflection properties.

LIPPRITE® High Resolution Finishing Rollers guarantee a defined and reproducible surface roughness.

Multi Purpose

LIPPRITE® High Resolution Finishing Rollers are ideal for:

- cleaning and deoxidising prior to dry film resist
- finishing prior to screen printing
- finishing prior to liquid resist
- finishing of inner layer
- finishing of flexible printed circuit boards

High Reliability

The three dimensional open web construction ensures a "self-cleaning action"; it prevents loading of surface contamination and generation of any excessive heat or "baking". Resilient brush construction allows the brush to follow an irregular surface.

New abrasive particles are continually exposed to the copper surface for a consistent and uniform finish.

Your advantages:

- uniform surface quality
- intense cleaning performance
- increased micro roughness
- increased adhesion of ink resist
- suitable for fine line technology
- low risk of hole blockage
- no damage to the bore edges
- no clogging of brush surface
- dynamic balancing
- metal flanges for a perfect fit (no tolerance problems) and concentric run



Stability and Durability

LIPPRITE® High Resolution Finishing Roller is enhanced by our own synthetic resin based treatment: I20. This special impregnation ensures improved cleaning performance, a better cushioning effect and longer service life. A further advantage: the Printed Circuit Boards can be processed more quickly and there is a subsequent increase in productivity.

Surface roughness on copper

Experience

On a perfectly flat surface (with no waviness included in measurements), the values should lie between R_z 1.5 – 3.0 μm .

Values determined in the transverse direction i.e. at 90° to the surface structure, are the most meaningful.

In the PCB industry this is the most common method of measurement, although seldom specifically mentioned.

Measurements determined in longitudinal direction (parallel to the surface structure) are generally lower than those in transverse direction and are usually only taken for control purposes.

These values are imprecise since it is almost impossible for measurements to be taken parallel to the brushing structure.

Surface Roughness

Brushing Roller Type	Expected surface roughness R_z (μm)	Roughness Profile	$R_A = 0.50 \mu\text{m}$	$R_{MAX} = 3.83 \mu\text{m}$
LIPPRITE® High Resolution S7 (very fine SiC 320)	2.5		$R_z = 3.36 \mu\text{m}$	$P_c = 158 / \text{C}$

Note: Due to waviness of the surface, surface roughness values appear higher than they really are

Brushing Roller Type	Expected surface roughness R_z (μm)	Roughness Profile	$R_A = 0.31 \mu\text{m}$	$R_{MAX} = 2.52 \mu\text{m}$
LIPPRITE® High Resolution S8 (super fine SiC 500/600)	2.0		$R_z = 2.23 \mu\text{m}$	$P_c = 175 / \text{C}$

Note: Due to waviness of the surface, surface roughness values appear higher than they really are

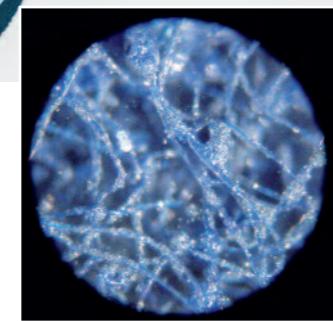
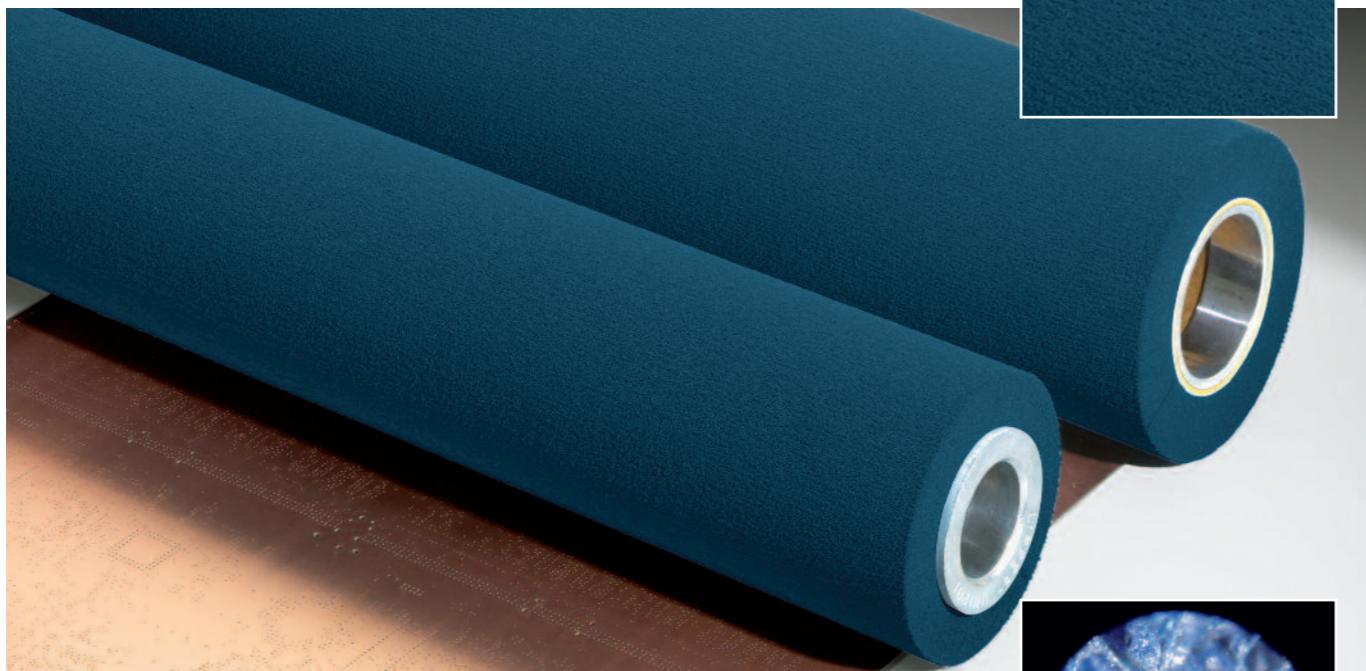
Brushing Roller Type	Expected surface roughness R_z (μm)	Roughness Profile	$R_A = 0.24 \mu\text{m}$	$R_{MAX} = 1.70 \mu\text{m}$
LIPPRITE® High Resolution S9 (ultra fine SiC 800/1000)	1.5		$R_z = 1.61 \mu\text{m}$	$P_c = 65 / \text{C}$

Note: Due to waviness of the surface, surface roughness values appear higher than they really are

Product Recommendation

LIPPRITE® High Resolution Finishing Roller	S7 Di 107/109 I20	SiC 320	$R_z = 2.5 \mu\text{m}$
LIPPRITE® High Resolution Finishing Roller	S8 Di 109 I20	SiC 600	$R_z = 2.0 \mu\text{m}$
LIPPRITE® High Resolution Finishing Roller	S9 Di 109 I20	SiC 800	$R_z = 1.5 \mu\text{m}$

LIPPRITE® HFR^{blue} HIGH RESOLUTION FINISHING ROLLER



LIPPRITE® HFR^{blue}

With finer circuitry, the dry film lamination process has become very common. Dry film must adhere perfectly to the copper surface of the laminate to ensure that there is neither contact failure nor under-etching during the subsequent etching process.

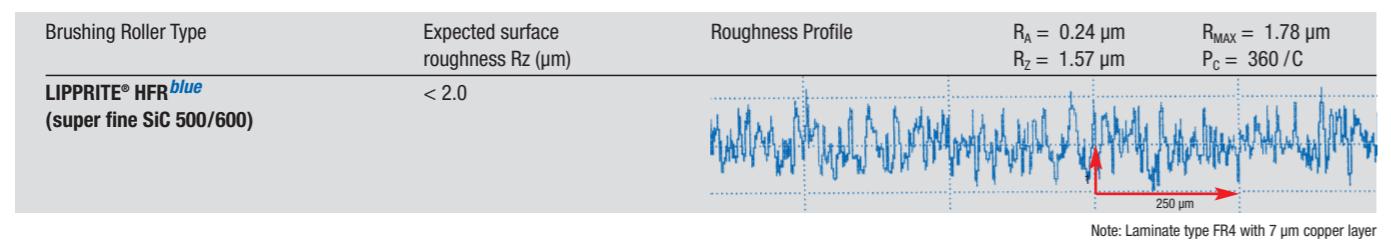
Prerequisites include a clean, matt surface with no oxidation and minimal reflection properties.

LIPPRITE® High Resolution Finishing Rollers guarantee a defined and reproducible surface roughness.

Your advantages:

- extra uniform surface quality without scratches
- intense cleaning performance
- increased adhesion of ink resist
- suitable for fine line technology
- low risk of hole blockage
- no damage to the bore edges
- no clogging of brush surface
- dynamic balancing
- metal flanges for a perfect fit (no tolerance problems) and concentric run

Surface roughness on copper



LIPPRITE® SFR SOLDERMASK FINISHING ROLLER



LIPPRITE® SFR

• Scrubbing prior to applying solder resist

Solder resist is applied by screen printing or through a photolithography method. It serves as insulation to protect the surface of circuitry and prevent deterioration or solder bridging. In this process, scrubbing must not be allowed to damage circuitry nor cause micro bridges.

• Finishing of flexible Printed Circuit Boards

Due to their light weight, flexibility and bending properties, flexible printed circuit boards have been increasingly used, in recent years, for wiring interconnections in confined spaces.

• Finishing of thin copper foils

Thin copper foils of just 50–100 µm thickness can be mechanically processed on a reverse brushing machine. Any risk of stretching, warping or folding is avoided.

• Cleaning after tin lead solder

• Removing residue after remelting

• Gold tab processing

Your advantages:

- uniform surface quality
- intense cleaning of circuitry
- increased micro roughness
- increased adhesion of ink resist
- suitable for fine line technology
- low risk of hole blockage
- no damage to the lines
- no clogging of brush surface
- dynamic balancing
- metal flanges for a perfect fit (no tolerance problems) and concentric run



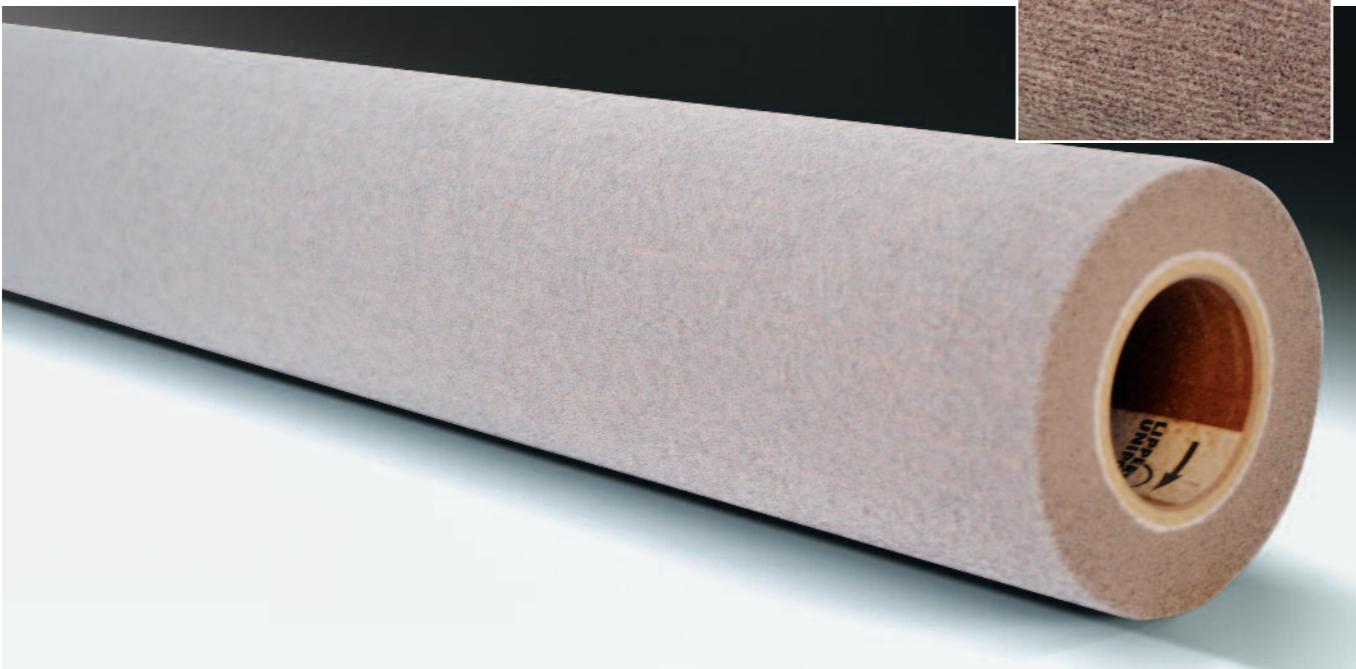
Your advantages:

- ... in a pumice system!
- non directional finish
- matt surface with minimal reflection properties
- increased micro roughness
- suitable for fine line technology (lines 50 µm apart)
- precise concentricity

Product Recommendation

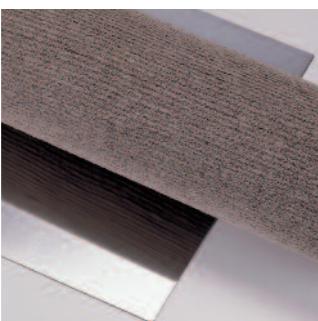
LIPPRITE® Soldermask Finishing Roller	S8 D107 I20	SiC 500/600	Rz = 2.0 µm
LIPPRITE® Soldermask Finishing Roller	S9 D107 I20	SiC 800/1000	Rz = 1.5 µm
LIPPRITE® Soldermask Finishing Roller	S8 D107	SiC 500/600	Rz = 2.0 µm
LIPPRITE® Soldermask Finishing Roller	S9 D107	SiC 800/1000	Rz = 1.5 µm

LIPPRITE® PCR PRESSPLATE CLEANING ROLLER



LIPPRITE® Pressplate Cleaning Rollers

Will remove resin that has become attached to the surface of the plates after pressing laminate or multi-layers. In the course of this process, the original surface roughness must remain unchanged.



LIPPRITE® Pressplate Cleaning Rollers have shown that in over 1,000 passes a constant brushing quality is maintained.

Your advantages:

- top brushing quality, clean surface
- no contamination of the pressplate
- precise abrasion over entire life of roller
- minimal brush debris
- no clogging of machine filter system
- concentric run
- dynamic balancing
- metal flanges for a perfect fit (no tolerance problems)

Surface Quality of Pressplates

Surface finish	Quality	Rz [µm]	Ra [µm]
No. 1	ground grit 80	8.0 – 15.0	1.20 – 2.50
No. 2	ground grit 180	5.0 – 8.0	0.70 – 1.20
No. 3	ground grit 240	2.5 – 5.0	0.30 – 0.70
No. 4	fine ground grit 320	1.6 – 2.5	0.15 – 0.30
No. 5	fine ground grit 400	1.0 – 1.6	0.13 – 0.15
No. 6	finest ground grit 500	0.6 – 1.0	0.07 – 0.13
No. 7	bright polished	0.2 – 0.4	0.03 – 0.04
No. 8	mirror polished	0.1 – 0.2	0.01 – 0.03

Product Recommendation

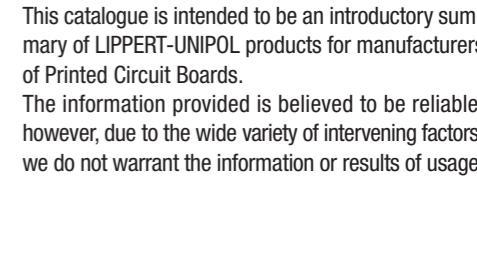
LIPPRITE® Pressplate Cleaning Roller	A4 D109 I22	Al ₂ O ₃ 120 MED	Rz = 1.6 – 2.5 µm
LIPPRITE® Pressplate Cleaning Roller	A5 D109 I22	Al ₂ O ₃ 180 MED-FN	Rz = 1.2 – 2.0 µm
LIPPRITE® Pressplate Cleaning Roller	A6 D109 I22	Al ₂ O ₃ 240 FN	Rz = 1.0 – 1.6 µm

Note: Rz on stainless steel 1.4542

INFORMATION

A selection of standard sizes available:

Dia. [mm]	Width [mm]	Bore	Machine Type
90	610	35 mm	Dilg
100	608	1"	Hibass
102	610 – 622 – 768	1"/1.25"	Chemcut
125	450	50 mm	Wesero Junior / Höllmüller 45 / Schmid 450
125	550	50 mm	Höllmüller 55
125	610	50 mm	IS Scrubbox-SHD / Wesero 600 / Schmid 600
125	650	50 mm	Schmid 650 / IS Scrubbox-2000 / Höllmüller 65 / Wesero U 600-1 / Pola & Massa / Wise
125	670	50 mm	Pola & Massa / Wise
125	750	50 mm	Wesero U700-1
125	770	50 mm	Schmid 770 / IS Scrubbox-2000 / Wise
140	610	2"	Chemcut, Marseco
152	610	2"	TTM, Billico, Somaca, Chemcut
152	610 – 650 – 710	3"	Seiko, Marugen, IML SD-1400, Ishii Hyoki, Pioneer / Wise
152	762	2"	Billico, Marseco, Chemcut
170	585	3"	Bunkyo
170	610 – 710	3"	Ishii Hyoki
254	1143	5.75"	Pioneer
300	1100 – 1500	5.75"	Century, Somaca
305	1270	180 mm	Aiki
350	1100 – 1500	190/200 mm	Wesero, Curtin Hebert



This catalogue is intended to be an introductory summary of LIPPERT-UNIPOL products for manufacturers of Printed Circuit Boards.
The information provided is believed to be reliable, however, due to the wide variety of intervening factors, we do not warrant the information or results of usage.

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