

## TECHNICAL DATA

Arborite® Phenolic Backer Laminates

Types: LB20, LB30 and LB45

### 1. Manufacturing facility locations

80 L a White Dr  
Fletcher, NC  
28732, USA

1051 NW H K Dodgen Loop  
Temple TX  
76504 USA

### 2. Product Description

#### **Recommended Uses**

Arborite® Phenolic Laminate Backer Sheets are designed for use in a three (3) ply fabrication on the backside of substrates faced with Arborite® High Pressure Decorative Laminates. Types of fabricated pieces using these products include commercial and residential furniture, wall panels, countertops, & cabinetry. Arborite® Phenolic Laminate Backer Sheets provide the fabricated piece with some balancing characteristics and added protection from the effects of humidity in their normal use. Arborite® Phenolic Laminate Backer Sheets are not designed as a functional decorative surface.

Arborite® Phenolic Laminate Backer Sheets are available in types LB20, LB30 and LB45.

For Arborite's Fire-Rated Backers, please refer to the Arborite Fire-Rated Laminate tech data sheet.

For Arborite's Solid Phenolic Backer grades, please refer to the Arborite's Compact Grades Laminates tech data sheet.

#### **Product Composition**

Arborite® Phenolic Laminate Backer Sheets are composed of kraft paper core sheets impregnated with phenolic resin. These sheets are then bonded at pressures greater than 1000 lbs. per square inch at temperatures approaching 300° F (149° C). Finished sheets are trimmed, and one or both sides are sanded to facilitate bonding.

#### **Basic Limitations**

Arborite® Phenolic Laminate Backer Sheets are designed for interior use only and are not recommended for direct application to plaster, concrete walls, or gypsum wallboard. These laminates are not structural materials, and must be bonded to suitable substrates.

Do not subject Arborite® Phenolic Laminate Backer Sheets to extremes in humidity, or temperatures higher than 275°F (135°C) for substantial periods of time, or intense, continuous, direct sunlight. Over exposure to extreme heat may cause cracking and crazing, or discoloration.

#### **Materials and Finishes**

Because the Arborite® Phenolic Laminate Backer Sheets sanded on one side are produced primarily for application to unexposed surfaces, Phenolic Laminate Backer sheets have one side sanded, and one brown (natural) colored or black side. There is no color guarantee.

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### Standard Panel size for backing laminate

Imperial Measure (in.)	Metric measure (mm)
4' x 8'	1220 mm x 2440 mm
4' x 10'	1220 mm x 3050 mm
5' x 8'	1525 mm x 2440 mm
5' x 10'	1525 mm x 3050 mm
5' x 12'	1525 mm x 3660 mm

*Note: Not all sizes are available from stock; contact your Arborite representative for details on availability.*

### 3. Technical Data

#### Thickness and Weight

Product Type	Sanded Sides	Thickness	Weight per sq. ft. (lbs.)
LB20 Brown or Black core	One	0.020" ± 0.003" (0.51mm ± 0.008mm)	0.131
LB30 Brown or Black core	One	0.028" ± 0.004" (0.71mm ± 0.10mm)	0.167
LB45 Brown or Black core	One	0.048" ± 0.005" (1.22mm ± 0.13mm)	0.297

#### General Standards

Arborite Phenolic Laminate Backer Sheet Types LB20, LB30 and LB45 conform to the relevant standards for BKL, BKV and BKH respectively

Since such backer sheets are designed for application to the unexposed backs of fabricated pieces, ISO 4586-1:2018 sets no standards for performance properties or appearance on these products.

#### Mobile Homes

U.S. Federal Register August 9, 1984, Housing and Urban Development Mobile Home Construction and Safety Standard (24CFR), 3280.203. Fire-Rated Laminate Types 264 and 266 comply.

The UL GREENGUARD Environmental Institute™ has awarded its UL GREENGUARD® Indoor Air Quality Certification to Arborite Phenolic Backer Laminates. All Arborite Phenolic Backer Laminate product types were tested under the stringent UL GREENGUARD Standards for low-emitting products. All UL GREENGUARD Indoor Air Quality Certified products ensure minimal impact on the indoor environment. For a copy of the certificate, visit [www.greenguard.org](http://www.greenguard.org).

### 4. Fabrication and Assembly

Fabrication should follow approved methods. Assembled pieces should meet the specifications of KCMA (Kitchen Cabinetmakers Manufacturers Association), ANSI A-162.2-1998 (revised), and "Architectural Woodwork Quality Standards, Guide Specifications and Quality Certification Program" guidelines of the Architectural Woodwork Institute where applicable.

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Arborite Phenolic Laminate Backer Sheets must be bonded to a suitable substrate of reliable quality, such as particleboard, medium density fiberboard or plywood with one A-face. All decorative laminate, plaster, concrete and gypsum board should not be considered suitable substrates. Wilsonart Phenolic Laminate Backer Sheets may not be used as structural members.

Arborite Phenolic Laminate Backer Sheets may be bonded with most adhesives. Recommended adhesives are permanent types, such as urea and polyvinyl acetate (PVA), and contact types. Wilsonart® Adhesives are recommended for most bonding applications. Please follow all manufacturers' recommended instructions and technical data information.

Take care to ensure an appropriate acclimation between the laminate the substrate and the phenolic backer sheets prior to fabrication. The materials should be acclimated/conditioned a minimum of 48 hours before fabrication.

The recommended conditioning/acclimation temperature for the materials is approximately 75°F (24°C), with 45-55% relative humidity.

Carbide-tipped saw blades and router bits are recommended for cutting. High tool speed and low feed rates are advisable. Cutting blades and bits should always be kept sharp. The use of a hold-down bar is recommended to prevent vibration.

**5. [Warranty](#)****6. Maintenance**

Surfaces with Arborite Phenolic Laminate Backer Sheets requires little or no maintenance as long as they are protected from physical abuse.

**7. Technical Services**

For samples, literature, questions or technical assistance, please email us at [info@arborite.com](mailto:info@arborite.com) or contact our toll-free number, 1-800-996-0366 Monday through Friday, 8:30 am – 5:00 pm, EST.