



# Alka-Max M | Technical Data Sheet

## Melamine Barrier Film

### *Alka-Max M Specialty Concrete Form Overlay*

#### **Description -**

Paneltech's Alka-Max M is a high resin content specialty overlay composed of a bleached kraft paper saturated with high levels of a melamine resin. Its higher resin content gives a smooth, glossy surface well suited for maximum durability as a concrete forming surface. It gives a very smooth surface finish to concrete and will release easily from set concrete when used with the appropriate form release.

Alka-Max M bonds well to a 396C cushion sheet as well as commonly used wood substrates. Alka-Max M has undergone extensive field testing and exceeds the requirements of the PS 1-07 Voluntary Product Standard. Alka-Max M uses the same well-proven release system as Paneltech HDO, eliminating the residue buildup on press cauls typical of competitive products. While the use of this product over suitable hardwood veneers is recommended, softwood veneers may be used with some reduced durability. Best results can be achieved using cauls or press surfaces free from scratches and dents, as these will transfer to the panel overlay.

#### **Features -**

- ✓ Hard, alkaline and abrasion resistant surface
- ✓ Smooth architectural finish on concrete
- ✓ Increases alkalinity resistance of concrete form
- ✓ Quality controlled continuously by online weight and volatile sensors, calibrated hourly
- ✓ Each sheet visually inspected
- ✓ No buildup of release on cauls

#### **Specifications -**

Base Paper: 50 lb/3000 sf Bleached Saturating Kraft  
Resin Content: 56% ± 1.5%  
Weight: 81 gsm / 192 gsm (as is)  
Caliper Thickness: 0.20mm (0.008 in.) (Before pressing)  
Color: Gray  
Opacity: High



## Technical Data Sheet (continued)

### Melamine Barrier Film

#### *Alka-Max M Specialty Concrete Grade Overlay*

#### **Laminating Recommendations:**

For best results, Alka-Max M should be applied over hardwood substrates with an exterior type glue line and have a process moisture content of not more than 8%. Press cycles may vary dependent upon press temperature. Smooth, clean release cauls are required between the press platens and panel overlay. To eliminate buildup and sticking, these cauls should be used only with other compatible release systems. A minimum temperature of 285°F (140°C) at 185 to 200 psi (13.0 to 14.1 kg/cm<sup>2</sup>) and a minimum press cycle of 6.5 minutes should be met. Panels require minimal cooling after pressing.

#### **Applications:**

Concrete Form  
Industrial Flooring  
Transportation Flooring  
Other applications requiring high alkalinity resistance

#### **Packaging -**

Sheet Dimensions in (cm)	50 in (127cm) x 99 in (252cm)	50 in (127cm) x 124 in (315cm)
Options	(Sheet Length, Sheet Width Sheets per Unit Adjustable)	(Sheet Length, Sheet Width Sheets per Unit Adjustable)
Sheets Per Unit	2000	1000
Total Area Measure sf (sm)	34,375 sf (3195 sm)	27,986 sf (2601 sm)
Gross Weight lb (kg)	2437 lb (1108 kg)	1526 lb (694 kg)

#### **Storage Recommendations -**

Recommended storage conditions are 70°F (21°C) or less in a dry location with the original packaging intact. High temperature and humidity will lead to blocking. Open rolls or pallets should be repackaged in the polyethylene material provided or equivalent. Under these conditions, the expected shelf life is 6 to 12 months.