



120N1 | Technical Data Sheet

High Density Overlay (HDO)

120N1 Concrete Grade

Description -

HDO 120-in-1 (120N1) is essentially equivalent to two sheets of HDO 173C. Paneltech's 120N1 HDO is a specialty overlay composed of a single sheet of bleached kraft paper saturated with high levels of phenolic thermoset resin. Its high resin content gives a smooth surface ideally suited for use as a concrete forming surface. It gives a smooth surface finish to concrete suitable for architectural pours. HDO 120N1 bonds well to an MDO cushion sheet as well as commonly used wood substrates. 120N1 exceeds the requirements of the PS1-19 Voluntary Product Standard. Its unique internal release system reduces the residue buildup on press cauls typical of competitive products.

Features -

- ✓ Hard surface quality, highly resistant to alkalinity and abrasion from concrete
- ✓ Smooth architectural finish on concrete
- ✓ Quality controlled continuously by online weight and volatile sensors, calibrated hourly
- ✓ No release buildup on press cauls – extends the life of your press cauls
- ✓ Excellent performance in 120/30 panels

Specifications -

Base Paper: 100 lb/3000 sf Bleached Saturating Kraft
Resin Content: 53.5% ± 1.5%
Weight: 157 gsm / 354 gsm
Caliper Thickness Before Pressing: 0.342mm (0.0135 in.)
Caliper Thickness After Pressing: 0.272mm (0.011 in.)
Color: Light Yellow
Opacity: Medium



Technical Data Sheet (continued)

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Laminating Recommendations:

For best results, 120N1 should be applied over substrates bonded with an exterior type glue resin. Panels should have a smooth, even surface with no low-pressure areas. One-step panels should have a moisture content of not more than 8%. Two-step panels should be evenly sanded with minimal calliper variation. Press cycles may vary dependent upon press temperature. Release cauls are normally required between the press platens and panel overlay. To eliminate buildup and sticking, these cauls should be used only with other compatible release systems. Please consult the appropriate overlay press chart in this binder for actual time and temperature recommendations. Panels require some cooling after pressing. Enough cooling time should be allowed so that your hand can rest comfortably on the panel for 30 seconds. For best results, we recommend field applications of Nox-Crete Release Agent #10 at the manufacturer's recommended application rate.

Applications:

- Concrete Form
Industrial Flooring
Transportation Flooring
Other applications requiring high moisture and abrasion resistance

Packaging -

Table with 3 columns: Sheet Dimensions in (cm), Sheets Per Unit, Total Area Measure sf (sm), Gross Weight lb (kg). Includes a note: (Sheet width, length and sheets per unit are adjustable)

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 9 months.