



180C | Technical Data Sheet

High Density Overlay (HDO)

180C Concrete Grade

Description -

Paneltech's 180C Conform HDO is a higher resin content specialty overlay composed of a bleached kraft paper saturated with high levels of phenolic thermoset resin. Its higher resin content gives a smooth, glossy surface well suited for a little extra durability as a concrete forming surface. It gives a smooth surface finish to concrete and will release easily from set concrete when used with the appropriate form release.

HDO 180C bonds well to an MDO cushion sheet as well as commonly used wood substrates. HDO 180C has undergone extensive field testing and exceeds the requirements of the PS1-19 Voluntary Product Standard. 180C uses the same well-proven release system as 173C, reducing the residue buildup on press cauls typical of competitive products.

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
- ✓ Minimal buildup of release on cauls

Specifications -

Base Paper: 50 lb/3000 sf Bleached Saturating Kraft
Resin Content: 57% ± 1.5%
Weight: 81 gsm / 192 gsm (as is)
Caliper Thickness: 0.20mm (0.008 in.) (Before pressing)
Color: Light Yellow (multi-colored logo available on request)
Opacity: Medium



Technical Data Sheet (continued)

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Laminating Recommendations:

HDO 180C is designed to enhance the performance of the 100/30 or 100/100 panels. We would recommend using 180 only with the 100/30 or 100/100 constructions. Using this higher resin content HDO in a 120 construction has reportedly increased the risk of panel checking.

For best results, 180C 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 caliper variation. Press cycles may vary dependent upon press patens and panel overlay. To eliminate buildup and sticking, cauls, as well as chrome or polished steel platens 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. For improved check resistance, we recommend cooling after pressing. We recommend applying a quality release agent to the panel before each pour. For best results, we recommend field applications of Nox-Crete Form Coating, Release Agent #10, or a functionally equivalent form release.

Applications:

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

Packaging -

Sheet Dimensions in (cm)	50 in (127cm) x 99 in (252cm)	50 in (127cm) x 124 in (315cm)
	(Sheet width, length and sheets per unit are adjustable)	
Sheets Per Unit	1000	1000
Total Area Measure sf (sm)	34,375 sf (3195 sm)	27,986 sf (2601 sm)
Gross Weight lb (kg)	1550 lbs (703 kg)	1750 lbs (794kg)

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.