

## 454 C | Technical Data Sheet

### Medium Density Overlay (MDO)

#### *454C Concrete Grade MDO*

##### **Description -**

Paneltech's 454 Conform MDO is a concrete form overlay saturated with a phenolic resin. It has high-masking properties with a mottled surface appearance that gives a pleasing leather-like finish to the concrete form. The combination of a high resin content and a resin formulated to resist the action of alkaline concrete fluids make the overlay especially useful for concrete forming applications. It gives a smooth matte finish to concrete and is treated to release easily from forms when coated with the appropriate form oil. The paper is well saturated with resin to ensure a high form life and to prevent internal paper delamination. This high internal bond is unique to Paneltech's overlays and is quite important for concrete forming applications.

As with other Paneltech MDO products, 454C has a proprietary glueline formulation that gives it strong adhesive properties when bonding to all commonly used wood substrates. MDO 454C exceeds the requirements of the PS1-19 Voluntary Product Standard.

##### **Features -**

- ✓ Hard, abrasion and alkaline resistant surface
- ✓ Masks panel defects
- ✓ Increases alkalinity resistance of concrete form
- ✓ Quality controlled continuously by online weight and volatile sensors, calibrated hourly
- ✓ Each sheet visually inspected

##### **Specifications -**

Base Paper: 132 lb Saturating Kraft (200 gsm bone dry weight)  
Resin Content: 35%  $\pm$  1.5%  
Weight: 215 gsm / 371 gsm  
Caliper Thickness: 0.53mm (0.021 in.) (Before pressing)  
Glueline Weight: 65 gsm  $\pm$  5 gsm  
Color: Natural Kraft



**Technical Data Sheet (continued)**

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**Laminating Recommendations:**

For best results, 454C should be applied over a smooth face, free of particulate and debris. Press cycles will vary dependent upon the species and thickness of wood, one or two step process and press temperature. Please consult the appropriate overlay press chart in this binder for actual time and temperature recommendations. Thinner panels may require a lightweight backer/MDO to help balance and add stability. Panel edges should be sealed for exterior applications. Application of form oil to the finished panel will give a top quality, ready-to-use concrete form element. For best results, we recommend field applications of Nox-Crete Form Coating, Release Agent #10, Bio-Nox, Chembeton or a functionally equivalent form release.

**Applications:**

Concrete Form – Smooth matte surface

**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	650
Total Area Measure sf (sm)	34,375 sf (3195 sm)	27,986 sf (2601 sm)
Gross Weight lb (kg)	2750 lbs (1275 kg)	2250 lbs (1020 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.