



## 407C | Technical Data Sheet

### Medium Density Overlay (MDO)

*407C Concrete Grade MDO*

#### **Description -**

Paneltech's new 407C Conform MDO is a high resin content specialty overlay. While it is cured sufficiently to reduce sticking in the press, it still densifies under heat and pressure and exhibits the desirable properties of a high flow MDO. The combination of high resin content with a resin formulated to resist the action of alkaline concrete fluids gives 407C unsurpassed performance 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 higher resin content, other things being equal, will give more pours on average than a standard MDO.

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, 407C has a proprietary glueline formulation that gives it strong adhesive properties when bonding to all commonly used wood substrates. MDO 407C exceeds the requirements of the PS1-07 Voluntary Product Standard.

#### **Features -**

- ✓ 38% resin content
- ✓ Hard, abrasion and alkaline resistant surface
- ✓ Masks grain pattern and panel defects
- ✓ Increases alkalinity resistance of concrete form
- ✓ Quality controlled continuously by online weight and volatile sensors, calibrated hourly
- ✓ Each sheet visually inspected



## Technical Data Sheet (continued) Medium Density Overlay (MDO)

### 407C Concrete Grade

#### Specifications -

Base Paper: 132 lb Saturating Kraft (200 gsm bone dry weight)
Resin Content: 38% ± 1.0%
Weight: 215 gsm / 398 gsm
Caliper Thickness: 0.53mm (0.021 in.) (Before pressing)
Glueline Weight: 65gsm ± 5gsm
Color: Natural Kraft

#### Laminating Recommendations:

For best results, 407C 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. Use a minimum press temperature of 285°F (140°C) at 175 psi (12.33 kg/cm<sup>2</sup>) and a press cycle of 6 to 7.5 minutes. 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.

#### 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)
Options	(Sheet Length Variable)	(Sheet Length Variable)
Sheets Per Unit	1200	1200
Total Area Measure sf (sm)	34,375 sf (3195 sm)	43,055 sf (4002 sm)
Gross Weight lb (kg)	2080 lb (945 kg)	2485 lb (1130 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 9 months.