



409P | Technical Data Sheet

Medium Density Overlay (MDO)

409P Paint Grade MDO

Description -

Paneltech's 409P Paint Grade MDO is a specialty overlay that gives the same superior surface quality of 357 & 360 with a higher caliper sheet. The added material in 409P lends itself to the more challenging paint grade applications presented by softwood plywood.

The overlay is saturated with petroleum-free phenolic resins derived from organic materials. When applied to a panel, 409P provides a smooth, high-masking overlay with enhanced paint adhesion characteristics for plywood, OSB, particleboard, MDF and a variety of composites. It also has good machineability for decorative applications. As with other Paneltech MDO products, 409P has a proprietary glue line formulation that gives it strong adhesive properties when bonding to all commonly used wood substrates.

Features -

- ✓ Smooth, paintable surface
- ✓ Excellent paint adhesion
- ✓ Superior masking properties for uneven surfaces
- ✓ 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)

409P Paint Grade

Specifications -

Base Paper: 132 lb Saturating Kraft (200 gsm bone dry weight)
Resin Content: 28% ± 1.5%
Weight: 215 gsm / 341 gsm
Caliper Thickness: 0.45mm (0.019 in.) (Before pressing)
Glueline Weight: 65gsm ± 5gsm
Color: Natural Kraft

Laminating Recommendations:

For best results, 409P MDO 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 275°F (135°C) at 175 psi (12.33 kg/cm²) and a press cycle of 5 to 7.5 minutes. Thinner panels may require a lightweight backer/ MDO to help balance and add stability. The panel edge should be sealed for exterior applications.

Applications:

Signs • Siding • Color accent panels • Gable ends • Garage doors • Marine bulkheads, decks, cabins, hatch covers • Chimney enclosures • Fruit and vegetable bins • Transportation side walls • Cabinets and built-ins • Privacy screens • Cupolas • Farm buildings and equipment • Fertilizer bins • Soffits and fascia • Painted exterior surfaces • Other applications requiring a paintable surface with good moisture resistance

Packaging -

Sheet Dimensions in (cm)	50 in (127cm) x 99 in (252cm)	50 in (127cm) x 124 in (315cm)
Options	(Sheet Length, Width, Sheets per Unit Adjustable)	(Sheet Length, Width, Sheets per Unit 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)	2514 lb (1142 kg)	2043 lb (920 kg)

Storage Recommendations -

Recommended storage conditions are 70°F (21°C) or less in a dry location with the original packaging intact. Stack height should be 5 units or less. 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.