TruNatur

Fabrication & Installation Guide

Polymer Veneer Woodgrain Indoor Panels
Australia & New Zealand

July 2024

INTRODUCTION

Thank you for interest in the *EGR Decor TruNatur product range.*

This document provides a comprehensive set of technical specifications for TruNatur, as well as answering common questions about machining, fabrication, installation, and care.

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Contents

Overview 3

Application 3

Quality Features 3

Core options 3

Notes 4

Design 4

Handling 4

Storage 4

Panel Fabrication 5

Laminate Fabrication 6

Installation Guide 6

Care and maintenance 7

Health and Safety 7

Warranty 7

Unsuitable Applications 7

Certifications 7

Overview

TruNatur is a premium polymer veneer-faced panel that incorporates nanosized technology and antibacterial properties, offering a high-performance alternative to timber veneer. The TruNatur collection features a range of woodgrain patterns and embossed surfaces, delivering a natural look and feel. These faced products are highly resistant to scratching, staining, chemicals, and UV light, ensuring lasting durability, aesthetic appeal, and functionality for your projects.

Application

TruNatur is designed for indoor use, suitable for vertical and light-duty horizontal applications.

Quality Features



Core options

- **TruNatur MR EO MDF panels**
  They are an excellent choice for both residential and commercial projects, including kitchen, vanities, shelving, displays, panels, wall and ceiling lining, and various other applications within the cabinetry and joinery industry.
- **TruNatur Laminate sheets**
  They are designed for curved applications, seamlessly complementing face panels in both residential and commercial projects. Ideal for enhancing reception areas, vanities, shelving, displays, and architectural features on walls and ceilings.
- **TruNatur Weatherproof Composite Core (WCC) panels**
  They are suitable for non-structural applications in high-humidity interiors or areas prone to frequent wetting, like kitchens, vanities, bathrooms, and laundries.
- **TruNatur Lightweight (LW) Plywood panels**
  They are a great option for internal fitouts in caravans and RVs, as well as other non-structural interior applications where weight-saving benefits are preferred.
- **TruNatur BLOCKBOARD panels**
  They are highly favoured by architects and designers for residential and commercial projects, sought after for vertical and horizontal beams, internal doors, floating shelves, timber screens, and various non-structural interior applications.
- **TruNatur BLACK Fire Rated (FR) Group 1 MDF panels**
  They are an excellent option for residential and commercial projects, particularly for wall and ceiling lining, designing routed panels, and other non-structural interior applications that necessitate a Group 1 fire-rated product.

- **TruNatur GREY Fire Rated (FR) Group 2 MDF panels**
  They are a great choice for residential and commercial projects, especially for wall and ceiling lining, designing routed panels, and other non-structural interior applications that require a Group 2 fire-rated product.

Notes

- Fabrication and installation of TruNatur products must comply with the relevant sections of AS 4386.
- TruNatur Products should never be used outdoors, as structural or built-in elements, or for horizontal applications.
- TruNatur may not be suitable for every application, and it is the installer's sole responsibility to ensure their suitability for the intended use.
- EGR DECOR accepts no liability or responsibility for the improper installation of TruNatur products.
- Read this document in conjunction with the TruNatur Cleaning Guide and Warranty available on our website.
- Visit egrdecor.com/trunatur

Design

- Plan the direction and matching of woodgrain for compatibility with the overall cabinet layout and assembly.
- Coordinate the plumbing and other service integration to prevent last minute and unwanted modifications.
- Single-piece doors larger than 600mm (24") in width and 1800mm (70") in height are not recommended.
- Single-piece doors larger than 600mm (24") in width and 1200mm (47") in height are not recommended for TruNatur WCC panels.
- Utilise split door construction or other appropriate methods for large doors.

Handling

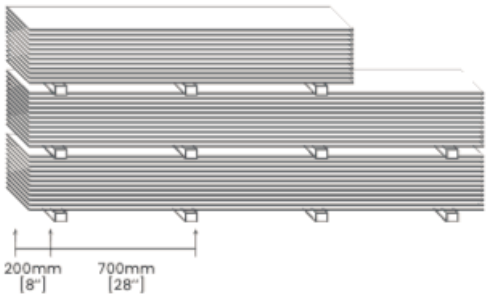
- Handle the panels and laminate sheets with great care to prevent breakage and damage .
- Always use two persons to handle large panels or laminate sheets.
- Keep the protective film intact until the project is complete.
- Lift panels and sheets during loading and unloading operations, avoid sliding them.

Storage

- Store panels and laminate sheets in in well-ventilated, clean, and dry conditions.
- Never store or transport panels and laminate sheets in direct sunlight.
- Use cover boards on top and bottom of stacked panels and laminate sheets.
- Place pack on four equally spaced bearers on a level, hard, dry surface.
- Stack multiple pallets with aligned bearers.
- TruNatur laminate sheets can be rolled up and transported in cartons but should be removed and stored flat and horizontally as soon as possible.

Correct storage method

— Always use suitable equipment for panel and laminate sheet transportation.



Panel Fabrication

Processing

— Always inspect panels and laminate sheet for visible defects or damage prior to fabrication.
— TruNatur panels and laminate sheets can be easily cut, drilled, and routed using standard woodworking tools.
— Use new, sharp, carbide-tipped saw blades, router bits, and drill bits for precise cutting.
— Operate at slow to medium speeds to prevent overheating.
— Rough edges may occur due to excessive friction, inadequate support, or worn/improper tooling.
— Adjust processing to prevent masking strands at the edges, which can complicate edgebanding.
— Always conduct trials to determine optimal operations and settings.
— Ensure adequate ventilation and extraction for the processing machines.

Routing

— Router cutting is the preferred and recommended method for TruNature panels and laminate sheets.
— Use a feed rate of 10 to 15 meters (11 to 16 yards) per minute and a spindle speed of 15,000 to 20,000 rpm.
— Twin or triple flute compression cutter is ideal to minimise chipping and feathering of the protective film.
— Ensure cutters penetrate into the sacrificial board slightly to prevent chipping.

Saw Cutting

— Use sharp carbide-tipped blades with 3 to 5 teeth per centimetre (8 teeth per inch).
— Utilise a 300mm (12") diameter blade spinning at 3200rpm for best results.
— Employ a panel saw machine with a scoring blade to prevent chipping.
— Maintain steady cutting rate.
— Trim all board edges for a clean finish.
— Clamp panels or hold firmly in place to minimize vibration to avoid chipping.

Drilling

— Use drills with a tip angle of 110° to 130°.
— Pre-drilling is recommended for best results.
— Apply sacrificial material on the backside to prevent chipping.

Fastening

— Carefully position screws to prevent splintering.
— Ensure adequate fixing with centers no greater than 500mm apart.
— Ensure adequate fixing with centers no greater than 350mm apart for TruNatur WCC panels.
— Place screws inserted into the face at least 12 mm away from the board edge.
— Keep screws inserted into the face at least 25 mm away from corners.
— Pilot holes are necessary for all screw fixings.
— Countersink holes are necessary for optimal results.

Hinge Recommendation

- Always conduct hinge drilling trials on a test piece to ensure proper depth and back set.
- Only use the recommended hinge quantities.

DOOR HEIGHT	COMPONENT WEIGHT	NUMBER OF HINGES
Up to 800 mm	≤ 7 Kg	2 hinges
800 to 1300 mm	≤ 11 Kg	3 hinges
1300 to 1800 mm	≤ 16 Kg	4 hinges

- Only use the recommended hinge quantities for TruNatur WCC panels.

DOOR HEIGHT	COMPONENT WEIGHT	NUMBER OF HINGES
Up to 800 mm	≤ 7 Kg	3 hinges
800 to 1200 mm	≤ 11 Kg	4 hinges

Edge Finishing

- Only use TruNatur edgeband products.
- TruNatur edgeband is made of ABS and supplied preprimed for EVA and PUR bonding.
- Store edgebands in clean, well-ventilated, and dry conditions.
- Use an edgebanding machine with a pre-milling function for best results.
- Set scrapers to avoid contact with the embossed surface.
- Edgebanding is necessary on all exposed panel edges.
- Remove excess glue with a microfiber cloth dampened with mineral turpentine.
- Always conduct trials to determine optimal operations and settings.

Laminate Fabrication

- Cold bending is the sole suitable fabrication method for TruNatur laminate sheets.
- TruNatur laminate sheets can be cold bent to a radius of 200 mm (8 ").
- Use templates, jigs and/or moulds to ensure strong laminate bonding.
- Press bonding is essential to achieve optimal results.
- Bendy plywood and craftform MDF panels are the recommended laminate substrates.
- Always perform pressing tests and trial bonding to determine the best settings.
- TruNatur laminate sheet are never be used for postforming fabrication.

Installation Guide

- Ensure cabinets are fitted square, plumb, and level to ensure correct function of doors and face panels .
- Install and align doors so they are square with the cabinet and operate freely without excessive looseness or binding.
- Doors shall also be installed and aligned so that they are square with the cabinet and can operate freely without excessive looseness or binding.
- Keep the protective film on the panel during fabrication and installation to prevent damage.
- Maintain a 6mm air gap adjacent to ovens and other heat sources.
- Avoid over-tightening or hammering in hardware.
- Use adhesive stickers for marking/coding and remove them immediately after installation.

Care and maintenance

- Use warm water and a clean microfiber cloth or soft sponge to clean most dirt and stains.
- Never use abrasive cleaners or rough materials.
- Refer to TruNatur Cleaning Guide available on our website .

Health and Safety

- Always adhere to health and safety guidelines when working with wood panel products.
- Exposure to wood dust and/or formaldehyde can cause irritation to the eyes, respiratory system, and skin, and may lead to asthma and/or dermatitis.
- Wood dust is classified as a known carcinogen, and prolonged inhalation may increase the risk of nasal cancer. Formaldehyde is classified as a group 1 carcinogen by the IAR.
- Ensure work areas are well-ventilated and clean. Processing machines should be equipped with dust extractors to maintain dust levels within safe limits as per local regulations.
- Dispose of offcuts, shavings, and dust in accordance with local regulations.

Warranty

- TruNatur is backed by a 7-year limited indoor warranty
- Refer to the TruNatur Warranty available on our website for full terms and conditions.

Unsuitable Applications

- TruNatur panels are never be used outdoors or for structural applications.
- TruNatur laminate sheet are not suitable for postforming fabrication.
- Do not use TruNatur products in high impact or high traffic installation such as benchtops, counter tops, or tables.
- Avoid using TruNatur products in areas with frequent or excessive exposure to heat, hot gases, or moisture.

Certifications

- TruNatur has achieved the GreenTag PHDTM PlatinumHEALTHTM rating, a designation recognised by WELL™ and LEED® as world-leading for the healthiness of products used by end-users. Made in Australia in an ISO9001 approved facility, these environmentally friendly panels meet strict quality standards.

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