TruNatur

Waterproof Cabinetry Fabrication & Installation Guide

Polymer Veneer Woodgrain Indoor Panels
Australia & New Zealand

September 2025

INTRODUCTION

Thank you for interest in the *TruNatur Waterproof product range.*

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

TECHNICAL SUPPORT

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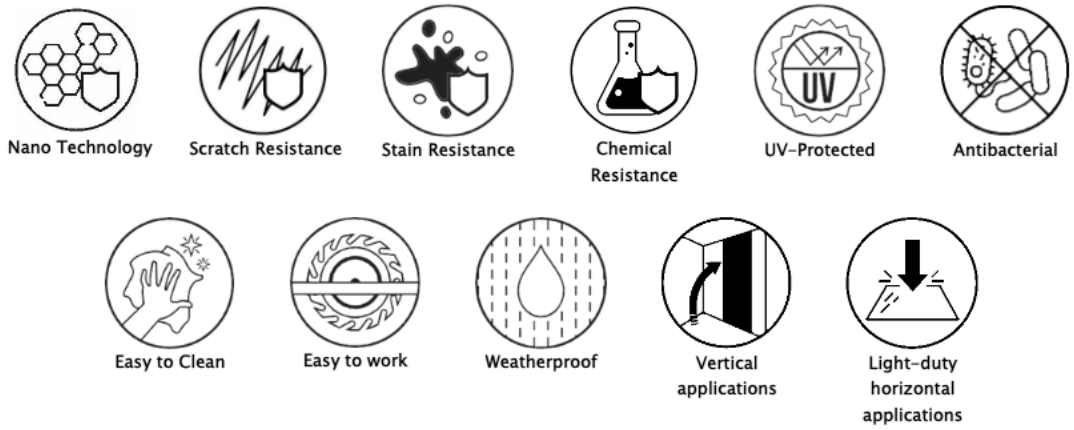
Overview

TruNatur Waterproof is a high-performance, water-resistant panel solution that combines a durable Weatherproof Composite Core (WCC) with a premium polymer veneer, bonded using advanced PUR reactive hotmelt technology. The premium polymer veneer features a nano coated surface that offers superior resistance to scratches, stains, chemicals, UV exposure and antibacterial protections.

Applications

TruNatur Waterproof is designed for interior decorative vertical and light-duty horizontal applications - including cabinet doors, drawer fronts, face panels, and floating shelves- and offers a high-performance alternative to natural timber veneer in flood-prone or high-moisture areas such as kitchens, bathrooms, laundries, utility rooms, and mudrooms.

Quality Features



TruNatur Waterproof Panels

Premium polymer veneer offers different woodgrain patterns and textured embossing for a natural timber look and feel.

SUBSTRATE	FINISHED PANEL SIZE	APPLICATION	WEIGHT	FINISH
Weatherproof Composite Core (WCC)	2400x1200x18mm	Cabinet doors, drawer fronts, face panels, and floating shelves	13kg/m^2	Woodgrain textured

Important Information

- Fabrication and installation must comply with AS/NZS 4386 standard and relevant guidelines in this document.
- EGR DECOR is not liable for improper fabrication or installation of TruNatur products.
- It is the installer's responsibility to ensure the product's suitability for the intended application.

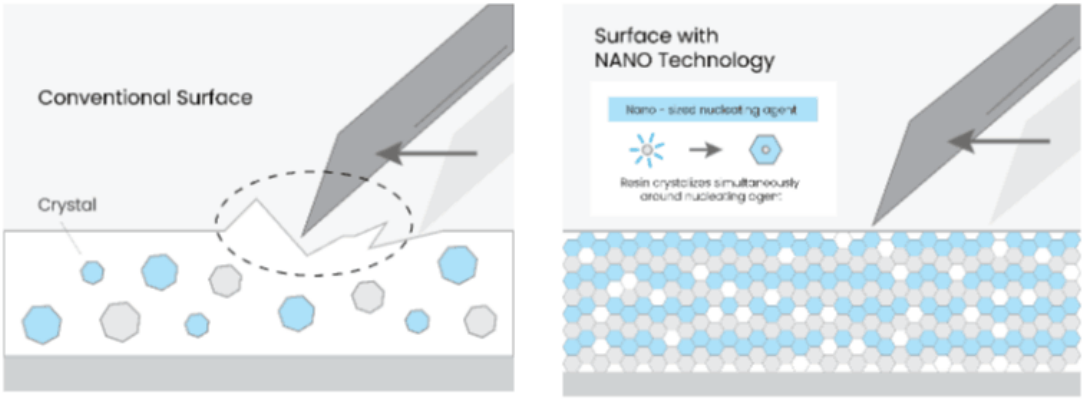
Warranty

- TruNatur panels include a limited 7-year warranty.
- TruNatur edgebanding include a limited 1-year warranty.

TruNatur Waterproof Panels – Installation & Fabrication Top Tips

- Install only in indoor, undercover areas, away from direct sunlight.
- Store panels flat, horizontal, and fully supported at all times.
- Panels can be cut and drilled using the same tools as MDF and other wood-based materials.
- Compatible with all standard hardware and hinge systems. Use 5 mm Euro screws for best results.
- Single doors should not exceed 600 mm width to maintain strength and stability.
- Place fixing points every 300 mm or less for proper support.
- Pre-drill and countersink to ensure stronger joints.
- Avoid cut-outs or openings; if required, reinforce to minimise warping/twisting.
- Seal all edges with suitable edging or sealant to protect against moisture and damage.
- Edgebanding is suitable with both EVA and PUR adhesives.
- Do not use as routed panels where the core is exposed, as this may cause bowing.
- Clean surfaces gently — avoid harsh chemicals, solvents, or abrasives.
- Always refer to the full TruNatur technical documents and warranty for complete guidance

NANO Technology



The NANO technology offers superior resistance compared to traditional finishes. With a special resin-crystallization method using nanosized materials, it achieves higher performance and durability in decorative sheets.

Certification

- TruNatur has achieved GreenTag PHD™ PlatinumHEALTH™ rating – recognised by WELL™ and LEED® as a world-leading certification for product health.

Unsuitable Applications

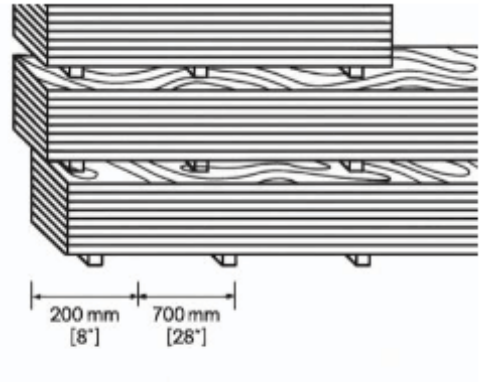
- TruNatur Waterproof panels are not intended for structural applications.
- TruNatur Waterproof panels are not suitable for outdoor areas.
- TruNatur Waterproof panels are combustible materials.

Guaranteed Quality

- TruNatur Waterproof panels comply with the relevant sections of AS/NZS4386.
- TruNatur is manufactured in Australia at EGR's ISO 9001-accredited facilities.
- All panels are laminated with advanced PUR reactive hot melt bonding technology by EGR.
- TruNatur Waterproof panels is designed to withstand full water submersion under ambient conditions for up to 7 days with no noticeable change

Storage and Handling

- Always handle panels with two people to prevent breakage or damage.
- Lift panels during loading and unloading, do not slide them.
- Store panels in a clean, dry, and well-ventilated area.
- Keep panels stored flat, horizontally, and fully supported at all times.
- Never transport or store panels in direct sunlight.
- Place panel packs on four evenly spaced bearers on a level, hard, and dry surface.
- Stack multiple packs with properly aligned gluts/bearers to ensure stability
- Protect panels with cover boards on the top and bottom of the stack.



Correct storage

- Follow correct storage practices to avoid bowing.

Fabrication

Overview

- TruNatur Waterproof panels can be cut and drilled with standard woodworking tools.
- Always test cut and drill on a sample piece to determine the optimal settings.
- 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.
- Keep machines well-ventilated and use dust extraction during processing.
- Control heat during cutting to prevent edge melting or surface marks.
- Inspect all panels for defects on arrival, before cutting or fabrication.

Cutting

- TruNatur Waterproof panels can be cut using standard carbide or diamond tools.
- TruNatur Waterproof panels cut best with tools specifically designed for HPL.
- A small-diameter, 2-flute solid carbide compression bit is recommended.
- Recommended cutting parameters

RPM	16,000–18,000
Feed rate:	Moderate — set to avoid burning from slow feeds or chipping from excessive speed.

- Other cutting parameters are the same as MDF.

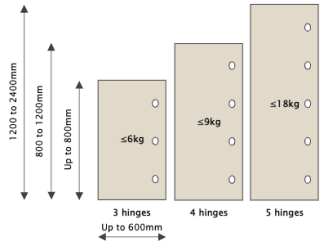
Saw Cutting

- TruNatur Waterproof can be cut using standard setting on beam and panel saws.
- A sharp carbide-tipped triple chip grind (TCG) blade with 3 to 5 teeth per cm is recommended.
- Maintain a low cutting height (15–30 mm) at standard or lower RPM to prevent overheating.
- Keep a steady, continuous feed speed — avoid stopping during the cut.
- A scoring blade should be used on panel saws to prevent edge chipping.

Drilling

- Use carbide or diamond-tipped drill bits with a point angle of 60° to 80° to ensure clean cuts and minimize chipping.
- Maintain a slow to moderate drill speed with low feed pressure to prevent overheating and material damage.
- Secure the panel on a stable surface with proper backing to prevent vibrations and reduce breakout on the exit side.
- Always drill perpendicular to the panel surface to ensure clean, precise holes and avoid delamination.
- Drill holes slightly larger than fasteners to allow expansion and prevent cracking.

TruNatur Waterproof Panel - Size & Design Requirements



- Single door panels must not exceed 600 mm in width.
- TruNatur Waterproof panels must not have cutouts or openings. If necessary, reinforce the door or panel with a frame or support to prevent warping or twisting

Hinge Recommendation

- Always test hinge drilling on a sample panel to confirm depth and backset.

TruNatur Waterproof doors require the correct number of hinges, with spacing no more than 300mm apart.

General Assembly Recommendation

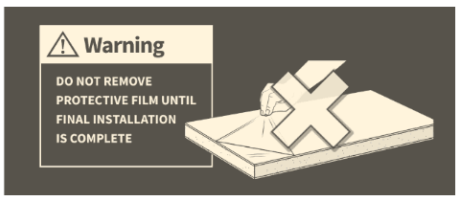
- TruNatur is compatible with conventional hardware and hinge systems. Use 5mm Euro screws for a strong and secure installation.
- Use stainless steel or outdoor-rated hardware and fasteners in harsh environments.
- For doors and front panels, fixings should be spaced at maximum 300mm apart.
- If drawer system fasteners are spaced over 300mm apart, add extra fixing points. A support bracket is usually fitted under the bottom drawer panel.
- Do not over-tighten screws or apply force (e.g., hammering) during assembly, as this may damage the panel.

Cleaning During Fabrication

- Wipe spills or stains immediately to avoid permanent damage, residue buildup, or surface deterioration.
- During fabrication, if surface contamination appears, lightly dampen a microfiber cloth with white spirit (mineral turpentine) and gently wipe
- Use new cleaning products with caution—test on an inconspicuous area first.
- Do not use abrasives, strong solvents, or harsh chemicals.
- The following products must never be used:
  - ✗ Acidic cleaners e.g. vinegar, rust removers, or limescale removers
  - ✗ Alkaline cleaners e.g. bleach, oven cleaners, baking soda.
  - ✗ Ammonia-based cleaners e.g. window and glass cleaners
  - ✗ Strong solvents e.g. acetone, isopropyl alcohol (IPA) or methylated spirits
  - ✗ Abrasive cleaners e.g. scouring pads, rough sponges, or gritty cleaners like CIF ABS edgetape cleaner.

Edge Finishing

- TruNatur edgeband works with EVA and PUR adhesives
- Use PUR glue bonding for harsh environments.
- Conduct run trials to determine the optimal settings and operations for each job.
- Adjust trimming tools and scrapers to avoid damaging the textured surface or causing lips.
- Use white adhesive for white panels and transparent adhesive for coloured or woodgrain panels.
- Only use cleaning agents recommended by the adhesive manufacturer and always test on a small sample first.
- During edging, if glue overrun appears, if surface contamination appears, lightly dampen a microfiber cloth with white spirit (mineral turpentine) and gently wipe.
  - ✗ **Never use ABS edgeband cleaners on TruNatur**.



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