

Summary

EGR Décor's TruNatur prefinished decorative polymer panels are manufactured in Southern California, USA. Visit www.trunatur.net.

TruNatur is a premium prefinished polymer panel that incorporates nanosized technology and antibacterial properties, offering a high-performance, user-friendly, low maintenance and cost-effective alternative to wood veneer. The TruNatur collection features a range of woodgrain patterns with gently embossed surfaces, delivering a natural look and feel. TruNatur veneers are highly resistant to scratching, marring, staining, chemical attack and UV light, ensuring lasting durability, aesthetic appeal, and functionality for many kinds of decorative indoor projects.

Due to the use of nano coat technology in manufacture, TruNatur panels are designed to withstand scratches and scuffs and are also easy to clean and maintain, making them an excellent option for beautiful and durable cabinets, furniture pieces, decorative elements and fixtures in high-traffic and high use areas.

All TruNatur panels are manufactured as 2S standard protected with removable clear protective peel coats. Matching 0.8mm thick TruNatur (with HPL base) laminates (SHAB) and 1mm thick ABS pre-primed edge band for automatic edge banders are also available.

Applications

TruNatur panels and SHAB are ideal for use in a range of indoor vertical applications including but not limited to:

- ✓ Residential and commercial cabinetry faces including kitchens, laundry and vanity cabinets and closets
- ✓ Residential and commercial furniture faces and shelving
- ✓ Commercial wall panels and store fixtures faces

Surface Specifications



Scratch Resistance

The surface technology includes nanosized agents, resulting in an exceptionally durable finish that resists wear. Steel wool testing reveals no signs of damage even after subjecting the surface to multiple cycles, highlighting the panels' ability to maintain their pristine appearance over time, even with heavy use.



Stain Resistance

The surface technology enhances TruNatur's "easy-clean" features, ensuring excellent resistance to common household stains associated with coffee, tea, wine, vinegar, cooking oils and other common foods. Tests indicate no significant visual or physical effects even after extended exposure to these products, ensuring that TruNatur products are easy to maintain and retain a fresh appearance for longer periods.



Chemical Resistance

The surface technology provides robust protection against chemicals, solvents, and cleaning agents including acetone, isopropyl alcohol, cosmetics, antibacterial cleaners, citrus cleaners, glass cleaners and other general purpose cleaning agents. Tests show no significant changes even with repeated exposure, demonstrating the panels' resistance to chemical damage and ensuring their long-lasting durability and appearance in various environments.



Weatherability

The surface technology offers protection against deterioration from exposure to UV light. Weathering tests conducted according to ISO 4892-3 Method B Cycle 5 reveal no significant changes to the surface after 3,000 hours of exposure, demonstrating TruNatur's durability and ability to maintain their appearance over time.



Antibacterial

The surface technology inhibits the growth of bacteria, including *S. aureus* and *E. coli*. Antibacterial tests conducted in accordance with ISO 22196 and JIS Z 2801 standards show a reduction of over 99% in bacterial growth after 24 hours of inoculation, demonstrating TruNatur's hygienic properties.

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TruNatur Prefinished Polymer Panel Products

Technical Data Sheet

October 2024

TruNatur TSCA TVI, ULEF MR MDF Panels

Panel Specifications

Property	Description / Feature				
Category	Premium polymer veneer panels				
Thickness	¼" (Standard)	5/8"	3/4" (Standard)	1"	1-¼"
Weight	<1 lb./ft ²	2.5 lbs./ft ²	2.7 lbs./ft ²	3.6 lbs./ft ²	4.6 lbs./ft ²
Core	TSCA TVI Plantation Grown MDF				
Core MR Properties	Standard	Standard	MR MDF	Standard	Standard
Construction	PUR laminated face and back				
Peel Coat	Transparent, high tack and residual free				
Environmental Health	GreenTag PHD™ PlatinumHEALTH™				
Sustainability	FSC certified sourced MDF				
Fire Resistance	Compliant with NCC/BCA Group Number 3				

Notes:

All thicknesses are nominal.

Panels thicknesses of 5/8", 1" and 1-1/4" are not typically stocked and may be available as a special order subject to availability of substrates, minimum order quantities and other conditions. Check with your local TruNatur distributor or contact EGR Décor for further information.

Core Specifications

Property	Description / Feature				
Thickness	¼" (Standard)	5/8"	3/4" (Standard)	1"	1-¼"
Density	44.9 lbs./ft ³			43.7 lbs./ft ³	
Internal Bond	101.5 psi				
MOR	4,351 psi				
MOE	507,632 psi				
Screw holding - face	≥157 lbf				
Screw holding - edge	≥247 lbf				
Thickness Swell 24hrs	<7%			<4%	
Formaldehyde Level	TSCA Title VI <0.11 ppm				

Notes:

All thicknesses are nominal.

Panels thicknesses of 5/8", 1" and 1-1/4" are not typically stocked and may be available as a special order subject to availability of substrates, minimum order quantities and other conditions. Check with your local TruNatur distributor or contact EGR Décor for further information.

Standard (Stocked) USA Made Panel Sizes

- ✓ Nominal ¼" 48 ¾" x 97"
- ✓ Nominal ¼" 48 ¾" x 120 ¾"
- ✓ Nominal ¼" 48 ¾" x 97"

Standard (Stocked) Australian Made Panel Sizes

Note that some of the initial TruNatur stock held in EGR's US DCs was made in Australia. **Note the metric size of the ¼" panels:**

- ✓ Nominal ¼" 48 ¾" x 97"
- ✓ Nominal ¼" 48 ¾" x 120 ¾"
- ✓ Nominal ¼" 47 ¾" x 95 ¼"

Moisture Resistance

StyleLite TruNatur MR MDF panels comply with the moisture resistance properties specified in AS/NZS 1859.2.

Fire Performance

StyleLite TruNatur MR MDF panels have been tested to AS5637 and achieved a Group 3 rating. For projects demanding superior fire ratings, StyleLite TruNatur panels with fire-rated properties are offered upon request.

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Certification

TruNatur has achieved the [GreenTag PHD™ PlatinumHEALTH™](#) rating, a designation recognized by WELL™ and LEED® as world-leading for the healthiness of products used by end-users. Made in the USA in an ISO9001 approved facility, these environmentally friendly panels meet strict quality standards.



TruNatur Laminate (SHAB) Applications

TruNatur SHAB is 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.

SHAB Specifications

Property	Description
Category	Premium polymer veneer (laminate)
Thickness	0.03" (0.8mm)
Size	48" x 96" (1,220mm x 2,440mm)
Weight	0.2 lbs./ft ²
Face	TruNatur polymer veneer
Substrate	High Pressure Laminate (HPL)
Construction	PUR laminated
Peel Coat	Transparent, high tack and residual free

Notes:

All thicknesses are nominal.

Panels thicknesses of 5/8", 1" and 1-1/4" are not typically stocked and may be available as a special order subject to availability of substrates, minimum order quantities and other conditions. Check with your local TruNatur distributor or contact EGR Décor for further information.

SHAB Core Specifications

Property	Description
Density	84.3 lbs./ft ³
Formaldehyde level	E0 ≤ 0.5mg/L

Storing & Transporting TruNatur

- ✓ Always wear applicable PPE when handling and transporting TruNatur panels, laminate and edge band
- ✓ Store all TruNatur products indoors only, in environments free of moisture, sunlight and dust. Ideal storage temperature is 50°F and 85°F and humidity of less than 60%
- ✓ Always maintain a cover board on top and bottom of complete and partial panel units for protection
- ✓ Protect panel edges
- ✓ Panels should be stored flat on a pallet or on a flat cover board at least ¼" thick supported by four equal height and evenly spaced full width stickers or runners, maximum of 8" in from both (long) ends. A minimum of five stickers should be used to store 10' long TruNatur panels
- ✓ Never walk on TruNatur panels and SHAB or on cover boards atop of TruNatur products
- ✓ Peel coats must be kept intact during storage and transportation of panels and finished components
- ✓ When packing panels for transportation, ensure no dust or foreign matter is trapped between panels
- ✓ Never drag panels and always have at least two people lift panels one at a time. Alternatively, use mechanical method such as vacuum lift with adequate care.
- ✓ Always store and transport panels horizontally
- ✓ If panels are to be transported on flatbed, ensure product is adequately tarped / covered to protect against the elements
- ✓ SHAB can be rolled up and transported in cartons no less than 50" x 15" x 15" (H x W x D) but should be removed and stored flat and horizontally protected by cover boards

Fabricating, Edging & Installing TruNatur Panels & Components

Prior to Fabrication

- ✓ Always wear suitable PPE when working with TruNatur products
- ✓ Inspect panels for visible defects or damage prior to fabrication. Contact your vendor if any issues are identified.
- ✓ Always keep the peel coat intact on the panel surfaces until fabrication and installation are complete. If the peel coat must be removed prior to transportation to the installation site, pack carefully to prevent damage during transportation.
- ✓ TruNatur panels can be cut, sawn, shaped, drilled and bored with a range of equipment including CNC router, table, panel, band and circular saw, hand or table router, etc. Ensure all equipment is operated and maintained as per manufacturer's instructions

Saw Cutting

- ✓ Peel coats must be kept intact until after installation except in specific circumstances
- ✓ Always use scoring blades when cutting TruNatur panels on table and panel saws
- ✓ When cutting panels with circular, panel or table saw, use sharp carbide teeth blades with minimum of 8 teeth per inch
- ✓ 12" diameter saw blades at 3200rpm provide best results
- ✓ Clamp panels or hold firmly in place to minimize vibration to avoid chipping
- ✓ Maintain steady cutting rate
- ✓ Machine with face side down

Boring

- ✓ When boring for hinge holes with dedicated hole borer, always drop the tool at slow speed
- ✓ Best results will be achieved by drilling or boring through a thin MDF sacrificial block
- ✓ Take care regarding depth of hole ensuring it is correct. Shallow holes can cause dimples or defects on the panel face
- ✓ When installing hinges, remove peel coat in the hinge area to prevent it from being caught under hinge plates

Routing

- ✓ When routing, twin or triple flute compression carbide router bits produce a cleaner finish than single flute bits
- ✓ Feed rate of 11 to 16 yards per minute with spindle speed of 20,000rpm provide best results
- ✓ Machine with face side down

Drilling

- ✓ Use sharp high-speed carbide tipped drill bits with drill speed set to slow to medium only
- ✓ Ideal drill bit tip angle range is from 110 to 130°
- ✓ Use sacrificial material on the backside to prevent chip out

Screwing

- ✓ Use pilot holes to prevent splitting
- ✓ Avoid over-tightening or hammering in screws

Avoiding Fiber Split of the MDF Core

- ✓ On rare occasions when fabricating TruNatur panels, the PET laminate may lift in a corner which can occur when a TruNatur panel or component is subject to impact with another solid surface in handling or fabrication, or if using blades or bits that are not well maintained.
- ✓ If this occurs, either trim the corner or pre-mill via automatic edgebander. Do not pull at the PET laminate as this can cause the MDF fibers to split as the PUR adhesive used to laminate is vastly stronger than the MDF fibers.

Edge Banding

TruNatur pre-primed ABS edge band suitable for use with glue applying edgebanders is available in 1mm 15/16"x328' rolls. Wider edge band (approximately 43mm) may be available. Check with your local distributor or contact EGR Décor.

- ✓ Best practice and results are achieved using TruNatur pre-primed edge band with automatic edge bander adhering the edge band with PUR (polyurethane reactant) adhesive. Consider using white PUR glue with white finishes such as White Ash and clear or natural with all other colors. Black PUR adhesive may produce a better aesthetic result with TruNatur Cinder Oak panels.
- ✓ Alternatively, EVA (ethylene vinyl acetate) adhesive can be used with automatic edgebander to apply TruNatur pre-primed edge band however this is not considered best practice and may leave unsightly glue lines. Consider using white EVA glue with white finishes such as White Ash and clear or natural with all other colors. Black EVA adhesive may produce a better aesthetic result with TruNatur Cinder Oak panels.
- ✓ Always ensure automatic edgebanders are clean and maintained especially in relation to dust extraction and regular sharpening of pre-miller, trimmers, corner rounders, profilers and scrapers.
- ✓ To remove edge band glue overrun where required, wipe with a clean microfiber cloth dipped in low odor kerosene or 100% mineral spirits using only light pressure.
- × **Never use harsh solvents such as acetone, paint and lacquer thinners to remove excess edge band glue.**

Installation

- ✓ Keep peel coats in place until installation is complete except where otherwise noted.
- ✓ Peel coats should be removed where another building / cabinetry component will interfere with its removal after installation. For example, remove peel coat of a vertical TruNatur component in the vicinity where a countertop adjoins the panel to prevent the peel coat from being trapped by the countertop.
- ✓ To avoid dimpling, hand tighten screws when installing hardware such as door handles on TruNatur faces
- ✓ Remove peel coats when all other trades have completed their work.
- ✓ Once peel coats are removed, wipe down TruNatur panels, laminate and edge band with **Matte Maxx** and clean, soft microfiber cloth. For more on these products, visit <https://trunatur.net>.

Hinge Requirements

- ✓ Number of hinges must meet both component height and weight in the table below
- ✓ Avoid making and hanging doors wider than 2'
- ✓ Avoid making and hanging long and slender doors where possible
- ✓ Consider using additional hinges for long / high / heavy doors

Door Height	Door Weight	Number of Hinges
Up to 31" (approx. 800mm)	≤ 15 lbs	2 hinges
31" to 51" (approx. 785mm to 1,295mm)	≤ 24 lbs	3 hinges
51" to 70" (approx. 1,295mm to 1,780mm)	≤ 33 lbs	4 hinges
70" to 82" (1,780mm to 2,080mm)	≤ 38 lbs	5 hinges
82" to 97" (approx. 2,080mm to 2465mm)	≤ 44 lbs	6 hinges

Manually Laminating TruNatur Laminate (SHAB)

Matching loose TruNatur laminate (SHAB) in 0.8mm 4x8' is available to complement TruNatur panels. Note that the loose SHAB is considerably thicker than the laminate used for TruNatur panels to allow for easier manual lamination. TruNatur SHAB can be laminated to composite panel substrates using various adhesives including:

- ✓ Contact cements
- ✓ Liquid PURs
- ✓ EVAs
- ✓ Two-sided tapes
- ✓ PVA & wood glues

Preparation

- ✓ Whichever adhesive is being used, ensure the manufacturer's instructions are followed
- ✓ Ensure all necessary and applicable health and safety precautions and procedures are always followed

Pre-Lamination Test

- ✓ It is important if you are new to laminating TruNatur SHAB, or if you have experience but are changing adhesives, to conduct a test to ensure the glue does not affect the SHAB and that it provides sufficient adhesion
- ✓ This test must be conducted for a minimum of 24 hours prior to commencing the job proper
- ✓ When satisfied with the adhesion level and the TruNatur SHAB is not adversely affected by the adhesive, then proceed to project lamination

Lamination

- ✓ Ensure substrates are clean, dry, flat and free of dust particles, residue, etc.
- ✓ Turn off fans and woodworking equipment in the vicinity of the lamination or even better, perform the lamination in a clean room / environment
- ✓ Inspect SHAB, ensuring the rear surface particularly is dry, pristine, clean, and free of dust
- ✓ Always leave the peel coat in place on the SHAB when laminating
- ✓ Importantly do not allow the adhesive to contact the face (front) of SHAB
- ✓ Water-based contact cements such as 1000NF by 3M and Wilsonart H2O may work but adequate testing and trialing should be conducted.
- ✓ Liquid PURs such as that by Gorilla are effective in that they produce excellent adhesion, are waterproof and low in viscosity allowing penetration into the pores of the substrate. However, they may be difficult to apply to the substrate such that the thickness is very fine and flat
- ✓ If using a PUR adhesive, a faster and superior bond may be achieved by dampening the substrate with a mist of water or moist cloth. This is because PUR needs moisture to activate and cure
- ✓ When using any glue for the first time to adhere the SHAB, perform a preliminary test on a small piece for 24 hours. This test should be for adhesion and impact / effect of the adhesive on the SHAB

- ✓ When using adhesives, consider that while applying to both rear of SHAB and substrate surface will often produce a stronger bond, the finish will generally be worse due to thicker adhesive increasing possibility of visual telegraphing especially in gloss finishes
- ✓ Adhesives can be sprayed, rolled, painted, trowelled or brushed on. It is crucial to achieve an even finish covering all areas of the surface being applied to. Thinner and even layers of adhesive facilitate a superior finish
- ✓ Two sided tapes such as 9505 by 3M can work excellently if applied properly. These tapes allow plenty of open time for orientation of the SHAB to correct position but when set, they produce a very strong bond. The tape should be applied to the rear of the SHAB first. Mechanical means (via roller type set up) generally produce a superior bond and help to prevent/minimize air bubbles
- ✓ Whether using adhesive or tape, importantly apply SHAB starting at one end using a soft roller or similar to force air from underside of SHAB. Trapped air severely affects the visual result and is a cause of delamination
- ✓ Allow adhesive and tape to cure as per manufacturer's recommendation

Curved SHAB Fabrication

- ✓ Cold curving is the sole suitable fabrication method for TruNatur laminate sheets when seeking a curved result.
- ✓ TruNatur SHAB can be cold curved to a minimum radius of 8 inches.
- ✓ When seeking a curved finish, flexible plywood and MDF panels such as those by Kerfkore are recommended laminate substrates.
- × **TruNatur SHAB is NOT to be used for postforming fabrication.**

Panel Balancing

- ✓ Whether laminating SHAB via manual or mechanical means, panels must be balanced except perhaps if they are used in wall applications where the panel is installed against a flat surface
- ✓ A panel using 0.8mm TruNatur SHAB on one side can be balanced with the same on the opposite side or other materials such as 0.7 to 1mm cabinet liner, ABS or HIPS
- ✓ Failure to balance panels significantly increases the propensity of panels to warp or bow and is not warranted

Clean-up

- ✓ Clean up adhesive residue using a soft microfiber cloth dampened with a benign solvent such as mineral spirits or kerosene.
- ✓ Never use acetone, paint or lacquer thinners or other aggressive solvents that will attack the TruNatur polymer
- ✓ If in doubt, test the cleaner on the face side of a TruNatur sample. If after 24 hours, there is no impact such as cracking, grazing, pitting or dulling of gloss finish or glossing of the matte finish, the cleaner will generally be fine.
- ✓ Best practice, however, is to use mineral spirits or kerosene

Care and Maintenance

For general cleaning:

- ✓ Wipe with soft, clean microfiber cloth dampened with warm soapy water. Nonabrasive liquid dishwashing soap at 5% ratio to warm water is suitable. For more challenging stains, increase ratio of dishwashing soap to 10% and use hotter water (still comfortable to physically touch). If streaks appear, the microfiber cloth is too damp.
- ✓ Spray with Matte Maxx (or equivalent) and wipe with soft, clean microfiber cloth
- ✓ For more persistent stains, test retail cleaning agents such as Windex, Lysol, Fabuloso or Mr. Clean on an inconspicuous area of the TruNatur panel for compatibility first. Apply cleaner as per manufacturer's instructions and wipe with a microfiber cloth then examine area in 24 hours. If no visible negative impact, then the cleaner should be suitable for use.
- × **Never use abrasive products or cleaners (scouring pads, steel wool, black soap...etc.), bleaching agents, wax furniture polishes, alcohols, solvents, acetone, or paint and lacquer thinners or strongly acidic/alkaline cleaners to clean TruNatur products.**

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Warranty

- ✓ TruNatur panels and SHAB are covered by a limited 7-year limited warranty in residential applications.
- ✓ TruNatur panels and SHAB are covered by a 3-year limited warranty in non-residential applications.
- ✓ TruNatur edge band is covered by a 12 months' limited warranty in all applications.

Please refer to the separate complete warranty statement for detailed warranty terms and conditions.

Property & Basic Warranty Details
TruNatur panels are designed for vertical applications only
TruNatur panels are designed for indoor applications only
Exposure to excessive direct or radiant heat >158°F (70°C) is not permitted
General fading, aging or discoloration are not covered by the warranty
Minor deviation in color or minor ripples/dents are not covered by the warranty
Contact with hot gases, steam, or hot objects is to be avoided and any damaged caused by such is not covered under the warranty
Warping, twisting or bowing due to large door dimensions or inappropriate door hinges are not covered by the warranty
Chipping caused by fabrication and during and after installation is not covered by the warranty
Prolonged exposure to excessive moisture is not permitted and will void the warranty
Panel edges must be sealed with TruNatur or equivalent edge band
Only follow the recommended care and maintenance guidelines
The warranty covers only the cost of replacement or repair of materials by EGR and does not cover incidental loss, labor or freight associated with replacement or repair