

## Fabrication and Installation Guide



Thank you for interest in the **StyleLex** product range.

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

For further information contact us at [info@egrdecor.com.au](mailto:info@egrdecor.com.au) or contact your nearest StyleLex distributor. For more information, please visit our website.

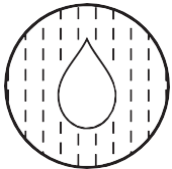
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### Overview

StyleLex is an innovative panel solution suitable for covered outdoor and interior wet areas. The panels combine a durable, weatherproof composite core (WCC) with a premium UV-resistant HPL or high-quality textured ABS acrylic surface, bonded using an advanced PUR reactive hotmelt system. StyleLex is the perfect solution for your covered outdoor entertaining spaces and indoor wet-area environments for quality and durability while achieving a custom integrated look.

### Quality Features



Weatherproof



UV-Protected



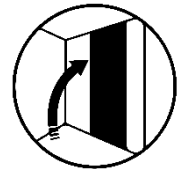
Easy to work



Easy to clean



Stain Resistance



Vertical applications

### StyleLex Face Panels

StyleLex face panels feature a premium UV-resistant HPL surface that offers superior resistance to weathering, wear, and colour fading.

Substrate	Finished Panel Size	Application	Weight	Finish
Weatherproof Composite Core (WCC)	2400x1200x18.5	Cabinet doors, face panels, and drawer fronts	13kg/m <sup>2</sup>	Matte and woodgrain textured HPL sheet

### StyleLex ABS Carcass Panels

StyleLex ABS carcass panels feature a high-quality textured ABS/acrylic surface that offers advanced water and moisture resistance.

Substrate	Finished Panel Size	Application	Weight	Finish
Weatherproof Composite Core (WCC)	2400x1200x16	Drawer base panels in undercover outdoor applications	11 kg/m <sup>2</sup>	Matte textured ABS sheet
Weatherproof Composite Core (WCC)	2400x1200x18	Cabinet carcass, kickboards, base frames Drawer base panels	12kg/m <sup>2</sup>	Matte textured ABS sheet

### StyleLex HPL Carcass Panels

StyleLex HPL carcass panels feature a premium white HPL surface that offers excellent stability and long-lasting durability.

Substrate	Finished Panel Size	Application	Weight	Finish
Weatherproof Composite Core (WCC)	2400x1200x16	Cabinet carcass, kickboards, base frames and drawer bases panels	11 kg/m <sup>2</sup>	White textured HPL sheet

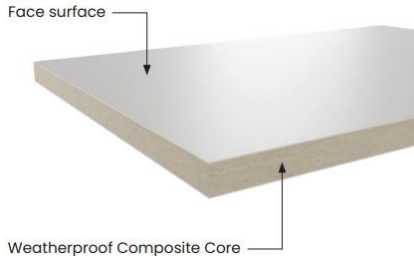
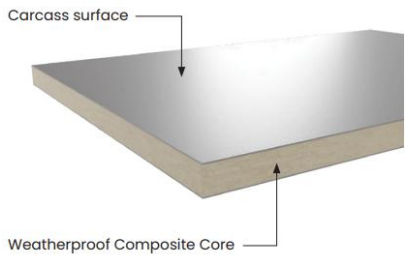
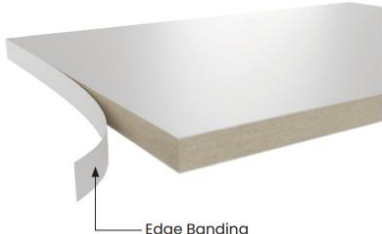
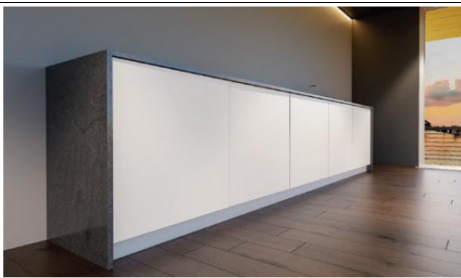
### Important Information

- 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 StyleLex products.
- It is the installer's responsibility to ensure the product's suitability for the intended application.

### Warranty

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

### The StyleLex System

StyleLex face panels – 18.5mm	StyleLex carcass panels – 16 & 18mm	StyleLex Edgebanding – 23x1mm
Face panels consist of a weatherable HPL laminated to Weatherproof Composite Core (WCC). Face panels can be used for cabinet doors, face panels and drawer fronts in cabinets and joinery works.	Carcass panels consist of HPL (16mm) and ABS (16 & 18mm) sheets laminated to Weatherproof Composite Core (WCC). Carcass panels can be used for cabinet frames, kickboards, base frames and drawer bases.	Edge banding gives the perfect finish to your outdoor kitchen.
		
 <p>Doors made from StyleLex face panels attached to cabinet structure. Benchtop material used for gable ends.</p>	 <p>Cabinet frames and kickboard constructed using StyleLex carcass panels.</p>	 <p>Diagram shows the complete system with edge banding being used on the doors and carcass to complete the cabinet.</p>

### Top Tips

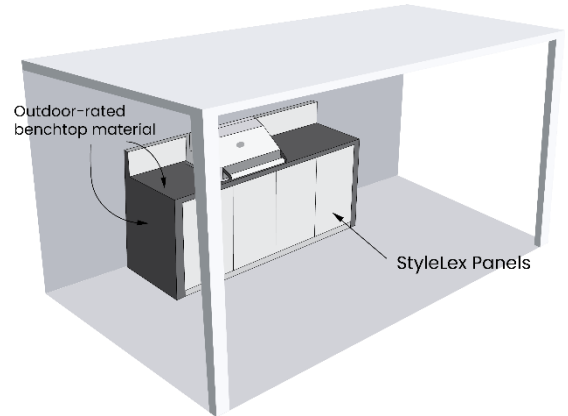
- StyleLex panels should always be installed in undercover locations with no direct sunlight exposure.
- StyleLex panels must be stored flat, horizontal, and well-supported at all times.
- StyleLex panels can be cut and drilled with the same ease as traditional wood-based (i.e. MDF) materials.
- StyleLex is fully compatible with conventional hardware and hinge systems.
- For optimal installation, use 5mm Euro screws with StyleLex panels.
- StyleLex panels require the following size requirements:
  - Single door panels must not exceed 600mm in width and 1200mm in height.
  - For door panels exceeding these dimensions, split panel construction methods are required.
  - Any single-piece panel over 1200mm in any direction must include appropriate fixing support.
- Pre-drilling and countersinking can help ensure a better joint when installing StyleLex panels.
- Screws of 51mm or longer are generally recommended for StyleLex carcass panels and supporting cabinet strength.
- Cutouts or openings in StyleLex panels are not recommended. If required, consider reinforcing the panel with a frame or support to help minimise the risk of warping or twisting.
- StyleLex edgebanding is compatible with both EVA and PUR adhesives,
- StyleLex 18 mm ABS carcass panels are compatible with Polyurethane (2PAC) and acrylic paints.
- StyleLex is not suitable for use as routed panel where core is exposed as this may cause the panel to bow.
- StyleLex surfaces must be cleaned with care — no harsh chemicals, solvents, or abrasive items.
- For complete details, please refer to all StyleLex technical documents and warranty terms.

### Unsuitable Applications

- StyleLex panels are not intended for structural applications.
- StyleLex panels are not suitable for exposed outdoor areas such as exterior wall and ceiling cladding.
- StyleLex panels are not suitable for use in areas where a Materials Group fire rating of 1 or 2 is specified.
- StyleLex panels should not be used for benchtop or exposed gable ends – use outdoor-rated materials instead.

### Positioning and Design

- StyleLex panels should always be installed in covered and shaded areas, with no direct sunlight exposure through the year.
- StyleLex panels are combustible, and precautions must be taken around gas cooktops and barbeques. Consult relevant gas standards and fire protection codes to maintain the required clearances and adequate ventilation.
- In Australia and New Zealand, installations around gas burners, barbeques, or cooktops must comply with the appliance manufacturer's installation instructions and AS/NZS 4386.
- For alfresco kitchens, all gas, electrical and plumbing works must be carried out by licensed or qualified tradesperson.



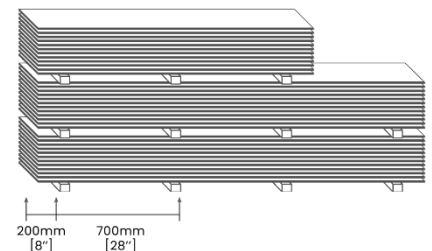
StyleLex panel in undercover locations

### Guaranteed Quality

- StyleLex panels comply with the relevant sections of AS/NZS4386.
- All StyleLex panels are laminated by EGR using an advanced PUR reactive hot melt bonding system.
- StyleLex is manufactured in Australia at EGR's ISO 9001-accredited facilities.
- StyleLex is a weatherproof solution and tested to resist water exposure under normal ambient temperatures:
  - StyleLex Face Panel – Withstands full water submersion for up to 7 days with no changes
  - StyleLex ABS Carcass Panel – Withstands full water submersion for up to 30 days with no changes
  - StyleLex HPL Carcass Panel – Withstands full water submersion for up to 7 days with no changes

### Storage and Handling

- Handle the panels with care with at least two people to avoid breakage and damage.
- Lift the panels during loading and unloading operations; never slide them.
- Keep panels in a clean, dry, and well-ventilated environment.
- Never transport or store panels in direct sunlight
- Panels must be stored flat, horizontal, and well-supported at all times.
- 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
- Use cover boards on both the top and bottom to ensure proper protection.
- Follow the correct storage method, as shown in the image, to prevent bowing.



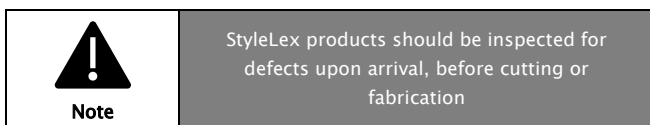
Correct storage method



### Fabrication

#### Overview

- StyleLex panels can be cut and drilled with using standard woodworking tools.
- Conduct trials to determine the best settings and operations.
- 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.
- Ensure proper ventilation and dust extraction for processing machines.
- Excessive heat generation during cutting can cause edge melting if proper care is not taken.

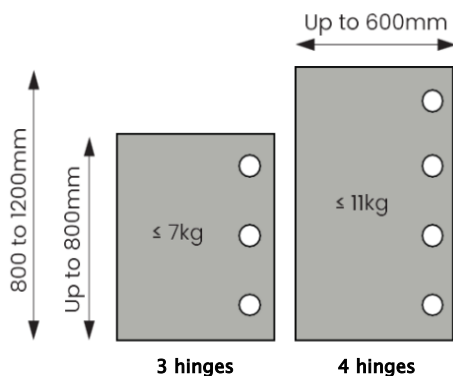


#### Cutting

- StyleLex can be cut using standard carbide or diamond tools.
- A 2-flute (wing) tool with a small diameter is recommended for optimal performance.
- StyleLex face and HPL carcass panels cut best with tools specifically designed for HPL.
- StyleLex ABS carcass panels are most effectively cut with carbide tools.
- Compression routers should be set to 16,000 to 18,000 RPM.
- All other cutting parameters are the same as MDF.

#### Hinge Recommendation

- Test hinge drilling on a sample to check depth and backset.
- StyleLex door panels require the correct number of hinges, with spacing no more than 300mm apart.

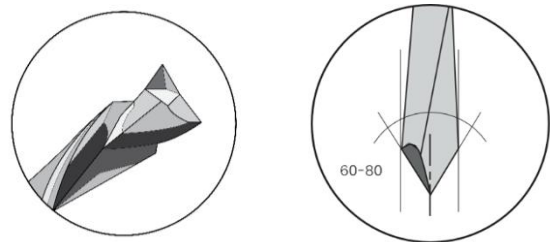


#### Saw Cutting

- StyleLex can be cut using standard setting on beam and panel saws.
- Use sharp carbide-tipped blades with 3 to 5 teeth per centimetre for clean results.
- StyleLex cuts well at a low cutting height of the saw blade, between 15 to 30 mm.
- Use standard or lower RPM to prevent overheating.
- Maintain a constant feed speed and avoid start-and-stop movements during the feeding process.
- Use a panel saw with a scoring blade to avoid 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.



#### StyleLex Panel Size Requirements

- Single door panels must not exceed 600mm in width and 1200mm in height.
- For door panels exceeding these dimensions, split panel construction methods are required
- Panels over 1200mm in any dimension require adequate fixing support to ensure stability
- StyleLex panels must not have cutouts or openings. If necessary, reinforce the door or panel with a frame or support to prevent warping or twisting.

### General Assembly Recommendation

- StyleLex 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 use force (e.g. hammering) during installation.

### Carcass Assembly Recommendation

- Use screws that are at least 51mm long to build a strong cabinet frame.
- Always pre-drill pilot holes and countersink before fastening to ensure secure joints.
- Do not over-tighten screws or use force (e.g. hammering) during carcass assembly.
- Place the first screw or fastener at least 35mm from each edge.
- For standard-sized cabinets, space fasteners (screws) 150–200mm apart on centre.
- For larger cabinets, reduce spacing to 100–150mm for additional reinforcement.

### 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.
- To prevent damage, avoid using the following abrasive products, solvents, or harsh chemicals on StyleLex.

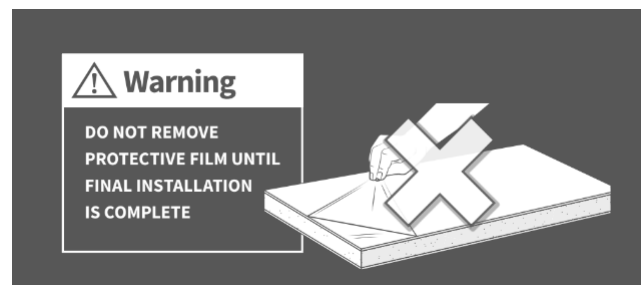
- ✗ Acidic cleaners e.g. vinegar, rust removers, or limescale removers
- ✗ Alkaline cleaners e.g. bleach, oven cleaners, baking soda.
- ✗ Ammonia-based cleaners e.g. window and glass cleaners
- ✗ Strong solvents e.g. acetone, isopropyl alcohol (IPA) or methylated spirits
- ✗ Abrasive cleaners e.g. scouring pads, rough sponges, or gritty cleaners like CIF
- ✗ ABS edgetape cleaner.

### Edge Finishing

- StyleLex edgeband works with EVA and PUR adhesives.
- Use PUR glue bonding for harsh environments.
- Conduct trials to determine the optimal settings and operations for each specific application
- 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.
- ABS edgeband cleaners are to never be used on StyleLex.

### Two-Pack and Acrylic Paint Finishing

- Use StyleLex 18mm ABS carcass panels for polyurethane (PU) and acrylic paint finishes.
- Ensure the paints are compatible with both ABS and PVC-based materials to avoid paint problems.
- Suggested paint system – MIROTHANE PU 5650 (2K topcoat) and PU 5631 (undercoat), supplied by Mirotone.
- Paint both sides of the panel to keep it stable and prevent warping or bowing from uneven paint.
- StyleLex is not suitable for use as routed panel, as this may expose the core and cause bowing





Luxury Outdoor & Wet Areas Cabinetry

StyleLex<sup>®</sup> by **EGR**  
**DECOR**

## Luxury Outdoor & Wet Areas Cabinetry Fabrication and Installation Guide

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