StyleLex®

INSTALLATION AND SPECIFICATIONS GUIDE



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Thank you for your 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 enquiries visit **www.stylelex.net** or contact your nearest StyleLex distributor.

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Product Information

Introduction

StyleLex Panels are designed for use in exterior covered areas and feature an extensive range of finishes over optimized plywood cores for unrivalled performance and durability.

StyleLex Face Panels

EGR StyleLex Face panels are manufactured using high quality High Pressure Laminates formulated for use in exterior covered area applications. The surfaces are bonded to premium quality recycled, advanced composite substrates using PUR hotmelt lamination technology.

Substrate	Finished Panel Size	Region	Weight	Finish
Advanced composite	2400 × 1200 × 17.6mm	Global	650 kg/m³	

StyleLex Carcass Boards

EGR StyleLex Carcass panels are manufactured using high quality textured white ABS sheet bonded to premium quality recycled, advanced composite substrates using PUR hotmelt lamination technology.

Substrate	Finished Panel Size	Region	Weight	Finish
Advanced composite	2400 × 1200 × 17.5mm	Global	650 kg/m³	Textured White Sheet

Things to Consider

- **Assembly:** Adequate fixing should be provided at no greater than 300mm [12"] centres.
- **Shelf Loading:** The maximum unsupported shelf span of StyleLex Boards is 750mm.
- **Edging: All StyleLex Boards should be edged around every perimeter.**
- **Clearance:** For maximum durability we recommend StyleLex carcass structure be supported on legs and not in direct contact with the floor where water or debris could accumulate.
- **Ovens:** We recommend an air gap of 6mm [¼"] adjacent to ovens and other heat sources.
- **Gas Appliances:** When installing EGR StyleLex in the vicinity of gas burners or gas barbecues, ensure that a minimum clearance of 200mm is maintained between the gas appliance and the StyleLex boards in accordance with AS/NZS 5601:2010 Gas Installation Code. For clearance requirements around a gas or electrical cooking appliance and a combustible surface, always adhere to the appliance manufacturer's installation requirements as certified under AS 4557.

Location

EGR StyleLex panels cannot be used for structural applications, including exterior wall cladding, building facades, balustrades, railings or swimming pool surrounds.

EGR StyleLex panels must not be used at a location where surfaces may come in contact with corrosive substances e.g.. Chlorine, Acid or Pesticides.

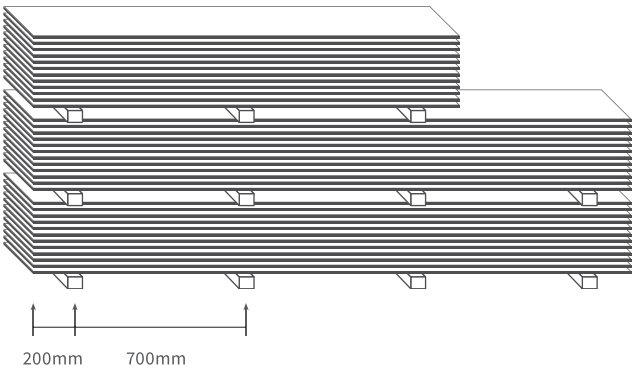
EGR StyleLex panels must avoid exposure to direct sunlight, with no more than 4 hours of direct sunlight exposure within a 24 hour period. A solid, opaque ceiling should provide full coverage of all product surfaces with an additional 1.5 metre overhang surrounding all edges.

Storage and Handling

StyleLex panels can be stored horizontally or vertically but should be well supported at all times.

- Do not store panels outside.
- Do not store or transport panels in direct sunlight.
- Avoid sliding the panels on the outer face surface.
- It is recommended that the panels are stored horizontally and supported at no more than 700mm [28"] from centres and 200mm [8"] from the ends to prevent the risk of warpage. All bearers should be of equal thickness and quality.
- Panels should be stored in well-ventilated and dry conditions.
- Cover boards should be placed on the top and bottom of stacked panels to provide protection and reduce the effects of environmental changes.

Correct storage method



Machining Guide

Routering

- Router cutting is the preferred method for cutting EGR StyleLex panels.
- Router cut using a feed rate of 25 metres per minute with a spindle speed of 18,000 rpm or higher.
- Solid carbide router cutters will deliver the best finish.
- Two flute compression cutters of diameter 10 mm or greater are ideal as they minimise the chance of chipping at the edge and eliminate any feathering of the masking material on either side of the sheet.

Saw Cutting

- Use very sharp carbide tipped blades with 3 to 5 teeth per centimetre.
- We recommend using a 300mm diameter blade at a speed of 3200rpm for best results. Results may vary depending on your equipment.

Band saw

- Band saws can be used to cut curves however a secondary finishing operation will be required.

Drilling

- Drilling can be done using high speed steel or carbide tipped drills.
- Use slow to medium speeds to avoid overheating the material.

Hinge Recommendations

When using EGR StyleLex for door installations, ensure the appropriate amount of hinges are used to deliver a professional result. Hinges suitable for covered exterior conditions recommended.

Door Height		No of Hinges
Up to 800mm	[Up to 31"]	2 hinges
800 to 1300mm	[31" to 51"]	3 hinges
1300 to 1800mm	[51" to 70"]	4 hinges
1800 to 2100mm	[51" to 82"]	5 hinges
2100 to 2440mm	[82" to 97"]	6 hinges

- Always test hinge boring tools to ensure a clean cut is achieved.
- Best results will be achieved by drilling or boring through a thin MDF sacrificial block.
- Only bore the required depth amount of your hinge hardware.

Edge Finishing

Colour matched Edge Band rolls are available for StyleLex face panels.

All StyleLex compatible Edge Band is of premium quality and offer high resistance to heat, abrasion, impact and colour fade.

23 x 1mm in 100m rolls, preprimed for EVA and PUR bonding. Only PUR bonding is recommended for use with StyleLex face and carcass panels to achieve the best bonding and weatherability.

Edge Band Technical Notes

Best results will be achieved using the following practices:

- CNC machining the panel edge or using an edge bander with pre-milling function.
- Set trimming and scrapers to flush with top surface of the face, do not leave a lip if possible.
- If there is glue overrun on the face, it can be removed using a microfibre cloth dampened with mineral turpentine, use sparingly and avoid excessive rubbing.
- If manual scraping or finishing is required, take care to avoid gouging the face of the panel.

PUR Polyurethane Adhesive - preferred for exterior applications

- Suitable for all colours and will deliver a highly moisture resistant panel. Use white adhesive on white panels and transparent on dark panels.

Care and Maintenance

For general cleaning use warm soapy water and a clean microfibre cloth. Liquid dish-washing detergent diluted is an ideal cleaner.

Do Use	Don't Use
✔ Clean wet microfibre cloth	✘ Paper towels
✔ Clean wet chamois	✘ Dry wipe at any time
✔ Non abrasive soap and detergent	✘ Brushes, scourers or scrapers
✔ Warm water	✘ Abrasive cleaners
	✘ Thinners or Methylated Spirits
	✘ High pressure water
	✘ Solvent based chemicals

StyleLex - Carcass

Description

The StyleLex Carcass board complies with the relevant sections of AS / NZS 4386.1 and is backed by a 7 year indoor / outdoor covered area warranty.

Properties	Specification	Test Method
Board Length	2400 mm	Steel Tape
Board width	1200 mm	Steel Tape
Board Thickness	17.6 mm	Micrometre
Board mass density	650 kg/m^3	Calibrated Scale
Board weight	8 kg/m^2	Calibrated Scale
Colour	Delta E1.5 reflected	Spectrophotometer
Surface Hardness	≥0.2N	EN438-2
Continuous service temperature	170° F (77° C)	
Light fastness (Xenon-arc light)	Rating 4 to 5 (min)	EN438-2
Resistance to wet conditions (exterior grade laminates), unedged	Rating 5	EN438-2
Resistance to impact	>100J	ASTM D4226

StyleLex - Face

Description

The StyleLex Face board complies with the relevant sections of AS / NZS 4386.1 and is backed by a 7 year indoor / outdoor covered area warranty.

Properties	Specification	Test Method
Board Length	2400 mm	Steel Tape
Board width	1200 mm	Steel Tape
Board Thickness	17.6 mm	Micrometre
Board mass density	650 kg/m^3	Calibrated Scale
Solid Colours	Delta E1.5 reflected	Spectrophotometer
Woodgrain or patterns	Visual match to master	Light Box
Resistance to surface wear	150 Rev (min)	EN 438-2
Resistance to impact with small diameter ball	20N (min)	EN 438-2
Resistance to scratching	Rating 3 (min)	EN 438-2
Resistance to wet heat at 100°C	Rating 3 (min)	EN 438-2
Resistance to dry heat at 160°C	Rating 3 (min)	EN 438-2
Resistance to stains	Rating 5 Group I & II Rating 4 Group III	EN 438-2
Resistance to steam	Rating 5 (min)	EN 438-2

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CUTTING TRIALS FOR EGR.

MATERIAL BASE Stylexlex

Hpl laminate Stylexlex face panel

Abs white Stylexlex carcase panel.

Testing covered the area of cutting and routing.

Results

Cutting beam saw and panel saw.

Stylexlex

material cuts for all intensive purpose the same as mdf , all standard saws in current use are suitable and all current cutting parameters are suitable. Both in the beam saw and panel saw.

Stylexlex hpl face panel

cuts as most hpl laminates do, tools and parameters are the same, this material benefits well from low cutting height of the saw blade.

Stylexlex abs carcase panel.

Material cuts well low height projection of the saw is important, all current high precision saws will cut well triple chips and group tooth formats will perform well.

There is always a need to be aware of unnecessary heat generation, melting of the edge is possible if care is not taken. this would normally mean to slow feed speed , to many teeth blunt saws. All normal parameters are suitable cutting speed and feed speed.

ROUTER TRIAL.

Trials were carried out on both flat bed router and pod style router.

Stylelexlex

This material cuts for all intensive purposes the same as MDF, all standard carbide and or diamond tools are suitable for cutting.

Stylexlex hpl face panel .

This material cut as most hpl product, all standard tools for cutting hpl are suitable.

Stylexlex abs carcase panel.

this material cuts for all intensive the same as mdf.stand 2 wing compression tools are best suited.

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As the same for mdf compression tools should be 2 wing,

Care should be taken when onion skinning onion skin should be 2mm this is to protect the abs from heat generated in the cut.

During nesting excessive heat generation can cause the offcut to compact in the groove.

Summary..

All stylelexlex material.

Saws,

Saws at standard speeds slower rpm where available,

low cutting height or saw projection, 15-30mm

standard triple chip or group tooth preferred.

Constant feed speed without start and stop in the panel.

A well functioning Dust extraction is important,

Routers.

On pod machines most routers are suitable 16,000-18,000 rpm

2 wing tools are preferred in small diameter

Surface material hpl stand tools for hpl

Surface material abs. standard carbide tools.

Nested base,

Compression routers 16,000-18,000 rpm.

Tools should be 2 wing.

Functioning dust extraction is needed

Onion skinning needs to be 2 mm.

All other cutting parameters same as mdf..

Regards.

NEIL STAGGS. Md leuco Australia.

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