

## Laying Instructions Terrace

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Any previous instructions and commitments will become obsolete with the publication of these Laying Instructions.

Any information in these Instructions are state-of-the-art and are based on thorough investigations and wide experience. Legal obligations and claims for indemnification, however, may not be derived or exercised. Subject to change without notice.

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### Discover our accessories catalogue

Our comprehensive accessories catalogue includes all the necessary components and detailed explanations of how to use them.

# Important laying information

You chose a quality product by buying our WPC decking boards. We would like you to enjoy our products over a long period of time. In this brochure, we will give you some tips for installation, care and maintenance.

Please observe the instructions below, and always follow your local building regulations and conditions during planning, execution and maintenance. For technical implementation, the 02 BDZ professional rules and the brochure "Terrassen- und Balkonbeläge" (Terrace and Balcony Covering) by GD Holz must be observed. Particularities regarding the typical material characteristics of our WPC products will be described in these Instructions and must be adhered to as well. These Laying Instructions must always be handed over to the client.

Prior to installation, the profiles must be checked for colour and structural differences caused by different production batches. To prevent damage to materials, the goods should be stored in a protected place from delivery to installation.

## Dimension tolerances

The length ordered has an excess length of +0 to 3 cm due to manufacturing. Dimension tolerances of width and thickness (-3 mm to +2 mm) are possible.

## Technically proper installation

Read the installation instructions, and confer with your salesperson or us in case of failing constructions or uncertainties about feasibility. Always keep in mind the peculiarities of roof terraces and public areas, since special requirements apply here and corresponding changes are required.

## Subsoil

The subsoil must be load-bearing, frost-proof and designed so that permanent drainage is possible.

## Rear ventilation

For durability, generous rear ventilation of the entire surface is important. Fully lateral sealing of the surface or substructure is thus not allowed.

## Spacing

Terrace constructions must be installed in a tension-free way. Always keep a distance of at least 1 cm from fixed components. This distance increases depending on the decking board length used (see page 19). Always insert an appropriate laying aid (green or black installation aid) from the Installation Clips. It gives you the exact distance between the boards (see page 20).

## Slope

Lay out the area with a slope of at least 1.5 to 2 % away from the building. For massive decks, the slope may be reduced to 1 % upon consultation with us.

## Constructive protection

Always protect the substructure and terrace area from waterlogging and direct soil contact. Standing moisture must be avoided.

## Honeycomb profile deck

Generally, seal both ends of the honeycomb profile decks with end caps and do not install them on the grass level.

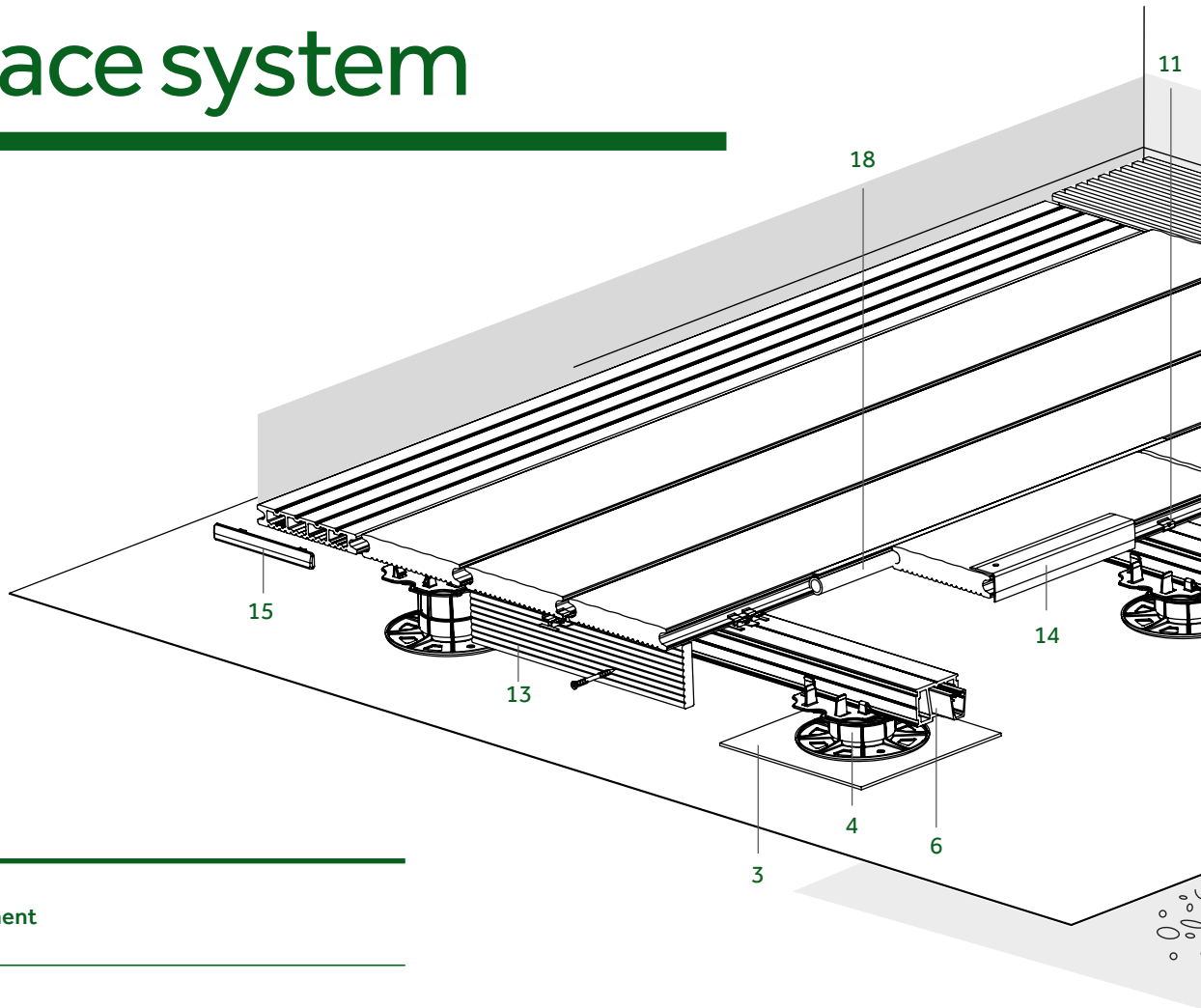
## Cutting

The decking boards are generally produced with excess lengths. Precise cutting according to the requirements on both sides is done as part of on-site installation.

## Installation direction

The decking board surface is refined during the manufacturing process. If the decking board direction is not observed during installation, this may lead to a varying colour effect due to striation. Arrows in the board groove indicate the installation direction.

# Terrace system



## Base height adjustment

### 1 Weed Control Fabric

1.6 × 10 m  
as a base to prevent unwanted vegetation under the terrace  
as required

### 2 Rubber Pad

60 × 60 × 3/6 / 10 mm,  
made of EPDM, levelling  
for solid subsoils  
min. 6–8 per m<sup>2</sup>

### Cork Pad

60 × 60 × 3/10 mm  
made of self-adhesive cork,  
unplasticised, can be applied  
directly to PVC, levelling  
material for solid subsoils  
min. 6–8 per m<sup>2</sup>

### 3 Cork Base

200 × 200 × 3 mm  
made of cork, unplasticised,  
can be applied directly to  
PVC, as separating layer  
between feet and subsoil,  
e. g. on foil sealing,  
protection against  
mechanical load and  
plasticiser migration  
as required

### 4 Decking Feet

to click onto the  
substructure, self-levelling.  
Support foot Ø 13.5 cm  
size S: 33–48 mm  
size M: 43–68 mm  
size L: 68–118 mm  
size XL: 118–218 mm  
min. 4–5 per m<sup>2</sup>

### 5 Load Distribution Plate

210 × 210 × 8 mm, made of PP,  
to increase the foot contact  
area, reduces sinking into  
the ground  
as required

## Substructure profiles

### 6 Base Profile WPC 2.0

40 × 60 mm, piece of 4 m  
to click onto the  
patio foot, for spans of  
up to max. 60 cm,  
min. 2.5–3 m per m<sup>2</sup>

### incl. Profile Reinforcer

22 × 27 mm, piece of 4 m  
for spans of up to  
max. 100 cm  
as required

### Base Profile ALU

22.5 × 40 mm, piece of 4 m  
to click onto the terrace foot,  
for spans of up to  
max. 65 cm, suitable for WPC  
and wooden decking boards  
min. 2.5–3 m per m<sup>2</sup>

### System Profile ALU

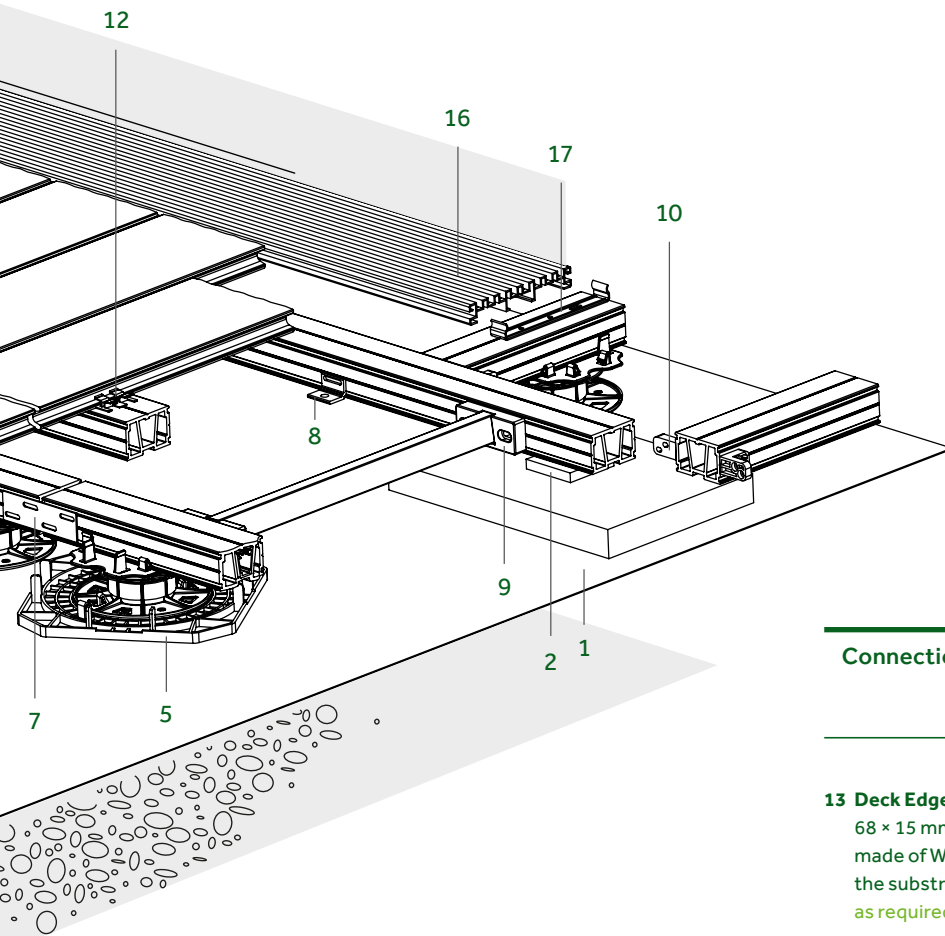
39 × 39 mm, piece of 4 m  
to click onto the terrace  
foot, can be used on both  
sides, for spans of up to  
max. 110 cm, one side with  
screw channel for fixing  
brackets, one side for  
profile drill screw (building  
inspectorate approval),  
suitable for WPC and  
wooden decking boards  
min. 2.5–3 m per m<sup>2</sup>

### 7 Profile Connector ALU

1.5 × 30 × 100 mm  
for continuous installation of  
Base profile WPC 2.0 and  
system profile ALU  
as required

### Profile Connector Plastic

22.5 × 40 × 120 mm  
for continuous installation of  
base profile ALU  
as required



### Accessories for substructures

- 8 Mounting bracket with Oblong Hole**  
22 × 23 × 30 mm, made of ALU for sliding fastening of the substructure to the subsoil  
*as required*
- 9 Bracket for Cross Bracing**  
33.5 × 80 × 15 mm, made of PP; for bracing the substructure or fastening of panels  
*as required*
- 10 L-Bracket**  
19 × 30 × 35 mm, made of PP, glass fibre reinforced, universal angle bracket, e.g. for covers, cross bracing and corner connections  
*as required*

### Fixing

- 11 Start/End Clip**  
16 × 38 mm, made of stainless steel, black; to mount the first and last decking board to the profile  
*as required*
- 12 Installation Clips**  
24.5 × 38 mm, made of stainless steel or V4A stainless steel, black; to mount the decking boards to the profile surface  
*for requirements, see pages 8 – 10*

### Connections and edges

- 13 Deck Edge**  
68 × 15 mm, piece of 4 m, made of WPC, to cover the substructure  
*as required*
- Piazza Edge**  
140 × 20 mm, piece of 4 m, made of WPC, to cover the substructure  
*as required*

- 14 Alu Finishing Profile**  
35 × 30 mm, piece of 2.7 m made of ALU; to cover the longitudinal edges of the decking board  
*as required*

- 15 Cover Caps**  
21 × 139 mm, made of WPC; colour-matching edge for honeycomb profile decks (no special colours), to be used imperatively as a protection against moisture  
*as required*

**Glue**  
for additional fixing of the cover caps

### Drainage and ventilation

- 16 Drainage Grid**  
140 × 20 mm, piece of 4 m made of ALU, for drainage and rear ventilation of the surface  
*as required*
- 17 Fixing Set**  
144 × 20 × 16.5 mm, concealed fastening of the Drainage Grid  
*as required*

### Visual surface sealing

- 18 Joint Profile Tube**  
Ø 14 / 18.5 mm, made of EPDM, creates a gap-free, opaque surface and drains water (does not water-proof!), size varies depending on board type (min. 8 cm adhere to installation height), tube cannot be used for all decking boards  
*as required*

**Insertion Aid**  
facilitates efficient, even installation

# Decking boards and special accessories



Decking boards	Exclusive 245	Exclusive 200	Exclusive 162	Exclusive 140
Version	Massive deck	Massive deck	Massive deck	Massive deck
Decking thickness	21 mm	21 mm	21 mm	21 mm
Decking width	245 mm	200 mm	162 mm	140 mm
Joint width / Laying Aid	5 mm / black	5 mm / black	5 mm / black	5 mm / black
Deck width (incl. joint)	250 mm	205 mm	167 mm	145 mm
Standard lengths	3 / 4 / 5 / 6 m	3 / 4 / 5 / 6 m	3 / 4 / 5 / 6 m	3 / 4 / 5 / 6 m
Special lengths (min. 10 pcs./length/ colour)	2–13 m	2–13 m	2–13 m	2–13 m
Substructure-to-substructure distance (clear opening)	max. 40 cm	max. 40 cm	max. 40 cm	max. 40 cm
Weight per m <sup>2</sup> (+ approx. 3 kg substructure per m <sup>2</sup> )	24.4 kg	23.5 kg	22.8 kg	22.4 kg
Weight per metre of decking	6.1 kg	4.7 kg	3.9 kg	3.2 kg
Breaking strength	600 kg / dm <sup>2</sup>	600 kg / dm <sup>2</sup>	600 kg / dm <sup>2</sup>	600 kg / dm <sup>2</sup>
Substructure profile per m <sup>2</sup>	2.5–3 m	2.5–3 m	2.5–3 m	2.5–3 m
Installation Clips per m <sup>2</sup>	11	12	14	16
Start/End Clips per m <sup>2</sup>	as required	as required	as required	as required
Support System Brackets per m <sup>2</sup>	11	12	14	16
Cover Cap	–	–	–	–
Glue (for 60 Cover Caps)	–	–	–	–
Joint Profile Tube	–	–	–	–
Insertion Aid for Joint Profile Tube	–	–	–	–
Spacer	–	–	–	–
Profile Drilling Screw 5.5 × 46 mm	–	–	–	–
Drill Bit	–	–	–	–
Decking Screw 5.5 × 80 mm	–	–	–	–

All technical dimensions are approximate.



Urban flair	Natureline / Robust	Popular massive*	Strong	Smart**
Massive deck	Massive deck	Massive deck	Massive bearing decking	Zero-degree decking
21 mm	21 mm	26 mm	38 mm	19 mm
162 mm	140 mm	139 mm	140 mm	139 mm
5 mm / black	7.5 mm / green	7.5 mm / green	min. 5 mm	7.5 mm / green
167 mm	147.5 mm	146.5 mm	min. 145 mm	146.5 mm
3 / 4 / 5 / 6 m	3 / 4 / 5 / 6 m	3 / 4 / 5 / 6 m	4 m	3 / 4 / 5 / 6 m
2–13 m	2–13 m	2–13 m	2–13 m	2–13 m
max. 40 cm	max. 40 cm	max. 30 cm (abZ)* max. 40 cm (without abZ*)	max. 80 cm	max. 40 cm
24.6 kg	23 kg	25.9 kg	44.1 kg	19.6 kg
4.1 kg	3.2 kg	3.7 kg	6.3 kg	2.8 kg
600 kg / dm <sup>2</sup>	600 kg / dm <sup>2</sup>	800 kg / dm <sup>2</sup>	700 kg / dm <sup>2</sup>	400 kg / dm <sup>2</sup>
2.5–3 m	2.5–3 m	as required	as required	2.5–3 m
14	16	16 (without abZ*)		16
as required	as required	as required		as required
14	16	16		16
–	–	–	–	–
–	–	–	–	–
–	Ø 14 mm	Ø 18.5 mm	–	–
–	1	1	–	–
–	–	–	as required	–
–	–	50	–	–
–	–	1	–	–
–	–	–	as required	–

\* Popular massive decks must be installed in accordance with the general building inspectorate (abZ) approval.

\*\* Also available for common click systems. Product specifications for the Smart click decking board differ from the details specified here.

# Decking boards and special accessories



Decking boards	Piazza Prima	Piazza Mondo	Piazza One	Piazza Pro
Version	Co-extruded massive deck	Co-extruded massive deck	Co-extruded massive deck	Co-extruded massive deck
Decking thickness	19 mm	21 mm	25 mm	25 mm
Decking width	140 mm	140 mm	140 mm	140 mm
Joint width / Laying Aid	7.5 mm / green	7.5 mm / green	7.5 mm / green	7.5 mm / green
Deck width (incl. joint)	147.5 mm	147.5 mm	147.5 mm	147.5 mm
Standard lengths	4 / 5 / 6 m	4 / 5 / 6 m	4 / 5 / 6 m	4 / 5 / 6 m
Special lengths (min. 10 pcs. / length / colour)	2–6 m	2–6 m	–	–
Substructure-to-substructure distance (clear opening)	max. 40 cm	max. 40 cm	max. 40 cm	max. 50 cm
Weight per m <sup>2</sup> (+ approx. 3 kg substructure per m <sup>2</sup> )	20.7 kg	23.2 kg	23.8 kg	27.2 kg
Weight per metre of decking	2.95 kg	3.23 kg	3.4 kg	3.88 kg
Breaking strength	450 kg / dm <sup>2</sup>	450 kg / dm <sup>2</sup>	450 kg / dm <sup>2</sup>	450 kg / dm <sup>2</sup>
Substructure profile per m <sup>2</sup>	2.5–3 m	2.5–3 m	2.5–3 m	2–2,5 m
Installation Clips per m <sup>2</sup>	16	16	16	13
Start/End Clips per m <sup>2</sup>	as required	as required	as required	as required
Support system brackets per m <sup>2</sup>	16	16	16	16
Cover Cap	–	–	–	–
Glue (for 60 Cover Caps)	–	–	–	–
Joint Profile Tube	Ø 14 mm	Ø 14 mm	Ø 18.5 mm	Ø 18.5 mm
Insertion Aid for Joint Profile Tube	1	1	1	1
Spacer	–	–	–	–
Profile Drilling Screw 5.5 × 46 mm	–	–	–	–
Drill Bit	–	–	–	–
Decking Screw 5.5 × 80 mm	–	–	–	–

All technical dimensions are approximate.



Compact	Compact honeycomb	Compact honeycomb plus
Massive deck	Honeycomb profile	Honeycomb profile
21 mm	21 mm	21 mm
139 mm	139 mm	140 mm
7.5 mm / green	7.5 mm / green	7.5 mm / green
146.5 mm	146.5 mm	147.5 mm
3 / 4 / 5 / 6 m	3 / 4 / 5 / 6 m	3 / 4 / 5 / 6 m
2–13 m	2–13 m	2–13 m
max. 40 cm	max. 40 cm	max. 40 cm
21.7 kg	14 kg	15.4 kg
3.1 kg	2 kg	2.2 kg
600 kg / dm <sup>2</sup>	400 kg / dm <sup>2</sup>	400 kg / dm <sup>2</sup>
2.5–3 m	2.5–3 m	2.5–3 m
16	16	16
as required	as required	as required
16	16	16
–	as required	as required
–	as required	as required
Ø 14 mm	Ø 14 mm	Ø 14 mm
1	1	1
–	–	–
–	–	–
–	–	–
–	–	–

# Configure your terrace

With the online terrace configurator, you can design your terrace including substructure, freeforms and bevels.

- + Complete decking system range
- + Over 30 colours
- + Free sample service
- + Local specialist retailers
- + Fast availability



Scan now & configure your terrace



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now &  
discover our  
YouTube  
channel

### NaturinForm on YouTube!

As an application engineer, NaturinForm expert Michael Leitsch has over 20 years of experience in installing our products. Here and on YouTube, he shares valuable tips and tricks on the subject of decking. Follow us on: [youtube.com/NaturinFormGmbH](https://youtube.com/NaturinFormGmbH).



# Subsoil

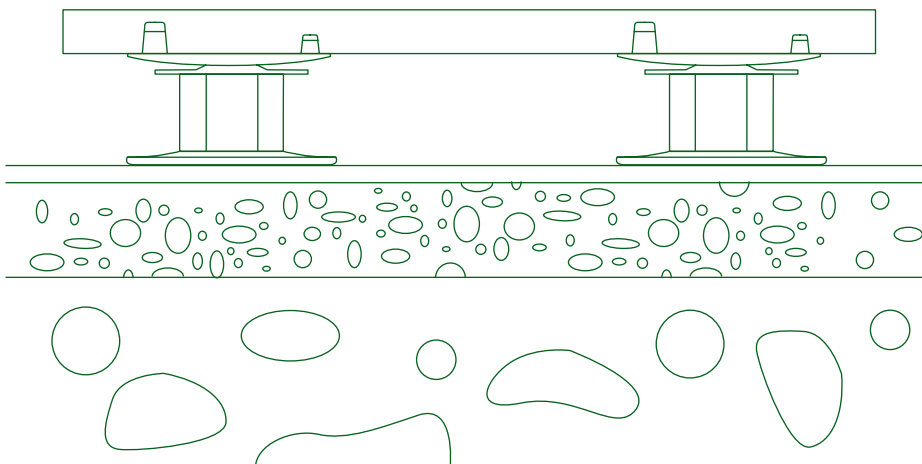
## The proper setup

The subsoil must be load-bearing and solid.

In case of a closed subsoil (tiles, foil, sheet metal), a slope is mandatory.

We recommend using a bed of gravel subsoil so that rainwater is drained to the bottom and can dry off quickly. Dirt and leaves falling through the joints can decay quickly. If a solid subsoil exists, it is useful to install individual modules that can be removed. This way, the water-bearing layer can be kept clean easily as well. For both variants, it is important to keep a distance as large as possible between the subsoil and the covering.

When using a bed of gravel, the drainage properties and frost resistance are particularly important. A Weed Control Fabric may also be included, if required. To avoid plasticiser migration on the foil sealing, the Cork Pad must be inserted between patio foot and foil as an isolation.



Compacted gravel bed

### Tip

Decking Feet can be used for any subsoil, can be quickly installed, precisely calculated and accurately set.

# Support points requirement in comparison

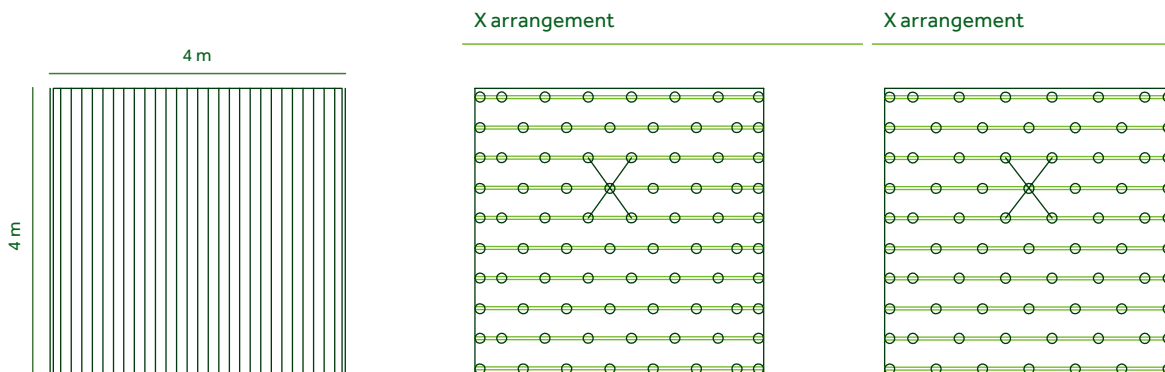
## Sample calculation: private terrace 2 kN/m<sup>2</sup>, 4 × 4 m

This calculation shows how the support points requirement changes depending on the substructure. The ideal distribution of support points (e. g. Decking Feet) is reached by an X arrangement. By this arrangement, vibrations are reduced, and the load is evenly distributed to the subsoil. Each terrace is unique in terms of layout, nature of the subsoil and structural situation. This is why the material requirements always differ to some extent, [see page 6 – 10](#).

**Tip:** Our terrace configurator supports you with our calculation and helps you getting an overview quickly: [terrassenkonfigurator.naturinform.com](https://terrassenkonfigurator.naturinform.com)



Requirement for sample area 4 × 4 m	Base profile WPC 2.0 40 × 60 mm	Base profile ALU 22.5 × 40 mm
Support points	80 pcs.	75 pcs.
Substructure	40 lfm Base Profile (10 pcs. / 400 cm)	40 lfm Base Profile (10 pcs. / 400 cm)
Decking boards, e. g. Compact Coverage 14.6 cm (13.9 cm + 7 mm joint)	108 lfm Decking Board (28 pcs. / 400 cm)	108 lfm Decking Board (28 pcs. / 400 cm)
Fixing	270 pcs. Installation Clips 20 pcs. Start/End Clips	270 pcs. Installation Clips 20 pcs. Start/End Clips



**Support points variants**

The load on the surface must be tolerated reliably and permanently and distributed to the subsoil. On a solid subsoil (tiles, foil, sheet metal, pavement), you must insert Cork or Rubber Pads and/or adjustable Feet depending on the height. On a gravel subsoil, concrete paving slabs (e. g. 40 × 40 × 4 cm) can be used as load dividers, and a Cork or Rubber Pad can be used as a support for the substructure. As an alternative to concrete paving slabs also deep kerbstones can be used. The best variant are the continuously adjustable Decking Feet available in heights of 3.3 – 21.8 cm. The distances from support point to support point depend on the substructure used, see page 16 – 17.

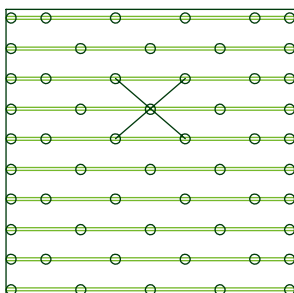
**Important, please note:**

- To install panels, please allow for additional substructures.
- In case of strong compressive load, e. g. due to large flower pots, an additional substructure must always be considered here.
- For roof terraces with roof-top insulation, the optimum load distribution must be discussed with the architect and client.
- Without fixing to the subsoil, a braced/torsion-resistant structure must be created.

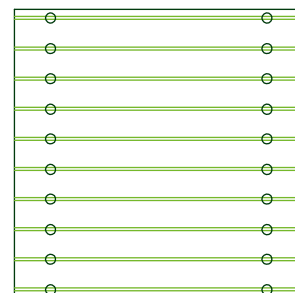
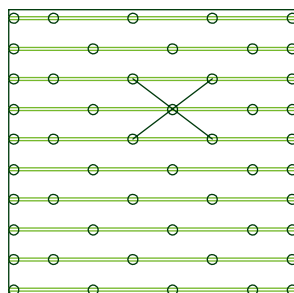


Base profile WPC 2.0 40 × 60 mm incl. Profile Reinforcer	System profile ALU 39 × 39 mm	Support profile ALU 100 × 60 mm
55 pcs.	50 pcs.	20 pcs. (small Decking Feet)
40 lfm Base Profile (10 pcs. / 400 cm)	40 lfm Base Profile (10 pcs. / 400 cm)	40 lfm Base Profile (10 pcs. / 400 cm)
108 lfm Decking Board (28 pcs. / 400 cm)	108 lfm Decking Board (28 pcs. / 400 cm)	108 lfm Decking Board (28 pcs. / 400 cm)
270 pcs. Installation Clips	270 pcs. Installation Clips	260 pcs. Support System Brackets
20 pcs. Start/End Clips	20 pcs. Start/End Clips	as initial L-Bracket / Screws

X arrangement



X arrangement



# Spacing depending on loads

## Substructure Profiles

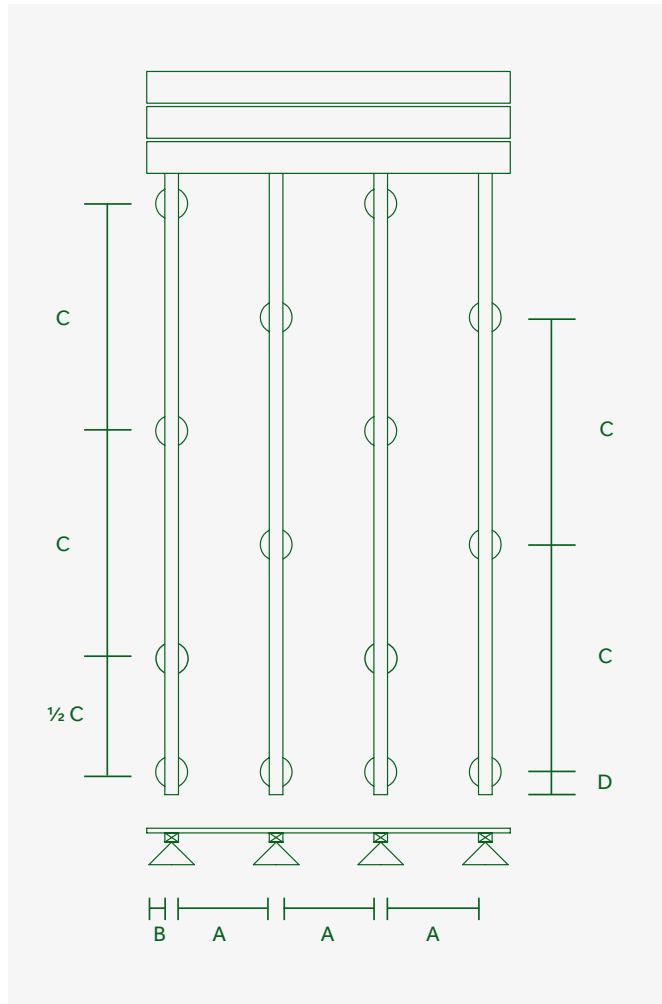
For a load-bearing substructure, it is advisable to make a calculation of requirements or use our terrace configurator. Our WPC or ALU Base Profiles, the System Profile ALU or the Support Profile ALU serve as substructure profiles. Our systems can be laid floating and do not have to be fixed to the subsoil.

If the substructure is a static installation, the decking boards must be fixed with Clips or Support System Brackets (no fixed screw connection), so that the covering can move slightly. Each deck board (including short lengths) must be supported by at least three joists.

Please keep in mind that when installing honeycomb profile decks with a length below 2 m, the outermost substructure profile must be weighted down or embedded, e. g. with the Wind Uplift Protection!

### Important:

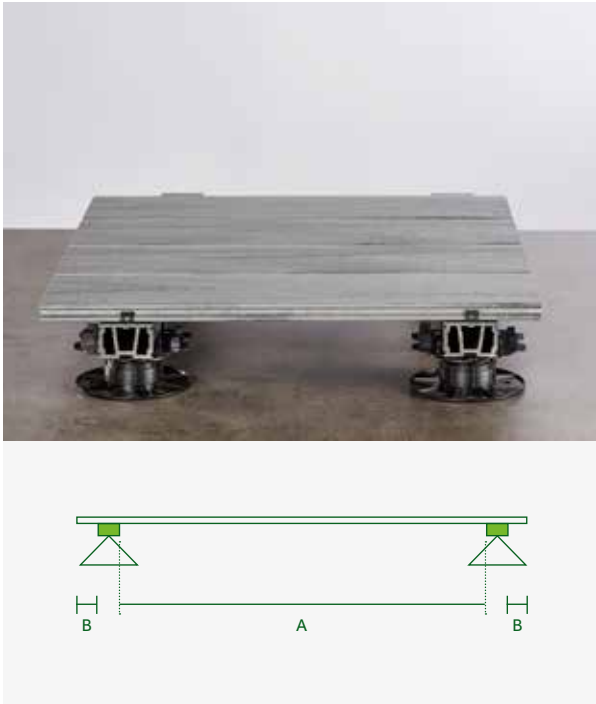
- Depending on the type of usage (load) of the terrace, the distance between the profiles and/or the support points must be reduced.
- It is also advisable to allow for more feet in areas with high loads, such as corner areas that are frequently walked on or areas with heavy planters.
- For WPC decking boards, the centre-to-centre distance (A) may not exceed 400 mm! Exception for the *Strong*, *Piazza Pro* and *Popular massive*. (see table on p. 17)
- For roof terraces, we recommend using a braced structure. Please also note our Wind Uplift Protection information.



The load tables for the substructure profiles can be found in the respective data sheet. Just scan the QR code.



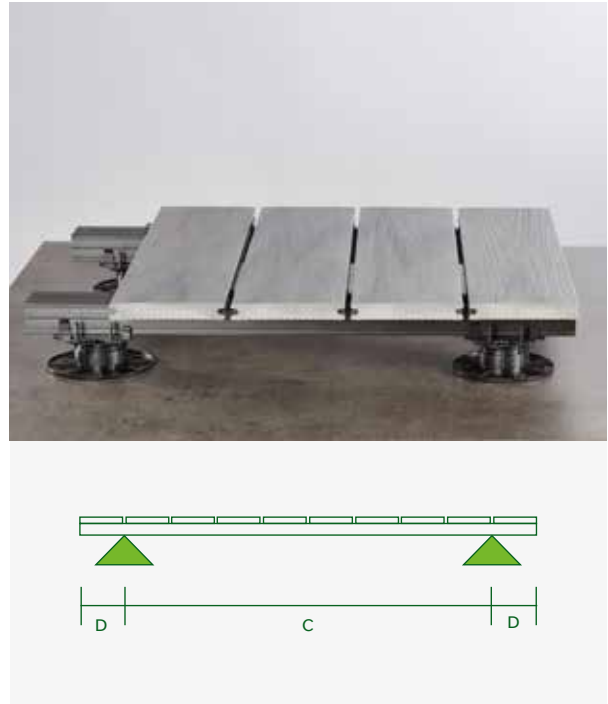
Any information on the subject of wind uplift protection and adding weight can be found in our accessories catalogue. Just scan the QR code.



**Max. spacing of the profiles  
when using different decking boards**

A	Popular <i>massive</i> (abZ)	30 cm
	Massive deck	40 cm
	Honeycomb profile deck	40 cm
	Popular <i>massive</i> (without abZ)	40 cm
	Piazza Pro	50 cm
	Strong	80 cm
B	Massive deck	8 cm
	Honeycomb profile deck	8 cm
	Strong	20 cm

(A) Spacing of the profiles (B) Overhang



**Max. spacing of the support points  
when using different substructure profiles  
2 kN / private terrace (when A = 40 cm)**

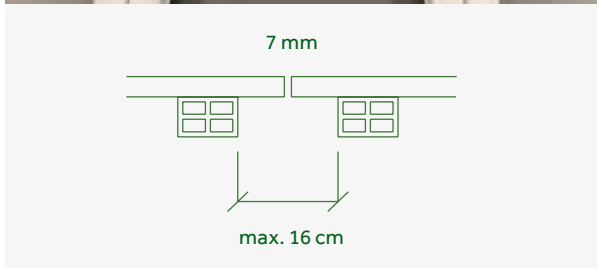
C	Base profile WPC 2.0 (40 × 60 mm)	60 cm
	Base profile WPC 2.0 + amplifier	100 cm
	Base profile ALU (22.5 × 40 mm)	65 cm
	System profile ALU (39 × 39 mm)	110 cm
	Support profile ALU (100 × 60 mm)	300 cm
D	Base profile WPC 2.0 (40 × 60 mm)	10 cm
	Base profile WPC 2.0 + amplifier	10 cm
	Base profile ALU (22.5 × 40 mm)	10 cm
	System profile ALU (39 × 39 mm)	20 cm
	Support profile ALU (100 × 60 mm)	100 cm

(C) Spacing of the supports (D) Overhang



Depending on the load on the terrace, whether private or public, the distance C must be adjusted. See QR code.

# Longitudinal edges



Always position edges on two substructures and keep in mind the overhangs. The max. decking board overhang is 8 cm.



For longitudinal edges of the substructure, the distance to fixed components must be observed. In addition to that, a minimum clearance of 1 cm per longitudinal edge must always be allowed for and taken into consideration. Use connecting elements with oblong holes to ensure linear expansion. Each longitudinal edge must be supported by a Decking Foot, Rubber Pad, Cork Pad or other material.

It is recommended to use decking boards over the entire length of the terrace. We offer special lengths of up to 13 metres for this purpose.

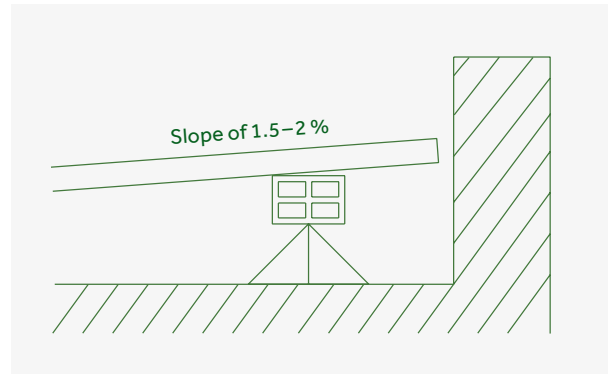
# Fixed components Slope



**Distance to fixed components on both sides depending on the length of the decking boards and substructure (with an installation temperature of approx. 20 °)**

A	for a length of 3 m	≥	cm	1.0
	for a length of 4 m	≥	cm	1.5
	for a length of 5 m	≥	cm	2.0
	for a length of 6 m	≥	cm	2.5

When using the Joint Profile Tube, edge joints must be twice as large. The Drainage Grid with a better rear ventilation can be used as an alternative.



Terraces should always be installed with a slope of 1.5–2 %. For honeycomb profile decks, the slope must follow the decking boards direction; massive decks may also be installed across the slope. Honeycomb profiles may not be installed to the level of adjacent grass or stone surfaces. The decking boards from the Piazza Family and *Smart* can be laid without a slope. However, a slope of at least 1% also offers the advantage of natural cleaning and faster drying of the terrace surface for these decking boards.

For massive decks, the slope may be reduced to 1 % upon prior consultation with us. It must be ensured that water can drain off and standing water is avoided also below the decking boards.

# Decking board installation

## Decking board installation

A terrace should be durable and give great pleasure to its owners in the long run. To achieve this, besides proper construction and quality of the decking boards, also the right accessories and most of all expert installation are required. Take your time for planning, and use quality products. Especially the substructure is extremely important.

Some key data for planning:

- ideal height of the overall structure:  
approx. 15 cm
- optimum slope of the surface: 2 %
- substructure on adjustable feet
- gravel bed subsoil

## Installation direction

The decking board surface is refined during the manufacturing process. If the decking board direction is not observed during installation, this may lead to a varying colour effect due to striation ("lawn mower effect"). Arrows in or below the board groove indicate the installation direction.

## Installation Aid

Boards with a joint width of 7.5 mm will be installed with the green installation aid. Boards with a joint width of 5 mm (*Exclusive, Urban flair*) will be installed with the black installation cross. The installation aids are contained in the Set of Installation Clips, see tables on pages 8 – 10.



## 1. Adjusting the substructure

After adjusting the substructure (different materials may be used here, e. g. Patio Foot, Rubber or Cork Pad, depending on the subsoil), the next step is the installation of the first decking board. Observe the installation direction of the boards (arrows in or below the groove).



## 4. Determining board spacing with the Installation Aid

The installation aid must be positioned on the boards as shown in the image above. This allows for some clearance in the bracket to ensure the board can move slightly. Subsequently, insert the next board, apply stainless steel Clip and screw down.



## 2. Fixing the first board

The installation of the first "entire" decking board is done either with the Start/End Clip, by means of a visible screw connection (see page 34) or concealed fastening using the L-Bracket. Decking boards cut to width can also be visibly mounted with the special screw. In this case, pre-drilling and countersinking is always needed.



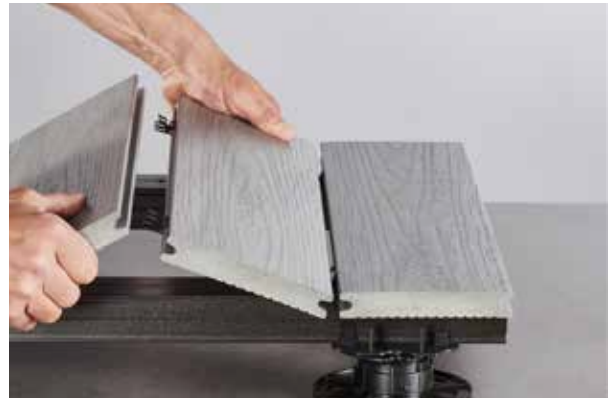
## 3. Attaching the Installation Clips

Screw down the first row of Installation Clips. Use the Support System Bracket for installation of the Support Profile System ALU. *Important:* Set the torque on the cordless screwdriver.



## 5. Laying the boards

Now follow the installation principle: Position the installation aids, insert the board, apply Installation Clips and screw down.



## 6. Installing the last row of decking boards

The last decking board may be mounted in a concealed way with the Start/End Clip (page 22: Replacing individual decking boards), with the L-Bracket or visibly with screws. Please make sure already at the planning stage that entire widths are used whenever possible. Replacing individual decking boards subsequently is possible, [see page 22](#).

# Replacing individual decking boards

## Subsequent replacement

When decking boards are to be removed, e. g. to install floor lamps, they can be detached even in the aftermath. Simply loosen the screws in the Clips along the board and lift the two boards upwards.

## To reinstall the board:

The two Clips will be attached to one of the two boards already inserted laterally.

see image 1

The second board will then carefully be inserted and pressed down onto the substructure.

see image 2

Then slide in the Installation Aids between the two boards and screw down the Installation Clips again.

see image 3



1. Laterally attaching the Installation Clips



2. Inserting the boards



3. Screwing down the Installation Clips again

# Joint profile tube

## Visual surface sealing

The joint profile tube by NaturinForm is used for sealing between the decking boards and enhances the look of the terrace. The result is a gap-free and opaque surface. The Joint Profile Tube prevents dirt and leaves from falling through and drains away most of the water; however, it does not make the surface 100 % watertight (useful for multi-storey balcony installations). When installed in nursery schools, for example, it also serves as a finger trap protection.

## Prerequisite for use:

- The minimum installation height below the decking boards is 8 cm.
- Sufficient rear ventilation must be provided. Therefore, the terrace surface may not be sealed on the sides.
- The terrace surface sealed with the Joint Profile Tube is a water-bearing layer and therefore must be installed with a slope (1.5–2 %) in the decking board direction.
- When using the Joint Profile Tube, the distances to fixed components must be doubled. The aluminium floor grating additionally contributes to better rear ventilation and reduces heat accumulation.
- Cut the Joint Profile Tube at the end of the board with an overhang of approx. 10 cm. Only align the tube length to the board length later on (after a few days), since the tube may expand due to installation or the outside temperature and will shrink again only after a certain time.



Manual installation by pushing



Installation with practical insertion aid

**Important:** The Joint Profile Tube is only inserted after the terrace has been completed. The spacing between the boards must be exactly 7.5 mm (green Installation Aid) in this case.

# Cover

## Panels

There are many design options for the edge finish: flowing transitions with gravel, stone or grass, boards sawn to shape, a decking board from the flooring as a flush or protruding edge, an Alu Finishing Profile, a colour-matching Deck Edge or our floor grating. However, you always need to consider the distance to fixed components. Free forms such as arches or bevelled edges are only possible with massive decks.

## Recessed terrace surface

The advantage of our solid WPC decking boards is that the terrace can be elegantly embedded flush into the environment. This design requires good preparation of the subsoil and a construction height of 15 cm to prevent waterlogging and ensure good ventilation (the Joint Profile Tube cannot be used here). The transition can be designed with stones, for example, or with other materials such as steel.

## Raised terrace surface

If the terrace surface is to be built higher than adjacent areas - i. e. a step is created - this should be clearly visible. To avoid dangerous tripping hazards, we recommend a step of 15 – 20 cm. The boards from the floor covering, sheet metal, perforated sheet metal or HPL laminate panels can be used to cover the structure.



Fixing panels with Profile Reinforcer



Fastening panels with Bracket for Cross Bracing



Concealed fastening of panels with L-Bracket

# Edges / Finishing Profiles

## Edges

The WPC *Deck Edge* (68 × 15 × 4000 mm) or *Piazza Edge* (140 × 20 × 4000 mm) can be used for low edges and covers. It has two different surfaces: finely ribbed and smooth, and is available in the colours Natural, Black Brown, Grey and Anthracite. It will be fixed in place using the corresponding screw depending on the material of the substructure.



### New

#### Piazza Edge

140 × 20 mm, Stück 4 m, made of WPC, to cover the substructure

### Important, please note:

- The distance from the wall and other fixed components must be kept.
- Ensure a completely surrounding, rear-ventilated overall structure.

*Tip:* Alternatively, you can also use our decking boards or façade profiles in various heights with matching colours and surfaces as covers.

The aluminium Alu Finishing Profile is a perfect material accentuation and visible edge for the longitudinal covering of the decking board groove.



Edges with Deck Edges



Edges with customised decking board



Edges with Alu Finishing Profile

# Drainage, ventilation & barrier-free building

## Drainage Grid

The aluminium Drainage Grid fulfils several functions:

- controlled drainage in front of balcony doors
- protection against rising water e. g. during heavy rains
- splash water protection at façade-ground connections or glass fronts
- ventilation of terrace structures
- creation of an inspection opening e. g. for easier cleaning

## Product benefits Drainage Grid

- direct installation possible on any substructure profile
- easy processing and cutting
- length of 4 m requires only few edges
- the format of 140 × 20 mm fits perfectly for most decking board formats and allows for a visually appealing effect even in the middle of the area
- concealed installation and easy removal possible with fixing set
- barrier-free transitions according to DIN possible

## Concealed installation

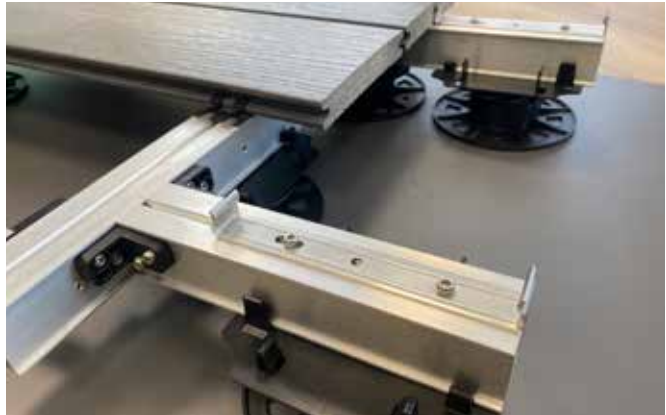
Once the fixing set has been screwed tight, the floor grating can simply be clicked into place.

## Visible attachment

For visible attachment, the grating is screwed down through the gaps.

## Installation direction

The installation of the Drainage Grid is independent of the decking board direction (Image 1: in an angle of 90 degrees; Image 2: parallel to the boards row). Every 40 cm, the floor grating rests on a substructure profile, analogous to the decking board.



1. Screwing down the fixing set



2. Clicking in the Drainage Grid



Alternative: Visible screw connection

# Edges for honeycomb profile decks

## Cover caps

There are special end caps for our honeycomb profile decks that protect against water penetration.

These are available in matching colours for all models:

*Compact honeycomb*: Brown/Chestnut Brown, Black brown, Grey, Anthracite

*Compact honeycomb plus*: Oak brown, Brown/Chestnut brown and Graphite grey.

## Important, please note:

The Cover Caps must be fitted on both sides!

The upper edge side can be attached with transparent glue for additional fixing of the Cover Caps, the lower edge side must remain unglued.



1. Applying glue to the upper edge side



2. Attaching the cover cap



3. Tapping carefully

# Screw connection for solid decking boards

## Visible decking board installation

For our *Strong* bearing decking or to obtain building inspectorate approval for the *Popular massive deck* (valid in germany), we offer special stainless steel screws to be screwed to WPC and wood or to aluminium.

### For wooden substructures

- Special Screw for massive decks 5 x 60 mm
- Special Screw for *Strong* 5.5 x 80 mm
- Drill Bit for Special Screws Ø 5 mm

### For aluminium substructures

- Profile Drilling Screw for massive decks 5.5 x 46 mm
- Profile Drilling Screw for *Strong* 5.5 x 61 mm
- Drill Bit for Profile Drilling Screw Ø 5.5 mm

Always use our template and the special drill to pre-drill and concurrently countersink the board prior to screwing.



Important: Installation with building inspectorate approval must be carried out in accordance with the regulations (no. Z-10.9- 484).



1. Positioning the template centrally to the substructure and marking the holes



2. Drilling and countersinking



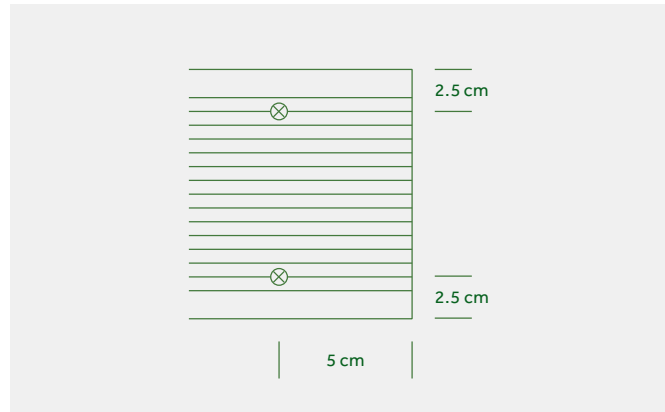
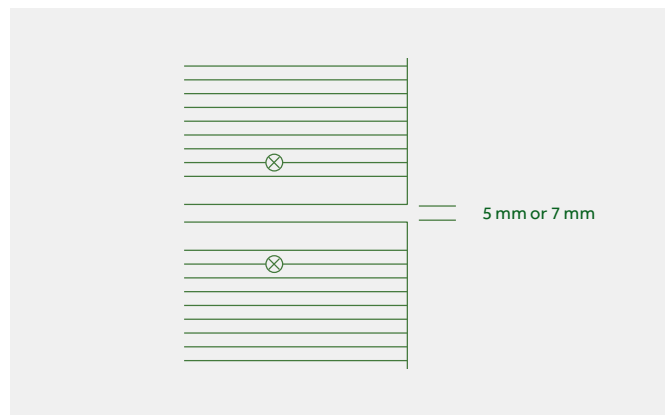
3. Screwing the decking board in place

**Important, please note:**

- Screw together massive decks only.
- Pre-drilling and countersinking is always necessary. NaturinForm terrace drills can be used for countersinking and have a depth stop.
- Floating laying: When using screws for visible attachment of the massive decks, the substructure must never be fixed to the base.
- Apply two screws, respectively, per board support point.
- Screw down with a distance of at least 50 mm to the front side.
- The distance between joints between each decking board must be at least 5 mm.
- The Joint Profile Tube cannot be used with a distance between joints of 5 mm.
- If the Joint Profile Tube is to be used, the distance between joints must be 7.5 mm (green Installation Aid).
- The minimum distance of the special screws to the lateral edge is 25 mm, respectively.
- For large areas or different decking board lengths we recommend prior consultation with one of NaturinForm's application engineers.

**For fixed substructures:**

A Spacer must be inserted between the substructure and the decking board. It ensures the expansion of the decking boards without stressing the screw connection and provides maximum ventilation.

**Spacing for screw connection (use the template!)****A distance between joints of 5 mm or 7,5 mm must be adhered to****Spacer for Strong**

# Worth knowing

## General information

The Laying Instructions must always be passed on to the client and permanently be kept on file, since they contain important information for cleaning and maintenance. When using products with a general building inspectorate approval, the specifications of abZ komplett must additionally be adhered to during installation.

## Note on storing

Prior to installation, please ensure that the goods are stored in a protected and damp-proof place after delivery up to and during installation. All packages must always be placed on a level ground so that loads are evenly distributed.

## Product characteristics

The wood composite material by NaturinForm is a material composition consisting of 70 % pine and spruce wood fibres, approx. 30 % food-safe PE, UV stabilisers and colour pads. Due to the high proportion of wood, the product behaves similar to wood, which is a natural product, with regards to colour changes when weathering.

## Advantages

Our decking boards made of wood composite material are slip-resistant and barefoot-friendly - without splinters and cracks. Special lengths of approx. 2 metres up to approx. 13 metres are available. You can save time, effort and money with all our WPC products, since oil-impregnating or painting once a year is not necessary - quality of living is gained solely by easy maintenance.

## Colour development and batches

Generally, all our products, with the exception of co-extruded Piazza products, run through a maturing process caused by light, air, sun, location and humidity. This colour change continues depending on weather conditions and installation location. The interaction of sun exposure, shadowing and exposure to humidity leads to colour changes, e. g. the colour of the WPC profiles brightens up, depending on the respective usage and installation situation. As part of this colour change, the surface of the freshly manufactured product loses its initial gloss, and the yellow colouring of the wood fibres occurring in the beginning will regress after full weathering. The desired natural matt shade emerges. These colour changes caused by the weather are product-specific, as with the natural product of wood, and do not constitute a flaw, but a natural, regular product characteristic due to the high proportion of wood. Different weathering conditions, e. g. due to partial roofing of the terrace area, may result in different colour developments.

We hereby point out that also the decking boards of our colour edition characterised by the special colouring may undergo colour changes over time as a result of weathering and natural maturing due to the high proportion of wood, as with the natural product of wood. In production, we pay attention to manufacturing a homogeneous quality, if possible. Fluctuations of the high-quality raw material, however, may still result in colour differences when different batches are installed. This does not compromise durability and is thus no cause for complaints.



Information on the individual colour maturity can be found on the respective product page at [www.naturinform.com](http://www.naturinform.com).

## Impact of chlorine or salt water

Chlorine or salt water have no negative impact on the characteristics of NaturinForm decking boards, the NaturinForm façade and the NaturinForm privacy fence tested according to DIN EN ISO 9227:2017-07. Stainless steel V4A brackets must be used when installing the terrace.

## Impact of the temperature

Wood composite materials may react to temperature fluctuations by visibly expanding or shrinking. Please allow for expansion joints and corresponding distances to fixed components. Installation of the decking boards is done with brackets so that zero-stress movement of the boards is possible.

## Impact of solar radiation

On hot days and in wind-protected locations, the usage of the WPC products with direct skin contact may be restricted due to high surface temperatures.

## Supporting structure element

Use *Popular solid* with the general building inspectorate approval Z-10.9-484 for supporting structures.

## Water stains

Water stains may develop on our products. Rainwater flows over the product and dries, dust particles remain on the ground. This effect is very low in open spaces that are constantly exposed to weather, but cannot be completely avoided. This does not compromise the quality and is thus no cause for complaints. Water stains can usually be removed with clear water and common cleaning equipment.

## Fibre inclusions

NaturinForm products contain approx. 70 % PEFC-certified wood fibres that are processed in a special manner, dried and supplied to the manufacturing process. In the manufacturing process, there may be fibre inclusions of other natural fibres such as liber (transition layer from bark to wood) due to the raw material. These particles may surface and break open during weathering as a result of humidity and water absorption. This does not constitute a flaw and does not impact the durability of the product.

## Electrostatic charges

In case of low relative humidity, longer dry periods or a well-isolated subsoil, there may be electrostatic charges. Use an earth cable between the area and, for example, a railing or a building wall to avoid electrostatic charges.

## Durability

Long-term durability is directly related to a well-planned and quickly drying substructure. Both heat accumulation and continuous waterlogging impacting the material must be avoided.

## Care and cleaning

NaturinForm products can easily be cleaned with water. Light soiling can be brushed down with a garden hose and broom or scrubbing brush. In case of severe soiling, a high-pressure cleaner (no steam jet) with a maximum of 80 bar at a distance of at least 20 cm to the material may be used. Our products made of wood composite materials are easy to clean due to the polymer part. Painting or oil-impregnating to extend durability are unnecessary. For persistent household stains such as grease or soot, use the biodegradable special cleaning agent specifically developed for us. For light surfaces, e. g. for the *Urban* decking board or the colour edition, a higher care and cleaning effort must be expected. Deposits due to environmental influences, such as Saharan sand, sooty particles, dust and pollen, may build on the surface of all WPC products. These deposits do not soak into the surface and may be cleaned or washed off with water in most cases. In autumn, e. g. mist, morning dew or condensation water may lead to slow and irregular removal and dripping off of the deposits. The deposits will not simply wash off by rainfalls, but have to be cleaned with water, as described above (in case of wooden façades, for example, environmental deposits may soak into the surface and result in discolouration. Deposits will not be washed off by rainfalls). Fertilisers containing iron or metal residues in the groundwater may cause discolouration.

## Installation direction

The surfaces of the decking boards are brushed during the manufacturing process. This creates a certain grain direction. If the decking board direction is not observed during installation, this may lead to a varying colour effect due to striation. To allow for a visually uniform installation, you will find arrows for your guidance in the lateral groove of the decking boards.

## Ventilation and rear ventilation / avoiding waterlogging

A slope on the surface away from the building leads to faster runoff and drying. Regular cleaning of the surface and above all keeping the joints clear is crucial. Fast drying of the material within the substructure must be ensured by means of the specified distances to fixed components and the subsoil. Waterlogging must be avoided. Especially when the joint profile tube is used for the installation, a supported, completely surrounding, rear-ventilated overall structure is a fundamental prerequisite. The minimum installation height is 8 cm (from the subsoil to the lower edge of the decking board).

## We offer you highest quality. Therefore, our products are constantly subject to quality checks and stress tests.



### Resistance testing against wood-destroying fungi - durability class 1 (very durable)

In the division for process engineering of wood-based materials at Fraunhofer-Institut für Holzforschung Wilhelm-Klauditz-Institut WKI, Brunswick, the resistance of our decking boards made of wood composite materials was tested based on DIN ENV 12038 (2002) in February 2012. The assessment was done according to the test for timbers (DIN CEN/TS 15083-1) with the result: durability class 1, very durable.



### "Safety of Toys – Part 3: Migration of specific elements" test – DIN EN 71-3:2019

In June 2025, Fraunhofer-Institut für Holzforschung Wilhelm-Klauditz-Institut WKI, Brunswick, tested various decking boards from the NaturinForm range for the "safety of toys". The test report confirms that the material tested satisfies the thresholds according to DIN EN 71-3:2019 "Safety of Toys – Part 3: Migration of specific elements".



### PEFC-certified: HW-PEFC-CoC-0286-23

"HW-Zert GmbH, notified by PEFC Deutschland e. V. confirmed that NaturinForm GmbH maintains an operational control system that fulfils the PEFC (Programme for the Endorsement of Forest Certification) chain of custody requirements in accordance with the PEFC ST 2002:2020 standard in its current version (see [www.pefc.org](http://www.pefc.org))."



### EPD by Institut Bauen und Umwelt e. V. (IBU)

#### Environmental product declaration according to ISO 14025 and EN 15804

"Together with VHI, we commit ourselves to sustainable building via EPDs for WPC decking boards and WPC façade elements at IBU" (Verband der Deutschen Holzwerkstoffindustrie e. V.)



### Member of DGNB - Deutsche Gesellschaft für Nachhaltiges Bauen

DGNB is Europe's largest network for sustainable building and has supported buildings proven to be climate-friendly, quarters worthy to live - in short, a sustainably built environment - since 2007.



### Fire behaviour test - class E

ift Rosenheim GmbH tested *Popular* for the classification on fire behaviour according to DIN EN 13501-1 with the result: class E. This is absolutely comparable with wood.



### Slip resistance test - DIN 51130

Our brushed decking board surfaces are particularly slip-resistant, even in wet conditions, and are therefore very well-suited for public areas (swimming pools, nursery schools, hotel terraces, etc.). The test results can be found on the respective product pages.



### Qualitätsgemeinschaft Holzwerkstoffe e.V. Gießen

As a member of Qualitätsgemeinschaft, NaturinForm GmbH is a driver of secured quality production. The high requirements resulting from that are tested internally on a daily basis and regularly also at external testing institutes with very good results. Our quality wood composite material thus consists 100 % of German wood fibres with PEFC certification, and the pure polymer used is freshly produced PE.

### Disposal

It is recommended to dispose of WPC leftover pieces with bulky waste or take them to a recycling depot. This may be subject to charges. As an alternative, NaturinForm offers a sustainable return option.

### Return option

Only wood fibres from suppliers certified with the PEFC seal are used in our manufacturing process. These are wood products from sustainable forestry that meet ecological standards. The certification of our NaturinForm WPC decking profiles associated with the fulfilment of the high quality standards of Qualitätsgemeinschaft Holzwerkstoffe, among the technical safety and the lack of health risks, also confirms the environmental safety of our products. As part of our manufacturing process, we are also able to recycle our WPC products, return them to our manufacturing process and reuse them in an ecologically friendly and sustainable way. Therefore, we will be pleased to take back our original NaturinForm WPC products free of charge, after reviewing the product cleanliness, when delivered to our factory in Redwitz an der Rodach, Flurstr. 7.

Since this take-back is not an actionable liability under the law of obligations, but a voluntary and non-binding return option, if you want to return used WPC products to us, we recommend to contact us in advance in order to ensure smooth handling. By returning used NaturinForm WPC products, you support our manufacturing process employing sustainable materials. By acting environment-consciously, you contribute to an environmentally friendly product cycle.

### Recycling box

You collect the leftover pieces from your projects and we return 100 % of them to our manufacturing process. Simply fill the box with NaturinForm products and register the recycling box online for collection. Please note that only WPC products by NaturinForm may be collected in the "Re-Form-Box". If other items end up in the box, disposal will be charged at cost, but at least at 50 €. Additional information can be found at: [www.naturinform.de/recyclingbox](http://www.naturinform.de/recyclingbox)



# Natur inForm

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