

Processing Guide

Drum Storage - Store drums at 59°F-77°F (15°C-25°C).

Drum Preparation - *The liquid in the drums needs to be between 70°F to 80°F (21°C-27°C)* for the material in the drums to spray high quality foam. For optimal results it is best to heat your drums in a warm room overnight. Be cautious when rapidly heating material using artificial means such as band heaters or heater plates as the external temperature of the drum does not always indicate true material temperature inside the drum. ***This material SHOULD NOT BE RECIRCULATED through the machine to heat it to temperature*** or frothing and loss of yield may occur. If this frothing out of the drum occurs stop recirculating immediately and place several bags of ice on top of the drum to stop the frothing.

Spray Pressures - *The optimal spray pressure should be set between 1200-1400 psi.* Keep an eye for a good spray pattern and a good mix producing a good cell structure.

Spray Temperatures - *The optimal spray temperature is 100°F (38°C)* in ideal conditions which is considered Room Temperature 77°F (21°C). When substrate and ambient temperature falls significantly below Room Temperature you may want to heat up pre-heat and hose temperatures as high as 110°F (43°C) to maintain proper speed of rise and no dripping overhead. When substrate and ambient temperature rise significantly above Room Temperature you may want to cool down pre-heat and hose temperatures as low as 95°F (35°C) to avoid shrinkage off the studs or scorching of the material.

Substrates - *Substrates should be clean, dry and warm.* When substrates are not clean or have oxidized, loss of adhesion may occur. If substrates are not dry and have a moisture content >20% for wood and >10% for concrete, shrinkage and loss of adhesion will likely occur. The optimal substrate temperature is Room Temperature 77°F (21°C). While you may spray down to 14°F (-10°C) ambient temperature you may experience a loss of yield and possible cracking and shrinkage off of studs and perlins if they are colder than 14°F (-10°C). We recommend heating up the area being sprayed and the substrate as close to Room Temperature as possible. If the substrate is over 120°F (49°C) which is not uncommon in metal buildings in the summer you may get blistering, loss of adhesion and poor cell structure. It may be necessary to wait until evening when the sun cools down to spray foam in these conditions.

Application Depths - *You may spray up to a 4" pass..* While you can safely spray one 4" pass, spraying thinner passes such as 2"-3" at a time will result in a smoother, more uniform finish and aesthetically pleasing look.

Application Inspection- *Inspect material carefully during the application and after application for good cell structure and adhesion*
Remove all off-ratio foam or unreacted chemical from substrates or walls due to pressure imbalances which is not uncommon in common spray foam equipment.