

Processing Guide

Drum Storage - Store drums at 70°F - 88°F (21°C - 26°C).

Drum Preparation - *The liquid in the drums needs to be between 70°F to 77°F (21°C to 25°C)* for the material in the drum 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 there is chemical frothing out of the resin drum STOP immediately, screw all bung caps back onto the lid, and place several bags of ice on the top and sides of the drum to stop the frothing.

Spray Pressures - *The optimal spray pressure should be set between 1200-1500 psi.* While spraying keep an eye for a good spray pattern and a good mix producing a good cell structure.

Spray Temperatures - *The optimal spray temperature is 110°F to 120°F (43°C to 49°C)* in ideal conditions which is considered Room Temperature 77°F (21°C). When substrate and ambient temperatures fall significantly below Room Temperature it may be necessary to turn up the proportioning machine pre-heaters and hose temperatures as high as 125°F (52°C) to maintain proper speed of rise and no dripping overhead. When substrate and ambient temperatures rise significantly above Room Temperature you may want to turn down the pre-heaters and hose temperatures as low as 105°F (41°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 >18% 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 ambient temperatures of 14°F (-10°C) with our winter blend formula and 45°F (7°C) with our summer/regular blend formulas you may experience a loss of yield up to 40% and possible cracking and shrinkage off of wood and metal studs and metal perlin's if they are colder than these temperatures. 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 the evening when the sun cools down to spray foam in these conditions. DO NOT spray Thermoseal 5G onto any other insulations without contacting Thermoseal first.

Application Depths - *You may spray 2" to 3" per pass.* Spraying more than 2"-3" per pass may result in a less uniform finish and unsightly look. When a thinner pass is desired we recommend using a .00 or .01 mixing chamber.

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.