



Spray Application Guide

Drum Storage

Store drums at 60°F to 100°F. Do not allow drum temperature to fall below 40°F – it can degrade the formulation and negatively affect the performance of the foam. This damage cannot be repaired.

Drum Prep

Prep drums to 70°F to 100°F. In order for the drum to be serviceable (ready to spray), it must be in a temperature range that the proportioner can take it the rest of the way to spray temperature. *Example: If your drum temp is 70°F and you have an E-20 with a .01 mix chamber your delta T is 50°F, so max spray temperature can only be 120°F. If you want to spray at 135°F with the same machine your drum must be 85°F to achieve that spray temperature. It is important to know the delta T of your proportioner, mix chamber size, and drum temperature to achieve the proper spray temperature.*

Mixing

GacoFireStop2 must be well mixed* (See Note) for 20 minutes to ensure a uniform solution before flushing or recirculating. You may continue to recirculate GacoFireStop2 to raise the drum temperature but do not recirculate the product over 100°F. You may continue to mix during recirculation to achieve a uniform temp for the drum. After initial mixing, turn mixer off to avoid frothing product with air bubbles. Mix once more during midday break for 20 minutes and turn mixer off again.

***NOTE: GacoFireStop2 should be mixed using a 3-Stage Collapsible Blade Mixer.** Make sure the three blades are evenly spaced out from top to bottom on the shaft. With GacoFireStop2, it is crucial that you be able to mix material in the top with the material in the bottom – if all the blades are on the lower end of the shaft this cannot be achieved.

Flushing

When changing from a closed cell product to GacoFireStop2, first purge the system with water to get the closed cell product out of the system, then come in behind with GacoFireStop2 to flush out the water. Remember to flush the entire system including recirc lines, reactor and spray hose. Use water again to flush the GacoFireStop2 out of the system before you go back to the closed cell product.

Spray Pressures

1,200 to 1,500 psi for optimal performance. 1200 psi minimum for .01 mix chamber (AR4242) and 1400 psi minimum for .02 mix chamber (AR5252). Look for good atomization and mix of chemical with proper spray pattern.

Spray Temperatures

90°F to 135°F. The lower temp spectrums are used in warmer climate and the higher temp spectrums are used in colder climates. If the foam is reacting slowly or is slightly runny down the wall it is too cold and requires more heat. If the foam starts to grow erratically and is pushing itself off the substrate it is too hot and temps need to be dialed down.

Substrate Limitations

Substrates should be: clean, dry, and warm. While clean and dry offers the best success for adhesion, warmer substrates provide better yields. The colder the substrate the lower the yields we can expect. Do not spray if surface temperatures are within 5 degrees of the dew point. Substrate moisture levels should be at or below 18%.

Application Depths

Anything from a flash pass (0.5") to a full fill pass (3.5" to 5.5") in a cavity and depending on technique and cavity even thicker than 5.5"). Keep in mind that the more passes you spray to fill a cavity the less yield you will get. While flash passes are not the most desired pass it is sometimes necessary to heat substrates for the next thicker pass or for overhead so we can spray thicker passes above us.

Application Techniques

Most common: Holding the trigger and moving the gun from side to side while working from bottom to top of cavity. Other options: Triggering the gun in an up and down motion within the cavity; or, holding the trigger down, starting at the bottom and center of the cavity and taking the gun straight up to the top of the cavity. There are several different styles and techniques used by thousands of applicators. Regardless of your style, your job is to seal the cavity and fill to proper depth.

Inspect Application

Look for good cell structure, adhesion, and a consistent light orange color (salmon color). Remove any unreacted chemical from wall (due to pressure imbalances while triggering gun). Press on cured foam and feel for voids, if voids are found inject foam into void by placing the gun tip to the foam and pulling the trigger to inject the product and fill the void.

EQUIPMENT SETTINGS

Pre-Heat - Iso (A):	90°F to 135°F (32°C to 57°C)
Pre-Heat - Poly (B):	90°F to 135°F (32°C to 57°C)
Hose Heat:	90°F to 135°F (32°C to 57°C)
Recommended Spray Pressure:	1,200 to 1,500 psi (dynamic)

REACTIVITY TIME

Cream Time:	0 - 1 sec
Rise Time:	2 - 5 sec
Tack Free Time:	2 - 5 sec
Cure Time:	1 hour