Icynene Classic™ Best Practices

In order to properly process Icynene Classic™ and to maximize yield, please adhere to the following guidelines:

Storage:
- Once received, Classic™ drums should be stored at 60°F to 85°F.
- This will allow for quicker warm up of materials and will keep the B-side resin from degrading prematurely.
- Do not store material on rigs other than what is required for current application needs, as materials left inside of rigs can easily exceed these recommended storage temperatures.
- Classic™ B-side resin has a 6 month shelf life if stored as stated.
- Follow FIFO (First-In-First-Out) stock rotation.

Mixing:
- Icynene Classic™ resin requires a hand mix at the beginning of each day and when starting a new set. Conduct mixing at the jobsite just before application.
- Mixing needs to be done with a clean aluminum canoe type paddle for 5 to 10 minutes depending on the age of the resin. If the resin is one month of age or older a minimum of 10 minutes of hand mixing is required.
- Mixing should be conducted by pulling material from the bottom to the top of the drum in a circular motion. It is important to mix until the material is thoroughly consistent (check the paddle when you pull it out of the drum for consistent appearance).
- If changing to Icynene Classic™ from another product follow the changeover procedure below.
- Once hand mix is complete, a drum mixer must be used for constant agitation of the mixed drum.
- A blade or auger type mixer should be run at low- to medium-speed but not fast enough to cause frothing and pull air into the resin as this could cause off-ratio foam.

Heating:
- The ideal drum temperature for processing Icynene Classic™ (B-side Resin and A-side Iso) is 90°F.
- If necessary in cooler weather and while mixing, the proportioner if equipped with circulation lines, can be used to warm up the drums to 90°F by circulating through the machine back to the drums. The machine heaters should be set no higher than 120°F during this operation.
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- If not equipped with a circulation system, drum band heaters or electrically heated drum blankets can be used to warm and maintain the drum temperatures at 90°F. Non-heated drum blankets can be used with a circulation system to maintain drum temperatures at 90°F. In all cases be careful not to overheat the drums (over 100°F).
- If you have a hose circulation block, it is also good practice to circulate the hose for about 10 minutes before spraying Classic™

Processing Temperature and Pressure:

- In standard ambient conditions of 60°F to 85°F Icynene recommends the following for processing Classic™:

  Drum Temperatures: 90°F
  A and B Primary Heaters: 135°F
  Hose Heat: 135°F
  Mix Chamber: AR5252 (02 round)
  Pressure: 1200 psi (dynamic)
  Spray Distance: 12” to 14”

- Ideally the foam should stop rising in about 5 to 6 seconds.
- In cold weather (below 60°F) increase the A, B and Hose heats in 3 degree increments (up to 160°F) to achieve this rise time.
- In hot weather (above 80°F) decrease the A, B and Hose heats in 3 degree increments (down to 120°F) to achieve this rise time.
- To maximize yield Icynene recommends using an AR5252 (02 round) at 1200 psi dynamic pressure. If it is necessary to use another sized chamber, use the following guidelines:

<table>
<thead>
<tr>
<th>Mix Chamber Size</th>
<th>Pressure (dynamic)</th>
<th>Distance</th>
</tr>
</thead>
<tbody>
<tr>
<td>00 (2929)</td>
<td>700-900 psi</td>
<td>10” - 12”</td>
</tr>
<tr>
<td>01 (4242)</td>
<td>900-1100 psi</td>
<td>12” - 14”</td>
</tr>
<tr>
<td>02 (5252)</td>
<td>1100-1500 psi</td>
<td>12” - 14”</td>
</tr>
<tr>
<td>03 (6060)</td>
<td>1500-2000 psi</td>
<td>15” - 18”</td>
</tr>
</tbody>
</table>

Please be aware that altering recommended settings may cause poor foam quality and a substantial reduction in yield.
Spray Technique:

- Always spray with the spray gun at a 90 degree angle to the substrate.
- Maintain the proper distance as recommended above.
- For wall cavities, spray side-to-side from the bottom of the bay to the top while wetting the studs all the way up.
- If spraying a flat wall, maintain gun angle and distance. Don’t spray more than 2ft wide. If necessary, create “foam studs” 2ft apart as a guide.
- **Spray the full thickness required in one single pass.** Spraying in layers or excessive touch-up work will lead to a reduction in yield.

Changeover:

- **If you are changing in to Classic™ from another product you must not allow the other product to contaminate the Classic™ resin drum.**
- After hand mixing the Classic™ resin as outlined above do the following:
  - Make sure the drum mixer, dip tubes, drum pump and pump housing are completely free of the previous resin.
  - Allow some air in to the drum pump or dip tube.
  - Put the drum pump in to the drum of Classic™ resin
  - If you have a re-circulation/pressure-relief line, pump the contents to the previous drum or into a waste container with the transfer pumps.
  - Connect the re-circulation/pressure relief line to the Classic™ drum lid.
  - Remove the gun from the hose manifold and pump the hose contents in to the previous drum until you see a color change or until you reach the air pocket in the line.
  - Keep the hose heat on at 125°F during changeover.
  - There will be some mixture of the two resins in the line which you can run in to a container for disposal or spray out as foam for disposal.
  - Spray a test bun and watch for good foam with no collapse.
- Make sure recommended settings above are followed before installing Classic™ as outlined above.

Before spraying Icynene Classic™ for the first time you should contact Icynene-Lapolla Technical Services for installation guidance.