

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:

<u>Mix Chamber Size</u>	<u>Pressure (dynamic)</u>	<u>Distance</u>
00 (2929)	700-900 psi	10" - 12"
01 (4242)	900-1100 psi	12" - 14"
02 (5252)	1100-1500 psi	12" - 14"
03 (6060)	1500-2000 psi	15" - 18"

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

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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.