

# PROCESSING GUIDE

**Drum Storage - Store drums at 50°F - 80°F (10°C - 27°C).**

**Drum Preparation - *The liquid in the drums needs to be between 70°F to 90°F (25°C - 32°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. You may recirculate the material through your hose back into the drum with a recirculation kit. Your recirculation temperatures should be set to 77°F - 90°F (21°C - 32°C). DO NOT recirculate above 90°F (32°C).

**Spray Pressures - *The optimal spray pressure should be set between 1100-1500 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 125°F to 135°F (52°C to 57°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 140°F (60°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 120°F (49°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 40°F (4°C) you will experience a loss of yield up to 40% and possible cracking and shrinkage off of wood and metal studs and metal perlins. 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. DO NOT spray Igloo Foam OC onto any other insulations without contacting Spray Foam Outlets first.

**Application Depths - *A 3" to 5" pass will produce best results.*** Spraying more than 5" per pass may result in pocketing between the substrate and the foam, as well as possible pocketing between layers of foam.

**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.