



TECH TIPS

a technical bulletin by the experts at Gaco Western

GacoFireStop2 Application & Flushing Procedures



In the last few months, we've looked at application procedures for our 052N and 183M. Now it's time to review application procedures for our new GacoFireStop2 Open Cell Foam.

DRUM PREP

Prep drums to 50-90°F. In order for the drum to be serviceable (meaning ready to spray), the drum must be in a temperature range that your reactor can take it the rest of the way to spray temperature.

Example: If your drum temperature is 70°F and you have an E-20 with a .01 mix chamber your delta T is 50°F, so your 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.

As you can see, it is important to know the delta T of your reactor, mix chamber size, and drum temperature to achieve the proper spray temperature.

MIXING/RECIRC

Auger style mixers are insufficient and the 3-Stage Collapsible Blade

Mixer is recommended. Before any flushing or recirculating, GacoFireStop2 must be well mixed for 20 minutes to ensure a uniform solution. You may continue to mix during recirculation to achieve a uniform temp for the drum. For those of you with recirc capabilities, you can recirculate the GacoFireStop2 to raise the drum temperature but do not recirculate the chemical over 100°F.

SPRAY PRESSURES

1200-1500 psi for optimal performance. 1200 psi is minimum for a .01 mix chamber (AR4242) and 1400 psi is minimum for an .02 mix chamber (AR5252). Look for good atomization and mix of chemical with a proper spray pattern.

SPRAY TEMPERATURES

105°F to 135°F. The lower temp spectrums are used in warmer climates

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**Having trouble with foam?
Just pick up the phone!**

Gaco Western's Tech Hotline:
855 639 4649

8am - 8pm CST, Mon-Sun

**Ideas, suggestions
or questions?**

techtips@gaco.com



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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 shrink after the initial reaction it is too hot and temps need to be dialed down. For Autumn and Winter seasons a good starting point is 125°F.

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.

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 deeper 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. 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.

FLUSHING PROCEDURES

Please refer to our previous Tech Tip "Eliminate Cross Contamination by Flushing with Water."

www.gacowallfoam.com/docs/TechTips028.pdf

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