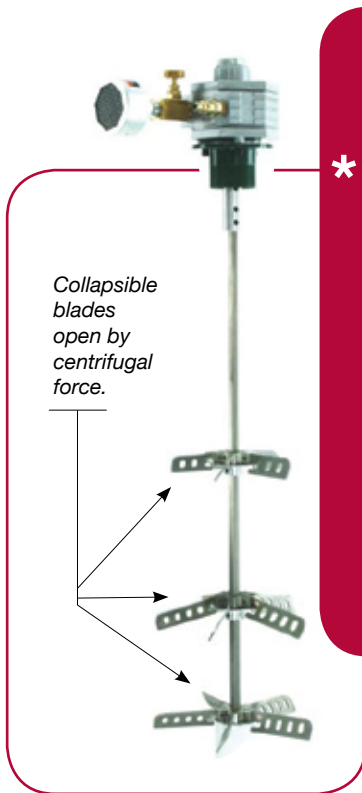




TECH TIPS

a technical bulletin by the experts at Gaco Western

GacoFireStop2 Application Procedures



Collapsible blades open by centrifugal force.

3-Stage Collapsible Blade Mixer

★ 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.

DRUM PREP AND MIXING

Prep drums to 50°F-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.

Before any flushing or recirculating, GacoFireStop2 must be well mixed★ for 20 minutes to ensure a uniform solution. For those of you with recirc capabilities, 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 this initial mixing, turn the mixer off to avoid frothing the product with air bubbles while spraying out the drum. Mix one more time during midday break for 20 minutes and turn the mixer off again.

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. For more information, please refer to our previous Tech Tip “Eliminate Cross Contamination by Flushing with Water.”

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.

(Continued on page 2)

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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GacoFireStop2

Application Procedures (Continued)

SPRAY TEMPERATURES

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

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 (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.

DRUM STORAGE

While storing drums prior to spraying, do not allow the 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. 

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