



TECH TIPS

a technical bulletin by the experts at Gaco Western

5 Questions & Answers about GacoONEPass™

CLOSED CELL FOAM



Question 1

What is the correct temperature to spray GacoOnePass?

Answer:

Since all machines spray differently, a good method for checking temperature is to observe the color of the material as you spray. Look for 1 second of time where the material is brown and adjust temperatures accordingly. If no brown is visible when spraying and you only see white material, the temperature is too hot and should be turned down. If brown time lasts for longer than 1 second or the material starts to run before rise, then the temperature is too cold and should be increased.

Question 2

How do I know how much to turn up my heat?

Answer:

GacoOnePass has a 6-7 degree per second change.

Example: If it takes 3 seconds before the foam starts to react but you want the reaction to occur at 1 second, you must raise the heat to make the reaction occur 2 seconds sooner.

Doing the math: 2 seconds x 6-7 degrees = **12-14 degrees**.

Increasing temperature by this amount should get you dialed in.

Question 3

How can I keep my gauges on ratio?

Answer:

One way to help keep your ratios closer is to raise the B side primary heat by 5-10 degrees. Set a cooler temperature on the A side primary heater and the hose, then raise the temperature on the B side primary. As an example, if you normally spray around 115°F and want your pressures closer on ratio, raise the B primary 10 degrees to 125°F and drop the A primary and hose temperatures 10 degrees to 105°F. Then the mixed material coming out of the gun is 115°F. This will help thicken the ISO and thin the resin to help keep pressures more uniform.

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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GacoWallFoam



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(Continued)



Question 4

How do I avoid overspray?


Answer:

- **Turn temperature down.** One likely cause of overspray is high temperature. When you spray too hot, the reaction of chemicals starts mid-air and then the mixed foam starts to float and fall to the floor. If you turn your heat down, the chemical will reach the substrate in liquid form and then begin to react.
- **Spray closer to the substrate.** Another possible cause of overspray is spraying too far from the substrate. Move closer for a more controlled and accurate spray.
- **Adjust pressure.** Having pressures too low or too high can cause overspray. When pressure is too low, gravity will cause material to fall before it reaches the substrate. When pressure is too high, the material will mist and turn into overspray.

Question 5

How can I increase yield?

Answer:

Yield will increase or decrease with thickness. If your job calls for 4" thickness and you spray two passes of 2" to get to 4", you will have a lower yield than you would spraying a single 4" pass. You can also increase yield by counting passes in the stud bay and staying consistent, watching how much you spray on the untouched substrate, and choosing an efficient spray technique. When spraying deep passes, aim the gun at a 45° angle toward the rising foam - this will help avoid blowing the foam apart and create a deeper lift. Decrease pressure if you continue to experience foam blowing apart. 

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