

ICYNENE CLASSIC MAX™

BEST PRACTICES

IN ORDER TO PROPERLY PROCESS ICYNENE CLASSIC MAX™ AND TO MAXIMIZE YIELD, PLEASE ADHERE TO THE FOLLOWING GUIDELINES:

STORAGE

- Once received, Icynene Classic Max™ 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.
- Follow FIFO (First-In-First-Out) stock rotation.

MIXING

- **Icynene Classic Max™ 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 Max™ 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 Max is 90°F (A and B).**
- 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.
- If not equipped with a circulation system, drum band heaters or electrically-heated drum blankets can be used to warm and maintain the drums 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 Icynene Classic Max™

Continued Over Page ►



If you have any questions, please contact Icynene Technical Services before spraying Icynene Classic Max™.

Call 1.800.758.7325

PROCESSING TEMPERATURE & PRESSURE

- In standard ambient conditions (60°F to 85°F), Icynene recommends the following for processing Classic Max™:

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 5-6 seconds.
- In cold weather (below 60°F) increase the A, B and Hose heats in three (3) degree increments to achieve this rise time.
- In hot weather (above 80°F) decrease the A, B and Hose heats in three (3) degree increments 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:

Mix Chamber Size	Pressure (dynamic)	Distance
00 (2929)	900 psi	10" - 12"
01 (4242)	1100 psi	12" - 14"
02 (5252)	1200 psi	12" - 14"
03 (6060)	1400 psi	15" - 18"

Please be aware that altering recommended settings may cause a reduction in yield!

SPRAY TECHNIQUE

- Always spray with 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 two (2) feet wide. If necessary, create "foam studs" two (2) feet 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 Icynene Classic Max™ for the first time you must not allow another product to contaminate the Icynene Classic Max™ resin.
- After hand mixing the Icynene Classic Max™ 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 into the drum pump or dip tube.
 - Put the drum pump into the drum of Icynene Classic Max™ resin
 - If you have a re-circulation line, pump the contents to the previous drum or into a waste container. Connect to the Icynene Classic Max™ drum lid.
 - Remove the gun from the hose manifold and pump the hose contents into the previous drum until you see a color change to white or until you reach the air pocket in the line.
 - There will be some mixture of the two resins in the line which you can run into a container for disposal or spray out as foam.
 - Spray a test bun and watch for good foam with no collapse.
- Make sure recommended settings are followed before installing Icynene Classic Max™ as outlined above.



If you have any questions, please contact Icynene Technical Services before spraying Icynene Classic Max™.

Call 1.800.758.7325