

## Icynene MD-C-200™ Best Practices

In order to properly process Icynene MD-C-200™ and to maximize yield, please adhere to the following guidelines:

### Storage:

- Once received, MD-C-200™ drums should be stored at 60°F to 85°F.
- MD-C-200™ drums should be stored out of direct sunlight and out of cold temperatures.
- Do not store material on rigs other than what is required for current application needs, as materials left inside of rigs can easily exceed these recommended storage temperatures.
- MD-C-200™ B-side resin has a 6 month shelf life if stored as stated.
- Follow FIFO (First-In-First-Out) stock rotation.

### Mixing:

- **Note:** Icynene MD-C-200™ does not require any mixing prior to or during application.
- If changing to Icynene MD-C-200™ from another product follow the changeover procedure below.

### Heating:

- Drum temperatures for processing Icynene MD-C-200™ (B-side Resin and A-side Iso) need to be between 60°F and 85°F.
- **In cold weather the Icynene MD-C-200™ drums should be kept at the stated storage temperature range so that pre-heating is not necessary.**
- Drum band heaters or electrically heated drum blankets can be used to warm and maintain the drum temperatures between 60°F and 85°F.
- Do not exceed 85°F as the blowing agent will start to come out of the resin blend which may lead to frothing, poor quality foam, and a possible pressure build up in the drum.
- **Note:** Do not circulate the Icynene MD-C-200™ B-side resin to warm the drum.

### Processing Temperature and Pressure:

- In standard ambient conditions of 60°F to 85°F Icynene recommends the following for processing MD-C-200™:

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**Drum Temperatures: 60°F to 85°F**  
**A and B Primary Heaters: 122°F to 127°F**  
**Hose Heat: 122°F to 127°F**  
**Mix Chamber: AR5252 (02 round)**  
**Pressure: 1200 psi (dynamic)**  
**Spray Distance: 12" to 24"**

- Ideally the foam should stop rising in about 4 to 5 seconds.
- In colder weather, increase the A, B and Hose heats gradually to achieve this rise time.
- In hotter weather, decrease the A, B and Hose heats gradually to achieve this rise time.
- To maximize yield Icnene recommends using an AR5252 (02 round) at 1200 psi dynamic pressure. If it is necessary to use another sized chamber, use the following guidelines:

<u>Mix Chamber Size</u>	<u>Pressure (dynamic)</u>	<u>Distance</u>
00 (2929)	700-900 psi	12" - 18"
01 (4242)	900-1100 psi	12" - 24"
<b>02 (5252)</b>	<b>1000-1300 psi</b>	<b>12" - 24"</b>
03 (6060)	1200-1500 psi	18" - 24"

**Please be aware that altering recommended settings may cause poor foam quality and a substantial reduction in yield.**

## Environmental Issues:

- Icnene MD-C-200™ may be sprayed at ambient / substrate temperatures between 23°F to 122°F
- Use wind screens if spraying where the wind speed is over 10mph.
- Wet, saturated substrates will cause bubbling in the foam and loss of adhesion.
- Substrates must be clean, dry and free of contaminants such as grease, oil and solvents.

## Spray Technique:

- Maintain the proper distance as recommended above.
- Always spray with the spray gun at a 90 degree angle to the substrate.
- For wall cavities the best technique is to "picture frame" the studs and then to vertically fill in the middle in 24" to 36" sections while overlapping by 50 percent.

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- For flat concrete or metal substrates maintain a gun angle of 90 degrees and a spray distance of around 18" to 24" (depending on chamber size and psi) with an overlap of around 50 percent.
- Build thickness by spraying on to the expanding material (known as the "cream").
- Cold substrates may require "flashing" to assist in warming and insulating them.
- Spray a minimum of ½" per pass so as to not affect the foam's adhesion.
- **For thickness greater than 3" (76mm), more than one pass will be required. For multiple passes Icynene recommends waiting at least 30 minutes before applying the next pass. For additional passes you should double the waiting time, so between the 2<sup>nd</sup> and 3<sup>rd</sup> passes wait at least 60 minutes and for 2 hours between the 3<sup>rd</sup> and 4<sup>th</sup> passes, etc. This will allow the previous pass to completely cool in order to avoid scorching, residual odor, and fire due to excessive heat buildup within the foam.**

## Changeover:

- **If you are changing in to MD-C-200™ from another product you must not allow the other product to contaminate the MD-C-200™ resin drum.**
  - Make sure the drum pump and pump housing are completely free of the previous resin.
  - Allow some air in to the drum pump.
  - Put the drum pump in to the drum of MD-C-200™ resin.
  - If you have a re-circulation/pressure-relief line, pump the contents to the previous drum or into a waste container with the transfer pumps.
  - Connect the re-circulation/pressure relief line to the MD-C-200™ drum lid.
  - Remove the gun from the hose manifold and pump the hose contents in to the previous drum until you see a color change 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 in to a container for disposal or spray out as foam for disposal.
  - Spray a test bun and watch for good foam with no collapse.
- Make sure recommended settings are followed before installing MD-C-200™ as outlined above.

**If you have any questions regarding the installation of MD-C-200™ contact Icynene-Lapolla Technical Services for installation guidance.**

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