

Tech Solutions 109.0

Calibration Procedure for Froth-Pak™ Refillable System

Introduction

When setting up a Froth-Pak™ refillable system*, it is important to make sure the pressure settings are correct. Incorrect settings can cause “off ratio” foam, which can mean one of two scenarios:

- The foam is “iso rich,” which means there is too much “A” side (isocyanate) chemical in the mix. The foam will appear reddish-brown and will be brittle.
- The foam is “polyol rich,” which means there is too much “B” side (polyol) chemical in the mix. The foam will become mushy, and may not cure, remaining runny.

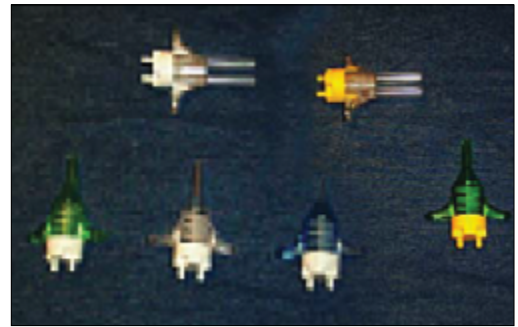
The proper ratio of “A” to “B” chemical is 1.05 to 1.15. To ensure this ratio between the two chemicals, the chemical output must be calibrated using a calibration nozzle.



Selecting a Calibration Nozzle

When selecting a calibration nozzle, the spray nozzle to be used must be known. The spray nozzles operate at different outputs, so the system must be calibrated for the output of the spray nozzle being used. Each spray nozzle has a different colored back cap (the side that snaps into the gun). Match the back cap color of the calibration nozzle to the cap color of the spray nozzle to be used.

Note: If there is a gross temperature change from when first calibrated, the system should be recalibrated.



Calibrating the Chemicals

To calibrate the chemicals, use two equal-weight containers (plastic cups or containers lined with plastic bags). Weigh each empty container to determine exact tare weight. Using the calibration nozzle, dispense product “A” in one and product “B” in the other simultaneously (approximately 6-8 seconds).

Weigh each container on a scale that provides weight in grams. Deduct the tare weights and divide the chemical weight of “A” by the chemical weight of “B.” The result is the nominal ratio. The nominal ratio should be approximately 1.05 to 1.15.

Example (Tared Weights):

“A” side = 188 g

“B” side = 170 g

$188/170 = 1.10$

This is a good mixture.

Example (Tared Weights):

“A” side = 206 g

“B” side = 164 g

$206/164 = 1.25$

This is not a good mixture. Adjust the nitrogen pressure higher on the “B” side.

Example (Tared Weights):

“A” side = 164 g

“B” side = 206 g

$164/206 = 0.79$

This is not a good mixture. Adjust the nitrogen pressure

Do not exceed 225 psi (1,551 kPa) nitrogen pressure in either “A” or “B” tank. Recommended pressure range: 120 psi (827 kPa) to 160 psi (1,103 kPa). Refer to Refill Systems Operation Manual for more details. higher on the “A” side.

* Froth-Pak™ Foam Insulation available in the United States only

** Froth-Pak™ Foam Sealant available in the United States and Canada**



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WARNING: Rigid foam insulation does not constitute a working walkable surface or qualify as a fall protection product.

Froth-Pak™ Polyurethane Spray Foam contains isocyanate, hydrofluorocarbon blowing agent and polyol. Read the instructions and Material Safety Data Sheets carefully before use. Wear protective clothing, gloves, goggles or safety glasses, and proper respiratory protection. Supplied air or an approved air-purifying respirator equipped with an organic vapor sorbent and a particle filter may be required to maintain exposure levels below ACGIH, OSHA, WEEL or other applicable limits. Provide adequate ventilation. Contents under pressure. Building and/or construction practices unrelated to building materials could greatly affect moisture and the potential for mold formation. No material supplier including DuPont can give assurance that mold will not develop in any specific system.

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