



CLASSIC™
BEST PRACTICES & GUIDE

In order to properly process Huntsman Building Solutions Classic and to maximize yield, please adhere to the following guidelines:

Storage:

- Once received, Huntsman Building Solutions Classic™ drums should be stored at 60°F to 85°F (15°C to 30°C).
- This will allow for quicker warm up of materials and will keep the B-side resin from degrading prematurely.
- 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.
- Classic™ B-side resin has a 6 month shelf life if stored as stated.
- Follow FIFO (First-In-First-Out) stock rotation.

Mixing:

- Huntsman Building Solutions Classic™ requires an initial mix of the Resin or "B" drum before each use. This initial mix can be accomplished with either a 3-blade or auger type pneumatic powered drum mixer attached to the drum lid and run on high-speed for 30 minutes.
- The Huntsman Building Solutions Classic™ resin requires constant agitation after this initial mix. This agitation can be accomplished with either a 3-blade or auger type pneumatic powered drum mixer attached to the drum lid and run at low-speed throughout the duration of the spray.
- If using a 3-blade drum mixer for constant agitation, turn mixer off when the resin in the drum reaches ¼ full in order to avoid inducing air into the resin which can lead to air pockets.
- If changing to Huntsman Building Solutions Classic™ from another product follow the changeover procedure below.

Heating:

- After mixing you can start spraying Huntsman Building Solutions Classic™ with drum temperatures as low as 60°F (15°C).
- For improved yield, it is recommended to warm the material in the drums. The ideal drum temperature for processing Huntsman Building Solutions Classic™ (B-side Resin and A-side Iso) is 80°F (27°C).
- If necessary in cooler weather and while mixing, the proportioner if equipped with circulation lines, can be used to warm up the drums to 80°F (27°C) by circulating through the machine back to the drums. The machine heaters should be set no higher than 110°F (43°C) 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 drum temperatures at 80°F (27°C). Non-heated drum blankets can be used with a circulation system to maintain drum temperatures at 80°F (27°C). In all cases be careful not to overheat the drums (over 90°F or 32°C).
- If you have a hose circulation block, it is also good practice to circulate the hose for about 10 minutes before spraying Classic™.

Processing Temperature and Pressure:

- In standard ambient conditions of 60°F to 85°F (15°C to 30°C) Huntsman Building Solutions recommends the following for processing Classic™:

Drum Temperatures: 80°F (27°C)
A and B Primary Heaters: 130°F to 135°F (54°C to 57°C)
Hose Heat: 130°F to 135°F (54°C to 57°C)
Mix Chamber: AR5252 (02 round)
Pressure: 1,200 psi (dynamic)
Spray Distance: 12" to 14"

- Ideally the foam should stop rising in about 5 to 6 seconds.
- In cold weather (below 60°F or 15°C) increase the A, B and Hose heats in 3 degree increments (up to 150°F or 66°C) to achieve this rise time.
- In hot weather (above 85°F or 30°C) decrease the A, B and Hose heats in 3 degree increments (down to 120°F or 48°C) 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:

MIX CHAMBER SIZE	PRESSURE (PSI)	DISTANCE
00 (2929)	700-900 psi	10" - 12" (25cm - 30cm)
01 (4242)	900-1100 psi	12" - 14" (30cm - 36cm)
02 (5252)	1100-1300 psi	12" - 14" (30cm - 36cm)
03 (6060)	1300-1500 psi	15" - 18" (38cm - 46cm)

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

Spray Technique:

- Always spray with the spray 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 2ft (60cm) wide. If necessary, create "foam studs" 2ft (60cm) 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.
- When applying the material in more than one pass, 15 minutes is recommended between passes.

Changeover:

- If you are changing in to Classic™ from another product you must not allow the other product to contaminate the Classic™ resin drum
- After hand mixing the Classic™ resin as outlined above do the following:
 - 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 Classic™ 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 Classic™ 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.
 - Keep the hose heat on at 125°F (50°C) during changeover.
 - 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 Classic™ as outlined above.

Before spraying Huntsman Building Solutions Classic for the first time you should contact Huntsman Building Solutions Technical Services for installation guidance.