

PC 2000 HFO CLOSED CELL Spray Foam Insulation APPLICATION GUIDELINE



Product Design

PolyCon 2000 HFO is a Class A rated, medium-density closed-cell spray polyurethane foam designed to deliver high yield and exceptional thermal performance. Engineered for consistent results across a broad range of temperatures, PC 2000 HFO provides outstanding installation flexibility and long-term durability. It forms a continuous air and vapor barrier that strengthens and protects the building envelope.

Product Use

PolyCon PC 2000 HFO adheres tenaciously to most common building substrates, including wood, metal, and masonry. When applied at a minimum thickness of 1.2 inches, it forms a durable air and vapor barrier, helping to reinforce and protect the building envelope in residential, commercial, and industrial applications.

Recommended Processing Guidelines

Ambient / Substrate Temp	PC 2000 HFO - S	PC 2000 HFO - R	PC 2000 HFO - W
	+80°F / +26°C	40 - 85°F / (4 - 29°C)	20 - 50°F / (-7 - 10°C)
Equipment Dynamic Pressure			1,000 - 1,500 psi
Preheat Temperature			110-135°F / 43 - 57°C
Drum and Storage Temperature			65 - 85°F / 18 - 29°C

Processing Application Method

Mix chamber	Minimum of 01
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Material Shelf Life

Six (6) months when stored properly

Storage Requirements

Store ISO and resin material in a covered warehouse out of direct sun exposure. Ambient temperature should not fluctuate outside of 50 – 90°F.

Recommended Product Applications

- Exterior Walls
- Attic Floors
- Crawl Spaces
- Basement Walls
- Band Joists
- HVAC Ducts
- Under roof deck
- Cathedral Ceilings
- Vaulted ceilings
- Hybrid Flash & Batt Application
- Tanks
- Coolers
- Piping
- Wine Storage
- Behind brick veneer

Application Characteristics

When properly processed on-ratio, PC 2000 HFO yields a uniform cell structure and consistent color throughout the installed foam. To ensure optimal performance and adhesion:

Maximum Pass Thickness	Additional Pass Wait Time
3.5"	Until surface temp reaches 100° or ambient temp

Substrate Requirements & Preparation

- Surface moisture content must be 18% or less.
- If adhesion issues are observed, increase wait time and confirm dew point and humidity conditions
- Surface Preparation: Remove dust, oils, release agents, wax, rust, or other contaminants by mechanical abrasion or approved chemical cleaners
 - **Concrete** - Cure ≥ 28 days, verify $\leq 18\%$ moisture with meter, allow to dry before spraying
 - **Galvanized Metal** - Rinse, dry, and prime (epoxy/polyurethane) if long-term adhesion or delayed application
 - **Stainless Steel** - Lightly abrade with non-ferrous abrasive pad, wipe clean, and spray promptly to prevent re-contamination
 - **Waxy or Contaminated Surfaces** - Test adhesion in a small area first; abrade and solvent clean if needed

Spray Technique & Tips

- For improved results on vertical surfaces, spray from the bottom up, allowing rising warm air to help condition the substrate.
- Avoid applying foam into rising lifts or thick accumulations, as this may result in:
 - Excessive exothermic reaction
 - Surface discoloration or odor retention
 - Potential fire hazards

By following these guidelines, applicators can ensure consistent foam quality, strong substrate adhesion, and safe application across a variety of environmental conditions.

Temperature Adjustments

Temperature Adjustments

If foam begins to run or drip during application:

- Gradually increase hose and preheat temperatures in 3°F increments
- Allow time for the adjusted material to reach the spray gun before making further changes

Maintain hose and preheat temperatures below 145°F for both the ISO and resin components

When spraying in cold temperatures (below 40°F/4°C), warm substrates using indirect heat before application. Start with a flash coat (~1/2 inch) to promote adhesion, especially on metal surfaces. Wait at least 15–20 minutes between lifts to allow adequate curing and temperature stabilization. Store drums in a temperature-controlled environment between 65–85°F and use drum heaters or hot boxes as needed.

Troubleshooting Shrinkage or Poor Pass Adhesion

If shrinkage, delamination, or poor adhesion is observed during application of PC 2000 HFO, evaluate the following common causes:

1. Off-Ratio Material Mix:

- Check A-side and B-side pressures at the proportioner
- A pressure variance greater than ± 250 psi may indicate:
 - Material restriction
 - Clogged screens
 - Improper proportioner settings
- Off-ratio foam can result in weak adhesion, soft spots, or poor cell structure

2. Excessive Substrate Moisture

- Surface must be $\leq 18\%$ (check with moisture meter)
- High moisture may result from:
 - Ambient temperature fluctuations
 - Dew point condensation on surfaces, especially in cool or humid conditions

3. Material Overheating

- High material temperatures can alter the reaction profile, leading to
 - Brittle or overly soft foam
 - Discoloration
 - Surface irregularities

Solution: Reduce hose or preheat temperature in 3°F increments and observe results

- Allow time for changes to propagate through the system before further adjustments



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Startup Procedure

Before charging equipment with new material, ensure that both A-side and B-side drums are within the recommended processing temperature range of 65–85°F. A target temperature of 70°F for both components is ideal for optimal performance. PC 2000 HFO should not be recirculated to elevate drum temperatures, as this may compromise material integrity.

To warm materials safely, use drum blankets, hot plates, or other approved heating methods that gradually raise the temperature of the material. Avoid exposing drums to direct flame or uncontrolled heat sources.

Flushing Procedure

Before introducing PC 2000 HFO into any proportioning or spray equipment, it is critical to thoroughly purge all lines and components of any previously used materials to prevent cross-contamination, which can negatively impact product performance and equipment function.

1. Shut Down Transfer Pumps:

- Turn off and disconnect air supply to all transfer pumps

2. Remove and Clean Drum Pumps:

- Remove the drum pumps from the ISO and Resin drums
- Wipe all pumps and dip tubes clean.
- Ensure the resin pump housing is completely empty

3. Reconnect and Purge:

- Insert the cleaned drum pumps and dip tubes into the new PolyCon ISO and PC 2000 HFO Resin drums.
- Reconnect air and activate the drum pumps
- Unless the material in the lines is bad, it can be sprayed on target. Prior to the PC 2000 and PC ISO reaching the spray gun begin spraying off target to prevent any contaminated or mixed foam to be applied onto the intended target
- Note: The purging process typically produces 1 to 2 gallons of waste material, depending on the length and size of the hose

4. Flush the Resin (B-Side) Line:

- Prior to switching to a different product, flush the Resin side with 3–4 gallons of water or compressed air only
- Do not use water or air on the ISO side, as this can result in hazardous reactions or equipment damage

This flushing procedure should be followed precisely each time the system is transitioned between materials or restarted after extended downtime.

Shutdown Procedure

For any shutdown period exceeding four (4) hours, follow these steps to ensure system integrity and material preservation:

1. Follow Manufacturer Recommendations

- Adhere to the equipment manufacturer's specific shutdown procedures for the proportioner, hose, and spray gun

2. Seal Material Drums

- Ensure that all A-side (ISO) and B-side (resin) drums are tightly sealed to prevent moisture contamination, pressure loss, or blowing agent degradation

3. Protect from Temperature Extremes

- Store drums in a climate-controlled environment between 65–85°F (18–29°C) and away from direct sunlight or sources of heat/cold

4. Secure Hoses and Gun

- Depressurize the system. Ensure all lines are properly capped or positioned to avoid air or moisture ingress

Tip: For extended shutdowns of 4 weeks or more, consider recirculating or flushing per manufacturer protocol to prevent ISO Side crystallization inside hoses or equipment.



Handling and Safety

Respiratory protection is mandatory during all spray foam application activities. Applicators must take all necessary precautions to avoid occupational exposure and ensure the safety of all personnel on or near the jobsite.

Personal Protective Equipment (PPE) Requirements:

- Supplied-air respiratory protection with a NIOSH-approved full-face mask
- Chemical safety goggles
- Protective, non-absorbent gloves
- Fully enclosed Tyvek® suit, secured at wrists & ankles

Ventilation Requirements:

- Maintain positive-pressure mechanical ventilation to limit vapor buildup
- Even with adequate ventilation, interior spaces should be treated as confined spaces and approached with caution

Exposure Limits & Health Hazards:

- Atomized vapors must not exceed the Threshold Limit Value (TLV) of 0.02 ppm for isocyanates
- Individuals with sensitivities/allergies must not be exposed
- In the event of inhalation, move the individual to fresh air immediately. If breathing difficulty occurs, administer oxygen and seek medical attention
- Avoid contact with skin, eyes, and clothing. Wash thoroughly with soap & water following any exposure

Safe Handling Practices:

- Open containers slowly to release pressure
- Wash used clothing before reuse
- Applicators must post high-visibility warning signs to restrict access during application/curing

Additional Resources

For detailed safety guidelines and jobsite hazard prevention, refer to:
Center for the Polyurethanes Industry (CPI): www.polyurethane.org
Spray Polyurethane Foam Alliance (SPFA): www.sprayfoam.org
Phone: (571) 748-5003

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Hot Work Precautions:

- No welding, soldering, or torch cutting within 45 ft of exposed or freshly installed spray foam
- If hot work must be performed, foam must be:
 - Fully cured
 - Covered with an approved fire blanket or welders shield
 - Monitored by a designated fire watch

Risks of Improper Application

Improper application of PC 2000 HFO spray foam can result in serious safety hazards and reduced product performance.

Potential issues include:

- Excessive heat buildup, which may lead to combustion or fire
- Offensive or lingering odors due to incomplete reaction or overheating
- Poor insulation performance from:
 - Off-ratio mixing
 - Improper lift thickness
 - Spraying into rising or uncured foam
 - Uneven cell structure or density defects

High-Mass Application Warning:

- Avoid creating large, monolithic foam masses
- If large accumulations occur: Remove from site, cut into smaller sections, wet with water, and cool completely before disposal

(Failure to follow these precautions may result in smoldering or fire)

Fire preparedness:

- A Class ABC fire extinguisher should be readily accessible in the work area at all times during application and for a cooling period afterward

Note: PC 2000 HFO is approved only with PC ISO. Use with other ISO will void warranty.



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