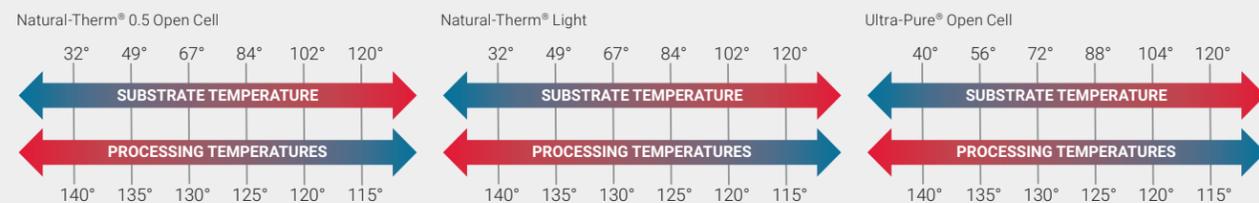


OPEN CELL

PROCESSING GUIDANCE

	NATURAL-THERM® 0.5, NATURAL-THERM® LIGHT	ULTRA-PURE® OPEN CELL
Ambient Temperature	50°F–100°F	50°F - 100°F
MACHINE SETTING TEMPERATURE		
A Component Pre-Heaters ¹	115°F–140°F	115°F–140°F
B Component Pre-Heaters	115°F–140°F	115°F–140°F
Hoses	115°F–140°F	115°F–140°F
Spray Pressure (Dynamic) ²	1,000–1,400 psi	1,000–1,400 psi
PROCESSING CHARACTERISTICS		
Cream Time	1–2 (Seconds)	1–2 (Seconds)
Tack-Free Time	5–6 (Seconds)	5–6 (Seconds)
Initial Cure Time	<1 Hour ³	<1 Hour ³

¹ The following chart provides guidance for initial proportioner and drum temperatures based on ambient conditions.



² Follow equipment manufacturer's recommendations for maximum hose lengths and additional heating. Extended hose lengths and/or elevation above proportioner can reduce pressure at spray gun.
³ Complete cure will depend on temperature, humidity, and degree of ventilation. Complete cure usually occurs within 24–72 hours.

STORAGE

Store containers between 50°F and 90°F in covered areas with no direct sunlight. It is important not to allow the materials to freeze. Containers should be opened carefully to allow any pressure buildup to be vented safely while wearing full safety protection. Excessive low or high temperatures may decrease shelf life.

Shelf Life: 6 months when stored in the original unopened container 50°F–90°F.

ENVIRONMENTAL CONDITIONS

Recommended substrate temperatures:

Natural-Therm® 0.5:	Minimum 32°F, Maximum 120°F
Natural-Therm® Light:	Minimum 32°F, Maximum 120°F
Ultra-Pure® Open Cell:	Minimum 40°F, Maximum 120°F

Note: For dense materials like concrete, steel, etc., add 10°F to minimum temperatures.

Moisture

Moisture in the form of rain, dew, and frost can seriously affect the quality and adhesion of the open cell SPF products to the substrate or itself. Natural Polymers does not recommend the spraying of this system when the relative humidity (RH) exceeds 85% or when temperatures are less than 5°F above dew point. When heating the interior of a building, the relative humidity can change dramatically and should be constantly monitored to ensure proper application.

For outdoor or open structure application – Wind speeds should be less than 10 mph unless wind screens are used.

Scan here for the
complete Open
Cell Product
Application Guide

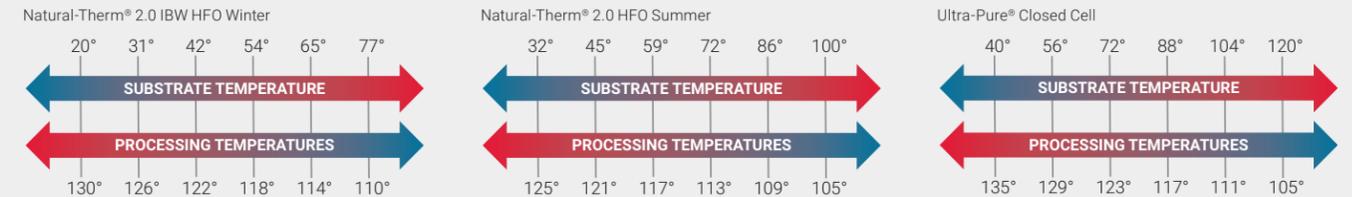


CLOSED CELL

PROCESSING GUIDANCE

	NATURAL-THERM® 2.0 HFO WINTER	NATURAL-THERM® 2.0 HFO SUMMER	ULTRA-PURE® CLOSED CELL
Ambient Temperature	32°F–80°F	50°F–100°F	50°F–100°F
MACHINE SETTING TEMPERATURE			
A Component Pre-heaters ¹	110°F–130°F	105°F–125°F	105°F–135°F
B Component Pre-heaters	110°F–130°F	105°F–125°F	105°F–135°F
Hoses	110°F–130°F	105°F–125°F	105°F–135°F
Spray Pressure (Dynamic) ²	1,100–1,500 psi	1,100–1,500 psi	1,100–1,500 psi
PROCESSING CHARACTERISTICS			
Cream Time	0.5–2 (Seconds)	1–2 (Seconds)	0.5–2 (Seconds)
Tack-Free Time	4–5 (Seconds)	6–7 (Seconds)	5–6 (Seconds)
Initial Cure Time	<1 Hour ³	<1 Hour ³	<1 Hour ³

¹ The following chart provides guidance for initial proportioner and drum temperatures based on ambient conditions.



² Follow equipment manufacturer's recommendations for maximum hose lengths and additional heating. Extended hose lengths and/or elevation above proportioner can reduce pressure at spray gun.
³ Complete cure will depend on temperature, humidity, and degree of ventilation. Complete cure usually occurs within 24–72 hours.

STORAGE

Store containers between 50°F and 80°F in covered areas with no direct sunlight. It is important not to allow the materials to freeze. Containers should be opened carefully to allow any pressure buildup to be vented safely while wearing full safety protection. Excessive venting of the B Component may result in higher density foam and reduced yield. Excessive low or high temperatures may decrease shelf life.

Shelf Life: 6 months when stored in the original unopened container at 50°F–80°F.

ENVIRONMENTAL CONDITIONS

Recommended substrate temperatures:

Ultra-Pure® Closed Cell	Minimum 40°F, Maximum 120°F
Natural-Therm® 2.0 HFO Summer	Minimum 32°F, Maximum 100°F
Natural-Therm® 2.0 HFO Winter	Minimum 20°F, Maximum 77°F

Note: For dense materials like concrete, steel, etc., add 10°F to minimum temperatures.

Moisture

Moisture in the form of rain, dew, and frost can seriously affect the quality and adhesion of the closed cell SPF products to the substrate or itself. Natural Polymers does not recommend the spraying of this system when the relative humidity (RH) exceeds 85% or when temperatures are less than 5°F above dew point. When heating the interior of a building, the relative humidity can change dramatically and should be constantly monitored to ensure proper application.

For outdoor or open structure application – Wind speeds should be less than 10 mph unless wind screens are used.

Scan here for the
complete Closed
Cell Product
Application Guide

