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SPECIAL PRE-MIXING AND RECIRCULATION INSTRUCTIONS FOR NCFI R-12-002

To maximize yield and achieve optimum physical properties, NCFI R-12-002(Resin) drum should be thoroughly agitated prior to use for at least 20 minutes and during spraying or re-circulating the material. Continuous mixing is mandatory to insure desired spray results and yield.

Agitating the material is best accomplished with an electrically driven mixer. Mixers should be designed to completely agitate 55 gallons of material. Mixer should have a minimum 33" long shaft with $\frac{3}{4}$ HP motor and turns at 1725 RPM with blades designed to create at least a 6" vortex on the top of the resin. Wetted parts should be stainless steel to withstand the corrosive nature of the water blown material. Mixers should be installed into the specially marked center bung opening of the drum for maximum efficiency.

Please note that merely re-circulating the material through the proportioner and back into the drum is not a suitable substitute for mechanically agitating the Resin component in the drum.

If spray equipment has been idle for a week or more, there may be a slight separation of the resin in the proportioner and hoses. Pre-mix the drum as directed above and then re-circulate the material back into the drum with preheater and hose heat either turned off or set no higher than 80°F. Repeat the mixing procedure as before to restore overall homogeneity.

Failure to completely pre-mix material can result in less desirable cell structure and decreased yield and adhesion.

Contact NCFI POLYURETHANES Technical Support at 800-346-8229, option 4, for any questions on this bulletin or for sourcing a mixer.