QUIK-SHIELD 106 - Troubleshooting Guide

Appearance Issues	Probable Causes	Recommended Solutions
Foam is noticeably darker and somewhat brittle	Blockage on Resin side of the gun, not enough material from Resin side	1. Check and clean in-line filters at proportioner and gun (over 20% plugged, replace). 2. Check for empty drum. 3. Check for blocked side seal. 4. Check ball valves on transfer pump, then ball valves and seals on proportioner unit.
Air Pockets	Cold material in resin drum, inadequate spray heat, spraying too close or too far from substrate, not spraying at right angle, improper spray pressure	1. Increase heat (primary and hose heaters). 2. Re-circulate until material in the drums reaches a minimum of 70°F, but 80°F is optimal (re-circ temp not to exceed 125°F). 3. Ensure proper distance as determined by pressure and mix chamber size. 4. Spray at 90° angle to substrate to ensure best possible results.

Other Issues	Probable Causes	Recommended Solutions
Overspray—foam adheres to surfaces outside of spray area	High wind, area not sealed off, spraying too far from substrate, pressures set too high for application	1. Protect areas not to be foamed with poly and be aware of surroundings and wind conditions. 2. Ensure proper distance as determined by pressure and mix chamber size.
Poor Yield (less than 18,000 board ft.)	Cold material in resin drum, inadequate spray heat, too much overspray, too much scarfing (over-fill of cavity), cold substrate, too many passes, storage-degraded material, resin rich/Iso rich foam, resin not thoroughly mixed	1. Increase heat (primary and hose heaters). 2. Re-circulate until material in the drums reaches a minimum of 70°F, but 80°F is optimal (re-circ temp not to exceed 125°F). 3. Pre-warm substrate if possible. If not, flashing technique can be used—spraying a thin layer of foam on the substrate to heat it up. 4. Check and clean in-line filters at proportioner and gun (over 20% plugged, replace). 5. Check for empty drum. 6. Check for blocked side seal. 7. Check ball valves on transfer pump, then ball valves and seals on proportioner unit. 8. Maintain sufficient speed of application for pressure and mix chamber size. 9. Thoroughly mix resin using SWD recommended mixer
Pressure Imbalance: Guage pressure differential greater than 400 psi or E24 on Graco Reactor	Cold material, blockage at the gun, lack of material from Resin or Iso side (ball valves, pump seals or proportioner packings leaking)	1. Increase heat (primary and hose heaters). 2. Re-circulate material until drum temperature reaches 80°F - not to exceed 100°F (use in-line temperature gauges). 3. Check and clean in-line filters at proportioner and gun (over 20% plugged, replace). 4. Check for empty drum. 5. Check for blocked side seal. 6. Check ball valves on transfer pump, then ball valves and seals on proportioner unit.