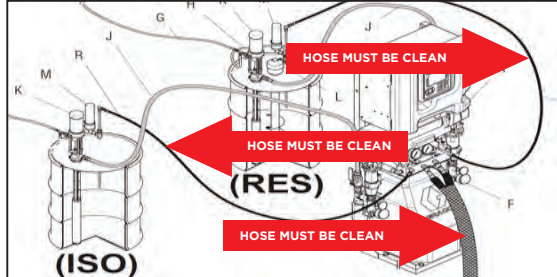
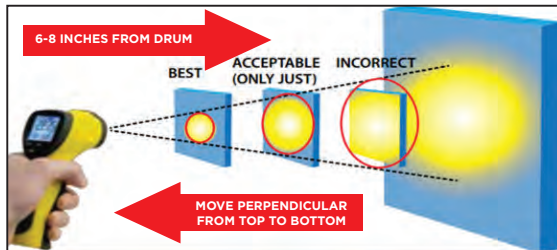


# OPEN CELL PROCESSING

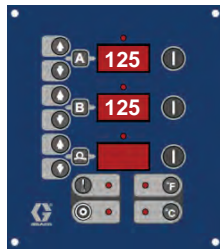
- 1 PPE (eye protection, skin protection, respirator)
- 2 Did you flush? All lines including relief lines must be clear of previous material.  
Do not recirculate previous material into new drum.



- 3 Drum Temperature: What is starting drum temperature?  
(See processing guide per product being used)  
Note: Actual temperature is 5 to 7 degrees hotter in drum than actual reading.



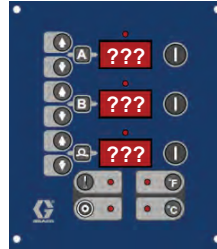
- 4 Note Lot Numbers: Reference both A and B.
- 5 If using supplementary drum heat (blankets) set temperatures to maintain warmth in drums.
- 6 Install Mixer: Begin mixing according to product processing guide. Continue mixing during entire spray process.
- 7 Set preheater temperatures A and B to 125°F.



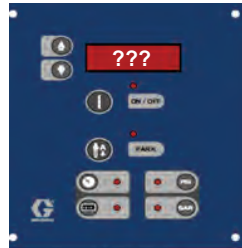
- 8 Turn heaters on and begin to recirculate (if JOG capabilities JOG J 5-7).
- 9 Monitor drum temperatures by using thermal gun or inlet temperature gauges.

Once desired drum temperature A and B reached.

- 10 Reduce JOG to 0.
- 11 Set preheaters A, B, & H to desired processing parameters according to processing guide.



- 12 Set pressure to desired pressure according to processing guide.



- 13 Pressurize machine and balance pressures.



- 14 Spray test on plastic or disposable substrate.
- 15 Check cell structure and rise.
- 16 DO NOT SPRAY ON RISING FOAM.

EVEN, SMOOTH CELL STRUCTURE	GOOD, EVEN RISE	CELL STRUCTURE TOO OPEN, ISO RICH, LACKING RESIN

CONTACT THE DEMILEC TECHNICAL SERVICE DEPARTMENT FOR QUESTIONS OR ASSISTANCE.

