



## SPF Material Change-Over Procedure

Rev 1

Purpose:

**Material Change-Over Procedure**, OC to CC or CC to OC, this two part procedure will provide the SPF applicator a method to reduce product waste, thru flushing the system with air, while minimizing possible cross contamination of materials.

Steps (may require two people for this procedure)

### Flushing the system with air

1. PPE – Latex gloves, coveralls , Safety glasses and or goggles and an air purifying respirator (APR) or supplied air respirator (SAR) are recommended
2. Turn off proportioner pumps
3. Turn off heat to primary heaters and the heated hose system
4. Set (B) side air supply regulator to ~ 50 psi
5. Disconnect air supply to (B) side transfer stick pump
6. Slowly relieve any (B) side hose pressure to the (B) container:
  - a. From the (B) side re-circulation line, or if one is not available, use the gun fluid manifold
  - b. Keep the (B) container vented & the inlet ball valve open
7. Remove the transfer stick pump from (B) container
  - a. Wipe off stick pump, with a clean towel /rag, as its removed from the drum
  - b. Pour out any residual material from the top of the transfer pump into a pail
8. Place suction end of transfer pump in a clean 1 or 5 gal pail
9. While securing the transfer pump with your hands, connect air hose to transfer pump, and if attached, adjust the needle air valve to a comfortable pump rate
10. Thru the recirculation line, pump to the (B) side container until air bubbles/frothy foam is seen exiting the recirculation hose, or air is felt moving through the hose to the container
  - a. Note: No dip tube in (B) side drum should be used with this procedure
11. Stop, (B) side transfer pump and close the recirculation pressure relief valve
12. Remove gun from gun fluid manifold and place the (B) side of gun fluid manifold over the large opening of the (B) container and repeat step 9
13. Continue pumping until air bubbles/frothy foam is seen exiting the gun fluid manifold
14. Close (B) side gun fluid manifold
15. Stop the (B) side transfer pump
16. Wipe off the transfer pump and place in the new (B) side product CC or OC

**Flushing the system with new material**

17. Vent the new (B) container and connect the air supply to (B) side transfer pump
  - a. Increasing the air supply regulator to transfer pumps to 100 psi may become necessary to actuate the transfer pump
18. With gun removed from gun fluid manifold
19. Slowly open and discharge from the (B) side gun fluid manifold into a waste bucket or waste drum, continue to pump material until no more air is observed exiting the gun fluid manifold.
  - a. For good measure an additional pint or quart should be removed into the waste bucket /drum after a solid stream flow is seen
  - b. Expect ~ 0.3 gal for each 50 ft. section for a 3/8" hose
  - c. Close gun fluid manifold
20. Place (B) side recirculation hose end into a 5 gal waste pail /drum
21. Slowly open the (B) side pressure relief valve and flush into the 5 gal waste pail/drum until a solid stream of liquid is observed.
22. Close (B) side pressure relief valve and connect recirculation hose to new material drum (small bung)
23. Wipe off any material on the connection side of the gun block, and gun fluid manifold.
24. Reconnect the gun and air supply
25. Confirm air supply regulator is at ~ 100 psi
26. Turn hose heat on, when up to temp, turn primary heaters on
27. When primary heaters are up to temp, it may be necessary to balance (A) & (B) pressure gages thru the pressure relief valves
28. Turn proportioner pump on
29. Verify (B) drum is vented
30. Off target, spray out enough foam to verify there is no contamination
31. End.