

2-COMPONENT FOAM SET

On base of BAYTHERM VP.PU.27.HK04R system.

Required conditions:

- Storage temperature 12-25°C
- Surrounding temperature during usage 10-25°C
- Material temperature during usage 18-25°C

ATTENTION: In case of storing the foam in temperature lower than given above, crystallization of the isocyanate can occur and make the foam unfit to use. The foam will again become fit to use after putting it in room of temperature of 30°C for three days.

Winter foams should be stored in same temperature as standard foams (summer foams), but can be used only in surrounding temperature from -17°C to +15°C.

Usage instruction:

- Prepare the joint for foaming.
- Unpack proper foaming set.
- Twist off both bottle caps.
- Pour bottle A to bottle B.
- Shake continuously for 20-30 seconds.
- Pour the foam to the inside of the joint fast.
- After about 2 minutes, check if the foam reached the air releasing plugs.
- Leave air releasing holes open for at least 30 minutes.

FOAM DOSAGE: same as 2-component tank.
(according to tables on pages 04-03 ÷ 04-06)

ATTENTION: It is necessary to check if the number of 2-component foam is adequate to the size of insulated joint before start of the foaming.

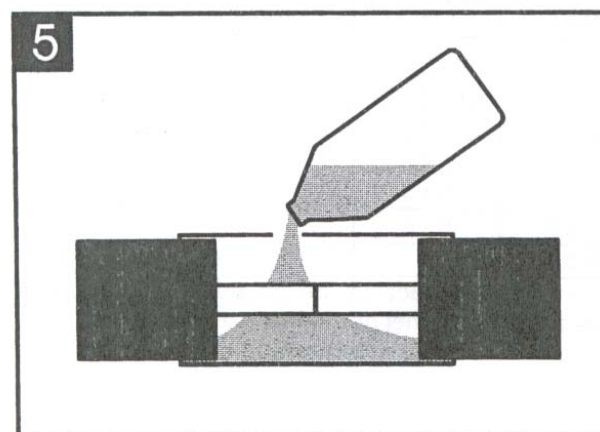
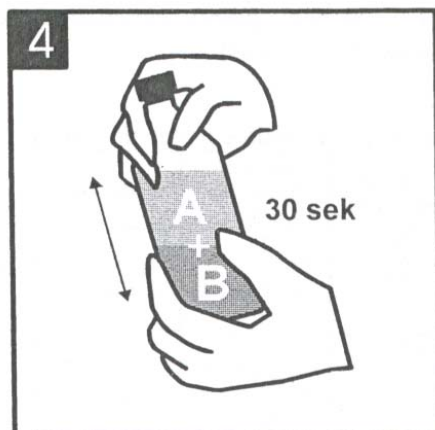
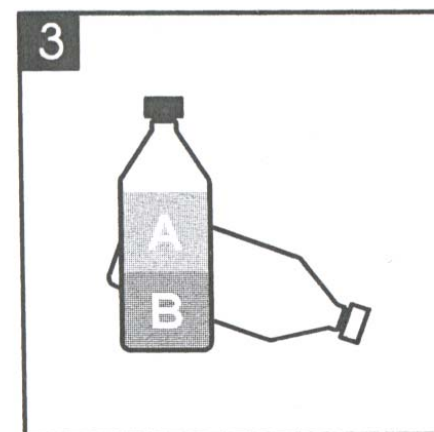
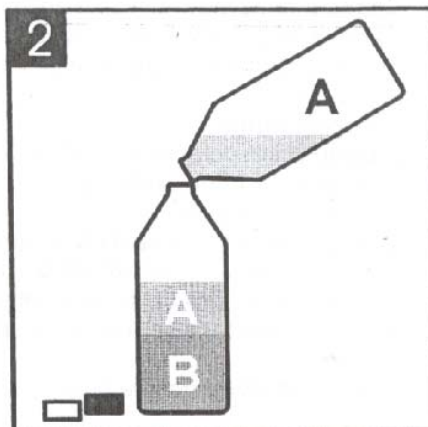
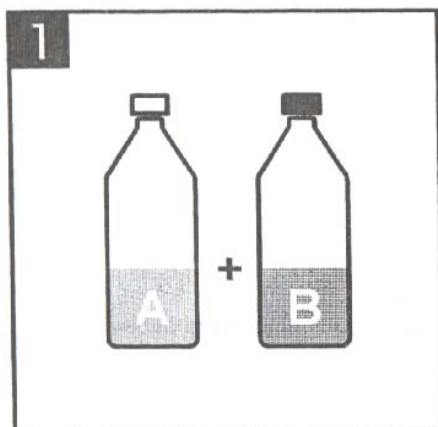
2-COMPONENT FOAM SET

2- Component Number	[dm ³]			[kg]		
	A+B	A	B	A+B	A	B
1	0,24	0,10	0,14	0,28	0,11	0,17
2	0,32	0,14	0,18	0,37	0,15	0,22
3	0,44	0,19	0,25	0,51	0,21	0,31
4	0,56	0,24	0,32	0,66	0,27	0,39
5	0,70	0,30	0,40	0,82	0,33	0,49
6	0,90	0,39	0,51	1,05	0,43	0,63
7	1,10	0,48	0,62	1,29	0,52	0,77

Component A - (polyol) contains polyol mixture. Non-hazardous substance.

Component B - (isocyanate) contains diphenylmethane- diisocyanate with isomers and homologues. Hazardous substance. It effects air passages, eyes and skin badly. It may cause allergy in the event of inhalation or contact with skin. Avoid any breathing of injected particles and vapour. Use appropriate clothing and gloves. In case of insufficient ventilation, use proper breathing equipment. In case of accident or bad disposition, seek medical treatment. Follow the rules in producers instruction.

USER INSTRUCTION FOR 2-COMPONENT FOAM SET on the base of BAYTHERM VP.PU.27.HK04R system.



FOAM LIQUID DOSAGE
STRAIGHT JOINTS

STANDARD INSULATION			PLUS INSULATION			PLUS-PLUS INSULATION		
Designation	A+B ₃ dm ³	2-Comp. No.	Designation	A+B ₃ dm ³	2-Comp. No.	Designation	A+B ₃ dm ³	2-Comp. No.
27 - 90	0,18	1	27 - 110	0,28	2	27 - 125	0,35	3
34 - 90	0,17	1	34 - 110	0,27	2	34 - 125	0,34	3
42 - 110	0,26	2	42 - 125	0,33	3	42 - 140	0,44	4
48 - 110	0,25	2	48 - 125	0,32	3	48 - 140	0,42	3
60 - 125	0,29	2	60 - 140	0,39	3	60 - 160	0,53	4
76 - 140	0,34	3	76 - 160	0,48	4	76 - 180	0,63	5
89 - 160	0,44	4	89 - 180	0,59	5	89 - 200	0,77	6
114 - 200	0,66	5	114 - 225	0,91	7	114 - 250	1,20	4+5
139 - 225	0,78	6	139 - 250	1,07	7	139 - 280	1,43	4+6
168 - 250	0,88	6	168 - 280	1,23	5+5	168 - 315	1,72	5+7
219 - 315	1,29	5+5	219 - 355	1,90	6+7	219 - 400	2,68	+
273 - 400	2,07	7+7	273 - 450	3,08	+	273 - 500	3,64	+
323 - 450	2,42	+	323 - 500	3,51	+	323 - 560	4,97	+
355 - 500	3,05	+	355 - 560	4,51	+	355 - 630	6,35	+
406 - 560	3,67	+	406 - 630	5,52	+	406 - 710	7,88	+
508 - 710	5,90	+	508 - 800	8,88	+	508 - 900	12,62	+
609 - 800	6,44	+	609 - 900	10,17	+	609 - 1000	14,34	+

Where no 2-comp. is mentioned, machine foaming is used.

E-COMPENSATOR JOINTS

STANDARD INSULATION			PLUS INSULATION			PLUS-PLUS INSULATION		
Designation	A+B dm ³	2-Comp. No.	Designation	A+B dm ³	2-Comp. No.	Designation	A+B dm ³	2-Comp. No.
34 - 90	0,19	1	34 - 110	0,32	2	34 - 125	0,43	3
42 - 110	0,28	2	42 - 125	0,39	3	42 - 140	0,52	4
48 - 110	0,26	2	48 - 125	0,38	3	48 - 140	0,50	4
60 - 125	0,32	3	60 - 140	0,48	3	60 - 160	0,65	5
76 - 140	0,38	3	76 - 160	0,59	4	76 - 180	0,82	6
89 - 160	0,49	4	89 - 180	0,73	5	89 - 200	0,99	7
114 - 200	0,84	6	114 - 225	1,24	6	114 - 250	1,67	6+6
139 - 225	0,94	7	139 - 250	1,38	7	139 - 280	2,01	7+7
168 - 250	1,08	4+4	168 - 280	1,77	5+5	168 - 315	2,67	+
219 - 315	1,53	5+6	219 - 355	2,68	+	219 - 400	4,15	+
273 - 400	2,77	+	273 - 450	4,60	+	273 - 500	6,64	+
323 - 450	3,87	+	323 - 500	6,28	+	323 - 560	9,51	+
355 - 500	4,55	+	355 - 560	7,73	+	355 - 630	12,08	+
406 - 560	5,60	+	406 - 630	9,96	+	406 - 710	15,56	+
508 - 710	10,15	+	508 - 800	17,07	+			
609 - 800	11,90	+						

Where no 2-comp. is mentioned, machine foaming is used.

FOAM LIQUID DOSAGE

REDUCTION JOINTS

Steel pipe mm	STANDARD			PLUS			PLUS-PLUS		
	Casing mm	A+B dm ³	2-Comp. No.	Casing mm	A+B dm ³	2-Comp. No.	Casing mm	A+B dm ³	2-Comp. No.
42,4 26,9	110 90	0,26	2	125 110	0,36	3	140 125	0,41	3
42,4 33,7	110 90	0,25	2	125 110	0,35	3	140 125	0,41	3
48,3 26,9	110 90	0,26	2	125 110	0,36	3	140 125	0,42	3
48,3 33,7	110 90	0,26	2	125 110	0,36	3	140 125	0,42	3
60,3 26,9	125 90	0,29	2	140 110	0,42	3	160 125	0,50	4
60,3 33,7	125 90	0,29	2	140 110	0,41	3	160 125	0,49	4
60,3 42,4	125 110	0,34	3	140 125	0,44	4	160 150	0,53	4
60,3 48,3	125 110	0,33	3	140 125	0,44	4	160 140	0,52	4
76,1 42,4	140 110	0,38	3	160 125	0,52	4	180 140	0,61	5
76,1 48,3	140 110	0,38	3	160 125	0,51	4	180 140	0,61	5
76,1 60,3	140 125	0,41	3	160 140	0,51	5	180 160	0,61	5
88,9 60,3	160 125	0,46	4	180 140	0,63	5	200 160	0,74	6
88,9 76,1	160 140	0,50	4	180 160	0,68	5	200 180	0,80	6
114,3 76,1	200 140	0,66	5	225 160	0,91	5	250 180	1,14	3+5
114,3 88,9	200 160	0,72	6	225 180	0,99	7	250 200	1,18	4+5
139,7 88,9	225 160	0,84	6	250 180	1,15	4+5	280 200	1,41	4+6

Where no 2-comp. is mentioned, machine foaming is used.

Steel pipe mm	STANDARD			PLUS			PLUS-PLUS		
	Casing mm	A+B dm ³	2-Comp. No.	Casing mm	A+B dm ³	2-Comp. No.	Casing mm	A+B dm ³	2-Comp. No.
139,7 114,3	225 200	1,00	7	250 225	1,38	5+6	280 250	1,63	6+6
168,3 114,3	250 200	1,10	3+5	280 225	1,54	5+6	315 250	1,89	6+7
168,3 139,7	250 225	1,19	4+5	280 250	1,66	6+6	315 280	2,00	7+7
193,7 139,7	280 225	1,34	4+5	315 250	1,66	6+7	355 280	2,00	x
193,7 168,3	280 250	1,41	4+6	315 280	1,66	7+7	355 315	2,00	x
219,1 168,3	315 250	1,60	5+6	355 280	2,31	x	400 315	2,88	x
273,7 219,1	400 315	2,65	x	450 355	3,89	x	500 400	4,72	x
323,9 219,1	450 315	3,04	x	500 355	4,42	x	560 400	5,61	x
323,9 273,7	450 400	3,71	x	500 450	5,38	x	560 500	6,57	x
355,6 273,3	500 400	5,24	x	560 450	7,70	x	630 500	9,57	x
355,6 323,9	500 450	5,56	x	560 500	8,13	x	630 560	10,01	x
406,4 323,9	560 450	6,43	x	630 500	9,51	x	710 560	12,01	x
406,4 355,6	560 500	7,08	x	630 560	11,0	x	710 630	13,06	x
508,0 355,6	710 500	11,56	x	800 560	17,32	x	900 630	22,66	x
508,0 406,4	710 560	12,37	x	800 630	18,64	x	900 710	23,98	x
610,0 406,4	800 560	13,10	x	900 630	20,83	x	1000 710	26,27	x
610,0 508,0	800 710	15,97	x	900 800	25,18	x	1000 900	30,62	x

FOAM LIQUID DOSAGE

SPLIT STEEL BENDS

STANDARD INSULATION			PLUS INSULATION			PLUS-PLUS INSULATION		
30° < v ≤ 90°	A+B dm ³	2-Comp. No.	30° < v ≤ 90°	A+B dm ³	2-Comp. No.	30° < v ≤ 90°	A+B dm ³	2-Comp. No.
27 - 90	0,20	1	27 - 110	0,30	2	27 - 125	0,38	3
34 - 90	0,19	1	34 - 110	0,30	2	34 - 125	0,38	3
42 - 110	0,29	2	42 - 125	0,37	3	42 - 140	0,48	4
48 - 110	0,28	2	48 - 125	0,36	3	48 - 140	0,48	4
60 - 125	0,34	3	60 - 140	0,46	4	60 - 160	0,62	5
76 - 140	0,43	3	76 - 160	0,60	5	76 - 180	0,79	6
89 - 160	0,55	5	89 - 180	0,75	6	89 - 200	1,31	5+5
114 - 200	0,90	6	114 - 225	1,25	5+5	114 - 250	1,66	6+6
139 - 225	1,13	4+5	139 - 250	1,56	5+6	139 - 280	2,09	7+7
168 - 250	1,37	5+5	168 - 280	1,93	6+7	168 - 315	2,67	+
219 - 315	2,26	+						

STANDARD INSULATION			PLUS INSULATION			PLUS-PLUS INSULATION		
v ≤ 30°	A+B dm ³	2-Comp. no.	v ≤ 30°	A+B dm ³	2-Comp. No.	v ≤ 30°	A+B dm ³	2-Comp. No.
27 - 90	0,19	1	27 - 110	0,29	2	27 - 125	0,36	3
34 - 90	0,18	1	34 - 110	0,28	2	34 - 125	0,36	3
42 - 110	0,27	2	42 - 125	0,34	3	42 - 140	0,44	4
48 - 110	0,26	2	48 - 125	0,33	3	48 - 140	0,44	4
60 - 125	0,31	3	60 - 140	0,42	3	60 - 160	0,56	5
76 - 140	0,38	3	76 - 160	0,52	4	76 - 180	0,68	5
89 - 160	0,48	5	89 - 180	0,64	5	89 - 200	1,12	4+5
114 - 200	0,74	6	114 - 225	1,03	7	114 - 250	1,36	5+5
139 - 225	0,90	6	139 - 250	1,23	4+5	139 - 280	1,65	6+6
168 - 250	1,04	7	168 - 280	1,47	5+6	168 - 315	2,03	7+7
219 - 315	1,61	6+6						

Where no 2-comp. is mentioned, machine foaming is used.

FOAM LIQUID DOSAGE

STEEL T- PIECES

STANDARD INSULATION

Branch	27-90		34-90		42-110		48-110		60-125		76-140		89-160		114-200	
Main pipe	dm ³	nr	dm ³	nr	dm ³	nr	dm ³	nr	dm ³	nr	dm ³	nr	dm ³	nr	dm ³	nr
27-90	0,38	3														
34-90	0,37	3	0,36	3												
42-110	0,44	4	0,43	3	0,55	4										
48-110	0,43	4	0,42	3	0,53	4	0,51	4								
60-125	0,48	4	0,46	4	0,58	5	0,56	5	0,65	5						
76-140	0,51	4	0,50	4	0,61	5	0,60	5	0,69	6	0,73	6				
88-160	0,60	5	0,59	5	0,70	6	0,68	6	0,78	6	0,82	6	0,98	7		
114-200	0,79	6	0,79	6	0,90	6	0,88	6	0,97	7	1,02	7	1,18	4+5	1,52	5+6
139-225	0,89	6	0,87	6	0,99	7	0,97	7	1,06	7	1,10	3+5	1,26	5+5	1,60	4+7
168-250	0,96	7	0,94	7	1,06	7	1,04	7	1,13	4+5	1,17	4+5	1,33	5+5	1,67	5+7
219-315	1,31	5+5	1,31	5+5	1,42	4+6	1,40	4+6	1,49	5+6	1,54	5+6	1,70	5+7	2,04	7+7

PLUS INSULATION

Branch	27-110		34-110		42-125		48-125		60-140		76-160		89-180	
Main pipe	dm ³	nr	dm ³	nr	dm ³	nr	dm ³	nr	dm ³	nr	dm ³	nr	dm ³	nr
27-110	0,60	5												
34-110	0,59	5	0,58	5										
42-125	0,65	5	0,64	5	0,75	6								
48-125	0,64	5	0,63	5	0,74	6	0,72	6						
60-140	0,70	6	0,68	6	0,79	6	0,78	6	0,84	6				
76-160	0,78	6	0,77	6	0,88	6	0,86	6	0,93	7	1,09	3+5		
89-180	0,88	6	0,87	6	0,98	7	0,96	7	1,03	7	1,19	4+5	1,38	4+6
114-225	1,16	4+5	1,15	4+5	1,26	5+5	1,24	5+5	1,31	5+5	1,48	5+6	1,66	5+7
139-250	1,28	5+5	1,26	5+5	1,37	4+6	1,36	4+6	1,43	4+6	1,60	5+6	1,78	6+6
168-280	1,43	4+6	1,42	4+6	1,53	5+6	1,51	5+6	1,58	5+6	1,74	5+7	1,93	6+7

PLUS PLUS INSULATION

Branch	27-125		34-125		42-140		48-140		60-160		76-180		89-200	
Main pipe	dm ³	nr	dm ³	nr	dm ³	nr	dm ³	nr	dm ³	nr	dm ³	nr	dm ³	nr
27-125	0,83	6												
34-125	0,84	6	0,81	6										
42-140	0,91	6	0,90	6	0,97	7								
48-140	0,90	6	0,89	6	0,96	7	0,95	7						
60-160	1,01	7	0,99	7	1,07	7	1,05	7	1,24	5+5				
76-180	1,11	3+5	1,10	4+5	1,18	4+5	1,16	4+5	1,34	5+5	1,54	5+6		
89-200	1,25	5+5	1,23	4+5	1,31	5+5	1,29	5+5	1,34	5+6	1,68	6+6	1,89	6+7
114-250	1,68	6+6	1,67	6+6	1,74	6+6	1,72	5+6	1,48	6+7	2,12	7+7	2,07	7+7
139-280	1,90	6+7	1,89	6+7	1,96	6+7	1,95	6+7	1,91	+	2,11	+	2,54	+
168-315	2,19	+	2,18	+	2,25	+	2,24	+	2,12	+	2,63	+	2,83	+

Where no 2-comp. is mentioned, machine foaming is used

FLEX BEND JOINTS

STANDARD INSULATION			PLUS INSULATION			PLUS-PLUS INSULATION		
Designation	A+B ₃ dm ³	2-Comp. No.	Designation	A+B ₃ dm ³	2-Comp. No.	Designation	A+B ₃ dm ³	2-Comp. No.
27 - 90	0,78	6	27 - 110	1,03	7	27 - 125	1,40	5+5
34 - 90	0,75	6	34 - 110	1,00	7	34 - 125	1,38	5+5
42 - 110	0,95	7	42 - 125	1,33	5+5	42 - 140	1,78	6+6
48 - 110	0,93	7	48 - 125	1,30	5+5	48 - 140	1,75	6+6
60 - 125	1,20	5+4	60 - 140	1,65	6+6	60 - 160	2,15	7+7
76 - 140	1,50	6+5	76 - 160	2,00	7+6	76 - 180	2,58	+
89 - 160	1,88	7+6	89 - 180	2,43	+	89 - 200	3,48	+
114 - 200	3,10	+	114 - 225	4,48	+	114 - 250	6,58	+
139 - 225	3,98	+	139 - 250	6,00	+			
168 - 250	5,23	+						

Where no 2-comp. is mentioned, machine foaming is used.

PEH END JOINTS

Straight joint for ex. Ø225 ins. standard
2

$$0,78/2 = 0,39 \text{ dm}^3 \rightarrow \text{2-comp. no. 3}$$