

THERMA - TITE® | 3004 2.8

APPLICATION GUIDE

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Setup & operating limits

1:1

MIX RATIO BY VOLUME

Use only IPS A-Side (ISO)

1,000-1,300

SPRAY PRESSURE · PSI

Proportioner: 1,250-1,550 psi

1½"

MAXIMUM PER PASS

½" minimum; cool each lift

PROCESSING PARAMETERS

Spray pressure	1,000-1,300 psi
Proportioner set pressure	1,250-1,550 psi
Hose + A/B preheat · cold	120-135°F
Hose + A/B preheat · warmer	110-125°F
Material during installation	70-75°F
Temperature adjustments	±3°F

SITE & MATERIAL CONDITIONS

F reactivity · ambient	50-75°F
R reactivity · ambient	65-90°F
S reactivity · ambient	85-120°F
Wood substrate minimum	50°F; flash pass
Metal / concrete minimum	60°F; flash pass
Porous substrate moisture	Below 19%

BEFORE YOU SPRAY

1

Confirm the roof system

Confirm deck compatibility, project suitability, and the specified roof assembly with IPS. Use for exterior roofing in new construction or re-roofing; approval depends on the complete assembly.

2

Match product to conditions

Select F, R, or S reactivity for measured ambient conditions. Check substrate temperature and moisture; changing weather and site conditions affect adhesion. Obtain weather limits from IPS.

3

Condition the materials

Warm material to at least **70°F for 24 hours** before installation. Maintain the material temperature shown during spraying. Cold material can thicken and cause cavitation.

4

Set and check the equipment

Use only IPS A-Side (ISO). Flush the proportioner before switching materials. Set pressures, both A/B preheaters, and hose heat as shown; adjust temperatures for substrate, ambient conditions, and humidity.

Use limits: THERMA-TITE® 3004 2.8 is a closed-cell exterior roofing foam. It is not an interior insulation system. Cold-storage use requires a structure designed for that purpose by a design professional.

Upper substrate temperatures and roof-assembly listing status remain unresolved in the TDS.

APPLICATION GUIDE

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Surface preparation & application

PREPARE THE SUBSTRATE

Surfaces must be clean, dry, and free of grease, oil, dirt, and surface moisture. Field-test compatibility and adhesion.

WOOD & WOOD-BASED DECKS

Remove dust, oil, and debris. Fill gaps with suitable backer rods or fillers. Verify moisture and temperature limits shown; use flash passes for cold-weather application.

STEEL & OTHER METALS

Field-test suitability and adhesion. Blast or prime as surface condition requires. Allow primer to cure fully. Use a flash pass at the stated minimum substrate temperature.

CONCRETE

Allow at least 28 days of cure. Remove dust and oil; fill voids or cracks. Verify dryness and temperature, using a flash pass at the stated minimum.

EXISTING FOAM & OTHER SURFACES

Remove old or incompatible foam or coatings. Test adhesion before full application. Consult IPS about plastics, unfamiliar substrates, preparation, and compatibility with the complete roof system.

APPLY & CHECK THE FOAM

1

Prepare and prime the roof

Complete cleaning, repairs, and substrate checks. Apply required primer and allow full cure. Confirm the upper substrate-temperature limit and roof-system details with IPS before spraying.

2

Spray a representative mock-up

Test the spray pattern and apply a sample area under actual site conditions. Evaluate adhesion and material installation. Confirm satisfactory results before starting the full roof.

3

Build thickness in controlled lifts

Keep every pass within the thickness limits shown. Let each lift cool before recoating; no timed interval is specified. Never spray into or under rising foam.

4

Inspect and finish the system

Inspect appearance and adhesion regularly. Remove and replace improperly installed foam. Complete the approved roof surfacing; confirm coating or granule selection and application timing with IPS.

SAFETY & FIRE PROTECTION

Control exposure: Read both component SDSs. Provide local exhaust ventilation and appropriate respiratory, skin, and eye protection, including chemical-resistant gloves. Avoid contact and inhalation. Follow SDS first aid.

Prevent excessive heat: Combustible foam: keep torches away; maximum service temperature **180°F**. Excessive pass thickness, off-ratio material, or spraying into rising foam can cause fire and persistent odors. Remove defective foam; move large masses safely outdoors, cut smaller, and cool before disposal.

Confirm the roof fire assembly: Fire classification depends on deck, thickness, incline, and surfacing. The TDS leaves listing status unresolved; obtain approved assembly details from IPS.

STORAGE & RETURN TO SERVICE

Storage: Store original, unopened containers at **50-80°F**, covered, secure, and out of sunlight. Keep seals intact. Shelf life from manufacture: **F/R: 5 months; S: approximately 3 months**. Excess heat shortens shelf life and can increase package pressure.

The TDS gives no re-entry interval. Confirm access, ventilation, and re-entry requirements with IPS using current component SDSs before others enter affected areas.

Equipment: Clean regularly; follow equipment manufacturer maintenance and storage instructions.

Confirm with IPS: Confirm roof assemblies, surfacing schedules, and re-entry conditions with IPS and current component SDSs. Obtain job-specific wind and dew-point guidance; numeric limits are not supplied.