

SOUDAFOAM MAXTWO HFO E84 (XL E84)

Revision: 08/25/25

Page 1 of 6

Product description:

Soudafoam MAXTWO HFO E84 is a high quality, quick rise, 2-component, polyurethane spray foam for insulating, filling and sealing in professional and industrial applications. It is air and watertight, but vapor open. The foam is class 1 (A) fire rated (flamespread index <25 and smoke developed index <450) which makes it suitable for many industrial and commercial applications which demands a high quality foam. It is supplied in a box containing two portable, disposable and pressurized cylinders requiring no external power source, no extra pressure and no pumps. The two tanks are connected by hoses to the dispensing gun equipped with special developed nozzles to assure a high quality foam is produced. Soudafoam MAXTWO HFO systems are containing a non-flammable, non-VOC, ultra-low GWP (<1) and zero ODP propellant which complies with the latest US regulations banning all CFC-, HCFC- and HFC-propellants. Soudafoam MAXTWO HFO E84 is ICC ES listed (evaluation report ESR-4728). Technical properties of the foam product:

Properties	Value	Unit	Method
Nominal density	1.76	lb/ft ³	ASTM D1622
Compressive strength	21.2	psi	ASTM D1621
Tensile Strength	43.8	psi	ASTM D1623
Thermal resistance per inch (R-value)		ft ² ·h·°F/Btu	ASTM C518
Initial 1"	6.7		
Initial 2"	13.2		
Aged 1" (180 days 73°F)	6.2		
Aged 2" (180 days 73°F)	13		
Flame spread/smoke developed* @ 2" thick, full coverage	20/350		ASTME84/UL723
Air leakage rate at 75 Pa (1" thick)	0.02	L/s/m ²	ASTM E283
Dimensional stability			ASTM D2126
-40°C (-40°F)	-0.2	%	
70°C/97% RH (158°F/97% RH)	6.6	%	
37.8°C/97% RH (100°F/97% RH)	3.5	%	
Water vapor transmission (2" thick)	1.869	perms	ASTM E96
Gel time	30	s	
Maximum service temperature	165	°F	ASTM C411/ASTM C447

Mentioned values are typical for production samples, but are no sales specifications.

* Note: fire classifications are not intended to reflect hazards presented by this or any other material under actual fire conditions.

Application area:

Soudafoam MAXTWO HFO E84 is developed for many uses in professional building and industrial applications. It can be used as thermal insulation, structural support, for repair jobs, filling and sealing of voids and cracks. This product is not suitable for load bearing applications (eg floors, roofs,...) which require a higher compressive strength.

Remarks: this TDS version supersedes all previous versions. The directives contained in this documentation are the result of our experiments and of our experience and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications which are out of our control, we cannot accept any responsibility for the results obtained. In every case it is recommended to carry out preliminary experiments. Soudal preserves the right to alter its products without prior notice.

Distributed by: Soudal Accumetric • Elizabethtown, KY 42701 • www.soudalusa.com • info@soudalusa.com • 877-873-8739

SOUDAFOAM MAXTWO HFO E84 (XL E84)

Revision: 08/25/25

Page 2 of 6

Recommendations of use:

Storage		
Temperature	59°F - 77°F	Higher storage temperature will speed up ageing
Conditions		Store in upright position and dry conditions

Application		
Ambient temperature	59°F - 95°F	
Substrate temperature	40°F - 95°F	A too low or too high temperature can have a negative effect on foam (adhesion)
Component temperature	68°F - 77°F	Too high or too low temperatures can have a negative influence on the mix ratio and foam quality
Substrate conditions	Dry and clean	Good adhesion on all surfaces (except for PE, PP and PTFE). Materials such as oil, grease, dust, loose debris, water and ice can affect adhesion. Substrates like aluminium and steel might require treatment with a primer or a coating. A damp surface can cause pin holes, blisters, a high percentage of open cells, poor mechanical strength, potential shrinkage and poor adhesion. Due to the exothermic reaction, substrates should be resistant to heat. When in doubt, the adhesion and/or heat resistance should be checked on the substrate or on a comparable sample.

For more product info and detailed instructions: check Product and Application guide.

Best Practice	
Preparing the system:	• Before use, shake both cylinders for approximately 20 seconds • Apply an amount of gun lubricant to the inside of the dispensing gun • Attach the end of the red hose to the ISO cylinder and the end of the blue hose to the polyol cylinder. Tighten securely with the included wrench. The wrench is developed to deform if excessive pressure is applied • Slowly open the valves of both cylinders until fully open and check for leaks and liquid flow inside hoses

Remarks: this TDS version supersedes all previous versions. The directives contained in this documentation are the result of our experiments and of our experience and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications which are out of our control, we cannot accept any responsibility for the results obtained. In every case it is recommended to carry out preliminary experiments. Soudal preserves the right to alter its products without prior notice.

SOUDAFOAM MAXTWO HFO E84 (XL E84)

Revision: 08/25/25

Page 3 of 6

Purging and checking the system:	• Purge the system for 5 seconds into a waste container by first activating the red safety trigger and subsequently the main black trigger completely. Both product flows should be equal in volume to assure good foam quality • When both flows are visually equal in volume, clean the gun with Soudal Gun & Foam Cleaner and re-apply some gun lubricant to the inside of the gun • Insert the nozzle into the front of the gun. Make sure the nozzle fits perfectly in the dispensing gun until a “click” is audible • Before spraying it is advised to do some test shots in a waste container to check if foam quality is good and if color of produced foam is homogeneous. A homogeneous foam indicates a good mix ratio • Before starting with the spray process, it is advised to do some test shots to get used to the spraying process if this is not the case
Applying:	• Check if the application conditions are conform the prescriptions mentioned in Product properties • Hold the dispensing gun about 6” - 24” away from the surface/space that has to be sprayed by pressing down the trigger completely • Make sure the trigger is always pressed down completely while spraying. A not completely opened trigger can result in bad foam quality (off ratio foam) • Move the dispensing gun under controlled movement to cover the desired surface/space with foam • Spray in foam layers of approx. 1” - 2” thickness. While spraying the product an amount of heat is released because of the exothermic nature of the chemical PU reaction. Make sure that the substrate is not affected by this heat release. It is advised to do a test shot to verify this • Replace nozzle when not been used for more than 20 seconds (earlier at higher component temperatures as 68°F) • Check during spraying continuously if the foam is homogeneous of color and if a rigid, hard foam is formed after some minutes

Remarks: this TDS version supersedes all previous versions. The directives contained in this documentation are the result of our experiments and of our experience and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications which are out of our control, we cannot accept any responsibility for the results obtained. In every case it is recommended to carry out preliminary experiments. Soudal preserves the right to alter its products without prior notice.

SOUDAFOAM MAXTWO HFO E84 (XL E84)

Revision: 08/25/25

Page 4 of 6

Application interruption:	Empty cylinder(s):	When the cylinders are empty, 2 new tanks should be connected. Make sure both cylinders are completely empty for disposal (see manual): • Close the valves of both cylinders • Empty remaining liquid in hoses into a waste container by activating the dispensing gun trigger • Follow instructions mentioned in the disposal part (see manual) • Clean both hose ends with Soudal Gun & Foam Cleaner. Pay special attention for cleaning of the ISO hose end. If not cleaned properly blockages or leaks may occur • Connect the hoses to the new cylinders • Remove nozzle and clean dispensing gun with Soudal Gun & Foam Cleaner • Shake new cylinders thoroughly for 20 seconds • Open cylinder valves slowly and check for leaks • Purge system as mentioned before and visually check if both flows are equal in volume • Clean dispensing gun with Soudal Gun & Foam Cleaner • Apply sufficient gun lubricant and insert new nozzle • Spray process can be continued
---------------------------	--------------------	--

Remarks: this TDS version supersedes all previous versions. The directives contained in this documentation are the result of our experiments and of our experience and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications which are out of our control, we cannot accept any responsibility for the results obtained. In every case it is recommended to carry out preliminary experiments. Soudal preserves the right to alter its products without prior notice.

SOUDAFOAM MAXTWO HFO E84 (XL E84)

Revision: 08/25/25

Page 5 of 6

	When cylinders are not empty and should be stored for a short period (1-7 days):	• Close both valves of the cylinders • Remove the nozzle and clean the gun with Soudal Gun & Foam Cleaner • Apply sufficient gun lubricant to the inside of the gun and reinsert the used nozzle • System can be stored according to storage conditions up to 1 week • If spray process has to be continued, remove nozzle, shake both canisters for 20 seconds and open valves of both cylinders • Follow “purging and checking the system” instructions before starting new spray job
	When cylinders are not empty and should be stored for a period longer than 1 week:	• Close both valves of the cylinders • Remove the nozzle and clean the gun with Soudal Gun & Foam Cleaner. Apply sufficient gun lubricant to the inside of the gun and reinsert the used nozzle • If the system has not been used for one week, it should be activated once a week • This is done by shaking both cylinders for 20 seconds and opening the valves of both cylinders completely • Remove nozzle and purge for few seconds in a waste container by pressing trigger completely. This will rinse the hoses • It is advised to repeat this once a week as long as the system is not used • Clean the gun with Soudal Gun & Foam Cleaner • Apply sufficient gun lubricant in the dispensing gun and reinsert the used nozzle for storage • Close both valves of the cylinders • System can be stored according to storage conditions • If the spray process has to be continued, remove nozzle, shake both canisters for 20 seconds and open both cylinder valves • Follow “purging and checking the system” instructions before starting new spray job

Foam layers		
Layer thickness	Approx. 2"	High foam thickness can be reached using several layers of 1" - 2". It is advisable to wait 20 minutes between applying more layers onto each other, when a total thickness of 4" is required.
UV-Protection	Coating	For outside applications, foam should be protected against UV-radiation.

Packaging:

	Soudafoam MAXTWO HFO E84	Soudafoam MAXTWO HFO E84 XL
Total net weight	26.5 lb	88.2 lb

Remarks: this TDS version supersedes all previous versions. The directives contained in this documentation are the result of our experiments and of our experience and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications which are out of our control, we cannot accept any responsibility for the results obtained. In every case it is recommended to carry out preliminary experiments. Soudal preserves the right to alter its products without prior notice.

SOUDAFOAM MAXTWO HFO E84 (XL E84)

Revision: 08/25/25

Page 6 of 6

Packaging:

	Soudafoam MAXTWO HFO E84	Soudafoam MAXTWO HFO E84 XL
Packaging	1 box with: -1 cylinder Soudafoam MAXTWO HFO poly E84 -1 cylinder Soudafoam MAXTWO HFO iso E84 -GHA 9 or 15 ft -plastic bag with 8 Cone, 4 Fan nozzles, wrench and gun lubricant	-1 box with 1 cylinder Soudafoam MAXTWO HFO-XL poly E84 -1 box with 1 cylinder Soudafoam MAXTWO HFO-XL iso E84
Theoretical yield (Board ft)*	185	615
Color	Champagne	
Shelf life	12 months	
Accessories (available separately)	-Soudal dispensing gun with hoses (9, 15 and 30 ft hose lengths available) -Fan nozzles -Cone nozzles -tube gun lubricant -Soudal Gun & Foam Cleaner -Wrench	

* Note: Theoretical volume yield calculations are determined in perfect laboratories conditions, without taking into consideration the loss of blowing agent during application. Lower component temperatures (<59°F) have a negative impact on yield, mix ratio and foam properties in general.

Certifications:

- ASTM C411
- ICC-ES (ESR-4728)
- ICC-ES AC308 Appendix X
- UL certified (R21831)
- NFPA 286

Safety advice:

Both cylinders are under pressure. Do not puncture the cylinders, do not dispose before emptying. Avoid prolonged storage in direct sunlight or near heat sources.

Do not breathe vapors or spray. Use only in a well-ventilated area. Use proper protective clothing (e.g. impermeable coveralls, no skin should be exposed) and chemical resistant gloves. It is recommended to wear respiratory protection, according to OSHA requirements, while operating the Soudafoam MAXTWO HFO systems (e.g. half face mask respirator with appropriate filter) in combination with safety goggles. Check SDS for further information on personal protection and protection of the environment

Remarks: this TDS version supersedes all previous versions. The directives contained in this documentation are the result of our experiments and of our experience and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications which are out of our control, we cannot accept any responsibility for the results obtained. In every case it is recommended to carry out preliminary experiments. Soudal preserves the right to alter its products without prior notice.