PUMP TYPES

• Variable Speed or Rex-Roth-type pumps are preferred

• Use “Oversized” pumps
  ✓ Oversize pumps can operate at reduced speed (RPM).
  ✓ FSI does not recommend running pumps at full speed.
    1750rpm is adequate for FSI systems.
  ✓ Slower speed (RPM) will generate less heat.
  ✓ Slower speeds will cause less wear on internal components.
  ✓ Larger housings are typical with larger pumps. Both assist with heat dissipation.

• Do NOT use Magnetic Drives on the Polyol side of equipment
  ✓ Mag Drives add cost to purchase, parts and maintenance.
  ✓ Mag Drives induce unnecessary heat.
  ✓ Polyols and most Polyol blends are self-lubricating; hence, a Mag drive on Polyol side is unnecessary.

TEMPERATURE

• Avoid High & Unnecessary Temperatures

• Use “Oversized” pumps
  ✓ Pump housing and polyol blend temperature is critical; this should be monitored and known.
  ✓ Recirculation to the back of pump can assist in heat reduction, and is preferred.
  ✓ Chemical temperatures and pump temperatures are different. Both need to be known.
  ✓ All Polyols and Polyol blends are subject to degradation in high temperatures.
  ✓ Typically, surfactants are the first to break down in high temperatures. This can lead to abrasion and erosion of equipment internals.
  ✓ Excess heat can occur in “recirculation mode”.

OTHER

• Use Carbide tips or hardened orifices

• Use Stainless Steel Flow Meters

UNNECESSARY ITEMS

• Epoxy-Coated Tanks

• Chrome & Protective Coatings

NOTE: Recommendations are what FSI knows to be true and accurate.