



HOLCIM BUILDING ENVELOPE DIVISION

1245 Chapman Drive
Waukesha, WI 53186

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GacoOnePass F1850 SPRAY FOAM INSULATION

CSI Section:

07 21 00 Thermal Insulation

1.0 RECOGNITION

GacoOnePass F1850 Spray Foam Insulation recognized in this report has been evaluated for use as spray foam insulation complying with IBC Section 2603, IRC Section R316, IECC Sections C303, C402, R303 and R402. The surface burning, physical properties, thermal resistance, and applications in Types I through IV construction of GacoOnePass F1850 Spray Foam Insulation has been evaluated to comply to the intent of the following codes and regulations:

- 2021, 2018, and 2015 International Building Code® (IBC)
- 2021, 2018, and 2015 International Residential Code® (IRC)
- 2021, 2018, and 2015 International Energy Conservation Code® (IECC)
- 2020 Florida Building Code, Building (FBC, Building)
- 2020 Florida Building Code, Residential (FBC, Residential)
- 2020 Florida Building Code, Energy (FBC, Energy)-supplement attached.

2.0 LIMITATIONS

Use of GacoOnePass F1850 spray foam insulation recognized in this report is subject to the following limitations:

2.1 GacoOnePass F1850 spray foam insulation shall be installed in accordance with the manufacturer's published installation instructions. The insulation shall also be installed in accordance with this evaluation report and the applicable code, and if there are any conflicts between the manufacturer's published installation instructions and this report, the more restrictive governs.

2.2 Except as indicated in Section 3.3.3 of this report or by the applicable code, the insulations shall be separated from the interior of the building by a code approved thermal barrier.

2.3 As noted in Sections 3.3.3 and 3.3.4 of this report, the insulation shall not exceed and the maximum thickness intended for use.

2.4 During installation, the insulation and the surfaces to which they are applied shall be protected from exposure to weather.

2.5 The contractors that will be installing the insulations shall be certified by Holcim Building Envelope Division, Gaco Western, LLC or by the Spray Polyurethane Foam Alliance (SPFA).

2.6 Use of the insulation in areas of "very heavy" termite infestation shall be in accordance with IBC Section 2603.8 or IRC Section 318.4, as applicable.

2.7 Labeling and jobsite certification of the insulation and coatings shall comply with IBC 2603.2, IRC 1101.10 and IECC Sections C303.1.1 and R303.1.1, as applicable.

2.8 Foam Plastic used in plenums as interior finish or interior trim shall comply with Section 2603.7 of the IBC.

2.9 The insulation recognized in this report is produced in Waukesha, Wisconsin, and Spring, Texas.

3.0 PRODUCT USE

3.1 General: When installed in accordance with Section 3.3 of this report, GacoOnePass F1850 spray foam insulation may be used in wall cavities, floor assemblies or ceiling assemblies, and in attic and crawl spaces as nonstructural thermal insulation material. The spray-applied foam plastic insulations are used in Type V construction under the IBC and in dwellings under the IRC. The spray-applied foam plastic insulations also may be used in Type I, II, III or IV construction when installed in accordance with Section 3.4 of this report.

GacoOnePass F1850 spray foam insulation may be used as air impermeable insulation when installed in accordance with Section 3.2.4 of this report.

3.2 Design:

3.2.1 General. GacoOnePass F1850 spray foam insulation shall comply with requirements in IECC Sections C303, C402, R303 and R402, as applicable.



3.2.2 Thermal Resistance. (R-Values): GacoOnePass F1850 spray foam insulations have a thermal resistance (R-Value) at a mean temperature of 75°F (24°C) as shown in Table 1 of this report.

TABLE 1 – Thermal Resistance (R-Value)
(°F·ft²·h/Btu)

Thickness (inch)	GacoOnePass F1850
1	6.5
2	14
3	21
3.5	24
4	28
5	35
6	42
7	48
8	55
9	62
10	69
11	76
12	83

For SI: 1 inch = 25.4 mm, 1°F·ft²·h/Btu = 0.176 110 K·m²/W.

¹ R-Values are calculated based on tested K values at 1-inch and 3.5-inch thicknesses.

² R-Values greater than 10 are rounded to the nearest whole number.

3.2.3 Surface Burning Characteristics: At a maximum thickness of 4 inches (102 mm) and a nominal density of 2.1 pcf (32 kg/m³), the GacoOnePass F1850 spray foam insulation has a flame spread index of 25 or less and smoke-developed index of 450 or less when tested in accordance with ASTM E84. Thicknesses are not limited for ceiling cavities and wall cavities when covered by a code complying prescriptive thermal barrier, such as minimum ½-inch thick (12.7 mm) gypsum board.

3.2.4 Air Permeability: When tested in accordance with ASTM E2178 at a minimum thickness of 1 inch (25.4 mm), GacoOnePass F1850 spray foam insulation has an air permeance of less than 0.02 l/s x m² (0.002cfm/ft²) at 75 pa pressure differential and is classified as air-impermeable insulation in accordance with Section 1202.3 of the 2021 and 2018 IBC, Section 1203.3 of the 2015 IBC, and Section R806.5 of the IRC, as applicable.

3.2.5 Vapor Permeance: When tested in accordance with the ASTM E96 desiccant method (Procedure A), GacoOnePass F1850 spray foam insulation has a vapor permeance of less than 1.0 perms [57.4 x 10⁻⁹ g/(Pa·s·m²)], at a minimum thickness of 1 inch (25.4 mm) and qualifies as a Class II vapor retarder in accordance with IBC Section 202 and IRC Section R202.

3.2.6 Fire-Protective Coatings and Coverings: Fire protective coatings, for use as part of an alternative thermal barrier assembly, shall be in accordance with Table 2 of this

report, as applicable, and installed in accordance with Section 4.6 of this report.

3.3 Installation:

3.3.1 General. The manufacturer’s published installation instructions for GacoOnePass F1850 spray foam insulation and this report shall be available on the jobsite during installation for quality control purposes.

GacoOnePass F1850 spray foam insulation shall be spray-applied on the jobsite using a volumetric positive displacement pump in accordance with the manufacturer’s published installation instructions. The applied insulation shall be sprayed in multiple passes having a maximum thickness of 5½ inches (140 mm) per pass up to the maximum insulation thickness specified in this report. The maximum in-service temperature for all areas shall not exceed 200°F (93°C). The spray-applied foam plastic insulation shall not be used in electrical outlets or junction boxes or in continuous contact with rain or water. The spray-applied foam plastic insulation shall be sprayed onto a substrate that is protected and clean from any debris or weather-related conditions during application.

3.3.2 Installation with a Prescriptive Thermal Barrier: GacoOnePass F1850 spray foam insulation shall be separated from the interior by an approved thermal barrier of minimum ½ inch thick (12.7 mm) gypsum wallboard or an equivalent thermal barrier. When installed in accordance with this section, the spray foam may be any thickness when installed behind a prescriptive thermal barrier. The barrier shall comply with, and be installed in accordance with, IBC Section 2603.4 or IRC Section R316.4, as applicable.

3.3.3 Installation with an Alternative Thermal Barrier Assembly: The thermal barrier required by IBC Section 2603.4 or IRC Section R316.4 may be omitted when applied as part of an alternative thermal barrier assembly as shown in Table 2 of this report.

3.3.4 Installation for Attics and Crawl Spaces: When used in an attic or crawl space where entry is made only for service of utilities, GacoOnePass F1850 spray foam insulation shall be installed in accordance with this section. The insulation shall be separated from the interior of the building by an approved thermal barrier as described in Sections 3.3.2 and 3.3.3 of this report, as applicable.

3.3.4.1 Installation with a Prescriptive Ignition Barrier: Where entry is made only for the service of utilities, GacoOnePass F1850 spray foam insulation may be installed within attics or crawl spaces with an ignition barrier in accordance with IBC Section 2603.4.1.6, or IRC Sections R316.5.3 and R316.5.4, as applicable. The ignition barrier shall be installed in a manner such that the foam plastic insulation is not exposed and is consistent with the requirements of the type of construction required by the applicable code.



3.3.4.2 Installation with an Alternative Ignition Barrier Assembly: When installation is in accordance with this section, the ignition barrier specified by Section 2603.4.1.6 of the IBC or Sections R316.5.3 and R316.5.4 of the IRC, as applicable, may be omitted.

3.3.4.2.1 General: When GacoOnePass F1850 spray foam insulations are installed in attics and crawl spaces without a prescriptive ignition barrier, the following conditions apply:

- a. The thickness of the foam plastic insulation applied to the underside of the top of the space shall not exceed 1 1/2 inches (292 mm).
- b. The thickness of the foam plastic insulation applied to the vertical surfaces shall not exceed 7/8 inches (190 mm).
- c. Entry is only to service utilities in the attic or crawl space and no storage is permitted.
- d. Attic or crawl space areas cannot be interconnected.
- e. Air from the attic or crawl space cannot be circulated to other parts of the building.
- f. In accordance with 2021 and 2018 IBC Section 1202.2, the 2015 IBC Section 1203.2 or IRC Section R806, as applicable, attic ventilation is provided, as applicable.
- g. In accordance with 2021 and 2018 IBC Section 1202.4, 2015 IBC Section 1203.4 or IRC Section R408.1, as applicable, crawl-space ventilation is provided, as applicable.
- h. In accordance with IMC (International Mechanical Code®) Section 701, combustion air is provided.

3.3.4.2.2 Attics and Crawl Spaces: GacoOnePass F1850 Spray Foam Insulations may be spray-applied in attics to the underside of roof sheathing, roof rafters and/or vertical surfaces, and in crawl spaces to the underside of floors and/or vertical surfaces as described in this section. When applied to the underside of the top of the space and the thickness of the GacoOnePass F1850 Spray Foam Insulation does not exceed 10 inches (254 mm), and when applied to vertical surfaces the maximum thickness does not exceed 8 inches (203 mm), the GacoOnePass F1850 Spray Foam Insulation does not require the application of either an ignition barrier or a fire protective coating.

3.3.4.2.3 Unvented Attics: GacoOnePass F1850 Spray Foam Insulation may be installed in unvented attic assemblies and unvented enclosed rafter assemblies in accordance with Section 1202.3 of the 2021 and 2018 IBC, Section 1203.3 of the 2015 IBC or Section R806.5 of the IRC, as applicable.

3.4 Exterior Walls of Buildings of Type I, II, III or IV Construction. When GacoOnePass F1850 Spray Foam Insulation is used in exterior walls of buildings of Type I, II, III or IV construction of any height, the insulation shall comply with Section 2603.5 of the IBC and this section. GacoOnePass F1850 Spray Foam insulation shall be installed at a maximum thickness of 4-inches (102 mm).

3.4.1 Complying Exterior Wall Assemblies. Wall assemblies complying with Section 2603.5.5 of the IBC and this report that may be used in exterior walls of buildings of Type I, II, III or IV construction of any height are described in Table 4 of this report.

3.5 Use as a Water-resistive- Barrier: GacoOnePass F1850, when applied to form a minimum 1.5-inch thick (38.1 mm) continuous layer, may be used as an alternative water-resistive barrier specified in Section 1403.2 of the 2021 and 2018 IBC, Section 1404.2 of the 2015 IBC and Section R703.2 of the IRC, as applicable.

3.6 Weather Protection: GacoOnePass F1850, when applied to form a minimum 1.5-inch thick (38.1 mm) continuous layer, may be used to meet the requirements for weather protection applied to sheathing over framing spaced at 16 inches on center as provided in Exception 2 of Section 1402.2 of the 2021 and 2018 IBC, and Exception 2 of Section 1403.2 of the 2015 IBC.

3.7 Duct Coverings and Linings: GacoOnePass F1850, when applied at a maximum thickness of 2 3/4 inches (70 mm), meets the requirements of IRC Section 1601.3 Item 2 for duct coverings and linings when tested to ASTM C411 at a temperature of 250°F (121°C).

4.0 PRODUCT DESCRIPTION

GacoOnePass F1850 Spray Foam Insulation is a closed cell, spray-applied, polyurethane foam plastic and complies as medium-density insulation in accordance with Section 3.1.1 and Table 1 of AC377. The insulation is a two-component spray foam plastic with a nominal in-place density of 2.1 pcf (32 kg/m³).

The spray-applied insulation is mixed in the field by combining a polymeric isocyanate (A component) and a resin blend (B component). The liquid components shall be stored in 55-gallon (208 L) drums at temperatures between 50°F and 70°F (10°C and 21°C). When Component A and Component B are stored in factory-sealed containers at the recommended temperatures, the maximum shelf life is six months.

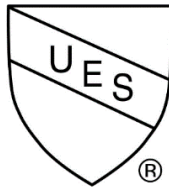
5.0 IDENTIFICATION

The spray foam insulation containers are identified with the following:

- a. Manufacturer's name (Gaco Western, LLC)
- b. address and telephone number,
- c. the product trade name (GacoOnePass F1850 Spray Foam Insulation)
- d. use instructions
- e. density, flame-spread and smoke-development indices
- f. date of manufacture or batch/run number
- g. the IAPMO Uniform ES evaluation report number (ER-858)
- h. the name or logo of the inspection agency



The IAPMO Uniform Evaluation Service Mark of Conformity may also be used as shown below:



IAPMO UES ER-858

6.0 SUBSTANTIATING DATA

6.1 Data in accordance with the ICC-ES Acceptance Criteria for Spray-applied Foam Plastic Insulation, AC377, dated April 2020 (Editorially Revised July 2020), including reports of tests in accordance with Appendix X of AC377.

6.2 Data in accordance with ICC 1100-2019 Standard for Spray-applied Polyurethane Foam Plastic Insulation.

6.3 Reports of room corner testing in accordance with NFPA 286.

6.4 Reports of fire characteristics testing and engineering analysis in accordance with NFPA 285.

6.5 Reports of potential heat of building material testing in accordance with NFPA 259.

6.6 Reports of water vapor transmission testing in accordance with ASTM E96.

6.7 Reports of testing in accordance with ASTM E331.

6.8 Reports of testing in accordance with ASTM E2178 for air impermeability.

6.9 Report of testing to ASTM C411.

6.10 Test reports are from laboratories in compliance with ISO/IEC 17025.

7.0 STATEMENT OF RECOGNITION

This evaluation report describes the results of research completed by IAPMO Uniform Evaluation Service on Holcim Building Envelope Division's GacoOnePass F1850 spray foam insulation to assess conformance to the codes shown in Section 1.0 of this report and serves as documentation of the product certification. Products are manufactured at the location noted in Section 2.9 of this report under a quality control program with periodic inspection under the supervision of IAPMO UES.

For additional information about this evaluation report please visit www.uniform-es.org or email us at info@uniform-es.org



TABLE 2 - ALTERNATIVE THERMAL BARRIER ASSEMBLIES

FIRE-PROTECTIVE COATING/COVERING ¹			MAXIMUM SPF THICKNESS (inch)	
TYPE	MINIMUM THICKNESS	THEORETICAL APPLICATION RATE (COATINGS ONLY)	WALLS AND VERTICAL SURFACES	CEILING AND OVERHEAD SURFACES
DC315 ²	14 mils WFT (9 mils DFT)	0.87 gal/100 ft ²	5.5	9.5
Plus ThB ³	14 mils WFT (9 mils DFT)	0.87 gal/100 ft ²	6.5	9.5

For SI: 1 inch = 25.4 mm, 1 gallon = 3.785 L, 1 ft² = 0.0929 m²

¹ Fire-protective coatings and coverings shall be applied over all exposed SPF surfaces in accordance with the coating/covering manufacturer's instructions and this report.

² International Fireproof Technology, Inc, recognized in [IAPMO UES ER-499](#) and tested to the requirements of [NFPA 286](#).

³ No-Burn, Inc, recognized in IAPMO UES ER-305 and tested to the requirements of UL 1715.

TABLE 3 – NFPA 285 COMPLYING EXTERIOR WALL ASSEMBLIES

Wall Component	Material Description
Base Wall System (BWS) Use either 1, 2 or 3	1 – Concrete wall 2 – Concrete masonry wall 3 – 1 layer of 5/8-inch thick Type X gypsum wallboard installed on the interior side of minimum 3 5/8-inch-deep minimum No. 20-gauge thick steel studs spaced a maximum of 24 inches on center. Lateral bracing installed minimum every 4 feet vertically or as required.
Floorline Firestopping	Wall stud cavities shall be filled at each floor line with minimum 4 pcf density mineral wool (e.g. Thermafiber) friction fit between steel wall studs.
Interior Insulation	Full cavity depth or less of GacoOnePass F1850 applied using sheathing as substrate and covering the width of the cavity and inside of the stud flange.
Exterior Sheathing	5/8-inch-thick Type X exterior type gypsum sheathing
Exterior Wall Covering² Use either 1 or 2	1 - Any noncombustible exterior wall covering material. 2 - Any combustible exterior wall covering system that has successfully been tested in accordance with NFPA 285
Flashing of windows, doors or other exterior wall penetrations	Frame as required for base wall. As an option, flash around windows, doors and other exterior wall penetrations with limited amounts of maximum 12-inch-wide flashing tape (acrylic, asphalt or butyl-based) or liquid-applied membrane material with or without fiber mesh reinforcement.

SI: 1 inch = 24.4 mm; 1 pcf = 16.0 kg/m³; 1 BTU/ft² = 0.01128 mJ/m²

¹ Fireblocking per Section 718 of the IBC and thermal barrier material requirements per Section 2603.4 of the IBC shall be met for Base Wall Systems 1 and 2, as required by specific wall construction details when a combustible concealed space is created on interior side of exterior wall assembly.

² Exterior wall coverings shall be installed in accordance with the manufacturer's installation instructions and shall comply with the provisions of Chapter 14 of the IBC and Chapter 7 of the IRC, as applicable.

³ The potential heat of 4-inch-thick GacoOnePass F1850 Spray Foam Insulation is 7080 Btu/ft² when tested in accordance with NFPA 259.



TABLE 5. NFPA 285 COMPLYING EXTERIOR WALL ASSEMBLIES WITH GacoOnePass F1850 APPLIED IN WALL STUD CAVITY WITH SPRAY FOAM INSULATION APPLIED ON THE EXTERIOR OF WALL ASSEMBLY

Wall Component	Material Description
Base Wall System (BWS) – Use Item 1, 2, or 3	<ol style="list-style-type: none"> 1) Concrete Walls 2) Concrete Masonry Unit Walls 3) 1 layer of 5/8-inch Type X gypsum wallboard installed on the interior side of minimum 35/8-inch No. 20 gauge steel studs spaced a maximum of 24 inches on center with lateral bracing every 4 feet vertically.
Fire-Stopping at floor lines – Use Item 1 or 2	4-inch 4 pcf mineral wool installed with Z-clips or equivalent in each stud cavity and at each floor line.
Cavity Insulation Use Item 1, 2, 3 or 4	<ol style="list-style-type: none"> 1) None 2) Full stud cavity or less of GacoOnePass F1850. 3) Any noncombustible insulation per ASTM E136 4) Any fiberglass insulation (faced or unfaced)
Exterior Sheathing	Minimum 1/2 - inch thick exterior gypsum sheathing
Exterior Insulation	GacoOnePass F1850 at a maximum thickness of 4 inches.
Exterior Cladding² - Use Item 1, 2, 3, 4 or 5	<ol style="list-style-type: none"> 1) Brick – Nominal 4-inch clay or concrete brick or veneer with maximum 2-inch air gap behind the brick. Brick Ties/Anchors 24 inches on center (maximum) 2) Stucco – minimum 7/8-inch-thick exterior cement plaster and lath. A secondary water-resistive barrier (WRB) may be installed between the exterior insulation and the lath. The secondary WRB shall not be full-coverage asphalt or butyl-based self-adhered membranes. 3) Natural Stone Veneer – minimum 2-inch-thick natural stone (granite, limestone, marble, and sandstone). Any standard non-open-jointed installation technique may be used. 4) Cast Artificial Stone – minimum 1½-inch thick complying with ICC-ES AC 51 or ASTM C1670 using any standard non-open-jointed installation technique. 5) Terra Cotta Cladding – minimum 1¼-inch thick (solid or equivalent by weight) using any standard installation technique.
Flashing	As an option, flash around windows, doors and other exterior wall penetrations with limited amounts of maximum 12-inch-wide flashing tape (acrylic, asphalt or butyl-based) or liquid-applied membrane material with or without fiber mesh reinforcement.
Window/Door Perimeters Use both 1&2 when required.	<ol style="list-style-type: none"> 1) The header of all window and door openings shall have a minimum 4-inch-high, full depth strip of mineral wool installed in conjunction with a steel window/door frame. 2) The jambs of all window and door opening shall have a minimum 4-inch-wide, full depth strip of mineral wool installed in conjunction with a steel window/door frame.

For SI: 1 inch = 25.4 mm



FLORIDA SUPPLEMENT

**HOLCIM BUILDING ENVELOPE
DIVISION
1245 Chapman Drive
Waukesha, WI 53186**

**GacoOnePass F1850 SPRAY FOAM
INSULATION**

CSI Section: 07 21 00 Thermal Insulation

1.0 RECOGNITION

GacoOnePass F1850 Spray Foam Insulation evaluated in IAPMO UES Evaluation Report ER-858 is a satisfactory alternative to the following codes and regulations:

- 2020 Florida Building Code, Building (FBC, Building)
- 2020 Florida Building Code, Residential (FBC, Residential)
- 2020 Florida Building Code, Energy (FBC, Energy)

2.0 LIMITATIONS

2.1 The clearance between the foam insulation installed above grade and exposed earth shall be in accordance with Sections 1403.8 and 2603.8 of the FBC, Building or Section R318.8 of the FBC, Residential, as applicable.

2.2 Verification shall be provided that a quality assurance agency audits the manufacturers quality assurance program and audits the production quality of products, in accordance with Section (5)(d) of Florida Rule 61G20-3.008. The quality assurance agency shall be approved by the Commission (or the building official when the report holder does not possess an approval by the Commission).

2.3 This supplement expires concurrently with ER-858.

For additional information about this evaluation report please visit www.uniform-es.org or email at info@uniform-es.org