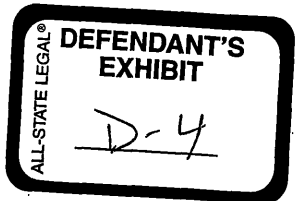


May 27, 1975
Supersedes V-976
Dated 5/1/75

MILFORD, VIRGINIA, PLANT FORMULA
READY MIX JOINT COMPOUND V-976 (HAND TOOLS)



DESCRIPTION OF PRODUCT - White ready mix joint compound used for taping, topping, and texturing.

- / <u>FORMULA</u>				
<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
*Water	Solvent	--	--	1013.0 (122 gals)
Elvace	Adhesive	185	4.00	80.0 (9 gals)
Nalco	Antifoaming agent	125	.10	2.0
**Asbestos 7RF-02	Bulking agent	9	2.50	50.0
***Troysan	Bactericide	193	.10	2.0
Gelvato1 3000	Adhesive	162	.60	12.0
Natrosol 250 HXR	Thickener	170	.60	12.0
Mica	Anticracking agent	11	9.00	180.0
Limestone	Filler	13	83.10	1653.0
			100.00	3004.0****

*Approximately 51.0 lbs./100 lbs. of active ingredients (this may vary $\pm$ 4 gallons per batch).

**Asbestos 7RF9 may be substituted. Use at a loading of 4% (80 lbs/batch).

*** Cosan JTA 20 may be substituted. Use at a loading of .05% (1 lb/batch).

****One batch yields 48 ± 1 five-gallon pail ready mix joint compound at 62 lbs/pail.

WORKING CONSISTENCY
Specifications for
paste:

- Refer to Plant Testing Procedure No. 32.

If paste is not proper working consistency, a maximum of 5 cc water per 150 grams of paste may be added to adjust.

Brabender:

580 $\pm$ 20 (For machine mix 400 $\pm$ 20, add 5 gals water)

WORKING PROPERTIES
Specifications:

- Refer to Plant Testing Procedure No. 33.

Compound shall be plastic, buttery working, and free of any coarse, gritty, or undispersed particles. Material shall be free from lumps due to incomplete mixing.

BONDING PROPERTIES
Specifications:

- Refer to Plant Testing Procedure No. 35.

After compound has dried, tape shall show at least 90% fiber tear when delaminated.

CRACK RESISTANCE
Specifications:

- Refer to Plant Testing Procedure No. 37.

There shall be no large fissure cracks in the wedge, and no cracks in the thinner half of the wedge.

COLOR

- White

Specifications:

Dried compound shall match color of standard sample.