

January 10, 1977
Supersedes Formula C-976
Dated: 7/21/76

CHICAGO, ILLINOIS, PLANT FORMULA
READY MIX JOINT COMPOUND C-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>Percent</u>	<u>Lbs/Batch</u>
-/ Water	Solvent	--	1038.00 (125 gals.)*
Nalco	Anti-foaming agent	.1	2.00
-/ Elvace EP-200	Adhesive	6.4	134.00 (15.0 gals.)
Filler C-970	Filler	<u>93.5</u>	<u>1950.00</u>
		100.0.	3124.00**

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch.

-/ **One batch yields 50 ± 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 ± 20) For machine tools add 10 gallons H₂O. (400 ± 20)

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
Dried compound shall match color of standard sample.

WNG:gvp

-/ denotes change

Lehnert 10.3.01-66

SGP 0018521

PLAINTIFF'S EXHIBIT

GP-2278

JAN. 17, 1977
~~July 21, 1976~~
Supersedes Formula C-976
Dated 3/23/76
7/21/76

CHICAGO, ILLINOIS, PLANT FORMULA
READY MIX JOINT COMPOUND C-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>Percent</u>	<u>Lbs/Batch</u>
-/ Water	Solvent	10.38	1038.00 (12.5 gals.)*
Nalco	Anti-foaming agent	.1	2.00
-/ Elvace 1875 @ 2.00	Adhesive	6.4	134.00 (15.0 gals.)
* Filler C-970	Filler	93.5	1950.00
		100.0.	3166.00**

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch.

-/ **One batch yields 50 ± 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 tools add 10 gallons H₂O. (400 $\pm$ 20)

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
Dried compound shall match color of standard sample.

WNG: gvp

-/ denotes change

SGP 0018538

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7.13.17, 1977
~~May 21, 1976~~
Supers. Formula C-979
~~DATE~~ DATED 5/21/76

CHICAGO, ILLINOIS PLANT FORMULA
READY MIX JOINT COMPOUND C-979 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for taping, topping and texturing. (Special asbestos free formula for all one gallon ready mix and selective five gallon shipment only.)

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Filler C-978	Filler	--	92.8	1950.0
Elvace 1875 CP 200	Adhesive	185	6.5	136.0 (15.25 gals.)
Nalco 71D-5	Defoamer	125	.2	4.0
Acrysol ASE-60	Thickener	147	.5	10.0 132
*/Water	Solvent	--	--	1104 1129.0 (135 gals.)
			100.0	3228.0** 3204

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch.

** One batch yields 51 $\pm$ 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

SPECIAL MIXING INSTRUCTIONS

- Blend ingredients in following order:

- 1) Water
- 2) Elvace 1875 CP 200
- 3) Nalco
- 4) Filler C-978
- 5) Mix until filler is dispersed
- 6) Add Acrysol ASE-60
- 7) Mix until Ready Mix is smooth - pumping viscosity should be 480 $\pm$ 20 to allow for 24 hour viscosity build of 100 pts.

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 tools add 7 gallons H₂O (400 $\pm$ 20)

pH Minimum - 9.0 Maximum - 10.0 (24 hrs.)

WORKING PROPERTIES

- 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.

WNG:gvp

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