

141

11001 014070 1000000

LABORATORY NO.

CONSISTENCY

COST CLASS.

DATE - 21-60

FOR USE ON

STRAINER

GRIND

CUSTOMER

MILL

WT. OR RE

[illegible]

GOODS

Japalac Empire Green

DISCONTINUED

LABORATORY NO.

85-7-20

CONSISTENCY

COST CLASS.

DATE

2/4/58

FOR USE ON

SEE 2/28/59 W.D.K.

STRAINER

GRIND

7-8

CUSTOMER

REPLACED BY Y-1271

MILL Pebble

WT. OR BE

9.4#

CODE NUMBER	ONE GALLON BATCH			LARGE BATCH			IS AGITATOR REQUIRED	
	PINTS	LBS.	OZS.	GALS.	LBS.	OZS.	VISC. F.B. 90-100"	TEMP.
YW-118		1	5-1/4		120		VISC. RED.	TEMP.
BL-74			3-3/4		21.2		VISCOSIMETER	#4 Ford Cup
W-170			1-1/2		8.5		COLOR	SHEEN
W-154			12		68		NON VOL.	FLASH PT.
CH-185			3/4		4.2		MATCH FOR	Y-1254 Chip
M-333			1		5.7			
V-862	6-3/4			76.7			REDUCER	S-43
O-320	1/4			2.8			AMT. FOR BRUSHING	
S-43	1			11.3			SPRAYING	TUMBLING
							DIPPING	DRIP TIME
							BAKE	TEMP.
VM-432			1/2	.35				
VM-530			1/2	.35			AIR DRIES IN	4-6 hrs.
CH-243			1/8	.09			A. D: TO RECOAT IN	24 hrs.
from file taken Not O.K. Standard formula number of pictures							REMARKS:	
							* USE	
							Y4554	
							* Glass Y-3204	
							* 828-4/1/58	
							* Glass Y-4131	
							* Glass Y-1132	
							FORMULATOR	J.E. Southwick
							OK PCM	28-9-9
YIELD	1.1			100	3-18-58			

FORMULA RECORD

FORMULA NO. Y-1254-E

NAME Japalac- Empire Green Enamel

LABORATORY NO.

CONSISTENCY

COST CLASS.

DATE 10/29/54

FOR USE

STRAINER

GRIND 7-B

CUSTOMER

MILL Pebble

WT. OR BE

CODE NUMBER	ONE GALLON BATCH			LARGE BATCH		
	PINTS	LBS.	OZS.	GALS.	LBS.	OZS.
G-3			8			
G-48		1	3			
W-104			4			
W-140			8			
CH-185			1			
H-333			1			
V-872	6-3/4					
O-320	1/4					
S-43	1					
D-29			2	Loz/gal.		
D-75			2	" "		
CH-269			1/8	" "		
93-W-170	Trace					
93-A-74	Trace					
YIELD	1312	Gal.				

Standard Formula.
Not to be taken
from File.

IS AGITATOR REQUIRED

VISC. F.F. 90-100" T.E.

VISC. RED.

TEMP.

VISCOSIMETER #4 Ford Cup

COLOR

SHEEN Gloss

NOI VOL.

FLASH PT.

BATCH FOR Y-1254 Chip

REDUCER

AMT. FOR DRUSHING

SPRAYING

TUNELING

DIPPING

DRIP TIME

BAKE

TEMP.

AIR DRIES IN 4-6 hrs.

A. D. TO RECOAT IN 24 hrs.

REMARKS:

Changed to reduce shading.

FORMULATOR

J.E. Southwick

28-8-7

GLD059627

U.S.A. FRONT FORM
Japalac Empire Green Enamel

Liquid

FORMULA RECORD

FORMULA NO. Y-1254-D

LABORATORY NO.

COST CLASS.

DATE 4/4/52

STRAINER

GRIND 7-8

Mr. Pebble

WT, CR FE 9-1/2#

CODE NUMBER	ONE GALLON BATCH			LARGE BATCH		
	PINTS.	LBS.	OZS.	GALS.	LBS.	OZS.
G-3			5			
G-48		1	6			
W-104			4			
W-140			8			
CH-185			1			
K-333			1			
V-872	6-3/4					
O-320	1/4					
S-43	1					
D-28			2			
D-75			2			
GH-269			1/8			
			Loz/gal.			
			" "			
			" "			
Standard Formula. Not to be taken from File.						
15 AGITATOR REQUIRED						
VISC. F.B. 90-105" TEMP.						
VISC. RED. TEMP.						
VISCOMETER #4 Ford Cup						
COLOR SHEEN Gloss						
NON VOL. FLASH PT. 100°F						
MATCH FOR Y-1254 Chip						
REDUCER						
A.T. FOR BRUSHING						
SPRAYING TUBING						
DIPPING DRIP TIME						
BAKE TEMP.						
AIR DRIES IN 6 hrs.						
A. O. TO RECOAT IN 24 hrs.						
REMARKS:						
Changed to replace V-357.						
FORMULATOR Southwick HGH						
YIELD 25-8-4						

CONSISTENCY

Liquid

LABORATORY NO.

FOR USE ON

COST CLASS.

DATE 11/12/51

CUSTOMER

STRAINER

CRIND 7-8

MILL Pebble

WT. OR EE 9-1/2#

CODE NUMBER	ONE GALLON BATCH			LARGE BATCH			IS AGITATOR REQUIRED	
	PINTS	LBS.	OZS.	GALS.	LBS.	OZS.	VISC. F.B.	TEMP.
G-3			5		25		80-90"	
G-48		1	6		110		VISC. RED.	TEMP.
W-104			8		40		VISCOSIMETER #4 Ford Cup	
W-140			4		20		COLOR Green	SHEEN
M-333			1		5		NON VOL.	FLASH PT. 100°F
CH-185			1/2		2-1/2		WATCH FOR Y-1254 Chip	
V-872	3-1/2			35			REDUCER	
V-357	4-1/4			42-1/2			AUT. FOR BRUSHING F.B.	
S-43	1/8			1-1/4			SPRAYING	TUMBLING
S-90	1/8			1-1/4			DIPPING	DRIP TIME
D-29		2 Loz/gal.		1-1/4			BAKE	TEMP.
D-75		2 " "		1-1/4			AIR DRIES IN 4-6 hrs.	
CH-269		1/8 " "				10 Loz	A. D. TO RECAT IN 24 hrs.	
RL-B721		1/8 " "				10 Loz	ADMARKS: Standard Formula	
							Active	
							Discontinued	
							OK SEE 1/2	
							FORMULATOR HGH	
YIELD								25-6-4

Analysis Change

Standard Formula
Not to be taken
from File

COST	DATE	ANALYSIS		CUSTOMERS Y-1254-C	
		PIGMENT	24.1	Jadralac	
		VEHICLE	75.9	1254 Empire Green	
			100.0 %	11/12/51	
		PIGMENT		<i>all Plants</i>	<i>12-4-51</i>
		C. P. Chroma Green	69.2 %		
		Basic Lead Carbonate	20.5		
		Calcium Carbonate	10.3		
			100.0 %		
		VEHICLE			
		* Varnish	94.6 %		
		Mineral Spirits	2.5		
		Liquid Drier	2.9		
			100.0 %		
		* Non-Vol. (Alkyd Resin, P.E.			
		Ester Gum, Tung, Linseed Oil)	54.6 %		
		Volatile (Mineral Spirits)	45.4		
			100.0 %		
		Y-1254	1511		

GLD059632

GOODS **Napalac Empire Green Enamel**

FORMULA RECORD

FORMULA NO. **Y-1254-B (Tomp)**

CONSISTENCY **Liquid**

LABORATORY NO.

FOR USE OF

COST CLASS.

DATE **9/16/50**

CUSTOMER

STRAINER

GRIND **7-8**

MILL

RT. OR RE **8-1/2**

CODE NUMBER	ONE GALLON BATCH			LARGE BATCH			IS AGITATOR REQUIRED
	PINTS	LBS.	OZS.	GALS.	LBS.	OZS.	
G-3			5		25		VISC. F.D. 80"-90" TEMP.
G-48		1	6		110		VISC. REF. TO-P.
W-104			8		40		VISCOSIMETER 1/4 Cup
Witcarb-R			4		20		COLOR Green SHEEN Glo
H-333			1		5		NCH VOL. FLASH PT.
CH-189			1/2		2-1/2		MATCH FOR Y-1254 Chip
V-872	3-1/2			35			REDUCER
V-357	4-1/4			42-1/2			AMT. FOR BRUSHING 1" B.
S-43	1/8			1-1/4			SPRAYING FLUHLING
S-90	1/8			1-1/4			DIPPING DRIP TIME
D-29		2 liq oz/gal		1-1/4			BAKE TEMP.
D-75		2 " " "		1-1/4			AIR DRIES IN 4-6 hrs
CH-243		1/8" " " "		10 liq oz			A. D. TO RECOAT IN 24 hrs
RL-8721		1/8" " " "		10 liq oz			REMARKS:
To be used when W-140 is not available							Standard Formula. Not to be taken from File.
YIELD							
							FORMULATOR H G H

26-4

GLD059633

Goods Japanese Empire Green Enamel

Formula No. V-1254-B

Consistency	Liquid
-------------	--------

Laboratory No.

For use on

Cost Class.

Date 6/2/49

Customer

Strainer

Grind 7-A

Mini Pebble

Wt. or Beg-1/2#

[illegible]

GLD059635

Cost	Date	Analysis	Customers
		Pigment 24.1 %	Y 125113
		Vehicle 75.9 %	17.54
			17.54
		Pigment	17.54
		C.P. Chrome Green 69.2 %	17.54
		Basic Lead Carbonate 20.5	17.54
		Calcium Carbonate 10.3	17.54
		100.0 %	17.54
		Vehicle	
		* Varnish 94.6 %	
		Mineral Spirits 2.5	
		Liquid Drier 2.9	
		100.0 %	
		* Non Vol 54.6%	
		Y 1254	154

GLD059636

Formula No. Y-1254-B

Laboratory No.

For use on

Cost Class.

Date 6/2/49

Customer

Strainer

Grind 7-8

Mill Pebble

Wt. or De 9-1/2#

Code	One Gallon Batch			Large Batch		Is agitator required
Number	Pints	Lbs.	Ozs.	Gals.	Lbs.	Wt. 9-1/2# Temp.
G-3			5		25	Viscosity 80"-90" Temp.
G-48		1	6		110	Viscosimeter #4 Cup
W-104			8		40	Color Green Sheen
W-140			4		20	Non Vol. Flash Pt. 100-F
M-333			1		5	Match for Y-1254 Chip
CH-185			1/2		2-1/2	
V-U72	3-1/2			35		Reducer
V-357	4-1/4			42-1/2		Amt. for brushing F.B.
S-43	1/8			1-1/4		Spraying Tumbling
S-90	1/8			1-1/4		Dipping Drip time
D-29		2 Loz/gal		1-1/4		Bake Temp.
D-75		2 " " "		1-1/4		Air dries in 4-6 hrs
CH-245-769		1/8 " " "		10 oz liq		A. D. to recoat in 24 hrs
RL-87-1		1/8 " " "		10 " "		Remarks:
Standard Formula	Changed to new quality using V-U72.					
Active						
Discontinued	Analysis changed					
See						Formulator
Yield						

GLD059637

FORMULA RECORD

Goods *Empire Cream Popcorn Caramel*
 Consistency *Liquid*
 For Use on *B*

Formula No. *Temp Y125414*
 Date *2-13-48*
 Laboratory No.
 Cost Classification

Code Number	One Gallon Batch			Gallon Batch			Gallon Batch			Manufacturing Specifications
	Pints	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	
<i>A-3</i>			<i>5</i>							Grind <i>1-8</i>
<i>A-48</i>		<i>1</i>	<i>6</i>							Kind of Mill <i>Pebble</i>
<i>W-104</i>			<i>8</i>							Strainer
<i>W-140</i>			<i>4</i>							Weight per Gallon <i>9.27</i>
<i>W-333</i>			<i>1</i>							Light Baume Temp.
										Heavy Baume Temp.
										Viscosity <i>80-90"</i> Temp.
										Viscosimeter <i>#4 Cup</i>
										Flash Point
										Is Agitator Required
										Remarks <i>Reducer S-43</i>
<i>V-357</i>	<i>4 1/4</i>									<i>Antifor brushing as needed</i>
<i>S-43</i>	<i>9 1/16</i>									<i>Air dressing - 4-6 Bars</i>
<i>D-44</i>			<i>2 1/2</i>							<i>A.D. to recast in concrete</i>
<i>H-29</i>			<i>2 1/2</i>							<i>Match for Plaster Chip</i>
										<i>H.G.H.</i>
Field	<i>Formula to be used until V-858 is available</i>									

DISCONTINUED

SEE *Y125413**6-2-49*

Standard Formula.

Not to be taken

from file.

GLD059639

FORMULA RECORD

Goods *Alcohol Denat. 95% Conc. 100% Grain*
 Consistency *Free*
 For Use on *Alcohol*

Formula No. *Y 1254*
 Laboratory No.
 Cost Classification

Code Number	One Gallon Batch			Gallon Batch			Gallon Batch			Manufacturing Spec
	Pints	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	
<i>W-10</i>										Grind
<i>W-11</i>										Kind of Mill
<i>W-12</i>										Strainer
<i>W-13</i>										Weight per Gallon
<i>W-14</i>										Light Baume Temp.
<i>W-15</i>										Heavy Baume Temp.
<i>W-16</i>										Viscosity Temp.
<i>W-17</i>										Viscosimeter
<i>W-18</i>										Flash Point
<i>W-19</i>										Is Agitator Required
<i>W-20</i>										Remarks
<i>W-21</i>										
<i>W-22</i>										
<i>W-23</i>										
<i>W-24</i>										
<i>W-25</i>										
<i>W-26</i>										
<i>W-27</i>										
<i>W-28</i>										
<i>W-29</i>										
<i>W-30</i>										
<i>W-31</i>										
<i>W-32</i>										
<i>W-33</i>										
<i>W-34</i>										
<i>W-35</i>										
<i>W-36</i>										
<i>W-37</i>										
<i>W-38</i>										
<i>W-39</i>										
<i>W-40</i>										
<i>W-41</i>										
<i>W-42</i>										
<i>W-43</i>										
<i>W-44</i>										
<i>W-45</i>										
<i>W-46</i>										
<i>W-47</i>										
<i>W-48</i>										
<i>W-49</i>										
<i>W-50</i>										
<i>W-51</i>										
<i>W-52</i>										
<i>W-53</i>										
<i>W-54</i>										
<i>W-55</i>										
<i>W-56</i>										
<i>W-57</i>										
<i>W-58</i>										
<i>W-59</i>										
<i>W-60</i>										
<i>W-61</i>										
<i>W-62</i>										
<i>W-63</i>										
<i>W-64</i>										
<i>W-65</i>										
<i>W-66</i>										
<i>W-67</i>										
<i>W-68</i>										
<i>W-69</i>										
<i>W-70</i>										
<i>W-71</i>										
<i>W-72</i>										
<i>W-73</i>										
<i>W-74</i>										
<i>W-75</i>										
<i>W-76</i>										
<i>W-77</i>										
<i>W-78</i>										
<i>W-79</i>										
<i>W-80</i>										
<i>W-81</i>										
<i>W-82</i>										
<i>W-83</i>										
<i>W-84</i>										
<i>W-85</i>										
<i>W-86</i>										
<i>W-87</i>										
<i>W-88</i>										
<i>W-89</i>										
<i>W-90</i>										
<i>W-91</i>										
<i>W-92</i>										
<i>W-93</i>										
<i>W-94</i>										
<i>W-95</i>										
<i>W-96</i>										
<i>W-97</i>										
<i>W-98</i>										
<i>W-99</i>										
<i>W-100</i>										

Standard Formula
 Not to be taken
 from File.

Standard Formula
 2-13-48
 Y 1254-A

GLD059641

Characteristics and Method of Using		Cost Data				Customers
Type of Goods						
Color						
Order						
Match for						
Kind of Reducer						
Amount of Reduction for						
Brushing						
Spraying	Pressure					
Dipping	Drip Time					
Flooding	Drip Time					
Tumbling						
Air dry to recoat						
To Sand or Rub						
Bake Time	Temp.					
Rub with						
Polish with						
Schedule						
		Analysis				
		Pigment			24.3%	
		Vehicle			75.7%	
					00.0%	
		Pigment				
		C.P. Chrome Green			67.2%	
		Zinc Carbonate white Lead			20.5%	
		Calcium Carbonate			10.3%	
					00.0%	
		Vehicle				
		* Varnish			86.9%	* New York State
		Bodied Linseed Oil			6.6%	
		Mineral Spirits			2.7%	
		Liquid Primer			3.8%	
					00.0%	

All plants 10-16-45

GLD059644

[illegible]

FORM NO. I-1254-F

LABORATORY, INC.

COST: 1125.

DATE 3-2-58

STRAPILE

CHINE 7-2

Bill Pebble

WT. 66.13 12.3

[illegible]

GLD059645

