

ACME, TEXAS PLANT FORMULA

ALL PURPOSE JOINT CEMENT NO. TEX-951

NAME OF MATERIAL

All purpose joint cement for embedding and covering joint tape, for spotting nailheads and for texturing.

<u>FORMULA</u>	<u>Batch</u>	<u>Percent</u>	<u>Ton</u>
Casein No. TEX-991	27.50 lbs.	5.500	110.00 lbs.
Pre-gelatinized starch	10.00 "	2.000	40.00 "
Soda Ash	2.50 "	0.500	10.00 "
Zinc Oxide	1.00 "	0.200	4.00 "
Yellow Oxide	0.25 "	0.050	1.00 "
Santobrite	1.00 "	0.200	4.00 "
Asbestos Floats	25.00 "	5.000	100.00 "
Fine Ground Mica	70.00 "	14.000	280.00 "
-/ Limestone	<u>362.75</u> "	<u>72.550</u>	<u>1451.00</u> "
	500.00 lbs.	100.000%	2000.00 lbs.

WORKING CONSISTENCY

Maximum

Minimum

Average

70

66

66

-/ CRACKING

Each time a new batch of casein is prepared, a cracking test is to be made on one of the first batches of Joint System using this casein. The test is made by first laying a 1/4" diameter metal rod on a 6" x 8" piece of wallboard. The cement at the proper consistency is then placed along one side of the rod. A 3" to 4" wide wedge is then troweled on to the board with a broad knife using the rod on one side and the face of the board on the other side as screeding edges. The formed wedge is then placed in front of a fan with the thin edge facing the fan. The speed of the fan and distance from the sample are regulated so that there is an air movement of 350 to 450 feet per minute across the sample. After two hours the sample shall be examined. There shall be no large fissure cracks in the wedge.

NOTE: This is a low cost all purpose joint system texture which utilizes Pre-Gelatinized starch in place of some of the casein and all of the keltose. It should be tested for bond, application as a topping compound, and stippling as a texture.

ALKALINITY

After the cement has been mixed and stood for 30 minutes, test for alkalinity with the Beckman pH meter. The pH meter shall be standardized at intervals to insure consistently accurate readings. The pH limits for Formula No. TEX-951 are 7.8 to 8.5.

-/ Denotes change in this re-issue.

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June 23, 1965
Supersedes Formula No. TEX-951
Dated 6/8/65

ACME, TEXAS PLANT FORMULA

ALL PURPOSE COMPOUND TEX-951 SPECIAL FOR DALLAS MARKET

DESCRIPTION OF PRODUCT - All Purpose Compound for taping, topping joints, spotting nailheads and texturing; shipped into Dallas market.

FORMULA

<u>Raw Material</u>	<u>Source</u>	<u>R. M. Spec.</u>	<u>%</u>	<u>Lbs./Batch</u>
Sterox CD	Monsanto Chemical Co.		0.025	0.5
Vancide 512	R. T. Vanderbilt	126	0.075	1.5
Natrosol 250 HXR (Fine Grind)	Hercules Powder	170	0.25	5.0
Zinc Oxide	Mallinkrodt Co.	119	0.10	2.0
Soda Ash	Open Market	32	0.40	8.0
Borax	Open Market		0.15	3.0
Casein 100M	International Casein Co.	10	4.50	90.0
Asbestos 7RF1		9	6.50	130.0
Mica P80H	Western Mica Co.	11	16.0	320.0
Limestone (Pure- stone)	Purestone Co.	13	72.0	1440.0
			100.00	2000.0

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.
Specifications: Maximum Minimum Average
 72 64 68

ALKALINITY - Refer to Plant Testing Procedure No. 34.
pH Specifications: Maximum Minimum Average
 9.2 8.6 8.9

Minimum soda ash content - 0.40%

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications: Wet mix shall be plastic and buttery working and free of grit or coarse particles.

CRACK RESISTANCE -
Specifications: There shall be at most, only a couple of very small cracks in the wedge.

COLOR -
Specifications: Dried compound should be a neutral color and match the standard sample.

-/ Denotes change in this re-issue.

JDR:se

SGP 0017127

June 25, 1965
Supersedes Formula No. TEX-951
Dated 6/23/65

ACME, TEXAS PLANT FORMULA

ALL PURPOSE COMPOUND TEX-951 SPECIAL FOR DALLAS MARKET

DESCRIPTION OF PRODUCT - All Purpose Compound for taping, topping joints, spotting nailheads and texturing; shipped into Dallas market.

FORMULA

<u>Raw Material</u>	<u>Source</u>	<u>R. M. Spec.</u>	<u>%</u>	<u>Lbs./Batch</u>
Sterox CD	Monsanto Chemical Co.		0.025	0.5
Vancide 51Z	R. T. Vanderbilt	126	0.075	1.5
Natrosol 250 HXR (Fine Grind)	Hercules Powder	170	0.25	5.0
Zinc Oxide	Mallinkrodt Co.	119	0.10	2.0
Soda Ash	Open Market	32	0.40	8.0
Borax	Open Market		0.15	3.0
Casein 100M	International Casein Co.	10	4.50	90.0
-/ Asbestos 7RF10	Phillip Carey	9	6.50	130.0
Mica P80H	Western Mica Co.	11	16.0	320.0
Limestone (Pure- stone)	Purestone Co.	13	72.0 100.00	1440.0 2000.0

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.
Specifications: Maximum Minimum Average
 72 64 68

ALKALINITY - Refer to Plant Testing Procedure No. 34.
pH Specifications: Maximum Minimum Average
 9.2 8.6 8.9

Minimum soda ash content - 0.40%

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications: Wet mix shall be plastic and buttery working and free of grit or coarse particles.

CRACK RESISTANCE -
Specifications: There shall be at most, only a couple of very small cracks in the wedge.

COLOR -
Specifications: Dried compound should be a neutral color and match the standard sample.

-/ Denotes change in this re-issue.

JDR:ss

SGP 0017128

September 20, 1977

Formula TEX-951

NEW

ACME, TEXAS, PLANT FORMULA
ALL PURPOSE JOINT COMPOUND FORMULA NO. TEX-951

DESCRIPTION OF PRODUCT - All Purpose compound for taping and finishing joints, spotting nailheads and texturing. For selected market trials and shipment to Memphis only.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Soda Ash	Viscosity stabilizer		.50	40.0
Gendriv 492-S	Thickener	223	.40	32.0
Vanicide 51Z	Fungicide	126	.05	4.0
Gelvato1 6000	Adhesive	126	1.65	132.0
Attagel 40	Fiber Filler	9	8.13	650.4
Mica p80-H	Anti-cracking agent	11	7.50	600.0
Defoamer M-111	Anti-foaming agent	--	.10	8.0
Land Plaster TEX-25	Filler	--	81.17	6493.6
Alto-White		--	.50	40.0
			100.00	8000.0

WORKING CONSISTENCY
Specifications

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
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70

66

68

WORKING PROPERTIES
Specifications

- Refer to Plant Testing Procedure No. 33.
Wet mix shall be plastic and buttery working and free of grit or coarse particles.

BONDING PROPERTIES
Specifications

- Refer to Plant Testing Procedure No. 35.
After compound has dried, tape shall delaminate when peeled back.

CRACK RESISTANCE
Specifications

- There shall be at most only a couple of very small cracks in the wedge.

COLOR
Specifications

- White or yellow*
Dried compound shall not vary in color from preceding batches.

*For yellow compound, add 8 lbs. of yellow oxide per batch.

HCF:jg

SGP 0017129

**ACME FORMULA #951
ASBESTOS CONTAINING PRODUCTS**

SGP 0017125