June 21, 1973
Supersedes Formula V-977
Dated 1/23/73

MILFORD, VIRGINIA PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE TOOLS)

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

FORMULA -

Raw Material	Function	RM Spec	Percent	Lbs/Batch
Water	Solvent	-		1140(136Gals
PVA Emulsion	Adhesive	185	7.40	148.0
NALCO	Antifoaming Agent	125	.10	2.00
Asbestos 7RF09	Bulking Agent	9	3.92	78.00
Dowicil 100	Bactericide	193	.14	3.0
PV Alcohol	Adhesive	162	.74	15.0
*Thickner	Thickner	170or223	.69	14.0
Mica	Anticracking Agent	11	6.46	129.0
Asbestos SG-210	Bulking Agent	18	1.62	32.0
Limestone	Filler	13	78.70	1575.0
Calgon T	Slip Agent	229	.23	4.0
			100.00	3140.0

*Natrosol 250 HXR or Gendriv 4925
*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary ± 4 gallons per batch.

**One batch yields 50 + 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.
Specifications for Paste: If paste is not proper working consistency, a maximum of 5 cc. water per 150 grams of paste may be added to adjust.

Brabender: 385 ± 20

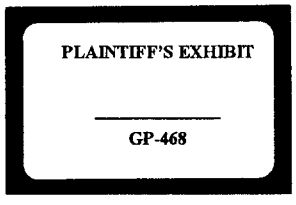
WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications Compound shall be plastic, buttery working, and free of any coarse, gritty, or undispersed particles. Material shall be free from lumps due to incomplete mixing.

BONDING PROPERTIES - Refer to Plant Testing Procedure No. 35.
Specifications After compound has dried, tape shall show at least 75% fiber tear when delaminated.

CRACK RESISTANCE - Refer to Plant Testing Procedure No. 37.
Specifications 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.

EDO:jg



July 12, 1973
Supersedes Formula V-977
Dated 6/21/73

MILFORD, VIRGINIA PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE TOOLS)

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

FORMULA -

Raw Material	Function	RM Spec	Percent	Lbs/Batch
Water	Solvent	-		1140(136Gals
PVA Emulsion	Adhesive	185	7.40	148.0
NALCO	Antifoaming Agent	125	.10	2.00
Asbestos 7RF09	Bulking Agent	9	3.92	78.00
Dowicil 100	Bactericide	193	.19	4.0
PV Alcohol	Adhesive	162	.74	15.0
*Thickner	Thickner	170or223	.69	14.0
Mica	Anticracking Agent	11	6.46	129.0
Asbestos SG-210	Bulking Agent	18	1.62	32.0
Limestone	Filler	13	78.65	1574.0
Calgon T	Slip Agent	229	.23	4.0
			100.00	3140.0

*Natrosol 250 HXR or Gendriv 4925
*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary ± 4 gallons per batch.

**One batch yields 50 + 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.
Specifications for Paste: If paste is not proper working consistency, a maximum of 5 cc. water per 150 grams of paste may be added to adjust.

Brabender: 385 ± 20

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications 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 - Refer to Plant Testing Procedure No. 35.
Specifications After compound has dried, tape shall show at least 75% fiber tear when delaminated.

CRACK RESISTANCE - Refer to Plant Testing Procedure No. 37.
Specifications 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.

EDO:jg

October 17, 1977
Supersedes Formula V-977
Dated 7/12/73

MILFORD, VIRGINIA, PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE TOOLS)

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

FORMULA

Raw Material	Function	RM Spec	Percent	[illegible]
Water	Solvent			[illegible]36gal
PVA Emulsion	Adhesive	185	7.40	[illegible]
NALCO	Antifoaming Agent	125	[illegible]	[illegible]
Asbestos 7RF09	Bulking Agent	9	3.92	[illegible]
-/ Troysan Cmp-10-Sep	Bactericide	193	.10	[illegible]
PV Alcohol	Adhesive	162	.7[illegible]	[illegible]
*Thickner	Thickner	170or223	.69	[illegible]
Mica	Anticracking Agent	11	6.46	[illegible]
Asbestos SG-210	Bulking Agent	18	1.62	[illegible]
-/ Limestone	Filler	13	78.97	[illegible]
			100.00	3140.0

*Natrosol 250 HXR or Gendriv 4925
*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary ± 4 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. 3[illegible]. If paste is not proper working consistency, a maximum of 5 cc. water per 150 grams of paste may be added to adjust.

Brabender: 385 ± 20

WORKING PROPERTIES
Specifications - Refer to Plant Testing Procedure No. [illegible]. Compound shall be plastic, buttery working, and free of any coarse, gritty, or well [illegible]rsed particles. Material shall be free from lumps due to incomplete mixing.

BONDING PROPERTIES
Specifications - Refer to Plant Testing Procedure No. [illegible]. After compound has dried, tape shall show at least 75% fiber tear when delaminated.

CRACK RESISTANCE
Specifications - Refer to Plant Testing Procedure No. [illegible]. There shall be no large fissure cracks in the Wedge, and no cracks in the thinner half of the wedge.

COLOR
Specifications - White
Dried compound shall match color of standard sample.

WNG:jg

SGP 0018146

October 18, 1973
Supersedes Formula V-977
Dated 10/17/73

MILFORD, VIRGINIA, PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE TOOLS)

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

FORMULA

Raw Material	Function	RM Spec	Percent	Lbs/Batch
-/ **Water	Solvent	-		1140(136gals
PVA Emulsion	Adhesive	185	7.40	148.0
NALCO	Antifoaming Agent	125	.10	2.0
Asbestos 7RF09	Bulking Agent	9	3.92	78.0
Troysan Cmp-10-Sep	Bactericide	193	.10	2.0
PV Alcohol	Adhesive	162	.74	15.0
*Thickner	Thickner	170or223	.69	14.0
Mica	Anticracking Agent	11	6.46	129.0
Asbestos SG-210	Bulking Agent	18	1.62	32.0
Limestone	Filler	13	78.97	1580.0
			100.00	3140.0 ***

*Natrosol 250 HXR or Gendriv 4925

**Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary ± 4 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: 385 ± 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 75% 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 Specifications - White
Dried compound shall match color of standard sample.

WNG:jg

January 15, 1974
Supersedes Formula V-977
Dated 10/18/73

MILFORD, VIRGINIA, PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE TOOLS)

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

FORMULA

Raw Material	Function	RM Spec	Percent	Lbs/Batch
-/ **Water	Solvent	-		1140(136gal
PVA Emulsion	Adhesive	185	7.40	148.0
NALCO	Antifoaming Agent	125	.10	2.0
Asbestos 7RF09	Bulking Agent	9	3.92	78.0
Troysan Cmp-10-Sep	Bactericide	193	.10	2.0
PV Alcohol	Adhesive	162	.74	15.0
Natrosol 250 HXR	Thickner	170	.69	14.0
Mica	Anticracking Agent	11	6.46	129.0
Asbestos SG-210	Bulking Agent	18	1.62	32.0
Limestone	Filler	13	78.74	1576.0
Calgon T	Dispersant	229	.23	4.0
			100.00	3140.0***

**Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary ± 4 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 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 75% 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 Specifications - White
Dried compound shall match color of standard sample.

February 22, 1974
Supersedes Formula V-977
Dated 1/15/74

MILFORD, VIRGINIA, PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE TOOLS)

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

-/ FORMULA

Raw Material	Function	RM Spec	Percent	Lbs/Batch
**Water	Solvent	-		1140(136gal
PVA Emulsion	Adhesive	185	7.00	140.0
NALCO	Antifoaming Agent	125	.10	2.0
Asbestos 7RF09	Bulking Agent	9	3.92	78.0
Troysan Cmp-10-Sep	Bactericide	193	.10	2.0
PV Alcohol	Adhesive	162	.75	15.0
Natrosol 250 HXR	Thickner	170	.70	14.0
Mica	Anticracking Agent	11	8.79	175.0
Asbestos SG-210	Bulking Agent	18	1.25	25.0
Limestone	Filler	13	77.19	1537.0
Calgon T	Dispersant	229	.20	4.0
			100.00	3132.0***

** Approximately 56.5 lbs/100 lbs. of actove ingredients (this may vary ± 4 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: 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 imcomplete mixing.

BONDING PROPERTIES Specifications - Refer to Plant Testing Procedure No. 35. After compound has dried, tape shall show at least 75% 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 Specifications - White
Dried compound shall match color of standard sample.

March 6, 1974
Supersedes Formula V-977
Dated 2/22/74

MILFORD, VIRGINIA, PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE TOOLS)

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

FORMULA

Raw Material	Function	RM Spec	Percent	Lbs/Batch
**Water	Solvent	-		1140(136gal
PVA Emulsion	Adhesive	185	7.00	140.0
NALCO	Antifoaming Agent	125	.10	2.0
Asbestos 7RF09	Bulking Agent	9	3.92	78.0
Troysan Cmp-10-Sep	Bactericide	193	.10	2.0
PV Alcohol	Adhesive	162	.75	15.0
Natrosol 250 HXR	Thickner	170	.70	14.0
Mica	Anticracking Agent	11	8.79	175.0
Asbestos SG-210	Bulking Agent	18	1.25	25.0
Limestone	Filler	13	77.19	1537.0
Calgon T	Dispersant	229	.20	4.0
			100.00	3132.0***

** Approximately 56.5 lbs/100 lbs. of actove ingredients (this may vary ± 4 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: 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 imcomplete 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 Specifications - White
Dried compound shall match color of standard sample.

May 20, 1974
Supersedes Formula V-977
Dated 3/6/74

MILFORD, VIRGINIA, PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE TOOLS)

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

-/ FORMULA

Raw Material	Function	RM Spec	Percent	Lbs/Batch
**Water	Solvent	-		1140(136gal
PVA Emulsion	Adhesive	185	7.00	140.0
NALCO	Antifoaming Agent	125	.10	2.0
Asbestos 7RF09	Bulking Agent	9	3.92	78.0
Troysan Cmp-10-Sep	Bactericide	193	.10	2.0
PV Alcohol	Adhesive	162	.375	7.5
Natrosol 250 HXR	Thickner	170	.70	14.0
Mica	Anticracking Agent	11	8.79	175.0
Asbestos SG-210	Bulking Agent	18	1.25	25.0
Limestone	Filler	13	77.565	1544.9
Calgon T	Dispersant	229	.20	4.0
			100.00	3132.0***

** Approximately 56.5 lbs/100 lbs. of actove ingredients (this may vary ± 4 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: 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 imcomplete 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 Specifications - White
Dried compound shall match color of standard sample.

WNG: jg

-/ denotes change

December 21, 1978
Formula TEX-978
NEW

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-978

DESCRIPTION: White Ready Mix Joint Compound used for taping, topping and texturing. To be used in 4 gallon cartons and 5 gallon pails.

Note: This formula is to be shipped to Phoenix or other approved markets only.

FORMULA

Raw Material	Function	RM Spec	Percent	Lbs/Batch
Water	Solvent			1120.0(135)
DuPont JCM	Adhesive	185	5.547	115.0(13 gal.)
Nalco 71D-5	Defoamer	125	.096	2.0
PMA-30	Preservative	193	.111	2.3
Filler TEX-975	Filler		94.053	1950.0
Acrysol ASE 60	Thickener	147	.193	4.0
			100.000	3193.3

Yield: One batch yields 64 ± 1 four gallon carton or 51 ± 1 five gallon pail at 50 lbs. per carton and 62 lbs. per pail.

SPECIAL MIXING INSTRUCTIONS: Blend ingredients in the following order.

1) Water
2) Adhesive
3) Nalco
4) Preservative
5) Filler
6) Mix 10 minutes
7) Acrysol ASE 60
8) Mix 2 minutes

WORKING CONSISTENCY: Plant Testing Procedure No. 32.

Brabender: As manufactured - 420
After 3 months - Maximum of 700

pH: Minimum - 9.0 Maximum - 9.5

WORKING PROPERTIES: Refer to Plant Texting 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.

Continued on page 2.....

BONDING PROPERTIES:	Plant Testing Procedure No. 35. When dried, tape shall show at least 90% fiber when delaminated.
CRACK RESISTANCE:	Plant Testing Procedure No. 37. Rating shall be 4 or better.
COLOR:	White Dried compounds shall match color of standard sample.
BACTERIA GROWTH:	Plant Testing Procedure No. 119. 48 hours: Maximum of 6 colonies 3 months: Maximum of 20 colonies

GWG:jr

April 9, 1979
Supersedes Formula TEX 978
Dated December 21, 1978

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-978

DESCRIPTION: White Ready Mix Joint Compound used for taping, topping and texturing. To be used in 4 gallon cartons and 5 gallon pails.

FORMULA

Raw Material	Function	RM Spec	Percent	Lbs/Batch
Water	Solvent			1120.0(135)
DuPont JCM	Adhesive	185	5.547	115.0(13 gal.)
Nalco 71D-5	Defoamer	125	.096	2.0
PMA-30	Preservative	193	.111	2.3
Filler TEX-975	Filler		94.053	1950.0
Acrysol ASE 60	Thickener	147	.193	4.0
			100.000	3193.3

Yield: One batch yields 64 ± 1 four gallon carton or 51 ± 1 five gallon pail at 50 lbs. per carton and 62 lbs. per pail.

SPECIAL MIXING INSTRUCTIONS: Blend ingredients in the following order.

1) Water
2) Adhesive
3) Nalco
4) Preservative
5) Filler
6) Mix as required
7) Acrysol ASE 60
8) Mix 2 minutes

WORKING CONSISTENCY: Plant Testing Procedure No. 32.

Brabender: As manufactured - 600 ± 20 at 75°F
After 3 months - Maximum of 730 at 75°F

pH Minimum - 9.0 Maximum - 9.5

WORKING PROPERTIES: Refer to Plant Texting 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.

Continued on page 2.....

BONDING PROPERTIES:	Plant Testing Procedure No. 35. When dried, tape shall show at least 90% fiber when delaminated.
CRACK RESISTANCE:	Plant Testing Procedure No. 37. Rating shall be 4 or better.
COLOR:	White Dried compounds shall match color of standard sample.
BACTERIA GROWTH:	Plant Testing Procedure No. 119. Current Production: Maximum of 6 colonies in 48 hrs. Retain 3 months: Maximum of 20 colonies in 48 hrs.

HCF:ps

October 29, 1968
NEW FORMULA

ACME, TEXAS PLANT FORMULA

READY MIX JOINT COMPOUND TEX-978 (MACHINE TOOLS) (READY MIX "X")

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for taping, covering tape, filling cornerbead and spotting nails.

FORMULA

Raw Material	Function	R.M. Spec.	Percent	Lbs./Batch
Water	Solvent	-	-	433.0 (52 gal.)*
Filler TEX-970	Body	-	91.44	700.0
UCAR WC-130	Adhesive	185	8.04	58.3
Benzoflex 50	Plasticizer	183	0.52	4.0
			100.00	1195.3**

*Approximately 56.5 lbs./100 lbs. of active ingredients (this may vary ± 2 gallons per batch).

**One batch yields 18 (±) - 5 gallon pails of Ready Mix Joint Compound at 65.6 lbs./pail.

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.
Specifications for Paste: If paste is not proper working consistency, a maximum of 5 cc water per 150 grams of paste may be added to adjust.

Brabender - 385 ± ~~20~~ 15

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications: Compound shall be plastic, buttery working, and free of any coarse, gritty or undispersed particles. Material should be free of lumps due to incomplete mixing.

BONDING PROPERTIES - Refer to Plant Testing Procedure No. 35.
Specifications: After compound has dried, tape shall show at least 75% fiber tear when delaminated.

CRACK RESISTANCE - Refer to Plant Testing Procedure No. 37.
Specifications: 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.

July 6, 1972
TEX-978
NEW FORMULA

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX-978 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound TEX-977 and TEX-979.

FORMULA

Raw Material	Function	R.M. Spec	Percent	Lbs/Batch
Dowicil 100	Fungicide 20-30	193	.15	12.00
Polyvinyl Alcohol	Adhesive Gelvatol	162	.60	48.00
Methocel 228	Water retention aid	170	.75	60.00
Mica	Anti-cracking agent	11	7.00	560.00
Asbestos (SG-210)	Bulking agent	-	3.75	300.00
Land Plaster	Filler	13	87.75	7020.00
			100.00	8000.00

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.
Specifications - Maximum Minimum Average

Maximum	Minimum	Average
62	58	60

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications - Filler shall be very heavily bodied and posses fair plasticity. It shall be free of any coarse, gritty or undispersed particles.

COLOR - White
Specifications - Dried compound shall match color of standard sample.

NOTE: A wet mix of the filler shall be prepared according to Formula No. TEX-979 at least twice a day or with every 6th or 7th batch of filler manufactured. This prepared mix shall be tested and shall meet all the specifications required of Ready Mix Joint Compound - Formula No. TEX-979.

EDO:elz

Gelvatol 33.82 lbs per cu ft
mica 12.54
Gypsum 31.73 - loose
49.78 - packed
7RF9 asbestos 20.14 - packed
" " 10.6 - loose
SG-210 asbestos 5.3 - loose
Ready mix filler 40.5 - loose 7-10-72

SGP 0018157

1-24-72 gypsum taken out of hopper spout weighted 45#

August 22, 1973
Formula TEX-978
NEW

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND: NO. TEX- 978 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for taping, covering tape, filling corner beads and spotting nailheads. To be used in 4-gallon cartons and 5-gallon pails. To be supplied to Houston only.

FORMULA

Raw Material	Function	RM Spec	Percent	Lbs/Batch
Nalco 71-D5	Anti-foaming agent		0.1	2.0
Water	Solvent		-	972.0 (117 gal
Filler TEX-977			99.9	1800.0
			100.00	2774.0

**One batch yields 60± one 4-gallon carton or 45 ± one 5-gallon pail.

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.
Specifications - If paste is not of proper working consistency, a maximum of 5 cc of water per 150 grams of paste may be added to adjust.

Brabender Viscosity - ~~520~~ 490 ± 20

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications - Compound shall be plastic, buttery working, and free of any coarse, gritty or undispersed particles. Materials should be free of lumps caused by incomplete mixing.

BONDING PROPERTIES - Refer to Plant Testing Procedure No. 35
Specifications - After compound has dried, tape shall show at least 75% fiber tear when delaminated.

CRACK RESISTANCE - 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.

WNG:elz

October 22, 1973
Supersedes Formula TEX-978
Dated 8/22/73

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND. NO. TEX- 978 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for taping, covering tape, filling corner beads and spotting nailheads. To be used in 4-gallon cartons and 5-gallon pails. To be supplied to Houston only.

FORMULA

	Raw Material	Function	RM Spec	Percent	Lbs/Batch
	Nalco 71-D5	Anti-foaming agent		0.1	2.0 160
	Water	Solvent		-	~~972.0~~ (~~117~~ gal)
-/	Filler TEX- 975			99.9	1800.0
				100.00	2774.0

1-9-74

**One batch yields 60± one 4-gallon carton or 45 ± one 5-gallon pail.

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.
Specifications - If paste is not of proper working consistency, a maximum of 5 cc of water per 150 grams of paste may be added to adjust.

Brabender Viscosity - ~~520~~ 490 ± 20

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications - Compound shall be plastic, buttery working, and free of any coarse, gritty or undispersed particles. Materials should be free of lumps caused by incomplete mixing.

BONDING PROPERTIES - Refer to Plant Testing Procedure No. 35
Specifications - After compound has dried, tape shall show at least 75% fiber tear when delaminated.

CRACK RESISTANCE - 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.

WNG:elz

-/ denotes change

SGP 0018159

ACME FORMULA #978
ASBESTOS CONTAINING PRODUCTS

SGP 0018143