KAISER CEMENT & GYPSUM CORPORATION

INTER-OFFICE MEMORANDUM

TO G. J. Chavalas
J. I. Walker

DATE April 8, 1975

COPIES TO

FROM I. M. Watson

Gypsum Product Changes

SUBJECT ASBESTOS REPLACEMENT IN ACCESSORIES - W.O. #696-314

Work on the above work order has proceeded to the point where the following three products have been lab tested, field tested and appropriate operating bulletin revisions issued to the plants.

1. Non-Asbestos K-Spray Ceiling Texture - Santa Ana Plant
2. Non-Asbestos Cover-Tex Wall Texture - Santa Ana Plant
3. Non-Asbestos Topping Compound - Seattle Plant

Please note that the revisions to the operating bulletins for the above products have been signed up through Ernie Schaper and issued to the respective plants. Please advise all the necessary people of this change so there will be no surprises.

The above-noted changes for reformulating the products on a non-asbestos basis will result in the following cost savings estimated by accounting department:

Bulletin Number	Item	$ Savings
J-5507	K-Spray Ceiling Texture	$7.53 per ton
J-5307	Cover-Tex Wall Texture	2.96 per ton
J-6803	Topping Compound	5.00 per ton

Please note on topping compound there is an additional cost saving of $17.00 per ton for change from limestone to raw gypsum. Copies of the product bulletins are attached.

Attachments

K ypsum Corp.
APR 10 1975
J. I. WALKER

FORM 150

KG-0084

DRYWALL ACCESSORY PRODUCTS	K-SPRAY CEILING TEXTURE (NON-ASBESTOS)	BULLETIN NO: J-5507 DATE: 3/13/75 PAGE: 1 of 1	
APPROVALS:	PRODUCING PLANT: SANTA ANA	CANCELS: J-5507 DATE: 10/9/74	

BULLETIN	DESCRIPTION	%	POUNDS	GALLONS
442	Talc	27.57	550	
165	Raw Gypsum	35.08	700	
446	Titanium Pigment	2.51	50	
056	Wyogel Clay	2.51	50	
301	Paper Dust	2.00	40	
187	Clay Hydrite MP	15.03	300	
441	Clay Sno Cal 50	10.02	200	
154	Bone Glue	0.50	10	
084	Casein	1.00	20	
102	Di Ammonium Phosphate	0.20	4	
026	Ammonium Penta Borate	0.25	5	
506	Zinc Oxide	0.05	1	
216	Hydrated Lime	0.05	1	
245	Thickener M/C 228	0.50	10	
074	Burnt Umber	0.01	2 ounces	
453	Preservative Dow 75	0.20	4	
324	Styrene Aggregate	2.51	50	
282	Odor Mask	0.01	2 ounces	
	TOTAL	100.00	1995.25	

MANUFACTURING INSTRUCTIONS:

1. See Process Bulletin No. J-4.
2. Dry blend for a minimum of 20 minutes.
3. Package 32 lbs. minimum per bag.

QUALITY CONTROL:

TM-1B	Viscosity, cc per 100 gm to give 5-5½" diameter patty	185 to 210 cc
TM-3A	Bond	Equal to Standard
TM-33	Density, lbs per cu. ft.	20 minimum

PRODUCT BULLETIN DRYWALL ACCESSORY PRODUCTS	COVER-TEX WALL TEXTURE NON-ASBESTOS	BULLETIN NO: J-5307 DATE: 4-3-75 PAGE: 1 of 2
APPROVALS:	PRODUCING PLANT: SANTA ANA	CANCELS: J-5307 DATE: 5/10/74

BULLETIN	DESCRIPTION	%	POUNDS	GALLONS
220	Limestone	42.41	1000	
442	Talcron 44-31	21.21	500	
247	Mica, Sericite "S"	12.72	300	
446	Titanium Pigment	2.12	50	
056	Wyojel Clay	4.24	100	
330	Polyvinyl Alcohol	0.64	15	
200	Keltose	0.25	6	
245	Methocel 228	0.25	6	
453	Preservative	0.13	3	
435	Dow XD-8655-1	3.18	75	
164	Glyoxal 80%	0.13	3	
489	Wollastonite	12.72	300	
	TOTAL	100.00	2358	

MANUFACTURING INSTRUCTIONS:

1. Mixing time shall be 8 minutes minimum and 12 minutes maximum
2. Blank out asbestos warning on sacks.

QUALITY CONTROL:

TM-1A	Viscosity, 100 gm cone @ 5 sec., 200 gm per 150 cc water	30 - 40 mm
TM-3A	Bond	Equal to Standard

Distributed 4/8/75

PRODUCT BULLETIN DRYWALL ACCESSORY PRODUCTS	COVER-TEX WALL TEXTURE NON-ASBESTOS	BULLETIN NO: J-5307 DATE: 4-3-75 PAGE: 2 of 2
APPROVALS:	PRODUCING PLANT: SANTA ANA	CANCELS: J-5307 DATE: 5-10-74

PRODUCT SPECIFICATIONS:

Test Method		
TM-1	Viscosity, 100 gm cone @ 5 sec. 200 bm to 150 cc water	30 to 40 mm
TM-1A	Viscosity (Brookfield, mixing water of 95 cc/100 gm), cps	
	a. 75°F after 30 minutes	20,000 - 30,000 cps
	b. 75°F after 20 hours	12,000 cps min.
	c. 100°F after 20 hours (with continuous agitation)	12,000 cps min.
TM-2	pH (Corning meter)	8.2 to 8.8
TM-2A	Indicator Paper	7.0 to 8.5
TM-3A	Bond @ 70°F	Equal to Standard
TM-13	Reflectance (%)	81 to 85
TM-17	Application	Equal to Standard
TM-18	Water Resistance (minutes)	5 minutes (min.)
TM-19	Settling (inches)	3/16" maximum
TM-20	Cracking	No cracks
TM-25	Normal Application Consistency, cc	90 - 100
TM-34	Hardness	20 minimum
TM-34	Wet Rub	8 minimum
TM-37	Resistance to Souring	No odor after 30 days
TM-39	Paintability Test	Equal to Standard

DRYWALL ACCESSORY PRODUCTS	PREMIX TOPPING COMPOUND (NON-ASBESTOS)	BULLETIN NO: J-6803 DATE: 3-10-75 PAGE: 1 of 2
APPROVALS: BBK JWP	PRODUCING PLANT: SEATTLE	CANCELS: J-6803 DATE: 4-8-74

BULLETIN	DESCRIPTION	%	POUNDS	GALLONS
165	Ground Raw Gypsum	58.79	3800	
489	Wollastonite	3.87	250	
442	Talc	1.55	100	
086	Celite 434	1.55	100	
052	Attagel 40	0.08	5	
245	Methocel 228	0.25	16	
330	Polyvinyl Alcohol	0.08	5	
453	Preservative - Dowicil 75	0.09	6	
470	PVAc Emulsion (4.41% on solids)	5.14	332	36
284	Oleic Acid	0.37	24	
450	Triethanolamine	0.19	12	
457	Nopco NXZ (defoamer)	0.19	12	
267	Odorless Mineral Spirits	0.77	50	8
	Water - start	24.45	1580	190
	Water - adjust to std. viscosity	2.63	170	20
	TOTAL	100.00	6462	

MANUFACTURING INSTRUCTIONS:

1. See Process Bulletin J-2.
2. Dry blend all powder materials 8 minutes.
3. For summer conditions add 8 gallons Ethylene glycol or Diethylene glycol per batch and increase Methocel to 20 lbs. per batch.

QUALITY CONTROL:

TM-1	Viscosity, Vicat, 150 gm cyl @ 5 sec.	20 - 23 mm
TM-1A	Viscosity, Brookfield, cps	230,000 - 270,000
TM-6	Application	No lumps
TM-7	Workability	Equal to Standard