Brabender Viscosity 480 ± 10. Viscosity can be adjusted by addition of water, reduction of mix water, or by addition of ASE-60 in small amounts. It is best to hold back a small amount of water to be added if the viscosity is too high. ASE-60 may be added to thicken the mix should too much water have been added. Should it be necessary to add ASE-60, the pH must again be checked since ASE-60 is acidic and its addition will lower pH. Remember, changes in the water content affect flow properties as well as the wet density.

WORKING CHARACTERISTICS: Shall extrude easily from tube and form a uniform bead that does not sag or run.

OPEN TIME - Refer to Plant Testing Procedure No. 114

WETTING CHARACTERISTICS: Refer to Plant Testing Procedure No. 115

TENSILE STRENGTH - Refer to Plant Testing Procedure No. 116

ALKALINITY - Refer to Plant Testing Procedure No. 34. Adjust with small quantities of AMP

Specifications:	Maximum	Minimum	Average
	8.0	7.7	7.9
DENSITY			
Specifications: -	10.75 lbs/gal	10.65 lbs/gal	10.7 lbs/gal

Case weight should be 35 lbs. ± 1 lb.

EDO:elz

Lehnert 10.3.01-82

PLAINTIFF'S EXHIBIT

GP-2284

SGP 0016181

A-802

February 11, 1972
Supersedes AK-501
Dated 1/27/72

AKRON, NEW YORK, PLANT FORMULA
DRYWALL ADHESIVE AK-501

DESCRIPTION: - Drywall stud adhesive. Provisional formula for salvaging formula AK-955.

FORMULA:

Raw Material	Function	RM Spec.	Percent	Lbs./Batch
Akron Stud Adhesive AK-955			54.9	2818.0 (102 cases of small tubes or 78½ cases large tubes)
Water	Solvent		1.6	82.0 (9.8 gals.)
Advawet 33	Wetting agent		1.0	51.0 (6.1 gals.)
Water	Solvent		6.0	308.0 (37 gals.)
Clay	Filler		9.0	462.0
Asbestos SG 210	Filler		0.8	41.0
Resin EB-12	Adhesive		8.2	421.0 (56 gals.)
Emulsion RA-315	Adhesive	217	5.2	267.0 (30 gals.)
Propasol	Filming Agent		1.1	56.0 (7.8 gals.)
Dibutyl Phthalate	Plasticizer		0.8	41.0 (4.7 gals.)
Water	Solvent		7.3	415.0 (50 gals.)
Acrysol ASE-60	Thickening agent		3.5	180.0 (21 gals.)
AMP 95	pH Buffer	225	0.6	31.0 (395 gals.)
			100.0	5133.0

YIELD - One batch yield 480 gals.

MIXING PROCEDURE - Extract AK-955 directly into mixer and proceed in the following order:

1) Add water followed by the Advawet 33.
2) Mix for five minutes.
3) Add the water (2nd addition) followed by the clay and asbestos.
4) Mix for a further 30 minutes.
5) Add the following ingredients allowing each ingredient to be thoroughly blended before addition of the next ingredient.

   Resin EB-12
   Emulsion RA-315
   Propasol
   Dibutyl phthalate

6) Add water and Acrysol ASE-60 (may be added simultaneously)
   AMP 95

VISCOSITY - Refer to Plant Testing Procedure No. 109.

Specifications: 120 to 300 Brabender unit

Lehnert 10.3.01-83

SGP 0016182

A-81

Brabender Viscosity — Viscosity can be adjusted by addition of water, reduction of mix water, or by addition of ASE-60 in small amounts. It is best to hold back a small amount of water to be added if the viscosity is too high. ASE-60 may be added to thicken the mix should too much water have been added. Should it be necessary to add ASE-60, the pH must again be checked since ASE-60 is acidic and its addition will lower pH. Remember, changes in the water content affect flow properties as well as the wet density.

WORKING CHARACTERISTICS: Shall extrude easily from tube and form a uniform bead that does not sag or run.

OPEN TIME - Refer to Plant Testing Procedure No. 114

WETTING CHARACTERISTICS: Refer to Plant Testing Procedure No. 115

TENSILE STRENGTH - Refer to Plant Testing Procedure No. 116

ALKALINITY - Refer to Plant Testing Procedure No. 34. Adjust with small quantities of AMP

Specifications:	Maximum	Minimum	Average
	9.0	7.7	8.3

DENSITY

Specifications:	Maximum	Minimum	Average
	11.20 lbs/gal	10.60 lbs/gal	10.9 lbs/gal

Case weight should be 35 lbs. ± 1 lb.

EDO:elz

Lehnert 10.3.01-84

February 18, 1972
Supersedes AK-501
Dated 2/11/72

AKRON, NEW YORK, PLANT FORMULA
DRYWALL ADHESIVE AK-501

DESCRIPTION: - Drywall stud adhesive. Provisional formula for salvaging formula AK-955.

FORMULA:

Raw Material	Function	RM Spec.	Percent	Lbs./Batch
Akron Stud Adhesive AK-955			54.9	2818.0 (102 cases of small tubes or 78½ cases large tubes)
Water	Solvent		1.6	82.0 (9.8 gals.)
Advawet 33	Wetting agent		1.0	51.0 (6.1 gals.)
Water	Solvent		6.0	308.0 (37 gals.)
Clay	Filler		9.0	462.0
Asbestos SG 210	Filler		0.8	41.0
Resin EB-12	Adhesive		8.2	421.0 (56 gals.)
Emulsion RA-315	Adhesive	217	5.2	267.0 (30 gals.)
Propasol	Filming Agent		1.1	56.0 (7.8 gals.)
Dibutyl Phthalate	Plasticizer		0.8	41.0 (4.7 gals.)
Water	Solvent		7.3	415.0 (50 gals.)
Acrysol ASE-60	Thickening agent		3.5	180.0 (21 gals.)
AMP 95	pH Buffer	225	0.6	31.0 (395 gals.)
			100.0	5173.00

YIELD - One batch yield 480 gals.

MIXING PROCEDURE - Extract AK-955 directly into mixer and proceed in the following order:

1) Add water followed by the Advawet 33.
2) Mix for five minutes.
3) Add the water (2nd addition) followed by the clay and asbestos.
4) Mix for a further 30 minutes.
5) Add the following ingredients allowing each ingredient to be thoroughly blended before addition of the next ingredient.

   Resin EB-12
   Emulsion RA-315
   Propasol
   Dibutyl phthalate

6) Add water and Acrysol ASE-60 (may be added simultaneously)
   AMP 95

VISCOSITY - Refer to Plant Testing Procedure No. 109.

Specifications: 120 to 300 Brabender unit

Lehnert 10.3.01-85

SGP 0016184

A-82

Brabender Viscosity — Viscosity can be adjusted by addition of water, reduction of mix water, or by addition of ASE-60 in small amounts. It is best to hold back a small amount of water to be added if the viscosity is too high. ASE-60 may be added to thicken the mix should too much water have been added. Should it be necessary to add ASE-60, the pH must again be checked since ASE-60 is acidic and its addition will lower pH. Remember, changes in the water content affect flow properties as well as the wet density.

WORKING CHARACTERISTICS: Shall extrude easily from tube and form a uniform bead that does not sag or run.

OPEN TIME - Refer to Plant Testing Procedure No. 114

WETTING CHARACTERISTICS: Refer to Plant Testing Procedure No. 115

TENSILE STRENGTH - Refer to Plant Testing Procedure No. 116

ALKALINITY - Refer to Plant Testing Procedure No. 34. Adjust with small quantities of AMP

Specifications:	Maximum	Minimum	Average
	9.0	7.7	8.3

DENSITY

Specifications:	Maximum	Minimum	Average
	11.20 lbs/gal	10.60 lbs/gal	10.9 lbs/gal

Case weight should be 35 lbs. ± 1 lb.

EDO:elz

Lehnert 10.3.01-86

SGP 0016185

A-82a