

SPECIAL BULLETIN

Operating Division
PRODUCT PROCEDURE

PERT-A-TAPE JOINT SYSTEM

No. 61-2-221
Date 10-29-45
Page 1 of 2

Sweetwater Area

Approved: *[Signature]*

Cancels
Dated NEW

DESCRIPTION

A single cement system using glue - stucco base cement for distribution to Dallas, Houston, and Sweetwater areas and part of Oklahoma City area.

MANUFACTURING PLANT - Gypsum

FORMULAS

	<u>JG61B</u>	<u>JG61C</u>
Armour's #2 C. W. Glue	--	6.0
Armour's #4 H. W. Glue	5.0	--
K B Paste	3.5	3.5
Sodium Pentachlorophenate	.2	.2
Aluminum sulfate	.25	.3
Chromic fluoride	.25	.4
Asbestos 793-7TF	6.6	6.6
#80 Mica	15.0	18.5
Pyrax B	15.0	15.0
#1 Gypsum Tube Milled Stucco	54.2	49.5
Pigments - as required to give standard color.		

RAW MATERIALS - See Bulletin 61-2-22

#4 Glue - See Bulletin 61-2-38

Chromic Fluoride - To be powdered, green, technical chromic fluoride of 45% minimum Cr_2O_3 equivalent. Ground to pass: 100% thru 100 mesh; 95% or more thru 200 mesh, and equal in waterproofing effect on the glue when tested in the JG61C formula to that of the laboratory sample obtained from the General Chemical Company, December, 1944.

PROCESSING

All equipment to be thoroughly cleaned before starting manufacture of glue - stucco joint cement, particularly when the equipment was last used for making any alkaline dry powder products such as casein joint cement, etc.

Method A - All raw materials are weighed out, and mixed 20 minutes in a Broughton, or similar mixer. The mix is then passed through a micropulverizer equipped with a screen having $1/32"$ wide slot openings. It is then ready for testing and packing.

Method B - In case the above micropulverizing of the whole batch with a $1/32"$ slot screen is too slow to meet production requirements, the stucco may be pre-ground on a separate micropulverizer equipped with a screen having $1/32"$ slot openings than the whole batch mixed and micropulverized using a screen having $1/16"$ slot openings.

FINISHED PRODUCT SPECIFICATIONS

Color - To match standard sample - approximately the color of Manila Sheetrock when dry.

Mixing - Must take water readily and stir to a lump free paste at joint cement consistency as readily as the standard sample of this cement.

Consistency - 66-72 cc for JG61B, 68-74 cc for JG61C.

Odor - To be similar to and no more pronounced than that of standard samples of the cement.

pH - 5 minutes after mixing should show a medium pink to methyl red. A yellow color indicates omission of alum and chrom fluoride or contamination with lime, etc.

New

NP007 0812

PERT-A-TAPE JOINT SYSTEM

Sweetwater Area

No. 61-2-22L
Date 10-29-45
Page 2 of 2

Cancels
Dated NEW

Application - Spread on Sheetrock should be equivalent to a standard sample of the cement in spread and slip, feathering to fine edges and freedom from grit or lumps. Texture should be no more grainy than standard sample. A piece of tape is to be applied with the cement and standard bond tests made after the cement has dried thoroughly (normally overnight is sufficient). Except in highly humid weather bond should be 'good to excellent'.

Jelling of mixed cement 30 min. after mixing - Should be approximately the same as that of the standard sample when tested under same conditions. Excessive jelling may indicate a double charge of chrome fluoride; a deficiency of jelling, the absence of chrome fluoride or alum or both. A deficiency of jelling will generally be accompanied by a low water resistance of the dried cement, and particularly in very hot weather by a sub-standard bond to tape.

Set - Not less than 4 hours initial (1/4 lb. Oilmore needle). No upper limit of set is specified, though in general the cement will set in 12 to 24 hours when kept in a covered pan or humidity cabinet at room temperature. The pH and 30 minute jelling tests are selected rather than set as a check on the presence of the proper amount of alum and chrome fluoride in the cement because these tests can be completed much more quickly than the set.

Hardness of dried cement - To be equal to that of a similarly dried standard sample. The hardness will vary with the humidity conditions under which the cement is dried, being noticeably less at high humidities.

Softening of Rewet Test - Pour 70°F water on the applied cement which has been dried 24 to 48 hours, let stand 5 minutes and note the wet hardness by scratching with fingernail. It should not be less than that of the standard cement sample similarly applied and tested - in general 5 min. after wetting, these cements can be scratched with the fingernail only with difficulty if at all.

Note: Because of the time needed to thoroughly dry the cements this test may not be completed before the cement is shipped. It should be made and recorded, however, for reference. A pronounced loss of water resistance is one of the first effects of package aging with excessive moisture in the cement for both casein and glue stucco type cements. This test should be made on any samples sent in with complaints involving poor bond, soft cement, etc. as a check on such aging.

Test for KB Paste - Test by procedure used with Perfatape Finishing Cement. A fairly strong blue violet color should be obtained with these cements.

PACKAGES

To be the same size and carry the same cement weights as present casein single cement Perfatape system packages. This will include 60' size (when this is again made available), 250' and 500' Perfatape packages; and 25 lbs. and 100 lb. packages of cement only.

Labels on the packages should carry the words 'Southwest System' or other designation which will enable our salesmen and users to identify this new joint cement system readily. This is essential as the new cement must not be mixed with the casein cements of other joint systems.

NEW

07007 0813

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE	PERF-A-TAPE JOINT SYSTEM SWEETWATER AREA	No. 61-2-22L Date 10-18-46 Page 1 of 2 Cancels 1 of 2 Dated 7-18-46
Approved: <i>[Signature]</i>		
<u>DESCRIPTION</u>		
A single cement system using low alkalinity casein base cement for distribution to Dallas, Houston, and Sweetwater areas and part of Oklahoma area.		
<u>MANUFACTURING PLANT</u> - Gypsum		
<u>FORMULA</u>		
Casein Sod. pentachlorophenate Powd. Ammonium oxalate Chromic Fluoride (dried) Hydrated Lime AMD (1:2) P80 or P80J Mica CCO Whiting Peerless Clay Pyrax A AA dolomite Pigments	J377B 7.0% .4 1.6 .4 .6 10.0 10.0 5.0 15.0 20.0 30.0	As required to match standard color.
<u>RAW MATERIALS</u> - see bulletins 61-2-22, 61-2-41.		
<u>PROCESSING</u>		
Grind Ammonium Oxalate in a Micropulverizer with a fine (1/32" slot width) screen before mixing with other materials. Preferred grind - 90 to 100% passing 100 mesh.		
Chromic fluoride is to be dried before mixing with other materials if it is moist as received.		
Weigh all materials and mix in a Broughton mixer for 15-20 minutes. Then pass the batch through a Micropulverizer equipped with a coarse (3/32" slot width) screen. It is then ready to pack.		
<u>FINISHED PRODUCT TESTS</u>		
<u>Color</u> - To match standard sample - approximately matching Sheetrock paper color when applied and dried.		
<u>Consistency</u> - 60-66 cc.		
<u>Mixing</u> - Should mix with water readily to form a stiff putty which will thin down to working consistency on standing a short time - note time required for this. It should be well under 20 min. and preferably under 15 min. for fresh cement. Batches requiring longer standing to reach consistency should be reworked or discarded.		

Kew

- NP007 0808

PERF-A-TAPE JOINT SYSTEM

SWEETWATER AREA

No. 61-2-22L
Date 10-13-46
Sheet 2 of 2
Cancels 2 of 2
Dated 10-29-45

Odor - No stronger than that of the standard sample of this cement; and is similar to that of the present Southwest Texture Paint.

Color to phenolphthalein - Colorless to faint pink. Any batches showing more than a slight pink should be reworked or discarded.

Application - to match that of the standard sample of the cement.

Dry hardness and bond to tape - To match that of standard sample of this cement applied and dried at the same time. "Good" to "Excellent" bond to tape is to be expected. There should be no tape edge cracking on the bond test application.

Revet test - Will normally be "Moderately good" or "Good." Anything less than this indicates possible deficiency of chromic fluoride either in amount or in solubility.

PACKAGING

Same size and weight packages as present single cement Perfatape Systems. Use Southwest Perfatape System Label and also stamp LA in 1 inch letters - as is done for the present Southwest Texture Paint. Insert special direction sheet to be furnished by Gypsum Wallboard Sales in each package.

Hen

0P007 0809

SPECIAL BULLETIN

Operating Division
PRODUCT PROCEDUREPERT-A-TAPE JOINT SYSTEM

No. 61-2-221

Date 7-18-46

Page 1 of 2

Sweetwater Area

Cancels Page 1

Dated 10-29-45

Approved: *[Signature]*DESCRIPTION

A single cement system using glue - stucco base cement for distribution to Dallas, Houston, and Sweetwater areas and part of Oklahoma City area.

MANUFACTURING PLANT - GypsumFORMULAS

	<u>JG61B</u>	<u>JG61C</u>	<u>JG65</u>
Armour's #2 C. W. Glue	--	6.0	6.0
Armour's #4 H. W. Glue	5.0	--	--
K B Paste	3.5	3.5	3.5
Sodium Pentachlorophenate	.2	.2	.3
Aluminum sulfate	.25	.3	.2
Chromic fluoride	.25	.4	.3
Asbestos 793-7TF	6.6	6.6	--
#80 Mica	15.0	18.5	18.5
Pyrex B	15.0	15.0	15.0
#1 Gypsum Tube Milled Stucco	54.2	49.5	49.5
Pigments - as required to give standard color.			
Asbestos Marble Dust 1:2	--	--	6.7

RAW MATERIALS - See Bulletin 61-2-22#4 Glue - See Bulletin 61-2-38

Chromic Fluoride - To be powdered, green, technical chromic fluoride of 45% minimum Cr_2O_3 equivalent. Ground to pass: 100% thru 100 mesh; 95% or more thru 200 mesh, and equal in waterproofing effect on the glue when tested in the JG61C formula to that of the laboratory sample obtained from the General Chemical Company, December, 1944.

PROCESSING

All equipment to be thoroughly cleaned before starting manufacture of glue - stucco joint cement, particularly when the equipment was last used for making any alkaline dry powder products such as casein joint cement, etc.

Method A - All raw materials are weighed out, and mixed 20 minutes in a Broughton, or similar mixer. The mix is then passed through a micropulverizer equipped with a screen having $1/32"$ wide slot openings. It is then ready for testing and packing.

Method B - In case the above micropulverizing of the whole batch with a $1/32"$ slot screen is too slow to meet production requirements, the stucco may be pre-ground on a separate micropulverizer equipped with a screen having $1/32"$ slot openings than the whole batch mixed and micropulverized using a screen having $1/16"$ slot openings.

FINISHED PRODUCT SPECIFICATIONS

Color - To match standard sample - approximately the color of Manila Sheetrock when dry.

Mixing - Must take water readily and stir to a lump free paste at joint cement consistency as readily as the standard sample of this cement.

Consistency - 66-72 cc for JG61B, 68-74 cc for JG61C.

Odor - To be similar to and no more pronounced than that of standard samples of the cement.

pH - 5 minutes after mixing should show a medium pink to methyl red. A yellow color indicates omission of alum and chrom fluoride or contamination with lime, etc.

7P007 0810

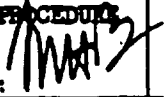
SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE 	<u>PERF-A-TAPE JOINT SYSTEM</u>	No. 61-2-227 Date 8-5-48 Page 1 of 1 Cancels - Dated NEW
This temporary bulletin authorizes the shipment of the low alkalinity joint cement J440 (250 ft. system and 25 lb. cement package) in bags constructed of a single ply of 90 lb. asphalt laminated and two plies of 60 lb. natural kraft paper. M-6189 Rev. 11/43 (U.S.A.) NS		

AUG 17 1950

7P007 1031

SPECIAL BULLETIN

Operating Division	PERF-A-TAPE JOINT SYSTEM	No. 61-2-22AA
PRODUCT PROCEDURE		Date 3/7/49
Approved: 		Page 1 of 1
		Cancels New Dated

This temporary bulletin authorizes Gypsum, New Brighton, and Sweetwater to make the following substitution for asbestos floats in the manufacture of Perf-A-Tape joint cements:

High alkaline cements:

5% AMD (asbestos marble dust 1:2) plus
5 to 7% asbestos floats as required,
until the supply of asbestos floats is exhausted.

Then use 10% AMD.

Low alkaline cement:

Use present formula until supply of asbestos floats is exhausted,
then use 13% AMD.

This bulletin expires 9/7/49

*Cancelled
7-5-49*

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE	<u>PERF-A-TAPE JOINT SYSTEM</u>	No. 61-2-22GG
Approved:		Date 5-12-49
		Page 1 of 2
		Cancels
		Dated NEW

Description
Low alkalinity formula cement for use during asbestos shortage. See bulletin 61-2-22 for other specifications.
Manufacturing Mill - Sweetwater

Formula -

J570

Casein	8.0 %
Sodium pentachlorophenate	.2 (.4 in areas now requiring this %).
Ammonium Oxalate	1.8
Chromic fluoride	.5
Hydrated Lime	.5 ± .2 (as required to give normal pH and casein solution rate).

Dicyandiamide	.7
A 200 talc	15.0
Pumice O	15.0
Dunlap clay AF	7.0

Mica C Per mica formula IV.
Carbotex To make up 100%.
Pigments As required to give standard color - approximately 0.125% Ferrite yellow.

Mica Formula IV -

$$\% \text{ mica} = 8 + .0386D^2 - .155D + .0005 S^2 + .038$$
 Where D = Density in lb./cu. ft.
 S = % passing 325 mesh.

Raw Materials -

All per current specifications together with the following new ones:
 Dicyandiamide - Technical grade, from American Cyanamide Company supplied in fine, soft crystal form.

Pumice O -

From Pumice Corporation of America. A light colored powdered pumice of approximately the following specifications:

Fineness -	100 mesh	.1%
	-100 + 200 mesh	18
	-325 mesh	65
Pouring Consistency -		80 to 85 cc

NP007 1100

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE <i>[Signature]</i>	<u>PERT-A-TAPE JOINT SYSTEM</u>	No. 61-2-22JJ Date 6-16-49 Page 1 of 1 Cancels Dated NEW
Approved: <i>[Signature]</i>		

This special bulletin authorizes New Brighton to ship the Leavitt job premixed low alkalinity formula J-475H (bulletin 61-2-22) joint cement in units as indicated below. Cement to be made up to a consistency of 475-500 Brabender using the heavy spring suspension and pin paddle at 70 R.P.M. Containers to be stamped or labeled to be used before a date one week from date of manufacture.

5 gallon non-returnable pail of cement plus two 250 ft. rolls of tape.

55 gallon returnable drum of cement plus 24 250 ft. rolls of tape.

NP007 1117

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE	<u>PERT-A-TAPE JOINT SYSTEM</u>	No. 61-2-22GG Date 7-8-49 Page 1 of 2
Approved: <i>[Signature]</i>		Cancels Dated 5-12-49

Description

Low alkalinity formula cement for use during asbestos shortage. See bulletin 61-2-22 for other specifications.

Manufacturing Mill - Sweetwater

Formula -

J570

Casein	8.0 %	
Sodium pentachlorophenate	.2 (.4 in areas now requiring this %)	
Ammonium Oxalate	1.8	
Chromic fluoride	.5	
Hydrated Lime	.5 ± .2 (as required to give normal pH and casein solution rate).	
Asbestos Floats	0 to 5% (as required to give normal consistency and application).	
Dicyandiamide	.7	
A 200 talc	15.0	
Pumice Q	15.0	
Dunlap clay AF	7.0	
Mica C	Per mica formula IV.	
Carhotex	To make up 100%.	
Pigments	As required to give standard color - approximately 0.125% Ferrite yellow.	

Mica Formula IV -

$\% \text{ mica} = 8 + .0386D^2 - .155D + .0005 S^2 + .03S$
 Where D = Density in lb./cu. ft.
 S = % passing 325 mesh.

Raw Materials -

All per current specifications together with the following new ones:
 Dicyandiamide - Technical grade, from American Cyanamide Company supplied in fine, soft crystal form.

Pumice Q -

From Pumice Corporation of America. A light colored powdered pumice of approximately the following specifications:

Fineness -	100 mesh	.1%
	-100 + 200 mesh	18
	-325 mesh	65
Pouring Consistency -		80 to 85 cc

/ Indicates change

Carroll
7-26-49

OP007 1098

PERF-A-TAPE JOINT SYSTEM

No.- 61-2-2266
Date 7-8-49
Page 2 of 2
Cancels Page 2
Dated 5-12-49

Dunlap Clay AF -

From Milwhite Co. - Houston, Texas. A powdered clay, light gray to pinkish white color, of exceptionally plastic character.

Pouring Consistency - 250 cc. minimum. Determine by mixing 50 grams to a smooth paste using a drink mixer to stir out lumps. Should pour to a pot diameter 3-3/4" to 4".

Reaction with Ammonium Oxalate - Addition of 50 cc 3% ammonium oxalate solution to a mix of 50 gm of this clay at pouring consistency should stiffen it rather than thin it out.

Finished Product Properties -

Mixing Properties - Like typical LA cements - 15 to 20 minutes required to reach normal stable consistency.

Consistency - Approximately 70 cc.

pH - 7-3/4 to 8 (1:1 suspension in dist. water, 30 min, after mixing).

Application - To match standard sample from Research.

Bond to tape - 6 or 7, except in extremely humid weather.

Check and edge cracking on bond test - None, even in 90°F. room dry test.

Revet test - 5 to 6.

Chrome fluoride spots - Not over 1 per sq.ft. on standard test.

Processing -

Same as for present LA type cements, including pregrinding of ammonium oxalate and chromic fluoride.

Cancellation - J570 is to be regarded as an emergency comment. Sweetwater shall request cancellation as soon as asbestos floats are again available in adequate supply, and stocks of Dunlap Clay and Pumice O are exhausted. Meanwhile J570 is to be shipped only to the Southeast and Southwest Divisions. Orders for LA type comments from other divisions, especially the Pacific and Western divisions, are to be filled with J44OP cement.

Indicates Change

00007 1039

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE	PERF-A-TAPE JOINT SYSTEM	No. 61-2-22JJ Date 9-28-50 Page 1 of 1
Approved: <i>WTC</i>		Cancels Page 1 Dated 6-16-49

This temporary bulletin authorizes New Brighton to ship the Leavitt Job pre-mixed low alkalinity formula J-475H (Formula Below) joint cement in units as indicated below. Cement to be made up to a consistency of 475-500 Brabender using the heavy spring suspension and pin paddle at 70 R.P.M. Containers to be stamped or labeled to be used before a date one week from date of manufacture.

5 gallon non-returnable pail of cement plus two 250 ft. rolls of tape.

55 gallon returnable drum of cement plus 24 250 ft. rolls of tape.

J-475 Formula

Casein	7.0%
Sodium Pentachlorophenate	.2
Ammonium Oxalate	1.4
Hydrated Lime	To give normal PH and solution rate normally .4 required, range .3 to .7
Chromic Fluoride	.4
Mica C	Per formula II
Talc or Pyrophyllite	25.0
Clay Fearless #4	15.0
Asbestos Floats	To give normal consistency and application properties 12 to 15% generally needed (JM7TF2 floats)
CCO Whiting	5.0
A Dolomite	To make up 100%
Tributylphosphate	.2%
Pigments	As required to match standard color.

NP007 1116

/ Indicates Change

new

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved: <i>MacK</i>	<u>PERF-A-TAPE JOINT SYSTEM</u> <u>NEW BRIGHTON</u>	No. 61-2-22RR Date 12-21-50 Page 1 of 1 Cancels New Dated																																		
DESCRIPTION: Low alkalinity Perf-A-Tape cement formula for shipment to following sales districts, and to others designated by Dept. 141-B. Other specifications to be as per bulletin 61-2-22. <table data-bbox="495 563 958 670"> <tr> <td>Boston</td> <td>Syracuse</td> </tr> <tr> <td>Providence</td> <td>Buffalo</td> </tr> <tr> <td>Albany</td> <td>Harrisburg</td> </tr> </table> If not cancelled previously, this bulletin expires 7-1-51. MANUFACTURING PLANT: New Brighton FORMULA: J387 <table data-bbox="289 840 1239 1276"> <tr> <td>Casein</td> <td>7.0</td> </tr> <tr> <td>Sodium Pentachlorophenate</td> <td>0.2</td> </tr> <tr> <td>Ammonium Oxalate</td> <td>1.4</td> </tr> <tr> <td>Hydrated Lime</td> <td>As required.</td> </tr> <tr> <td>Chromic Fluoride (Premixed with mica and ground)</td> <td>0.4</td> </tr> <tr> <td>Dicyandiamide</td> <td>0.5</td> </tr> <tr> <td>Asbestos Floats</td> <td>As required.</td> </tr> <tr> <td>Pyrox A (or approved talc)</td> <td>15.0</td> </tr> <tr> <td>Pearless Clay</td> <td>15.0</td> </tr> <tr> <td>CCO Whiting</td> <td>10.0</td> </tr> <tr> <td>Pumice</td> <td>10.0</td> </tr> <tr> <td>Mica C</td> <td>Per formula V</td> </tr> <tr> <td>A Dolomite</td> <td>To make up 100%</td> </tr> <tr> <td>Pigments</td> <td>As required to match standard color.</td> </tr> </table> PACKAGE: 250 ft. system) 25 lb. cement) Coded "MF" on face of container.			Boston	Syracuse	Providence	Buffalo	Albany	Harrisburg	Casein	7.0	Sodium Pentachlorophenate	0.2	Ammonium Oxalate	1.4	Hydrated Lime	As required.	Chromic Fluoride (Premixed with mica and ground)	0.4	Dicyandiamide	0.5	Asbestos Floats	As required.	Pyrox A (or approved talc)	15.0	Pearless Clay	15.0	CCO Whiting	10.0	Pumice	10.0	Mica C	Per formula V	A Dolomite	To make up 100%	Pigments	As required to match standard color.
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Pigments	As required to match standard color.																																			

Approved: *ABC*TESTING AND REPORTING QUALITY OF TAPE: (Cont'd.)

shall be so spaced that only unbeveled tape shall be between the jaws. To test the ironing, a piece of finished tape shall be applied with joint cement and observations made as to any edge wrinkling.

(g) Above results are to be recorded daily and file maintained at mill.

JOINT CEMENTS - (High Alkalinity Formulas)

Except at Hagersville, manufacture of this type cement is to be discontinued as soon as the Sales Department has fully completed necessary ground work for converting all U.S.A. to Low Alkalinity Cement.

	<u>HAGERSVILLE</u>	<u>GYP SUM, NEW BRIGHTON</u>
	J-318	J-301
Lauxoin 10B (Old Type)	4.0%	-
Casoin	7.0%	7.3%
Soy Flour	-	3.1%
Hydrated Lime	3.0%	1.0%
Kemikal Oxide-Superfine or Equivalent	-	2.0%
Sodium Oxalate	-	1.1%
Sodium Pentachlorophenate	.3%	.3%
*Talc or Pyrophyllite	10.0%	15.0%
FF Limestone	15.0%	-
Tri Sodium Phosphato	1.7%	-
Mica C	Per Formula V	Per Formula V
Asbestos Floats		
J.M. and Asb. Corp Floats or	10-15%	10-15%
Philip Carey TRF "	7-11%	7-11%
Asbestos Marble Dust (1:2)	8.0%	-
CCO Whiting	15.0%	25.0%
Carbotex	-	-

A Dolomite

To make up 100% To make up 100%
As required to match standard color

*Talc in J-301 may be Loomis #200 talc, Broughton M4 talc.
Pyrax B or Southwestern A200 talc.

"

See Mica Formula V on Page 5.

/ Indicates Change

DP010 0536

Operating Division
Product Procedure

PERF-4-TAPE JOINT SYSTEM

No. 61-2-22TT
Date 6-4-51
Page 1 of 1

Meck

Approved:

Cancel
Dated Nov

PLANTS CONCERNED:

Ogden
New Brighton
South Gate
Sweetwater
Hagerville

INSTRUCTIONS:

During current shortage of Ferrite Yellow, Perf-4-Tape cements made at USA plants to match J735 color standard distributed 5-7-51. (This does not apply to topping cements)

Hagerville to make natural (Unpigmented) color cement, when present supplies of tinting pigments are exhausted.

7P007 1229

SPECIAL BULLETIN

Operating Division
PRODUCT PROCEDUREPERF-A-TAPE JOINT SYSTEM

NEW BRIGHTON

No. 61-2-22RR
Date 8-7-51
Page 1 of 1Cancels Page 1
Dated 12-21-50

Approved:

mck

DESCRIPTION: Low alkalinity Perf-A-Tape cement formula for shipment to following sales districts, and to others designated by Dept. 141-B. Other specifications to be as per bulletin 61-2-22.

Boston	Syracuse
Providence	Buffalo
Albany	Harrisburg

If not cancelled previously, this bulletin expires 12-31-51.

MANUFACTURING PLANT New Brighton

FORMULA: J587

Casein	7.0
Sodium Pentachlorophenate	0.2
Ammonium Oxalate	1.4
Hydrated Lime	As required.
Chromic Fluoride (Premixed with mica and ground)	0.4
Dicyandiamide	3.5
Asbestos Floats	As required
Pyrax A (or approved talc)	15.0
Pearless Clay	15.0
CCO Whiting	10.0
Pumice	10.0
Mica C	Per formula V
A Dolomite	To make up 100%
Pigments	As required to match standard color.

PACKAGE

250 lb. system)
25 lb. cement) Coded "T3" on face of container.

0P007 1215

Approved: *11/11*TESTING AND REPORTING QUALITY OF TAPE: (Cont'd.)

shall be so spaced that only unbeveled tape shall be between the jaws. To test the ironing, a piece of finished tape shall be applied with joint cement and observations made as to any edge wrinkling.

(g) Above results are to be recorded daily and file maintained at mill.

JOINT CEMENTS: (High and Medium Alkaline Formulae)

	<u>Hagersville</u>	<u>Gypsum</u> <u>New Brighton</u>	<u>Sweetwater</u>
	J-31B	JF31A	JF31F
Lauzein 10B	4.0	-	-
Soy Flour	-	3.5	3.5
Casein	7.0	5.7	5.7
Hydrated Lime	3.0	As req'd. for normal pH-Approx. 1.0%	
Tri sodium phosphate	1.7	-	-
Sodium oxalate	-	1.0	1.0
Sodium pentachlorophenate	.3	.4	.4
*Talc or pyrophyllite	10.0	15.0	20.0
AMD (1:2)	8.0 (Until stock depleted, then use asbestos floats)		
**Asbestos Floats	As req'd. for normal consistency and application properties.		
Silversheen Mica	-	5.0	5.0
Mica C	Per formula V	2/3 formula V	2/3 formula II
*** Carbonate Fillers	See Footnote	To make up 100%	

Footnotes -

- * Talc or pyrophyllite - Hagersville - Broughton M4 Talc
Gypsum and New Brighton - Pyrax B
Sweetwater - A 200 talc
- ** Asbestos Floats - The following asbestoses are approved for use in JF31 A & F cements:
John Mansville 7TF2 - Normally 11 to 16% needed
Nicollet 7TG - " 8 to 12% "
Philip Carey 7RF (asphalt tile) Normally 4 to 7% needed
- *** Carbonate Fillers - Hagersville - 15% CCO Whiting
15% FF limestone
plus A dolomite to make up to 100%
New Brighton A Dolomite
Gypsum - Stonelite (or A Dolomite)
Sweetwater - Carbotex

General: All cements, except topping cement, to be made in natural color. All topping cements, both medium and low alkaline, to be colored to an approximate match of wallboard manila paper. This color standard to be shipped to each producing plant by the Research Department.

Gypsum Wallboard Sales will advise the plants of the divisions or districts into which medium alkline and low alkaline cements will be shipped.

PERF-A-TAPE JOINT SYSTEM

No. 61-2-22
Date 12-26-51
Page 4 of 13
Cancels Page 4
Dated 8-27-51

JOINT CEMENTS - Low Alkaline Formulae:

	South Gate J639B	Sweetwater J440P	Sweetwater J735
Casein	7.0	7.0	6.6
Sodium Pentachlorophenate*	0.2	0.2	0.2
Ammonium Oxalate	1.25	1.25	1.25
Hydrated Lime, to give normal pH & solution rate -	.15 - .4	.15 - .4	.15 - .3
Dicyandiamide (note 1)	0.5	0.5	0.5
Asbestos Floats **	As required to give normal consistency		
	8-25	8-25	Appr. 20 JM7TF2 or 8-10 P.Carey
A200 Talc	-	25.0	-
M350 Sericite Mica (note 2)	20.0	-	20.0
3X Mineralite	-	-	-
Mica C, Formula number	V	II	V
Peerless Clay	15.0	15.0	-
Carbonate Filler ***	To make up 100%	-	-
Carbotex	-	To make up 100%	To make up 100%
Merpel C	0.2	-	-
Camphor	0.04	-	-
CS-112	-	-	0.4
Sterox CD .1% plus .1% tributylphosphate (note 3)	-	-	0.2

Cements to be natural color (i.e. unpigmented)

NOTES:

- (1) Sweetwater to delete dicyndiamide in J440P cement for Texas when dicyndiamide is not available in sufficient quantity, and into all markets from February to June, inclusive.
- (2) When Philip Carey asbestos is used in J735 cement, one half the M350 sericite may be replaced with A200 talc.
- (3) In cool weather, Sterox CD may be thinned slightly with I.P. alcohol to thin it sufficiently to permit spraying it into the batch.

GENERAL REVISION

OP010 0517

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PERF-A-TAPE JOINT SYSTEM

No. 61-2-22

Date 6-26-52

Page 3 of 13

Cancels Page 3

Dated 6-6-52

Approved:

TESTING AND REPORTING QUALITY OF TAPE: (Cont'd.)

shall be so spaced that only unbeveled tape shall be between the jaws. To test the ironing a piece of finished tape shall be applied with joint cement and observations made as to any edge wrinkling.

(g) Above results are to be recorded daily and file maintained at mill.

JOINT CEMENTS: (High and Medium Alkaline Formulas)

	<u>Hagersville</u>	<u>Gypsum</u> <u>New Brighton</u>	<u>Sweetwater</u>
	<u>J-318</u>	<u>JF31A</u>	<u>JF31F</u>
Lauzein 10B	4.0	-	-
Soy Flour	-	3.5	3.5
Casein	7.0	5.7	5.7
Hydrated Lime	3.0	As req'd. for normal	pH-Approx. 1.0%
Tri sodium phosphate	1.7	-	-
Sodium oxalate	-	1.0	1.0
Sodium pentachlorophenate	.3	.4	.4
*Talc or pyrophyllite	10.0	15.0	20.0
AMD (1:2)	3.0	(Until stock depleted, then use only asbestos floats. Meanwhile use about 2/3 normal quantity of asbestos floats together with AMD).	
**Asbestos Floats	As req'd. for normal consistency and application properties.		
Silversheen Mica	-	5.0	5.0
Mica C	Per formula V	2/3 formula V	2/3 formula V
***Carbonate Fillers	See Footnote	To make up 100%	

Footnotes -

* Talc or pyrophyllite - Hagersville - Broughton M4 Talc
Gypsum and New Brighton - Pyrax B
Sweetwater - A 200 talc

**Asbestos Floats - The following asbestoses are approved for use in JF31 A & F, and in J318 cements.

John Mansville 7TF2 - Normally 11 to 16% needed

Nicolet 7TG - " 8 to 12% "

Philip Carey 7RF (asphalt tile) Normally 4 to 7% needed

*** Carbonate Fillers - Hagersville - 15% CCO Whiting
15% FF limestone
plus A dolomite to make up to 100%
New Brighton A Dolomite
Gypsum - Stonelite (or A Dolomite)
Sweetwater - Carbotex

General: All cements, except topping cement, to be made in natural color. All topping cements, both medium and low alkaline, to be colored to an approximate match of wallboard manila paper. This color standard to be shipped to each producing plant by the Research Department. Exception: Hagersville to color all joint cement to approximate match of manila paper.

Gypsum Wallboard Sales will advise the plants of the divisions or districts into which medium alkaline and low alkaline cements will be shipped.

/ Indicates Change

DP010 0496

Approved:

TESTING AND REPORTING QUALITY OF TAPE: (Cont'd)

shall be so spaced that only unbeveled tape shall be between the jaws. To test the ironing a piece of finished tape shall be applied with joint cement and observations made as to any edge wrinkling

(g) Above results are to be recorded daily and file maintained at mill.

JOINT CEMENTS: (High Alkaline Formulas)

	<u>Hagersville</u>	<u>Gypsum and New Brighton</u>
	J318	J766
Lauzein	4.0%	-
Soy Flour	-	2.5%
Casein	7.0	7.3
Hydrated Lime	3.0	1.0
Kemikal Oxide	-	2.0
Trisodium phosphate	1.7	-
Sodium Oxalate	-	1.2
Sodium Pentachlorophenate	.3	.4
Talc (Broughton M4)	10.0	-
Mineralite DXW	-	15.0
Asbestos *	As required to give normal consistency and application properties. See note.	
Mica C	Per formula V	Per formula V
CCO Whiting **	15.0	10 to 25%
Carbonate Fillers	15.0 FF Lime stone	Stonelite or Adolomite to
	/ Adolomite to make	make up 100%
	up 100%	
Pigments	As required to give	None - to be left natural
	standard Manila	color
	color.	
Coaisi Pyrophyllite **	-	5 to 15%

* The following asbestoses are approved. The approximate amounts needed of each are indicated:

For J318 - Nicolet 7TG or Johns Manville AX-2390M 8 to 12%

For J766 - Nicolet 7TG 10 to 14% or Johns Manville 7TF2 14 to 20%

** The sum of the CCO whiting and coarse pyrophyllite is to be 25%. The amounts of each to be used may be varied within the indicated limits to control application properties (gumminess, smoothness and plasticity).

General: All cements, except topping cement, to be made in natural color. All topping cements, both medium and low alkaline, to be colored to an approximate match of wallboard manila paper. This color standard to be shipped to each producing plant by the Research Department. Exception: Hagersville to color all joint cement to approximate match of manila paper.

Gypsum Wallboard Sales will advise the plants of the divisions or districts into which medium alkaline and low alkaline cements will be shipped.

/ Indicates change

DP010 0485

PERF-A-TAPE JOINT SYSTEM

No. 61-2-22
Date 12-26-52
Page 4 of 13
Cancels Page 4
Dated 8-27-51

JOINT CEMENTS - Low Alkaline Formulae:

	South Gate J639B	Sweetwater J44OP	Sweetwater J735
Casein	7.0	7.0	6.6
Sodium Pentachlorophenate*	0.2	0.2	0.2
Ammonium Oxalate	1.25	1.25	1.25
Hydrated Lime, to give normal pH & solution rate -	.15 - .4	.15 - .4	.15 - .3
Dicyandiamide (note 1)	0.5	0.5	0.5
Asbestos Floats **	As required to give normal consistency		
	8-25	8-25	Appr. 20 JM7TF2 or 8-10 P.Carey
A200 Talc	-	25.0	-
M350 Sericite Mica (note 2)	20.0	-	20.0
3X Mineralite	-	-	-
Mica C, Formula number	V	II	V
Peerless Clay	15.0	15.0	-
Carbonate Filler ***	To make up 100%	-	-
Carbotex	-	To make up 100%	To make up 100%
Merpel C	0.2	-	-
Camphor	0.04	-	-
CS-112	-	-	0.4
Sterox CD .1% plus .1% tributylphosphate (note 3)	-	-	0.2

Cements to be natural color (i.e. unpigmented)

NOTES:

- (1) Sweetwater to delete dicyndiamide in J44OP cement for Texas when dicyndiamide is not available in sufficient quantity, and into all markets from February to June, inclusive.
- (2) When Philip Carey asbestos is used in J735 cement, one half the M350 sericite may be replaced with A200 talc.
- (3) In cool weather, Sterox CD may be thinned slightly with I.P. alcohol to thin it sufficiently to permit spraying it into the batch.

GENERAL REVISION

OP010 0486

SPECIAL BULLETIN

Operating Division
PRODUCT PROCEDURE

PERF-A-TAPE JOINT SYSTEM

No. 61-2-22JJ

Date 3-24-53

Page 1 of 1

Cancels Page 1

Dated 9-28-50

Approved: *nm*

This temporary bulletin authorizes New Brighton to ship the Leavitt Job pre-mixed low alkalinity formula J-475H (Formula Below) joint cement in units as indicated below. Cement to be made up to a consistency of 475-500 Brabender using the heavy spring suspension and pin paddle at 70 R.P.M. Containers to be stamped or labeled to be used before a date one week from date of manufacture.

5 gallon non-returnable pail of cement plus two 250 ft. rolls of tape.

55 gallon returnable drum of cement plus 24 250 ft. rolls of tape.

J-475 Formula

Casein	7.0%
Sodium Pentachlorophenate	.2
Ammonium Oxalate	1.4
Hydrated Lime	To give normal PH and solution rate normally .4 required, range .3 to .7
Chromic Fluoride	.4
Mica C	Per formula II
Talc or Pyrophyllite	25.0
Clay Peerless #4	15.0
Asbestos Floats	To give normal consistency and application properties 12 to 15% generally needed (JM7TF2 floats)
CCO Whiting	5.0
A Dolomite	To make up 100%
Tributylphosphate	.2%
Pigments	As required to match standard color.

Cement without pigments (uncolored) to be supplied on specific order, (Not Stocked). Containers of uncolored cement to be stencilled with red ink to distinguish from colored cement stencilled with white ink.

f Indicates change

NP007 1115

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE	PERT-A-TAPE JOINT SYSTEM	No. 61-2-2233
Approved: <i>JWTK</i>		Date 4-2-54
		Page 1 of 1
		Cancels Page 1
		Dated 6-16-53

This temporary bulletin authorizes New Brighton and Gypsum to ship the Leavitt Job premixed low alkalinity formula J-475H (Formula Below) joint cement in units as indicated below. This cement may be shipped to other customers when orders have approval of Chicago Sales. Cement to be made up to a consistency of 475-500 Brabender using the heavy spring suspension and pin paddle at 70 R.P.M. Containers to be stamped or labeled to be used before a date 10 days from date of manufacture.

5 gallon non-returnable pail of cement plus two 250 ft. rolls of tape.

55 gallon returnable drum of cement plus 24 250 ft. rolls of tape.

J-475 Formula

Casein	7.0%
Sodium Pentachlorophenate	.2
Ammonium Oxalate	1.4
Hydrated Lime	To give normal PH and solution rate normally .4 required, range .3 to .7
Chromic Fluoride	.4
Mica C	Per formula II
Talc or Pyrophyllite	25.0
Clay Peerless #4	15.0
Asbestos Floats	To give normal consistency and application properties 12 to 15% generally needed (JM7TF2 floats)
CCO Whiting	5.0
A Dolomite	To make up 100%
Tributylphosphate	.2%
Pigments	As required to match standard color.

Cement without pigments (uncolored) to be supplied on specific order, (Not Stocked). Containers of uncolored cement to be stencilled with red ink to distinguish from colored cement stencilled with white ink.

/ Indicates Change

DP007 1113

SPECIAL BULLETIN

Operating Division
PRODUCT PROCEDURE

PERF-A-TAPE JOINT SYSTEM

No. 61-2-22JJ

Date 3-16-53

Page 1 of 1

Cancels Page 1

Dated 3-24-53

Approved: *[Signature]*

This temporary bulletin authorizes New Brighton to ship the Leavitt Job pre-mixed low alkalinity formula J-475H (Formula Below) joint cement in units as indicated below. This cement may be shipped to other customers when orders have approval of Chicago Sales. Cement to be made up to a consistency of 475-500 Brabender using the heavy spring suspension and pin paddle at 70 R.P.M. Containers to be stamped or labeled to be used before a date 10 days from date of manufacture.

5 gallon non-returnable pail of cement plus two 250 ft. rolls of tape.

55 gallon returnable drum of cement plus 24 250 ft. rolls of tape.

J-475 Formula

Casein	7.0%
Sodium Pentachlorophenate	.2
Ammonium Oxalate	1.4
Hydrated Lime	To give normal PH and solution rate normally .4 required, range .3 to .7
Chromic Fluoride	.4
Mica C	Per formula II
Talc or Pyrophyllite	25.0
Clay Peerless #4	15.0
Asbestos Floats	To give normal consistency and application properties 12 to 15% generally needed (JM7TF2 floats)
CCO Whiting	5.0
A Dolomite	To make up 100%
Tributylphosphate	.2%
Pigments	As required to match standard color.

Cement without pigments (uncolored) to be supplied on specific order, (Not Stocked). Containers of uncolored cement to be stencilled with red ink to distinguish from colored cement stencilled with white ink.

/ Indicates change

OP007 1114

SPECIAL BULLETIN

Operating Division	PERF-A-TAPE JOINT COMPOUND	No. 61-2-22-M
PRODUCT PROCEDURE	FORMULA J1297B	Date 1-14-64
Approved: <i>gmb</i>	DALLAS	Page 1 of 2
		Cancel Page 1
		Dated 9-26-63

Dallas to manufacture Perf-A-Tape Joint Compound, Formula J1297B, for shipments to Denver District as directed by Merchandising. Specifications as follows:

<u>FORMULA</u>	<u>J1297B</u>
Argentine F. G. uncoiled casein	5.33%
Kelsize LV	.4
SG-62	.333
Advacide TJP	.1
Dicyandiamide	1.0
Zinc oxide (#42 green label)	.1
Ammonium oxalate	.6
Niccollet 7TG25 Asbestos	As req'd (4.0% in lab batch)
Carey TRF9	3.33
Mica JC	Per formula V
Micro Fill #1	To make 100%
Polyglycol P1200	.4
Neutralizer 50%O	.001

RAW MATERIALS

Per Bulletin 61-2-22 or 61-2-23 with addition of:

Advacide TJP - A tributyl tin oxide type fungicide containing approximately 10% active ingredient dispersed on 90% fine calcium carbonate.
Source: Advance Division, Carlisle Chemical Works, New Brunswick, N. J.

Microfill #1 per FMS 6-24-10.

PROCESSING

Mix and pulverize per Bulletin 61-2-22.

SPECIAL BULLETIN

Operating Division

PRODUCT PROCEDURE

Approved: *JJ***CONFIDENTIAL**DO NOT REPRODUCE OR COPY
PERF-A-TAPE VINYL TOPPING COMPOUND
(FORMULA-95)

No. 61-2-23-P

Date 7-11-66

Page 3

Cancels

Dated NEW

FORMULA (FE-95)

GP-702	2.5%
Santicoizer #9	0.25
B-329	2.5
Vancide 51-Z	0.15
JM7RPO2	5.0 (1)
P-85 Mica	- (2)
GM-65	0.8
Carbonate Filler (3)	- (4)
Zinc Oxide	0.1
Tetra Sodium Pyrophosphate	0.1
Ferrite Yellow	0.1 (5)

- (1) About the amount specified above to control consistency.
- (2) Per Formula V.
- (3) Chamblee and Dallas to use #9 MCS. New Brighton to use Rambo #4.
- (4) To make 100%.
- (5) About the amount specified above to match manila color of SHEETROCK.

RAW MATERIALS

Gelva Powder 702
GM-65 (-60 mesh)
B-329 (-60 mesh)

Monsanto
Dow Chemical
A. E. Staley Co.

MANUFACTURING PROCEDURE

Per Bulletin 61-2-23.

A thorough brushing down, followed by a clean-out charge of carbonate filler must be done before this product is manufactured.

End

NOV 16 1966

Operating Division

CONFIDENTIAL
 No. 61-2-26-3
 Date 5-25-70
 Page 2
 Cancels Page 2
 Dated 8-27-65

PRODUCT PROCEDURE

DO NOT REPRODUCE OR COPY
 PERF-A-TAPE DUAL PURPOSE COMPOUND
 NEW BRIGHTON
Approved: *[Signature]*

FORMULA	AP-52	AP-52A
Casein	5.5	Same
Ammonium Alginate	0.7	Same
Ammonium Oxalate	1.8	1.2
Hydrated Lime	as required for PH (approx. 0.1)	Same
Ammonium Pentaborate	1.2	Same
Dicyandiamide	0.8	Same
JM 7RF-1 Asbestos	1/2 of amount re- quired (3.5%)	2/3 of amt. (4.6%)
PC 7RF-9 Asbestos	1/2 of amount re- quired (3.5%)	1/3 of amt. (2.3%)
	Lab Batch	req. Lab Batch
Mica J. C.	0.7 Formula V	Same
DXW Mineralite	-	15.0
Ser-X	15.0	-
Rambo No. 4	To make 100%	Same
Liq. Mix	0.153	Same
PPG-1200	0.150	
Neutralizer 5050	0.003	
Ferrite Yellow*	0.15	Same (when req.)
Ultramarine Blue	-	0.03 (in natural white only)

*Do not include this item in the formulation when packaging in 5# units;
60 Ft. Systems; and 250 Ft. System.

RAW MATERIALS

Ammonium Alginate - Protatek A-155 from Croda, Inc.

Asbestos Usage - Normal range should be 6.5 to 8.5%. If asbestos use con-
sistently drops below 6.5% or is over 8.5%, send samples
of the asbestos and compound to Research.

Rambo No. 4 - per Bulletin 6-24-9

Mica JC - PMS Bul. 6-143-1

Other Raw Materials per Bulletin 61-2-23.

Processing - per Bulletin 61-2-22.

END