March 30, 1978
Supersedes Formula M-971
Dated: 11/30/77

MARIETTA, GEORGIA, PLANT FORMULA
READY MIX TOPPING COMPOUND M-971 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Topping Compound used for finishing joint and spotting nail heads.

FORMULA

| Raw Material | Function | RM Spec | Percent | Lbs/Batch |
|---|---|---|---|---|
| Proxel CRL | Preservative | | .047 | .98 |
| -/Filler M-970 | Filler | | 94.068 | 1950.02 |
| -/Elvace EP-200 | Adhesive | 185 | 5.596 | 116.0 (13.0 gals) |
| -/Nalco 71D-5 | Defoamer | 125 | .096 | 2.0 |
| -/Acrysol ASE-60 | Thickener | 147 | .193 | 4.0 |
| -/*Water | Solvent | | | 1114.0 (134.2 gals) |
| | | | 100.000 | 3187.0* |

*Approximately 52 lbs/100 lbs. of active ingredients (this may vary ± 8 gallons per batch.

**One batch yields 51 ± 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

SPECIAL MIXING INSTRUCTIONS - Blend ingredients in following order:
1) Water/Proxel
2) Elvace
3) Nalco
4) Filler M-970
5) Mix until filler is dispersed
6) Add Acrysol ASE-60
7) Mix until Ready Mix is smooth - pumping viscosity should be 480±20 to allow for 24 hour viscosity build of 100 pts.

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.

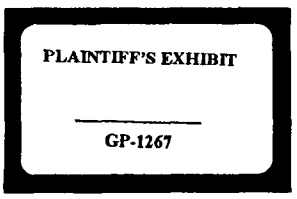
Brabender: (580 ± 20) For machine tools add 7 gallons $H_2O$ (400 ± 20)

pH Minimum - 9.0 Maximum - 10.0 (24 hrs.)

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.

Continued on Page 2 . . .

HCF:jr



NEW
July 2, 1979

MARIETTA, GEORGIA, PLANT FORMULA
READY MIX FILLER M-971

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound M-972 for shipments to Adobe D/W - Miami, Florida only.

FORMULA

| Raw Material | Function | RM Spec | Percent | Lbs/Batch |
|---|---|---|---|---|
| Pyrophylite-SK | Bulking Agent | | 5.4 | 300.0 |
| Limestone | Filler | 13 | 89.74 | 4985.0 |
| Methocel 240 | Water Retention | | .360 | 20.0 |
| Aqua-Fil K-8 | Bulking Agent | | 3.6 | 200.0 |
| Starch C-9-136 | Adhesive | 23 | .900 | 50.0 |
| | | | 100.000 | 5555.0 |

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.

| Maximum | Minimum | Average |
|---|---|---|
| 62 | 58 | 60 |

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33

Specifications: Filler shall be very heavily bodied and possess fair plasticity. It shall be free of any coarse, gritting 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 M-972 at least twice a day or with every sixth or seventh batch of filler manufactured. This prepared mix shall be tested and shall meet all the specifications required of Ready Mix Joint Compound - Formula No. M-972.

HCF:ps

October 30, 1979
Supersedes Formula M-971
Dated: July 2, 1979

MARIETTA, GEORGIA, PLANT FORMULA
READY MIX FILLER M-971

-/ DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound M-972 and topping compound M-974.

FORMULA

| Raw Material | Function | RM Spec | Percent | Lbs/Batch |
|---|---|---|---|---|
| Pyrophylite-SK | Bulking Agent | | 5.4 | 300.0 |
| Limestone | Filler | 13 | 89.74 | 4985.0 |
| -/Methocel 240 | Water Retention | 163 | .360 | 20.0 |
| Aqua-Fil K-8 | Bulking Agent | 229 | 3.6 | 200.0 |
| -/Starch C-9-136 | Adhesive | 10 | .900 | 50.0 |
| | | | 100.000 | 5555.0 |

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.

| Maximum | Minimum | Average |
|---|---|---|
| 62 | 58 | 60 |

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33

Specifications - Filler shall be very heavily bodied and possess fair plasticity. It shall be free of any coarse, gritting 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 M-972 at least twice a day or with every sixth or seventh batch of filler manufactured. This prepared mix shall be tested and shall meet all the specifications required of Ready Mix Joint Compound - Formula No. M-972.

HCF:ps

-/ denotes change

June 30, 1981
Supersedes Formula M-971
Dated 10/30/79

MARIETTA, GEORGIA, PLANT FORMULA
READY MIX FILLER M-971

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound M-972 and topping compound M-974.

FORMULA

| Raw Material | Function | RM Spec | Percent | Lbs/Batch |
|---|---|---|---|---|
| Pyrophylite-SK | Bulking Agent | | 5.4 | 300.0 |
| Limestone | Filler | 13 | 89.66 | 4980.75 |
| Methocel 240 | Water Retention | 163 | .360 | 20.0 |
| Aqua-Fil K-3 | Bulking Agent | 229 | 3.6 | 200.0 |
| Starch C-9-136 | Adhesive | 10 | .900 | 50.0 |
| -/ Tektamer 38 | Preservative | 128 | .08 | 4.25 |
| | | | 100.000 | 5555.0 |

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.

| Maximum | Minimum | Average |
|---|---|---|
| 62 | 58 | 60 |

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33

Specifications: Filler shall be very heavily bodied and possess fair plasticity. It shall be free of any coarse, gritting 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 M-972 at least twice a day or with every sixth or seventh batch of filler manufactured. This prepared mix shall be tested and shall meet all the specifications required of Ready Mix Joint Compound - Formula No. M-972.

BGR :ps

-/ denotes change

October 2, 1981
Supersedes Formula M-971
Dated 6/30/81

# MARIETTA, GEORGIA, PLANT FORMULA
## READY MIX FILLER M-971

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound M-972 and topping compound M-974.

FORMULA

| Raw Material | Function | RM Spec | Percent | Lbs/Batch |
|---|---|---|---|---|
| Pyrophylite-3K | Bulking Agent | | 5.4 | 300.0 |
| Limestone | Filler | 13 | 89.74 | 4985.0 |
| Methocel 240 | Water Retention | 163 | .360 | 20.0 |
| Aqua-Fil K-8 | Bulking Agent | 229 | 3.6 | 200.0 |
| Starch C-9-136 | Adhesive | 10 | .900 | 50.0 |
| | | | 100.000 | 5555.0 |

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.

| Maximum | Minimum | Average |
|---|---|---|
| 62 | 58 | 60 |

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33

Specifications: Filler shall be very heavily bodied and possess fair plasticity. It shall be free of any coarse, gritting 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 M-972 at least twice a day or with every sixth or seventh batch of filler manufactured. This prepared mix shall be tested and shall meet all the specifications required of Ready Mix Joint Compound - Formula No. M-972.

BGR :ps

-/ denotes change

MARIETTA FORMULA # 971
ASBESTOS CONTAINING PRODUCTS

January 29, 1969
NEW FORMULA

ATLANTA, GEORGIA PLANT FORMULA

READY MIX FILLER M-971 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound M-974, M-976

FORMULA

| Raw Material | Function | R.M. Spec. | Percent | Lbs./Batch |
|---|---|---|---|---|
| Nalco 71 D5 | Anti-Foaming Agent | - | 0.11 | 4.5 |
| Troysan CMP-10-Sep | Fungicide | 193 | 0.10 | 4.0 |
| Gelvatol 20-30 BP (Poly Vinyl Alcohol) | Adhesive | 162 | 0.80 | 32.0 |
| Natrosol 250 HXR | Water Retention Agent | 170 | 0.65 | 26.0 |
| Mica P80-H | Anti-Cracking Agent | 11 | 13.00 | 520.0 |
| Asbestos 7RF-9 | Bulk | 9 | 4.50 | 180.0 |
| Limestone | Filler | 13 | 80.84 | 3233.5 |
| | | | 100.00 | 4000.0 |

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.

| Specifications: | Maximum | Minimum | Average |
|---|---|---|---|
| | 56 | 53 | 55 |

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

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

NOTE: A wet mix of the filler shall be prepared according to Formula No. M-974 or M-976 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 specification required of Ready Mix Joint Compound - Formula No. M-974 or M-976.

EDO:kkt

February 11, 1972
Supersedes Formula M-971
Dated 1/29/69

MARIETTA, GEORGIA PLANT FORMULA

READY MIX FILLER M-971 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound M-974, M-976.

-/ FORMULA

| Raw Material | Function | R.M.Spec. | Percent | Lbs/Batch |
|---|---|---|---|---|
| Nalco 71-D5 | Anti-Foaming agent | - | 0.11 | 4.5 |
| Dowicil 100 | Fungicide | 193 | 0.15 | 6.0 |
| Gelvatol 20-30 BP (Polyvinyl Alcohol) | Adhesive | 162 | 0.80 | 32.0 |
| Natrosol 250 HXR | Water Retention agent | 170 | 0.65 | 26.0 |
| Mica PSO-H | Anti-Cracking agent | 11 | 13.00 | 520.0 |
| Asbestos 7RF-9 | Bulk | 9 | 4.50 | 180.0 |
| Limestone | Filler | 13 | 80.79 | 3231.5 |
| | | | 100.00 | 4000.0 |

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

| Maximum | Minimum | Average |
|---|---|---|
| 56 | 53 | 55 |

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

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

NOTE:

A wet mix of the filler shall be prepared according to Formula No. M-974 or M-976 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. M-974 or M-976.

-/ Denotes change in this reissue.

EDO:dek

SGP 0017480

March 25, 1974
New Formula M-971

MARIETTA, GEORGIA, PLANT FORMULA
READY MIX JOINT COMPOUND M-971 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for topping and spotting nailheads. (To be supplied to selected customers only.)

FORMULA

| Raw Materials | Function | Percent | Lbs/Batch |
|---|---|---|---|
| Water | Solvent | -- | 1030.00 (129 gals)* |
| Nalco | Anti-foaming agent | 0.1 | 2.00 |
| Polyvinyl Acetate Emulsion (preplasticized) | Adhesive | 6.4 | 128.00 (14.2 gals) |
| Filler M-970 | Filler | 93.5 | 1865.00 |
| | | 100.0 | 3025.00** |

*Approximately 54.4 lbs/100 lbs. of active ingredients (this may vary ± 8 gallons per batch).

**One batch yields 53 ± 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: 580 ± 20 For machine tools add 5 gals. $H_2O$ (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.

WNG:jg

June 23, 1975
Marietta Formula: M-971
NEW

MARIETTA, GEORGIA, PLANT FORMULA
READY MIX JOINT COMPOUND M-971 (HAND TOOLS)

DESCRIPTION OF PRODUCT- White Ready Mix Joint Compound used for taping, topping and texturing. Special low cost formula.

| FORMULA | Function | Percent | Lbs/Batch |
|---|---|---|---|
| Water | Solvent | -- | 1024.00 (128 gals.)* |
| Nalco | Anti-foaming agent | .2 | 4.00 |
| Elvace 1875 | Adhesive | 2.0 | 39.00 (4.4 gals.) |
| Filler M-970 | Filler | 97.8 | 1950.00 |
| | | 100.0 | 3017.00** |

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary ± 8 gallons per batch.

**One batch yields 49 ± 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: (580 ± 20) For machine tools add 10 gallons water (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 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 - White
Dried compound shall match color of standard sample.

WNG:elz

November 30, 1977
Formula M-971
NEW

MARIETTA, GEORGIA, PLANT FORMULA
READY MIX TOPPING COMPOUND M-971 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Topping Compound used for finishing joint and spotting nail heads.

FORMULA

| Raw Material | Function | RM Spec | Percent | Lbs/Batch |
|---|---|---|---|---|
| Proxel CRL | Preservative | | .047 | .98 |
| Filler M-970 | Filler | | 93.669 | 1950.02 |
| Elvace EP-200 | Adhesive | 185 | 5.998 | 126.0 (14.0 gals) |
| Nalco 71D-5 | Defoamer | 125 | .095 | 2.0 |
| Acrysol ASE-60 | Thickener | 147 | .191 | 4.0 |
| *Water | Solvent | | | 1104.0 (133 gals) |
| | | | 100.000 | 3187.0* |

*Approximately 52 lbs/100 lbs. of active ingredients (this may vary ± 8 gallons per batch.

**One batch yields 51 ± 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

SPECIAL MIXING INSTRUCTIONS - Blend ingredients in following order:
1) Water/Proxel
2) Elvace
3) Nalco
4) Filler M-970
5) Mix until filler is dispersed
6) Add Acrysol ASE-60
7) Mix until Ready Mix is smooth - pumping viscosity should be 480±20 to allow for 24 hour viscosity build of 100 pts

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: (580 ± 20) For machine tools add 7 gallons $H_2O$ (400 ± 20)

pH Minimum - 9.0 Maximum - 10.0 (24 hrs.)

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.

Continued on Page 2 . . .

HCF:jr

January 29, 1969
NEW FORMULA

ATLANTA, GEORGIA PLANT FORMULA

READY MIX FILLER M-971 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound M-974, M-976

FORMULA

| Raw Material | Function | R.M. Spec. | Percent | Lbs./Batch |
|---|---|---|---|---|
| Nalco 71 D5 | Anti-Foaming Agent | - | 0.11 | 4.5 |
| Troysan CMP-10-Sep | Fungicide | 193 | 0.10 | 4.0 |
| Gelvatol 20-30 BP (Poly Vinyl Alcohol) | Adhesive | 162 | 0.80 | 32.0 |
| Natrosol 250 HXR | Water Retention Agent | 170 | 0.65 | 26.0 |
| Mica P80-H | Anti-Cracking Agent | 11 | 13.00 | 520.0 |
| Asbestos 7RF-9 | Bulk | 9 | 4.50 | 180.0 |
| Limestone | Filler | 13 | 80.84 | 3233.5 |
| | | | 100.00 | 4000.0 |

WORKING CONSISTENCY Specifications: - Refer to Plant Testing Procedure No. 32.

| Maximum | Minimum | Average |
|---|---|---|
| 56 | 53 | 55 |

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

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

NOTE: A wet mix of the filler shall be prepared according to Formula No. M-974 or M-976 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 specificatior required of Ready Mix Joint Compound - Formula No. M-974 or M-976.

EDO:kkt

February 11, 1972
Supersedes Formula M-971
Dated 1/29/69

MARIETTA, GEORGIA PLANT FORMULA

READY MIX FILLER M-971 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound M-974, M-976.

-/ FORMULA

| Raw Material | Function | R.M.Spec. | Percent | Lbs/Batch |
|---|---|---|---|---|
| Nalco 71-D | Anti-Foaming agent | - | 0.11 | 4.5 |
| Dowicil 10[illegible] | Fungicide | 193 | 0.15 | 6.0 |
| Gelvatol 2[illegible]-30 BP (Polyvinyl Alcohol) | Adhesive | 162 | 0.80 | 32.0 |
| Natrosol 250 HXR | Water Retention agent | 170 | 0.65 | 26.0 |
| Mica PSO-H | Anti-Cracking agent | 11 | 13.00 | 520.0 |
| Asbestos 7RF-9 | Bulk | 9 | 4.50 | 180.0 |
| Limestone | Filler | 13 | 80.79 | 3231.5 |
| | | | 100.00 | 4000.0 |

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

| Maximum | Minimum | Average |
|---|---|---|
| 56 | 53 | 55 |

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

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

NOTE:

A wet mix of the filler shall be prepared according to Formula No. M-974 or M-976 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. M-974 or M-976.

-/ Denotes change in this reissue.

EDO:dek

SGP 0017485

March 25, 1974
New Formula M-971

MARIETTA, GEORGIA, PLANT FORMULA
READY MIX JOINT COMPOUND M-971 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for topping and spotting nailheads. (To be supplied to selected customers only.)

FORMULA

| Raw Materials | Function | Percent | Lbs/Batch |
|---|---|---|---|
| Water | Solvent | -- | 1030.00 (129 gals)* |
| Nalco | Anti-foaming agent | 0.1 | 2.00 |
| Polyvinyl Acetate Emulsion (preplasticized) | Adhesive | 6.4 | 128.00 ( 4.2 gals) |
| Filler M-970 | Filler | 93.5 | 1865.00 |
| | | 100.0 | 3025.00** |

*Approximately 54.4 lbs/100 lbs. of active ingredients (this may vary ± 8 gallons per batch).

**One batch yields 53 ± 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: 580 ± 20 For machine tools add 5 gals. $H_2O$ (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.

WNG:jg

June 23, 1975
Marietta Formula: M-971
NEW

MARIETTA, GEORGIA, PLANT FORMULA
READY MIX JOINT COMPOUND M-971 (HAND TOOLS)

DESCRIPTION OF PRODUCT- White Ready Mix Joint Compound used for taping, topping and texturing. Special low cost formula.

| FORMULA | Function | Percent | Lbs/Batch |
|---|---|---|---|
| Water | Solvent | -- | 1024.00 (128 gals.)* |
| Nalco | Anti-foaming agent | .2 | 4.00 |
| Elvace 1875 | Adhesive | 2.0 | 39.00 (4.4 gals.) |
| Filler M-970 | Filler | 97.8 | 1950.00 |
| | | 100.0 | 3017.00** |

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary ± 8 gallons per batch.

**One batch yields 49 ± 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: (580 ± 20) For machine tools add 10 gallons water (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 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 - White
Dried compound shall match color of standard sample.

WNG:elz

November 30, 1977
Formula M-971
NEW

MARIETTA, GEORGIA, PLANT FORMULA
READY MIX TOPPING COMPOUND M-971 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Topping Compound used for finishing joint and spotting nail heads.

FORMULA

| Raw Material | Function | RM Spec | Percent | Lbs/Batch |
|---|---|---|---|---|
| Proxel CRL | Preservative | | .047 | .98 |
| Filler M-970 | Filler | | 93.669 | 1950.02 |
| Elvace EP-200 | Adhesive | 185 | 5.998 | 126.0 (14.0 gals) |
| Nalco 71D-5 | Defoamer | 125 | .095 | 2.0 |
| Acrysol ASE-60 | Thickener | 147 | .191 | 4.0 |
| *Water | Solvent | | | 1104.0 (133 gals) |
| | | | 100.000 | 3187.0* |

*Approximately 52 lbs/100 lbs. of active ingredients (this may vary ± 8 gallons per batch.

**One batch yields 51 ± 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

SPECIAL MIXING INSTRUCTIONS - Blend ingredients in following order:
1) Water/Proxel
2) Elvace
3) Nalco
4) Filler M-970
5) Mix until filler is dispersed
6) Add Acrysol ASE-60
7) Mix until Ready Mix is smooth - pumping viscosity should be 480±20 to allow for 24 hour viscosity build of 100 pts

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: (580 ± 20) For machine tools add 7 gallons $H_2O$ (400 ± 20)

pH Minimum - 9.0 Maximum - 10.0 (24 hrs.)

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.

Continued on Page 2 . . .

HCF:jr

SGP 0017472

**MARIETTA FORMULA #971**
**ASBESTOS CONTAINING PRODUCTS**