

July 30, 1963
Supersedes Formula TFX-9
Dated March 27, 1963

ACME, TEXAS PLANT FORMULA

ONE DAY WALLBOARD JOINT COMPOUND TEX-992

DESCRIPTION OF PRODUCT - For use in all applications in the reinforcing and concealing of joints, except the final finish.

FORMULA

Raw Materials	Source	R.M.Spec.	%
Sodium Citrate	Open Market		0.125
Methocel MC, 4000 cps	Dow Chemical Co.		0.40
DiButyl Phthalate	Monsanto Chem. Co.		0.50
Gelvatol 20-30 BP	Shawinigan Resins Co.		1.50
Gelva D-702	" " "		3.00
Clay CW	J. M. Huber Co.		3.00
Asbestos 7RP-9	Phillip Carey Co.	9	1.50
-/ Tex-38	Bestwall Gypsum, Acme		86.675
Petr6-Ad	The Thornley Co.		0.100
-/ Yellow Oxide #2087	C. K. Williams Co.		0.200

*Vary to adjust setting time.

Working Consistency - Refer to Plant Testing Procedure No. 32.

Specification	-	Maximum	Minimum	Average
		62	58	60

Setting Time - Refer to Plant Testing Procedure No. 6 (slow set).

Specification	-	Maximum	Minimum	Average
		3 hrs., 45 min.	2 hrs., 45 min.	-

Working Properties - Refer to Plant Testing Procedure No. 33.

Specification - Must be plastic and buttery working; free of grit or coarse particles.

Bonding Properties - Refer to Plant Testing Procedure No. 35.

Specification - After compound has dried, tape shall delaminate when peeled back.

Crack Resistance - Refer to Plant Testing Procedure No. 37.

Specification - There shall be no large fissure cracks in the wedge and very few, if any, cracks in the thinner half of the wedge.

-/ Denotes change.

NFM

PLAINTIFF'S EXHIBIT

GP-442

SGP 0018373

September 17, 1969
NEW FORMULA

ACME, TEXAS PLANT FORMULA

ONE DAY WALLBOARD JOINT COMPOUND (WHITE) NO. TEX-992
(speed-set)

DESCRIPTION OF PRODUCT - For reinforcing and concealing joints and nailheads.
To be supplied on request only.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs./Batch</u>	
Sodium Citrate*	Retarder	134	0.1	2 lbs.	6 oz
Natrosol 250HXR	Thickner	170	0.50	10 "	3 = 11 oz
Gelvato1 RS6219	Adhesive	162	3.50	70 "	26 = 502
Clay K-70	Filler	167	3.00	60 "	22 = 802
Asbestos 7RF-9	Fiber Filler	9	4.00	80 "	30 "
Petro AD	Wetting Agent	143	0.10	2 "	11 oz
TEX-38	Filler	-	88.80	1776 "	666 "
			100.00	2000 "	750 "

* (vary to adjust-setting time)

WORKING CONSISTENCY

Specification:

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
64	56	60

SETTING TIME

Specification:

- Refer to Plant Testing Procedure No. 6 (slow set)

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
120 105-min.	90 75 min.	90 min.

*for M.P. 9.22.69
L.H.*

WORKING PROPERTIES

Specification:

- Refer to Plant Testing Procedure No. 33.
Should have good working properties and be free of any grit or extraneous material.

BONDING PROPERTIES

Specification:

- Refer to Plant Testing Procedure No. 35.
After the compound has dried, the tape shall delaminate when peeled back.

CRACK RESISTANCE

Specification:

- Refer to Plant Testing Procedure No. 37.
There shall be no large cracks in the wedge.

EDO:dek

For 993 add 1 1/2 lb yellow oxide

SGP 0018374

ACME, TEXAS PLANT FORMULA

ONE DAY WALLBOARD JOINT COMPOUND (WHITE) NO. TEX-992
(Speed-Set)

DESCRIPTION OF PRODUCT - For reinforcing and concealing joints and nailheads.
To be supplied on request only.

<u>FORMULA</u>	-				
<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>	
Sodium Citrate*	Retarder	134	0.1	2	12 oz
Natrosol 250 HXR	Thickner	170	0.2	4	1 lb 8 oz
Gelvatol RS 6219	Adhesive	162	3.0	60	22 lb 5 oz
Gelva	Adhesive	161	1.0	20	7 lb 8 oz
Asbestos	Fiber Filler	9	3.5	70	26 lb 4 oz
Defoamer M111	Defoamer	196	0.1	2	12 oz
TEX-38	Filler	-	92.1	1842	690 lb 12 oz
			100.0	2000	750 lb

* Vary to adjust-setting time.

<u>WORKING CONSISTENCY</u>	-	Refer to Plant Testing Procedure No. 32.
<u>Specifications:</u>		<u>Maximum</u> <u>Minimum</u> <u>Average</u>
		62 54 58

<u>SETTING TIME</u>	-	Refer to Plant Testing Procedure No. 6. (slow set)
<u>Specifications:</u>		<u>Maximum</u> <u>Minimum</u> <u>Average</u>
		105 min. 75 min. 90 min.

WORKING PROPERTIES - Refer to Plant Testing Procedure No.33.
Specifications: Should have good working properties and be free of any grit or extraneous material.

BONDING PROPERTIES - Refer to Plant Testing Procedure No. 35.
Specifications: After the compound has dried, the tape shall delaminate when peeled back.

CRACK RESISTANCE - Refer to Plant Testing Procedure No. 37.
Specifications: There shall be no large cracks in the wedge.

EDO:dek

-/ Denotes change in this reissue.

September 8, 1971
NEW FORMULA TEX-992

ACME, TEXAS PLANT FORMULA
SPEED SET JOINT COMPOUND WHITE TEX-992
(1 hour working cement)

DESCRIPTION OF PRODUCT: - For use in reinforcing and concealing joints and nailheads.

FORMULA:

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
*Sodium Citrate	Retarder	134	0.10	0.750
Natrosol 250 HXR	Thickner	170	0.25	1.875
Gelvaton RS-6278C	Adhesive	162	2.00	15.000
Gelva GP702	Adhesive	167	0.50	3.750
Asbestos SG210	Fiber Filler	-	1.50	11.250
Asbestos 7RF09	Fiber Filler	9	3.25	24.375
Mica p80H	Anti-Cracking Agent	11	5.00	37.500
Defoamer M117	Anti-Foaming Agent	196	.10	.750
Vanicide	Fungicide	126	.10	.750
Denscal	Plaster	-	87.20	645.375
			100.00	750.000

*Adjust quantity according to set time requirements.

<u>WORKING CONSISTENCY:</u>	<u>Refer to Plant Testing Procedure No. 32.</u>		
<u>Specifications</u>	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
	62	58	60

<u>SETTING TIME:</u>	<u>Refer to Plant Testing Procedure No. 6 (slow set)</u>		
<u>Specifications</u>	110 min.	70 min.	90 min.

<u>WORKING PROPERTIES:</u>	<u>Refer to Plant Testing Procedure No. 33.</u>		
<u>Specifications</u>	Must be plastic and buttery working; free of grit or coarse particles.		

<u>BONDING PROPERTIES:</u>	<u>Refer to Plant Testing Procedure No. 35.</u>		
<u>Specifications</u>	After compound has dried, tape shall delaminate when peeled back.		

<u>CRACK RESISTANCE:</u>	<u>Refer to Plant Testing Procedure No. 37.</u>		
<u>Specifications</u>	There shall be no large fissure cracks in the wedge and very few, if any, cracks in the thinner half of the wedge.		

EDO:dek

SGP 0018376

January 28, 1972
Supersedes TEX-992
Dated 9/8/71

ACME, TEXAS PLANT FORMULA
SPEED SET JOINT COMPOUND WHITE TEX-992
(1 hour working cement)

DESCRIPTION OF PRODUCT: - For use in reinforcing and concealing joints
and nailheads.

FORMULA:

<u>-/ Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
*Sodium Citrate	Retarder	134	0.10	0.750 3-07
Natrosol 250 HXR	Thickner	170	0.25	1.875 1 lb 14 oz
Gelvatol RS-6278C	Adhesive	162	1.50	11.250 11 lb 2 oz
Gelva GP702	Adhesive	167	0.50	3.750 3 lb 12 oz
Asbestos SG210	Fiber Filler	-	1.75	13.125 13 lb 2 oz
Asbestos 7RF09	Fiber Filler	9	5.00	37.500 37 lb 8 oz
Mica p80H	Anti-Cracking Agent	11	5.00	37.500 37 lb 8 oz
Defoamer M111	Anti-Foaming Agent	196	.10	.750 12 oz
Vanicide	Fungicide	126	.10	.750 12 oz
Denscal	Plaster	-	85.70	642.750
			100.00	750.000

*Adjust quantity according to set time requirements.

<u>WORKING CONSISTENCY:</u>	- Refer to Plant Testing Procedure No. 32.
<u>Specifications</u>	<u>Maximum</u> <u>Minimum</u> <u>Average</u>
	62 58 60

<u>SETTING TIME:</u>	- Refer to Plant Testing Procedure No. 6 (slow set)
<u>Specifications</u>	110 min. 70 min. 90 min.

<u>WORKING PROPERTIES:</u>	- Refer to Plant Testing Procedure No. 33.
<u>Specifications</u>	Must be plastic and buttery, working; free of grit or coarse particles.

<u>BONDING PROPERTIES:</u>	- Refer to Plant Testing Procedure No. 35.
<u>Specifications</u>	After compound has dried, tape shall delaminate when peeled back.

<u>CRACK RESISTANCE:</u>	- Refer to Plant Testing Procedure No. 37.
<u>Specifications</u>	There shall be no large fissure cracks in the wedge and very few, if any, cracks in the thinner half of the wedge.

-/ denotes change

EDO:elz

SGP 0018377

**ACME FORMULA #992
ASBESTOS CONTAINING PRODUCTS**