

NEW
Formula V-972
October 30, 1979

MILFORD, VIRGINIA, PLANT FORMULA
READY MIX TOPPING COMPOUND V-972 (HAND TOOLS)

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

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Pyrophyllite-SK	Bulking Agent	1	7.289	150.00
Limestone	Filler	13	83.677	1722.00
Methocel 240	Water Retention	163	.340	7.00
PMA-30	Preservative	--	.044	.91
Aqua-Fil K-8	Bulking Agent	229	3.450	71.00
C-9-136 Starch	Adhesive	10	.875	18.00
DuPont JCM	Adhesive	185	4.325	89.00 (10.0 gal)
Water *	Solvent	--	--	1026.00 (124 gal)
			100.000	3083.91 **

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

** One batch yields 49 five-gallon pails Ready Mix Joint Compound at
62 lbs/pail.

SPECIAL MIXING
INSTRUCTIONS

- Blend ingredients in following order:
 - 1) Water/PMA-30
 - 2) JCM
 - 3) Filler
 - 4) Mix until REady Mix is smooth - pumping
viscosity should be 520 ± 20.

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 (520 ± 20)

For machine tools, add 4 gallons H₂O
(470 ± 20).

pH

Minimum - 8.0 Maximum - 9.0 (24 hrs)

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October 30, 1979

Formula V-972

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WORKING PROPERTIES

Specifications

- Refer to Plant Testing Procedure No. 33.
Compound shall be plastic, buttery working and free of any coarse, gritty and 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.
Rating shall be 4 or better.

COLOR

Specifications

- White
Dried compound shall match color of standard sample.

HCF:ps

SGP 0017578

September 23, 1980
Supersedes Formula V-972
dated 10/30/79

MILFORD, VIRGINIA, PLANT FORMULA
READY MIX TOPPING COMPOUND V-972 (HAND TOOLS)

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

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Pyrophyllite-SK	Bulking Agent	1	7.288	150.00
Limestone	Filler	13	83.652	1722.00
Methocel 240	Water Retention	163	.340	7.00
-/ Proxel CRL	Preservative	--	.074	1.52
Aqua-Fil K-8	Bulking Agent	229	3.449	71.00
C-9-136 Starch	Adhesive	10	.874	18.00
DuPont JCM	Adhesive	185	4.323	89.00 (10.0 gal)
Water *	Solvent	--	--	1024.48 (124 gal)
			100.000	3083.00 **

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

** One batch yields 49 five-gallon pails Ready Mix Joint Compound at
62 lbs/pail.

SPECIAL MIXING
INSTRUCTIONS

- Blend ingredients in following order:
 - 1) Water/PMA-30
 - 2) JCM
 - 3) Filler
 - 4) Mix until Ready Mix is smooth - pumping
viscosity should be 520 ± 20.

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 (520 ± 20)

For machine tools, add 4 gallons H₂O
(470 ± 20).

pH

Minimum - 8.0 Maximum - 9.0 (24 hrs)

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-/ denotes change

SGP 0017579

September 24, 1980
Supersedes Formula V-972
dated 9/23/80

MILFORD, VIRGINIA, PLANT FORMULA
READY MIX TOPPING COMPOUND V-972 (HAND TOOLS)

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

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Pyrophyllite-SK	Bulking Agent	1	7.284	150.00
Limestone	Filler	13	83.620	1722.00
Methocel 240	Water Retention	163	.340	7.00
-/ Proxel CRL	Preservative	--	.112	2.31
Aqua-Fil K-8	Bulking Agent	229	3.448	71.00
C-9-136 Starch	Adhesive	10	.874	18.00
DuPont JCM	Adhesive	185	4.322	89.00 (10.0 gal)
Water *	Solvent	--	--	1023.69 (124 gal)
			100.000	3083.00 **

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

** One batch yields 49 five-gallon pails Ready Mix Joint Compound at
62 lbs/pail.

SPECIAL MIXING
INSTRUCTIONS

- Blend ingredients in following order:

- 1) Water/PMA-30
- 2) JCM
- 3) Filler
- 4) Mix until Ready Mix is smooth - pumping
viscosity should be 520 ± 20 .

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 (520 ± 20)

For machine tools, add 4 gallons H_2O
(470 ± 20).

pH

Minimum - 8.0 Maximum - 9.0 (24 hrs)

Continued on Page 2

-/ denotes change

BGR:ps

SGP 0017580

April 20, 1981
Supersedes Formula V-972
dated 9/24/80

MILFORD, VIRGINIA, PLANT FORMULA
READY MIX TOPPING COMPOUND V-972 (HAND TOOLS)

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

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
-/ Pyrophyllite-SK	Bulking Agent	1	7.285	150.00
-/ Limestone	Filler	13	83.638	1722.00
Methocel 240	Water Retention	163	.340	7.00
-/ Proxel CRL	Preservative	--	.092	1.90
Aqua-Fil K-8	Bulking Agent	229	3.448	71.00
C-9-136 Starch	Adhesive	10	.874	18.00
-/ DuPont JCM	Adhesive	185	4.323	89.00 (10.0 gal)
-/ Water *	Solvent	--	--	1024.10 (124 gal)
			100.000	3083.00 **

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

** One batch yields 49 five-gallon pails Ready Mix Joint Compound at
62 lbs/pail.

SPECIAL MIXING
INSTRUCTIONS

- Blend ingredients in following order:
 - 1) Water/PMA-30
 - 2) JCM
 - 3) Filler
- / 4) Mix until Ready Mix is smooth - pumping
viscosity should be 550 ± 20.

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 (550 ± 20)

For machine tools, add 4 gallons H₂O
(420 ± 20).

pH

Minimum - 8.0 Maximum - 9.0 (24 hrs)

Continued on Page 2

-/ denotes change

BGR:ps

SGP 0017581

September 17, 1981
Supersedes Formula V-972
dated 4/20/81

MILFORD, VIRGINIA, PLANT FORMULA
READY MIX TOPPING COMPOUND V-972 (HAND TOOLS)

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

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
-/ Pyrophyllite-SK	Bulking Agent	1	7.283	150.00
-/ Limestone	Filler	13	83.603	1722.00
Methocel 240	Water Retention	163	.340	7.00
-/ Proxel CRL	Preservative	--	.133	2.73
-/ Aqua-Fil K-8	Bulking Agent	229	3.447	71.00
C-9-136 Starch	Adhesive	10	.874	18.00
-/ DuPont JCM	Adhesive	185	4.320	89.00 (10.0 gal)
-/ Water *	Solvent	--	--	1023.27 (124 gal)
			100.000	3083.00 **

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

** One batch yields 49 five-gallon pails Ready Mix Joint Compound at
62 lbs/pail.

SPECIAL MIXING
INSTRUCTIONS

- Blend ingredients in following order:
1) Water/PMA-30
2) JCM
3) Filler
4) Mix until Ready Mix is smooth - pumping
viscosity should be 550 ± 20.

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 (550 ± 20)

For machine tools, add 4 gallons H₂O
(420 ± 20).

pH

Minimum - 8.0 Maximum - 9.0 (24 hrs)

Continued on Page 2

-/ denotes change

BGR:ps

SGP 0017582

October 2, 1981
Supersedes Formula V-972,
dated 6/17/81

MILFORD, VIRGINIA, PLANT FORMULA
READY MIX TOPPING COMPOUND V-972 (HAND TOOLS)

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

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Pyrophyllite-SK	Bulking Agent	1	7.283	150.00
Limestone	Filler	13	83.603	1722.00
Methocel 240	Water Retention	153	.340	7.00
-/ Proxel CRL ***	Preservative	--	.133	2.73
Aqua-Fil K-8	Bulking Agent	229	3.447	71.00
C-9-136 Starch	Adhesive	10	.874	18.00
DuPont JCM	Adhesive	185	4.320	89.00 (10.0 gal)
Water *	Solvent	--	--	1023.27 (124 gal)
			100.000	3083.00 **

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

** One batch yields 49 five-gallon pails Ready Mix Joint Compound at
62 lbs/pail.

*** Nuosept 95, at a loading of 9 lbs/batch, may be substituted for Proxel
CRL.

SPECIAL MIXING
INSTRUCTIONS:

- Blend ingredients in following order:
1) Water/Proxel CRL
2) JCM
3) Filler
4) Mix until Ready Mix is smooth - pumping
viscosity should be 550 ± 20.

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 (550 ± 20)

For machine tools, add 4 gallons H₂O
(420 ± 20).

pH

Minimum - 8.0 Maximum - 9.0 (24 hrs)

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-/ denotes change

BGR:ps

SGP 0017583

April 26, 1982
FORMULA V-972
N E W

MILFORD, VIRGINIA, PLANT FORMULA
READY MIX JOINT COMPOUND V-972 (HAND TOOLS)

-/ DESCRIPTION OF PRODUCT

- White Ready Mix Joint Compound used for taping, topping and texturing. For selected market trials only.

FORMULA:

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs./Batch</u>
Filler	Filler		95.08	2050.0
DuPont JCM	Adhesive	185	4.41	95.0 (10.7 gals
Nuosept 95	Preservative	129	.42	9.0
Water *	Solvent			994.0 (119.8 gal
-/ MD-76 ***	Defoamer	195	.09	2.0 -
				3150.0 **

* Approximately 48 lbs/100 lbs. of active ingredients (this may vary $\pm$ 6 gallons per batch).

** One batch yields 50 $\pm$ 1 five-gallon pail Ready Mix Joint Compound at 62 lbs/batch.

*** Nalco 11-D5 can be substituted at equal loading

SPECIAL MIXING INSTRUCTIONS - Blend ingredients in following order:

- 1) Water / Nuosept 95.
- 2) JCM
- / 3) Defoamer MD-76
- / 4) Filler V-973
- 5) Mix until Ready Mix is smooth — pumping viscosity should be 540 $\pm$ 20.

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WORKING CONSISTENCY

Specifications for
Paste

Brabender (540 $\pm$ 20)

pH

- 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.
- For machine tools add 4 gallons H₂O (450 $\pm$ 20).
- 7.0 - 8.5

WORKING PROPERTIES

- 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

- Refer to Plant Testing Procedure No. 35.
- After compound has dried, tape shall show at least 90% fiber tear when delaminated.

CRACK RESISTANCE

- Refer to Plant Testing Procedure no. 37.

Rating shall be 4 or better.

COLOR

Specification

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

June 11, 1982
Supersedes FORMULA V-972
dated 4/26/82

MILFORD, VIRGINIA, PLANT FORMULA
READY MIX JOINT COMPOUND V-972 (HAND TOOLS)

-/ DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound
used for taping, topping and
texturing.

FORMULA:

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs./Batch</u>
Filler	Filler		95.08	2050.0
DuPont JCM	Adhesive	185	4.41	95.0 (10.7 gals.)
Nuosept 95	Preservative	129	.42	9.0
Water *	Solvent			994.0 (119.8 gals.)
MD-76 ***	Defoamer	195	.09	2.0
				<u>3150.0 **</u>

* Approximately 48 lbs/100 lbs. of active ingredients (this
may vary $\pm$ 6 gallons per batch).

** One batch yields 50 + 1 five-gallon pail Ready Mix Joint
Compound at 62 lbs/batch.

*** Nalco 71-D5 can be substituted at equal loading.

SPECIAL MIXING INSTRUCTIONS - Blend ingredients in following
order:

- 1) Water / Nuosept 95.
- 2) JCM
- 3) Defoamer MD-76
- 4) Filler V-973
- 5) Mix until Ready Mix is smooth —
pumping viscosity should be
540 $\pm$ 20.

(continued on page 2)

HCF:ps

SGP 0017586