

March 17, 1966
NEW FORMULA
Paoli Laboratory

PLAINTIFF'S EXHIBIT

GP-459

AKRON, NEW YORK PLANT FORMULA

READY MIX JOINT COMPOUND AK-976-Y (MACHINE TOOLS) (READY MIX "Y")

DESCRIPTION OF PRODUCT - Yellow

Ready Mixed Joint compound used for taping, covering tape, filling cornerbead and spotting nails.

FORMULA

<u>Raw Material</u>	<u>Source</u>	<u>% Act. Ingr.</u>	<u>Lbs./Batch</u>
Water	Akron Plant	-	433.0 (52 gal.)*
Nalco 71-DS	Nalco Chemical Co.	0.10	0.8
Filler AK-971	Akron Plant	91.315	700.0
Elvacet 81-900	DuPont	8.00	61.5
Benzoflex 30	Tennessee Products Chem.	0.50	4.0
Yellow Oxide #2087	C. K. Williams Co.	.085	1.0
		<u>100.00</u>	<u>1200.3**</u>

*Approximately 56.5 lb./100 lbs. of active ingredients (this may vary $\pm$ 2 gallons per batch).

**One batch yields 18 (+) - 5 gallon pails of Ready Mix Joint Compound at 65.6 lbs./pail.

TESTING CONSISTENCY

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

Specifications for Paste: If paste is not proper working consistency, a maximum of 5 c.c. water per 150 grams of paste may be added to adjust.

Brabender - 330⁺ - 30

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

Compound shall be plastic, buttery working, and free of any coarse, gritty, or undispersed particles. Plaster shall be free from lumps due to incomplete mixing.

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

Specifications: After compound has dried, tape shall show at least 75% fiber tear when delaminated.

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

Specifications: There shall be no large fissure cracks in the wedge, and no cracks in the thinner half of the wedge.

Color - Yellow

Specifications: Dried compound shall match color of standard sample.

SGP 0018019

AKRON, NEW YORK PLANT FORMULA

READY MIX JOINT COMPOUND AK-976-Y (MACHINE TOOLS) (READY MIX "X")

DESCRIPTION OF PRODUCT - Yellow Ready Mix Joint compound used for taping, covering tape, filling cornerbead and spotting nails.

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<u>FORMULA</u> <u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs./Batch</u>
Water	Solvent	-	-	2165.0 (260 gal.)
Filler C-971	Body	-	91.32	3500.0
Poly Vinyl Ace- tate Emulsion	Adhesive	185	8.03	306.0
Benzoflex 50	Plasticizer	183	.52	20.0
Yellow Oxide 2087	Pigment	139	.13	3.2
			100.00	5994.2 **

*Approximately 56.5 lbs/100 lbs of active ingredients (this may vary $\pm$ 8 gallons per batch).

**One batch yields 90 (+) - 5 gallon pails of Ready Mix Joint Compound at 65.6 lbs/pail.

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 - 385 $\pm$ 20

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.

BONDING PROPERTIES - Refer to Plant Testing Procedure No. 35.
Specifications: After compound has dried, tape shall show at least 75% fiber tear when delaminated.

CRACK RESISTANCE - Refer to Plant Testing Procedure No. 37.
Specifications: There shall be no large fissure cracks in the wedge, and no cracks in the thinner half of the wedge.

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

-/ Denotes change in this reissue.

RRB:kgc

SGP 0018020

May 27, 1970

Supersedes Formula No. AK-976-Y

Dated 9/16/68

AKRON, NEW YORK PLANT FORMULA

READY MIX JOINT COMPOUND AK-976-Y (MACHINE TOOLS) (READY MIX "X")

DESCRIPTION OF PRODUCT: - Yellow Ready Mix Joint compound used for taping, covering tape, filling cornerbead and spotting nails.

-/ FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M.Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Water	Solvent	-	-	2165.0 (260 gal.)*
Filler C-971	Body	-	91.87	3500.0
Poly Vinyl Ac tate Emulsion	Adhesive	185	7.50	285.0
Benzoflex 50	Plasticizer	183	.50	19.0
Yellow Oxide 2087	Pigment	139	.13	3.20
			100.00	5972.2**

* Approximately 56.5 lbs/100 lbs of active ingredients (this may vary $\pm$ 8 gallons per batch).

** One batch yields 90 (+) - 5 gallon pails of Ready Mix Joint Compound at 65.6 lbs/pail.

WORKING CONSISTENCY

- Specifications for Paste: Refer to Plant Testing Procedure No. 32.
If paste is not proper working consistency, a maximum of 5cc water per 150 grams of paste may be added to adjust.

Brabender - 385 $\pm$ 20

WORKING PROPE TIES

- 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: Yellow
Dried compound shall match color of standard sample.

-/ Denotes change in this reissue.

EDO:dek

SGP 0018021

**AKRON FORMULA #976-Y
ASBESTOS CONTAINING PRODUCTS**