

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved: <i>JF</i>	CONFIDENTIAL DO NOT REPRODUCE OR COPY READY MIXED JOINT COMPOUND JE-533A - DALLAS	No. 61-2-24-2-D Date 8-29-66 Page 2 Cancels Dated NEW
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FORMULA

	<u>N.V.</u>	<u>lbs. per 2000 lbs N.V. batch</u>
Mica JC	0.8 V value	230 to 280 lbs. normal range
Carey 7RP9 asbestos	as req'd - approx. 4.25%	about 65 lbs.
Methocel 65HG - 4000 cps	0.9%	18 lbs.
Excello clay	2.5%	50 lbs.
Flo Float JP	to make 100% NV	to make 2000 lbs. N.V.
-100 mesh Possolanic Filler (Knox Co.)	40.0%	800 lbs.
Ammonium pentaborate	1.0%	20 lbs.
PR 674 plasticized emulsion	6.0% N.V.	200 lbs.
Carbitol	-----	20 lbs.

*Based on 60% solids emulsion. If a diluted emulsion is used the emulsion weight must be increased proportionately.

RAW MATERIAL SPECIFICATIONS

All are current paint plant raw materials except the possolanic filler which is being sent to the Dallas Plant by Mr. F. C. Appleyard's direction. It must be screened through a 100 mesh screen before use to remove "grit".

End

00009 1495

SPECIAL BULLETIN

Operating Division	CONFIDENTIAL DO NOT REPRODUCE OR COPY READY MIXED JOINT COMPOUND-ALL PURPOSE (JE-604-A) DALLAS	No. 61-2-42-2-P
PRODUCT PROCEDURE		Date 8-22-67
Approved: <i>[Signature]</i>		Page 2
		Canceled
		Dated NEW

FORMULA

	JE-604-A
Mica	0.8 Formula V
75F9 Asbestos	5.0% N.V.
Excallo Clay	2.5
Huber CWF Clay	2.5
Methocel	.8
Pozzolanic Filler (Ground at Ft. Worth WMC plant)	40.0
Microfil #2	To Make 100% N.V.
G.P. 952-3 milo flour	1.5
PM 4386 emulsion	4.5% N.V.
PMA 30	1.2 lbs. per 230 gal. batch

RAW MATERIALS

All raw materials are standard at Dallas except the Ft. Worth grind - pozzolanic filler.

End

00009 1501

SPECIAL BULLETIN

Operating Division	READY MIXED JOINT COMPOUND	No. 61-2-24-2-F
PRODUCT PROCEDURE	ALL PURPOSE	Date 8-30-67
Approved: <i>JP</i>	(JZ-604-A)	Page 1
	DALLAS	Cancels Page 1
		Dated 8-22-67

C This Bulletin expires 3-1-68.

Dallas is authorized to make 1 batch (230 gallons) of JZ-604-A Ready Mixed Compound using pozzolanic filler from the Ft. Worth (Western Mica) plant. Ship only for field trials as directed by #961 or #151.

IDENTIFICATION AND PACKAGING

In standard 5 gal. RM Cartons (or cans if so directed by AB Knudsen). Add PF after date-batch code.

FINISHED PRODUCT SPECIFICATIONS

Color

Natural White

Viscosity

At normal 525 BB, unless trials to be run with Marck Bros. (Houston). In this case adjust BB to 'Marck consistency' i.e. 450 BB.

Other Properties

Per Bulletin 61-2-24-2.

- 0 -

EXPIRED 3-1-68

0P009 1500

SPECIAL BULLETIN

Operating Division

PRODUCT PROCEDURE

Approved:

CONFIDENTIALDO NOT REPRODUCE OR COPY
READY MIXED JOINT COMPOUND-ALL PURPOSE
(JE-604-A) DALLAS

No. 61-2-24-2-F

Date 8-30-67

Page 2

Cancels 61-2-42-2-F

Dated 8-22-67

FORMULA

JE-604-A

Mica	0.8 Formula V
7RF9 Asbestos	5.0% N.V.
Excello Clay	2.5
Huber CWF Clay	2.5
Methocel	.8
Pozzolanic Filler (Ground at Ft. Worth W&E plant)	40.0
Microfil #2	To Make 100% N.V.
G.P. 952-3 milo flour	1.5
PM 4386 emulsion	4.5% N.V.
PMA 30	1.2 lbs. per 230 gal. batch

RAW MATERIALS

All raw materials are standard at Dallas except the Ft. Worth grind -
pozzolanic filler.

End

DP009 1571

No. 61-2-24-AA
Date 11-19-69
Page 2
Cancels Page 2
Dated 4-16-69

READY-MIXED JOINT COMPOUND - ALL PURPOSE
(JZ-6847)

FINISHED PRODUCT SPECIFICATIONS

		<u>Dallas</u>	<u>Cytsum</u>
A. Viscosity	- Regular	- 525 to 575BB	600 $\pm$ 30 BB
	Marek	- 425 to 475BB	
	Extra	- Per Bulletin 61-2-24-2	700 $\pm$ 30 BB
	Mechanical		
	Tools	- Per Bulletin 61-2-24-2	400 $\pm$ 25 BB

All viscosities run using VC-3 Brabender, pin paddle, @ 75 RPM
250 cm. gm. torque head.

- B. Bond - 4 minimum. Tested as per Bulletin 61-2-24-2.
- C. Color - White or pigmented. To match standards.
- D. Application & Dry Appearance - To match plant standards. No grit or lumps in application. No cracking on bond test panel. Testing as per Bulletin 61-2-24-2.
- E. Weight Per Gallon - 12.5 to 12.8 lbs. per gal. for regular viscosity material.

- 0 -

SPECIAL BULLETIN

Operating Division

PRODUCT PROCEDURE

Approved: *[Signature]***CONFIDENTIAL**

DO NOT REPRODUCE OR COPY

READY-MIXED JOINT COMPOUND -
ALL PURPOSE (JE-684A)

No. 61-2-24-AA

Date 11-19-69

Page 3

Cancels Page 3

Dated 4-16-69

FORMULA

	<u>3 Non-Volatile</u>	<u>Pounds-2000 Lbs. N. V.</u>
Mica JC	V	280 to 300 approx.
PC72F9 Asbestos	As req'd for visc. 4.5 to 5.5% normal	90 to 110 approx.
Methocel 65 HG	0.7	14
Flo-Float*	to 100% N. V.	1500 approx.
Hamaco 267	2.0%	40
FM4386 (w/o FMA-30)	2.5%	83.3
Tamol 850	---	3 to 4 as req'd
FMA-30	---	1
Water		160 to 162 gal. approx. for regular viscosity

* Gypsum to use Stonelite, Per FMS 6-24-2 for Pigmented Ready Mix, and #9NCS, per FMS 6-24-9, for White Ready Mix.

RAW MATERIALS

Per Bulletin 61-2-24-2 plus:

Tamol 850	FMS 6-177-9
Hamaco 267	A. E. Staley Mfg. Co., Decatur, Ill.

MANUFACTURING PROCEDURE

General procedures as per Bulletin 61-2-42-2.

- Note: 1. Add Tamol 850 to water and emulsion and mix before adding dry ingredients.
2. If FMA-30 is normally added to the emulsion in bulk, extra FMA-30 will be necessary since the amount of emulsion has been reduced. This extra preservative should be added to the water/emulsion premix.

END

JP009 1059

Operating Division	USG READY MIXED JOINT	No. 61-2-24-1
PRODUCT PROCEDURE	COMPOUND - ALL PURPOSE	Date 1-5-70
Approved:		Page 1
		Cancels Page 1
		Dated 4-16-69

DESCRIPTION

A resin-emulsion base, ready-mixed joint compound, with a package life of one year.

MANUFACTURING PLANT

Chamblee

PRODUCT LINE

A. USG Ready Mixed Joint Compound - All Purpose. Regular Consistency 600-650 Brabender.

B. Ames Consistency

A USG Ready Mixed Joint Compound - All Purpose at an Ames Tool Consistency of 425-475 Brabender units, at 77° F, by diluting with extra water.

C. Heavy Consistency

On special order only. Brabender range to be 700-750. Cans to be marked "Heavy".

D. "EXTRA HEAVY" on special order only, 800-850 BB. Cans to be marked "Extra Heavy".

E. Special Ames Consistency

Brabender to be on the high side of the Ames range. Cans will not be marked special for customers who use this for hand application.

IDENTIFICATION AND PACKAGING

A. 1 Gallon Can

Per P'S 8-15-2. Master carton per P'S 8-10-34. Label as directed by 147-2.

B. 4 Gallon Carton

Per P'S 8-10-29-2. Liner per P'S 8-5-4.

C. 5 Gallon Pail

Per P'S 8-29-3.

D. 100' System

Two gallon cans per P'S 8-15-12 of compound packed with a 100' roll of PERF-A-TAPE on top of each can. Master carton per P'S 8-10-16. Label as directed by 147-2. Two (2) WB-34 folders to be included in each master carton.

SPECIAL BULLETIN

Operating Division	CONFIDENTIAL DO NOT REPRODUCE OR COPY READY-MIXED ALL PURPOSE JOINT COM- POUND-CF SOUTH GATE	No. 61-2-24-4-B
		Date 1-30-70
PRODUCT PROCEDURE .		Page 2
Approved: _____		Cancelis Dated NEW

FORMULA (JE-684F)

	<u>% Non-Volatile</u>	<u>Pounds-2000 Lbs. N.V.</u>
Mica JC	V	280 to 300 approx.
UCC 210 Standard grade Asbestos	As required for visc. 3% normal	60 approx.
Methocel 65HG	0.8%	16
MW-325	To 100% N.V.	1500 approx.
Banaco 267	2.0%	40
PM#386 (w/o PMA-30)	2.5%	83.3
Tamol 850	- -	3
PMA-30	- -	1
Water		160 to 162 gal. approx. for regular viscosity.

RAW MATERIALS

Per Bulletin 61-2-24-4 plus:

Tamol 850	FMS 6-177-9
Banaco 267	A.E. Staley Mfg. Co., Decatur, Ill.

MANUFACTURING PROCEDURE

General procedure as per Bulletin 61-2-24-4.

- NOTE: 1. Add Tamol 850 to water and emulsion and mix before adding dry ingredients.
2. If PMA-30 is normally added to the emulsion in bulk extra PMA-30 will be necessary since the amount of emulsion has been reduced. This extra preservative should be added to the water/emulsion premix.

END

Originally issued 4-16-69.

SPECIAL BULLETIN

1st Extension

Operating Division	READY-MIXED JOINT COMPOUND- ALL PURPOSE (JE-684F)	No.	61-2-24-AA
PRODUCT PROCEDURE		Date	3-3-70
Approved: <i>[Signature]</i>		Page	1
		Cancels Page 1	
		Dated	11-19-69

C This bulletin expires 3-1-71.

DESCRIPTION

C Gypsum to manufacture Ready-Mixed Joint Compound - All Purpose and ship on all orders unless otherwise specified or authorized by Chicago #971-E.

MANUFACTURING PLANT

C Gypsum

IDENTIFICATION AND PACKAGING

C Packaging per Bulletin 61-2-24. Letter "K" to follow code on all production.

DP009 1054

No. 61-2-24-AA
Date 3-3-70
Page 2
Cancels Page 2
Dated 11-19-69

READY-MIXED JOINT COMPOUND - ALL PURPOSE
(JE-684F)

FINISHED PRODUCT SPECIFICATIONS

		Gypsum
C A. Viscosity	- Regular	600 $\pm$ 30 BB
	Extra	700 $\pm$ 30 BB
	Mechanical	
	Tools	400 $\pm$ 25 BB

All viscosities run using VC-3 Brabender, pin paddle, @ 75 RPM
250 cm. gm. torque head.

- B. Bond - 4 minimum. Tested as per Bulletin 61-2-24-2.
- C. Color - White or pigmented. To match standards.
- D. Application & Dry-Appearance - To match plant standards. No grit or lumps in application. No cracking on bond test panel. Testing as per Bulletin 61-2-24-2.
- E. Weight Per Gallon - 12.5 to 12.8 lbs. per gal. for regular viscosity material.

- 0 -

SPECIAL BULLETIN

Operating Division	CONFIDENTIAL DO NOT REPRODUCE OR COPY	No. 61-2-24-AA
PRODUCT PROCEDURE		Date 3-3-70
Approved: <i>[Signature]</i>	READY-MIXED JOINT COMPOUND - ALL PURPOSE (JZ-684A)	Page 3
		Cancels Page 3
		Dated 11-19-69

FORMULA

	<u>Non-Volatile</u>	<u>Pounds-2000 Lbs. N. V.</u>
Mica JC	V	280 to 300 approx.
PC7379 Asbestos	As req'd for visc. 4.5 to 5.5% normal	90 to 110 approx.
Methocel 65 HG	0.7	14
Carbonate Filler*	to 100% N. V.	1500 approx.
Hamaco 267	2.0%	40
IMA386 (w/o PMA-30)	2.5%	83.3
Tamol 850	—	3 to 4 as req'd
IMA-30	—	1
Water		160 to 162 gal. approx. for regular viscosity

* Gypsum to use Stonelite, Per PMS 6-24-2 for Pigmented Ready Mix, and #9NCS, per IMS 6-24-9, for White Ready Mix.

RAW MATERIALS

Per Bulletin 61-2-24-2 plus:

Tamol 850	PMS 6-177-9
Hamaco 267	PMS 6-124-11

MANUFACTURING PROCEDURE

General procedures as per Bulletin 61-2-42-2.

Note: 1. Add Tamol 850 to water and emulsion and mix before adding dry ingredients.

2. If IMA-30 is normally added to the emulsion in bulk, extra IMA-30 will be necessary since the amount of emulsion has been reduced. This extra preservative should be added to the water/emulsion premix.

END

Originally issued 4-16-69.

SPECIAL BULLETIN

1st Extension

Operating Division	READY-MIXED JOINT COMPOUND- ALL PURPOSE	No.	61-2-24-AA
PRODUCT PROCEDURE		Date	4-20-70
Approved: <i>[Signature]</i>		Page	1
		Cancels Page 1	
	(JE-684F)	Dated	3-3-70

This bulletin expires 3-1-71.

DESCRIPTION

Gypsum to manufacture Ready-Mixed Joint Compound - All Purpose and ship on all orders unless otherwise specified or authorized by Chicago #971-E.

MANUFACTURING PLANT

C Gypsum and Midway

IDENTIFICATION AND PACKAGING

C Packaging per Bulletin 61-2-24.

0P009 1051

SPECIAL BULLETIN

Operating Division
PRODUCT PROCEDURE

CONFIDENTIAL
DO NOT REPRODUCE OR COPY

READY-MIXED JOINT COMPOUND -
ALL PURPOSE (JE-684A)

Approved: *[Signature]*

No. 61-2-24-AA

Date 4-20-70

Page 3

Cancel Page 3

Dated 3-3-70

FORMULA

	<u>% Non-Volatile</u>	<u>Pounds-2000 Lbs. N. V.</u>
Mica JC	V	280 to 300 approx.
PC7RF9 Asbestos	4.0%	80
Methocel 65 EG	0.8%	16
Carbonate Filler*	to 100% N. V.	1500 approx.
Hamaco 267	2.0%	40
PM4386 (w/o PMA-30)	2.5%	83.3
Tamol 850	—	3 to 4 as req'd
PMA-30	—	1
Water		160 to 162 gal. approx. for regular viscosity

* Gypsum to use Stonelite, Per PMS 6-24-2 for Pigmented Ready Mix, and #9NCS, per PMS 6-24-9, for White Ready Mix.

RAW MATERIALS

Per Bulletin 61-2-24-2 plus:

Tamol 850 PMS 6-177-9
Hamaco 267 PMS 6-124-11

MANUFACTURING PROCEDURE

General procedures as per Bulletin 61-2-24-2.

- Note:
1. Add Tamol 850 to water and emulsion and mix before adding dry ingredients.
 2. If PMA-30 is normally added to the emulsion in bulk, extra PMA-30 will be necessary since the amount of emulsion has been reduced. This extra preservative should be added to the water/emulsion premix.

END

07009 1053

Originally issued 3-3-70

SPECIAL BULLETIN

Operating Division	READY-MIXED JOINT COMPOUND-ALL PURPOSE (JE-774D)	No.	61-2-24-DD
PRODUCT PROCEDURE		Date	5-11-70
Approved: <i>[Signature]</i>		Page	1
		Cancels	Page 1
		Dated	3-3-70

This bulletin expires 3-1-71.

DESCRIPTION - Dallas to manufacture and ship Ready Mixed Joint Compound - All Purpose JE-774D on all orders into both the Central and Southern Divisions unless otherwise specified or authorized by Chicago #971-E or Atlanta #981.

Chamblee to manufacture and ship JE-774D for field trials and initial shipments as directed by Atlanta #981.

MANUFACTURING PLANTS - Dallas and Chamblee.

IDENTIFICATION AND PACKAGING - Packaging for Dallas per 61-2-24-2-1 and Chamblee per 61-2-24-1. Letter "K" to follow code on all production.

FINISHED PRODUCT SPECIFICATIONS -

	Dallas	Chamblee
A. <u>Viscosity</u> - Extra Heavy	-	800 to 850 BB
Heavy	700 to 750 BB	700 to 750 BB
Regular	575 to 625 BB	600 to 650 BB
Medium	450 to 500 BB	-
Ames	400 to 450 BB	425 to 475 BB

All viscosities run using VC-3 Brabender, pin paddle, @ 75 rpm with 250 cm torque head.

B. Bond - 4 minimum at 75°F - 50% RH.

C. Color -
(Chamblee) White unless ordered pigmented.
(Dallas) Unpigmented only.

D. pH - 8.9 to 9.2.

- 0 -

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved: <i>[Signature]</i>	CONFIDENTIAL DO NOT REPRODUCE OR COPY READY-MIXED JOINT COMPOUND-ALL PURPOSE (JE-774D) - CHAMBLEE AND DALLAS	No. 61-2-24-DD Date 5-11-70 Page 2 Cancels Page 2 Dated 3-3-70
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FORMULA

	<u>% Non-Volatile</u>	<u>Pounds 2000 lbs. N.V.</u>
Mica JC	Formula V	280 to 300 approx.
Asbestos JMRFO2	as req'd for visc.	60 to 70 approx.
Methocel 65HG	.7	14
#9NCS Carbonate Filler	to 100% N.V.	1450 approx.
Hamaco 267	2.0	40
Huber Clay	2.5	50
Nopco PD-1	.3	6
PM4386 (w/o PMA-30)	2.5	83.3 approx.
CMP Acetate	-	1
Troyan 174		1

RAW MATERIALS

Per Bulletin 61-2-24 except:

Hamaco 267	Per PMS 6-124-11
Nopco PD-1	Nopco Chemical Co.
CMP Acetate	Per PMS 6-100-5
Troyan 174	Per PMS 6-100-14

MANUFACTURING PROCEDURE

General procedure as 61-2-24.

NOTE: 1. Add defoamer and the two preservatives to water and emulsion and mix before adding dry ingredients.

END

OP009 1013

No. 61-2-24-AA
Date 5-15-70
Page 2
Cancels Page 2
Dated 3-3-70

READY-MIXED JOINT COMPOUND - ALL PURPOSE
(JE-684F)

FINISHED PRODUCT SPECIFICATIONS

C	A. Viscosity	- Regular Extra Mechanical Tools	<u>Gypsum</u>
			630 $\pm$ 30 BB
			700 $\pm$ 30 BB
			430 $\pm$ 30 BB

All viscosities run using VC-3 Brabender, pin paddle, @ 75 RPM
250 cm. gm. torque head.

- B. Bond - 4 minimum. Tested as per Bulletin 61-2-24-2.
- C. Color - White or pigmented. To match standards.
- D. Application & Dry- To match plant standards. No grit or lumps in
Appearance application. No cracking on bond test panel. Testing
as per Bulletin 61-2-24-2.
- E. Weight Per - 12.5 to 12.8 lbs. per gal. for regular viscosity
Gallon material.

- 0 -

SPECIAL BULLETIN

Operating Division
PRODUCT PROCEDURE**CONFIDENTIAL****DO NOT REPRODUCE OR COPY**READY-MIXED JOINT COMPOUND -
ALL PURPOSE (JE-684A)

No. 61-2-24-AA

Date 5-15-70

Page 3

Cancels Page 3

Dated 4-20-70

Approved: FORMULA

	<u>% Non-Volatile</u>	<u>Pounds-2000 Lbs. N. V.</u>
Mica JC	V	280 to 300 approx.
PG7279 Asbestos	4.0%	80
Methocel 65 HG	0.8%	16
Carbonate Filler*	to 100% N. V.	1500 approx.
Hamaco 267	2.0%	40
FM4386 (w/o PMA-30)	2.5%	83.3
Tamol 850	—	3 to 4 as req'd
PMA-30	—	1
Water		160 to 162 gal. approx. for regular viscosity

* Gypsum to use Stonelite, Per FMS 6-24-2 for Pigmented Ready Mix, and #9NCS, per FMS 6-24-9, for White Ready Mix. Midway to use Quincy #3.

RAW MATERIALS

Per Bulletin 61-2-24-2 plus:

Tamol 850	FMS 6-177-9
Hamaco 267	FMS 6-124-11

MANUFACTURING PROCEDURE

General procedures as per Bulletin 61-2-24.

- Note: 1. Add Tamol 850 to water and emulsion and mix before adding dry ingredients.
2. If FM4-30 is normally added to the emulsion in bulk, extra FM4-30 will be necessary since the amount of emulsion has been reduced. This extra preservative should be added to the water/emulsion premix.

END

OP009 1350

SPECIAL BULLETIN

Operating Division

PRODUCT PROCEDURE

Approved: **CONFIDENTIAL****DO NOT REPRODUCE OR COPY**READY-MIXED JOINT COMPOUND -
ALL PURPOSES (JE-684F)

No. 61-2-24-AA

Date 5-25-70

Page 3

Cancels Page 3

Dated 5-15-70

FORMULA

	<u>% Non-Volatile</u>	<u>Pounds-2000 Lbs. N. V.</u>
Mica JC	V	280 to 300 approx.
PG73F9 Asbestos	4.0%	80
Methocel 65 HG	0.8%	16
Carbonate Filler*	to 100% N. V.	1500 approx.
Hamaco 267	2.0%	40
FM4386 (w/o FMA-30)	2.5%	83.3
Tamol 850	---	3 to 4 as req'd
FMA-30	---	1
Water		160 to 162 gal. approx. for regular viscosity

* Gypsum to use Stonelite, Per FMS 6-24-2 for Pigmented Ready Mix, and MNCS, per FMS 6-24-9, for White Ready Mix. Midway to use Quincy #3.

RAW MATERIALS

Per Bulletin 61-2-24-2 plus:

Tamol 850	FMS 6-177-9
Hamaco 267	FMS 6-124-11

MANUFACTURING PROCEDURE

General procedures as per Bulletin 61-2-24.

- Note: 1. Add Tamol 850 to water and emulsion and mix before adding dry ingredients.
2. If FMA-30 is normally added to the emulsion in bulk, extra FMA-30 will be necessary since the amount of emulsion has been reduced. This extra preservative should be added to the water/emulsion premix.

JND

OP009 1047

SPECIAL BULLETIN

Operating Division	CONFIDENTIAL DO NOT REPRODUCE OR COPY READY-MIXED ALL PURPOSE JOINT COM- POUND-CF SOUTH GATE	No. 61-2-24-4-B
PRODUCT PROCEDURE		Date 5-28-70
Approved: 		Page 2
		Cancels Page 2 Dated 1-30-70

FORMULA (JE-684F)

	<u>% Non-Volatile</u>	<u>Pounds-2000 Lbs. N.V.</u>
Mica JC	V	280 to 300 approx.
UCC 210 Standard grade Asbestos	As required for visc. 3% normal	60 approx.
Methocel 65HG	0.8%	16
MW-325	To 100% N.V.	1500 aprox.
Banaco 267	2.0%	40
PM4386 (w/o PMA-30)	2.5%	83.3
Tamol 850	- -	3
Troysan CMP acetate (liquid)	- -	1
Troysan 174		2
Water		160 to 162 gal. approx. for regular viscosity.

RAW MATERIALS

Per Bulletin 61-2-24-4 plus:

Tamol 850	PMS 6-177-9
Banaco 267	A.E. Staley Mfg. Co., Decatur, Ill.

MANUFACTURING PROCEDURE

General procedure as per Bulletin 61-2-24-4.

- NOTE:**
1. Add Tamol 850 to water and emulsion and mix before adding dry ingredients.
 2. If PMA-30 is normally added to the emulsion in bulk extra PMA-30 will be necessary since the amount of emulsion has been reduced. This extra preservative should be added to the water/emulsion premix.

END

Operating Division.
PRODUCT PROCEDURE

Approved: 

CONFIDENTIAL

DO NOT REPRODUCE OR COPY

USG READY MIXED JOINT COMPOUND
ALL PURPOSE - SOUTH GATE

No. 01-2-24--
Date 5-28-70
Page 3
Cancels Page 3
Dated 10-22-68

FORMULAS

A. Formula JE-304C - Special White and Regular (Tinted)

<u>Fillers</u>	<u>% Non-Volatile</u>	(For 250 Gal.) <u>Lbs. (Batch Approx.)</u>
Mica JC	Formula V	275 (Approx.)
Astracal M Sericite	10.0	200
Asbestos UC210	2.5 (approx.)	50
#400 Whiting or Marble White 325	To Make 94%	To Make 1880 Lbs.
Methocel 65HG	0.8	16
<u>Paste Mix</u>	<u>% Non-Volatile</u>	<u>Lbs. (for 250 gal. batch appr.)</u>
Fillers	94.0	1880
VA-301P	6.0	218
Troysan CMP acetate (liquid)	-	1
Troysan 174	-	2 lbs.
Water	-	140 gallons (approx.)

B. Formula JE-201

<u>Filler Mix</u>	<u>% Non-Volatile</u>	<u>Lbs. (For 945# Filler Charge)</u>
Mica JC	Formula V	150 approx.
MTO-50	30.0	300
Asbestos Floats	As Req'd.	35 approx.
Huber Clay	10.0	100
Methocel HG	0.8	8
Ferrite Yellow*	To match manila color of SHEETROCK Face Paper.	
#400 Whiting or Marble White 325	To make 94.5%	To make up 945 lbs.

* Plant to manufacture unpigmented form when requested by Sales Dept.

<u>Paste Mix</u>	<u>% Non-Volatile</u>	<u>Lbs. (for approx. 130 gal.)</u>
Fillers	94.5	945
VA-301P	5.5	96
Troysan CMP acetate (liquid)	-	4 oz.
Troysan 174	-	8 oz.
Water	-	71 gal. approx.

No. 61-2-24-4
Date 5-28-70
Page 4
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Dated 1-30-68

CONFIDENTIAL

DO NOT REPRODUCE OR COPY

USG READY-MIXED JOINT COMPOUND ALL PURPOSE - SOUTH GATE

RAW MATERIALS

VA-301P	Per FMS Bulletin	6-104-55
Methocel HG		6-25-6
P80F Mica		6-143-1
Ser-X		6-146-2
- Asbestos		6-14-5
#400 Whiting or Marble White 325		6-24-1
Stonelite		6-24-2
Nuodex PMA-18		6-100-2
Huber CWF Clay		6-36-5
M350 and MTO-50 Sericite		6-146-2
A Dolomite	Per Bulletin	58-2-2
Astracal M Sericite	Per FMS Bulletin	6-146-2
Troysan CMP Acetate (Liquid)		6-100-5
Troysan 174		6-100-14

C-5791-C (Back)

D Indicates Deletion

A Indicates Addition

OP009 1711

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved: <i>[Signature]</i>	CONFIDENTIAL DO NOT REPRODUCE OR COPY READY-MIXED JOINT COMPOUND - ALL PURPOSE (JE-684F)	No. 61-2-24-AA Date 6-8-70 Page 3 Cancels Page 3 Dated 5-25-70
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FORMULA

	<u>% Non-Volatile</u>	<u>Pounds-2000 Lbs. R. V.</u>
Mica JC	V	280 to 300 approx.
PC7K9 Asbestos	As req'd for visc. 4.5 to 5.5% normal	90 to 110 approx.
Methocel 65 HG	0.7	14
Carbonate Filler*	to 100% R. V.	1500 approx.
Bamco 267	2.0%	40
PM4386 (w/o PMA-30)	2.5%	83.3
Tamol 850	---	3 to 4 as req'd
CMP Acetate	---	1
Troyan 174	---	1
Water	---	160 to 162 gal. approx. for regular viscosity

* Gypsum to use Stonelite, Per PMS 6-24-2 for Pigmented Ready Mix, and #9NCS, per PMS 6-24-9, for White Ready Mix.

RAW MATERIALS

Per Bulletin 61-2-24-2 plus:

Tamol 850	PMS 6-177-9
Bamco 267	PMS 6-124-11
CMP Acetate	PMS 6-100-5
Troyan 174	PMS 6-100-14

MANUFACTURING PROCEDURE:

General procedures as per Bulletin 61-2-42-2.

Note: 1. Add Tamol 850 and the two preservatives to the water and emulsion and mix before adding dry ingredients.

END

ORR 69 / 1045 A

SPECIAL BULLETIN

Operating Division	CONFIDENTIAL DO NOT REPRODUCE OR COPY READY-MIXED JOINT COMPOUND-ALL PURPOSE (JE-774D) - CHAMBLEE AND DALLAS	No. 61-2-24-DD
PRODUCT PROCEDURE		Date 6-15-70
Approved: <i>[Signature]</i>		Page 2
		Cancels Page 2
		Dated 5-11-70

FORMULA

	<u>% Non-Volatile</u>	<u>Pounds 2000 lbs. N.V.</u>
Mica JC	Formula V	280 to 300 approx.
C Asbestos JMRF02	as reg'd for visc.	80 to 90 approx.
C Methocel 65HG	.8	16
C #9MCS Carbonate Filler	to 100% N.V.	1430 approx.
Bamco 267	2.0	40
Euber Clay	2.5	50
C Nopco PD-1	.15	3
PM386 (w/o PMA-30)	2.5	83.3 approx.
CMP Acetate	-	1
Troyan 174		1

RAW MATERIALS

Per Bulletin 61-2-24 except:

Bamco 267	Per PMS 6-124-11
Nopco PD-1	Nopco Chemical Co.
CMP Acetate	Per PMS 6-100-5
Troyan 174	Per PMS 6-100-14

MANUFACTURING PROCEDURE

General procedure as 61-2-24.

NOTE: 1. Add Nopco PD-1 and the two preservatives to water and emulsion and mix before adding dry ingredients.

END

9801 6000

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved: <i>[Signature]</i>	CONFIDENTIAL DO NOT REPRODUCE OR COPY READY-MIXED JOINT COMPOUND - ALL PURPOSE (JE-684F)	No. 61-2-24-AA Date 6-18-70 Page 3 Cancels Page 3 Dated 6-8-70
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FORMULA

	<u>% Non-Volatile</u>	<u>Pounds-2000 Lbs. N. V.</u>
Mica JC	V	280 to 300 approx.
C PC7RF9 Asbestos	4.0%	80
C Methocel 65 HG	0.8	16
Carbonate Filler*	to 100% N. V.	1500 approx.
Bamaco 267	2.0%	40
PM4386 (w/o PMA-30)	2.5%	83.3
Tamol 850	---	3 to 4 as req'd
CMP Acetate	---	1
Troysan 174	---	1
Water	---	160 to 162 gal. approx. for regular viscosity

* Gypsum to use Stonelite, Per PMS 6-24-2 for Pigmented Ready Mix, and #9HCS, per PMS 6-24-9, for White Ready Mix. Midway to use Quincy #3.

RAW MATERIALS

Per Bulletin 61-2-24-2 plus:

Tamol 850	PMS 6-177-9
Bamaco 267	PMS 6-124-11
CMP Acetate	PMS 6-100-5
Troysan 174	PMS 6-100-14

MANUFACTURING PROCEDURE

C General procedures as per Bulletin 61-2-24.

Note: 1. Add Tamol 850 and the two preservatives to the water and emulsion and mix before adding dry ingredients.

END

0P009 1044

special bulletin

Operating Division	CONFIDENTIAL DO NOT REPRODUCE OR COPY READY-MIXED JOINT COMPOUND-ALL PURPOSE (JE-774D) - CHAMBLEE AND DALLAS	No. 61-2-24-DD
PRODUCT PROCEDURE		Date 11-9-70
Approved: <i>[Signature]</i>		Page 2
		Cancels Page 2
		Dated 6-15-70

FORMULA

	<u>% Non-Volatile</u>	<u>Pounds 2000 lbs. N. V.</u>
Misc JC	Formula V	280 to 300 approx.
Asbestos JMRF02	as req'd for visc.	80 to 90 approx.
Methocel 65HG	.8	16
#9NCS Carbonate Filler	to 100% N. V.	1430 approx.
Hamaco 267	2.0	40
Huber Clay	2.5	50
Defoamer*	.15	3
PM-4386 (w/o PMA-30)	2.5	83.3 approx.
CMP Acetate	-	1
Troysan 174		1

RAW MATERIALS

Per Bulletin 61-2-24 except:

Hamaco 267	Per FMS 6-124-11
*Nopco PD-1	Nopco Chemical Co.
CMP Acetate	Per FMS 6-100-5
Troysan 174	Per FMS 6-100-14
*Tamol 850	Per FMS 6-177-9

MANUFACTURING PROCEDURE

General procedure as 61-2-24 except add CMP Acetate and Troysan 174 separately instead of mixing the two preservatives together. When mixed together in concentrated form and allowed to stand, some of the mercury is precipitated from solution.

NOTE: 1. Add *Nopco PD-1 or *Tamol 850 and the two preservatives to the water and emulsion and mix before adding dry ingredients.

2. Dallas to add *Tamol 850, Chamblee to add *Nopco PD-1.

END

Operating Division

PRODUCT PROCEDURE

Approved:

CONFIDENTIALREADY-MIXED JOINT COMPOUND-ALL PURPOSE
(JE-774D) - CHAMBLEE AND DALLAS

No. 61-2-24-3D

Date 4-6-72

Page 1

Cancels Page 1

Dated 2-18-71

C This bulletin expires 3-1-73.

DESCRIPTION - Dallas to manufacture and ship Ready Mixed Joint Compound - All Purpose JE-774D on all orders into both the Central and Southern Divisions unless otherwise specified or authorized by Chicago #971-E or Atlanta #981.

Chamblee to manufacture and ship JE-774D for field trials and initial shipments as directed by Atlanta #981.

MANUFACTURING PLANTS - Dallas and Chamblee

IDENTIFICATION AND PACKAGING - Packaging for Dallas per 61-2-24-2-1 and Chamblee per 61-2-24-1. Letter "K" to follow code on all production.

FINISHED PRODUCT SPECIFICATIONS -

	<u>Dallas</u>	<u>Chamblee</u>
A. Viscosity - Extra Heavy	-	800 to 850 BB
Heavy	700 to 750 BB	700 to 750 BB
Regular	575 to 625 BB	600 to 650 BB
Maxek	450 to 500 BB	-
Ames	400 to 450 BB	425 to 475 BB

All viscosities run using VC-3 Brabender, pin paddle, @ 75 rpm with 250 cm torque head.

B. Bond - 4 minimum at 75°F - 50% RH.

C. Color -

(Chamblee) White unless ordered pigmented.

(Dallas) Unpigmented only.

D. pH - 8.9 to 9.2

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O-5791-C 1/68 (Printed in U.S.A.) T C Indicates Change

OPC09 1617

No. 61-2-24-AA
Date 6-20-72
Page 2

Cancels Reinstatement
Dated

CONFIDENTIAL

READY-MIXED JOINT COMPOUND -
ALL PURPOSE - (JE-684F)

FINISHED PRODUCT SPECIFICATIONS

A. Viscosity	- Regular	630 $\pm$ 30 BB
	Extra	700 $\pm$ 30 BB
	Mechanical	
	Tools	430 $\pm$ 30 BB

All viscosities run using VC-3 Brabender, pin paddle, @ 75 RPM 250 cm. gm. torque head.

- B. Bond - 4 minimum. Tested as per Bulletin 61-2-24-2.
- C. Color - White or pigmented. To match standards.
- Midway to only produce unpigmented. Pigmented may be specially ordered with 5 days lead time to produce and with approval of the Division Product Manager; these orders must be in batch increments of 500 gallons.
- D. Application & Dry Appearance - To match plant standards. No grit or lumps in application. No cracking on bond test panel. Testing as per Bulletin 61-2-24-2.
- E. Weight Per Gallon - 12.5 to 12.8 lbs. per gal. for regular viscosity material.

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0-5791-C (Back)T

Operating Division

PRODUCT PROCEDURE

Approved:

CONFIDENTIAL

READY-MIXED JOINT COMPOUND -
ALL PURPOSE - (JE-684F)

No. 61-2-2-AA

Date 6-20-72

Page 3

Cancels Reinstatement

Dated

FORMULA

	% Non-Volatile	Pounds-2000 Lbs. N. V.
Mica JC	V	280 to 300 approx.
PC7RP9 Asbestos	3.0%	60
Methocel 65 HG	0.8	16
Carbonate Filler*	to 100% N. V.	1500 approx.
Hamaco 267	2.0%	40
PM4386 (w/o PMA-30)	2.5%	83.3
Tamol 850	---	3 to 4 as req'd.
CMP Acetate	---	1
Troysan 174	---	1
Water	---	160 to 162 gal. approx. for regular viscosity

*Carbonate Filler to be Stonelite for pigmented product and for "ones" in natural color. White to be 90% #9NCS and 10% Stonelite Filler.

RAW MATERIALS

PM4386	PMS 6-104-55
Tamol 850	PMS 6-177-9
Hamaco 267	PMS 6-124-11
CMP Acetate	PMS 6-100-5
Troysan 174	PMS 6-100-14
Methyl Cellulose	PMS 6-25-6
Asbestos Floats	PMS 6-14-5
Carbonate Filler	PMS 6-24-2 (Stonelite), 6-24-9 (#9NCS)

MANUFACTURING PROCEDURE

General procedures as per Bulletin 61-2-24.

Note: 1. Add Tamol 850 and the two preservatives to the water, then emulsion and mix before adding dry ingredients. Add dry ingredients and necessary water to keep at fairly heavy consistency. Mix at heavy consistency for 10 minutes then adjust with water to proper viscosity.

END

UP009 1019

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0-5791-C 1/68 (Printed in U.S.A.)T

Operating Division	CONFIDENTIAL	No. 61-2-24-AA
PRODUCT PROCEDURE		Date 9-28-72
Approved:		Page 3
		Cancels Page 3 Dated 6-20-72
READY-MIXED JOINT COMPOUND - ALL PURPOSE - (JE-684P)		

FORMULA

	% Non-Volatile	Pounds-2000 lbs. N. V.
Mica JC	V	280 to 300 approx.
PC7RF9 Asbestos	3.0%	60
Methocel 65 HG	0.8	16
Carbonate Filler*	to 100% N. V.	1500 approx.
Hamaco 267	2.0%	40
PM4386 (w/o PMA-30)	2.5%	83.3
D Tamol 850	—	3 to 4 as req'd.
A Cosan 158	—	2
Water	—	160 to 162 gal. approx. for regular viscosity

*Carbonate Filler to be Stonelite for pigmented product and for "ones" in natural color. White to be 90% #9NCS and 10% Stonelite Filler.

RAW MATERIALS

PM4386	PMS 6-104-55
Tamol 850=	PMS 6-177-9
D Hamaco 267	PMS 6-124-11
Methyl Cellulose	PMS 6-25-6
Asbestos Floats	PMS 6-14-5
Carbonate Filler	PMS 6-24-2 (Stonelite), 6-24-9 (#9NCS)

MANUFACTURING PROCEDURE

General procedures as per Bulletin 61-2-24.

Note: 1. Add Tamol 850 and the two preservatives to the water, then emulsion and mix before adding dry ingredients. Add dry ingredients and necessary water to keep at fairly heavy consistency. Mix at heavy consistency for 10 minutes then adjust with water to proper viscosity.

END

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0-5791-C 1/68 (Printed in U.S.A.)† A Indicates Addition D Indicates Deletion

JP009 1036

Originally Issued 3-3-70

SPECIAL BULLETIN

3rd Extension

Operating Division

CONFIDENTIAL

No. 61-2-24-DD

Date 3-1-73

Page 1

Cancels Page 1

Dated 4-6-72

PRODUCT PROCEDURE

READY-MIXED JOINT COMPOUND-ALL PURPOSE
(JE-774D) - DALLAS

This bulletin expires 9-1-73.

DESCRIPTION - Dallas to manufacture and ship Ready Mixed Joint Compound - All Purpose JE-774D on all orders into both the Central and Southern Divisions unless otherwise specified or authorized by Chicago #971-E or Atlanta #981.

MANUFACTURING PLANT - Dallas

IDENTIFICATION AND PACKAGING - Packaging per 61-2-24-2-1. Letter "K" to follow code on all production.

FINISHED PRODUCT SPECIFICATIONS -

Dallas

A. Viscosity - Extra Heavy	-
Heavy	700 to 750 BB
Regular	575 to 625 BB
Marek	450 to 500 BB
Ames	400 to 450 BB

All viscosities run using VC-3 Brabender, pin paddle, @ 75 rpm with 250 cm torque head.

B. Bond - 4 minimum at 75°F - 50% RH.

C. Color - Unpigmented only.

D. pH - 8.9 to 9.2

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0-5791-C Rev. 1/73 (Printed in U.S.A.) T C Indicates Change D Indicates Deletion

9P009 1079

Operating Division

PRODUCT PROCEDURE

CONFIDENTIAL

READY-MIXED JOINT COMPOUND-ALL PURPOSE
(JE-774D) - DALLAS

No. 61-2-24-22

Date 3-1-73

Page 2

Cancels Page 2

Dated 1-24-73

FORMULA

	% Non-Volatile	Pounds 2000 lbs. N.V.
Mica JC	Formula V	280 to 300 approx.
Asbestos JMRFO2	as req'd. for visc.	80 to 90 approx.
Methocel 65HG	.8	16
#9NCS Carbonate Filler (Note 1)	to 100% N. V.	1430 Approx.
Hamaco 267	2.0	40
Huber Clay	2.5	50
Defoamer*	.15	3
PM-4386 (w/o PMA-30)	2.5	83.3 approx.
Troysan EX 364		2

NOTE 1: Dallas to use Microfil #4.

PAW MATERIALS

Per Bulletin 61-2-24 except:

Hamaco 267	Per PMS 6-124-11
Troysan EX 364	Troy Chemical Co.
*Tamol 850	Per PMS 6-177-9
Microfil #4	Per PMS 6-24-10

MANUFACTURING PROCEDURE

General procedure as 61-2-24.

NOTE: 1. Add *Tamol 850 and the two preservatives to the water and emulsion and mix before adding dry ingredients.

END

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JP009 1030

Operating Division	CONFIDENTIAL	No. 61-2-24-2-2
PRODUCT PROCEDURE		Date 3-14-73
		Page 2
		Cancels NEW
		Dated
READY-MIXED JOINT COMPOUND-ALL PURPOSE (JE-774D) - DALLAS		

<u>FORMULA</u>	<u>% Non-Volatile</u>	<u>Pounds 2000 lbs. N.V.</u>
Mica JC	Formula V	280 to 300 approx.
Asbestos JMRFO2	as req'd. for visc.	80 to 90 approx.
Methocel 65HG	.8	16
Microfil #4 Carbonate Filler	to 100% N.V.	1430 approx.
Hamaco 267	2.0	40
Huber Clay	2.5	50
Tamol 850	.15	3
PM-4386 (w/o PMA-30)	2.5	83.3 approx.
Troysan EX 364		2

RAW MATERIALS

Per Bulletin 61-2-24 except:

Hamaco 267	Per PMS 6-124-11
Troysan EX 364	Troy Chemical Co.
Tamol 850	Per PMS 6-177-9
Microfil #4	Per PMS 6-24-10

MANUFACTURING PROCEDURE

General procedure as 61-2-24.

NOTE: 1. Add Tamol 850 and the two preservatives to the water and emulsion and mix before adding dry ingredients.

END

Operating Division	CONFIDENTIAL	No. 61-2-24-2-2
PRODUCT PROCEDURE		Date 7-31-73
	READY-MIXED JOINT COMPOUND-ALL PURPOSE JE-1128C - DALLAS	Page 1
		Cancels Page 1
		Dated 3-14-73

DESCRIPTION

An emulsion based product containing two-thirds the normal amount of mica in conjunction with DXW Mineralite to alleviate current mica shortage.

MANUFACTURING PLANT

Dallas

IDENTIFICATION AND PACKAGING

Per Bulletin 61-2-24-2-1.

FINISHED PRODUCT SPECIFICATIONS

Viscosity - 600 $\pm$ 30 Brabender units with pin paddle at 77°F.

Color - Natural unless pigmented specified.

Bond-to-Tape - 5 minimum at 77°F. - 50% RH.

Weight per gallon - 12.8 to 13.0 lbs. per gallon.

<u>RAW MATERIAL NO.</u>	<u>FORMULA</u>	<u>% N.V.</u>	<u>LBS. PER 250 GAL.</u>
61747	P-80F	2/3 formula V	approx. 200
61762	DXW Mineralite	15.0%	300
61741	TRPO2 Asbestos	3.5 to 4.0%	70 to 80
66481	Methocel 65HG	0.8%	16
61466	Microfill #4	To make 94.5%	To make 1,890 lbs.
65272	PM-4386 (60%)	5.5	183
66660	CMP Acetate	---	1
66685	Troysan 174	---	1

RAW MATERIALS

61762 DXW Mineralite Per PMS 6-146-2

Other raw materials per Bulletin 61-2-24-2-1.

66660 - CMP Acetate Per PMS 6-100-5

END