

ACME, TEXAS PLANT FORMULAREADY MIX FILLER TEX-972 (FILLER "X")DESCRIPTION OF PRODUCT: - Filler for Ready Mix Joint CompoundFORMULA:

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>%</u>	<u>#/Batch</u>
Nalco 71-D5	Anti-foaming agent	-	0.10	2.0
Troysan CMP-10Sep.	Fungicide	189	0.10	2.0
Polyvinyl Alcohol	Adhesive	162	0.80	16.0
Natrosol 250HXR (fine grind)	Water retension agent	170	0.60	12.0
Mica P-80-H	Anti cracking agent	11	15.10	302.0
Asbestos 7-RF-9	Bulking agent	9	5.5	110.0
Air separated Land Plaster	Filler	-	77.85	1556.0
(See Provisional Specs.)			100.00%	2000.0#

WORKING CONSISTENCY:

- Refer to Plant Testing Procedure #32.

Specifications:

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
67	60	64

WORKING PROPERTIES

- Refer to Plant Testing Procedure #33.

Specifications:

- Filler shall be very heavily bodied and possess fair plasticity. It shall be free of any coarse, gritty or undispersed particles.

Color: - White

Specifications:

- Dried compound shall be prepared according to formula No. TEX-973 at least twice a day or with every 7th batch of filler manufactured. This prepared mix shall be tested and shall meet all specifications required of Ready Mix Joint Compound - Formula No. S-973.

EDO'N:kgc

ACME, TEXAS PLANT FORMULA

READY MIX FILLER TEX-972 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R. M. Spec.</u>	<u>Percent</u>	<u>Lbs./Batch</u>
Nalco 71-D5 5.2	Anti-foaming agent	-	0.10	2.0 5.0
Troysan CMP-10 Sep.	Fungicide	189	0.10	2.0
Polyvinyl Alcohol 66	Adhesive	162	0.80	16.0
Natrosol 250-HXR (fine grind)	Water retension agent	170	0.60	12.0
Mica P-80-H 2.7	Anti-cracking agent	11	15.10	302.0
Asbestos 7-RF-9 2.8	Bulking agent	9	5.5	110.0
Land Plaster TEX-25 4.6	Filler	-	77.85	1556.0
			100.00	2000.0

WORKING CONSISTENCY

Specifications:

- Refer to Plant Testing Procedure #32.
- <u>Maximum</u> <u>Minimum</u> <u>Average</u>
67 60 64

WORKING PROPERTIES

Specifications:

- Refer to Plant Testing Procedure #33.
- Filler shall be very heavily bodied and posses fair plasticity. It shall be free of any coarse, gritty or undispersed particles.

COLOR

Specifications:

- White
- Dried compound shall be prepared according to formula No. TEX-973 at least twice a day or with every 7th batch of filler manufactured. This prepared mix shall be tested and shall meet all specifications required of Ready Mix Joint Compound - Formula No. TEX-973.

EDO:dek

Helvatol 33.82 lbs per cu ft.
Natrosol 25.46 lbs per cu ft.
mica 12.54 lbs per cu ft.
Land plaster 31.73 lbs per cu ft. (loose)
49.78 " " " (packed)
asbestos 20.14 lbs per cu ft.

RECEIVED

JUN 23 1969

GEORGIA-PACIFIC CORPORATION
ACME, TEXAS

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SGP 0017507

May 27, 1970

Supersedes Formula No. TEX-972

Dated 6/18/69

ACME, TEXAS PLANT FORMULA

READY MIX FILLER TEX-972 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound.

<u>FORMULA</u>				
<u>Raw Material</u>	<u>Function</u>	<u>R.M.Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Nalco 71-D5	Anti-foaming agent	-	0.25	5.0
Troysan CMP-10 Sep.	Fungicide	189	0.10	2.0
Polyvinyl Alcohol	Adhesive	162	0.80	16.0
Natrosol 250-HXR <i>cellulose</i> (fine grind)	Water retension agent <i>6-23-70</i>	170	0.60	12.0
Mica P-80-H	Anti-cracking agent	11	15.10	302.0
Asbestos 7-RF-9	Bulking agent	9	5.5	110.0
Land Plaster TEX-25	Filler	-	<u>77.65</u>	<u>1553.0</u>
			100.00	2000.0

WORKING CONSISTENCY: - Refer to Plant Testing Procedure #32.
Specifications:

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
67	60	64

WORKING PROPERTIES: - Refer to Plant Testing Procedure #33.
Specifications: Filler shall be very heavily bodied and posses fair plasticity. It shall be free of any coarse, gritty or undispersed particles.

COLOR: - White
Specifications: Dried compound shall be prepared according to formula No. TEX-973 at least twice a day or with every 7th batch of filler manufactured. This prepared mix shall be tested and shall meet all specifications required of Ready Mix Joint Compound - Formula No. TEX-973.

Alvitol 33.82 lbs per cu ft
Natrosol 25.46
Mica 12.54
Land plaster 31.73 (loose)
" " 49.78 (packed)
asbestos 20.14

-/ Denotes change in this reissue.

EDO:dek

SGP 0017508

ACME, TEXAS PLANT FORMULA

READY MIX JOINT COMPOUND NO. TEX-972 (MACHINE TOOLS)

DESCRIPTION OF PRODUCT: - White Ready Mix Joint Compound used for taping, covering tape, filling corner beads and spotting nailheads.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M.Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Nalco 71-D5	Anti-foaming agent	-	0.1	1.67
Water	Solvent	-	-	370.00(44 gal)
Preplasticized PVA Emulsion	Adhesive	185	7.4	49.33
Filler TEX-970	-	-	<u>92.5</u>	<u>613.67</u> 655.2
			100.00	1034.67 1066.20

**One batch yields 18 ± one 5 gallon pails

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

Brabender Viscosity - 385 ± 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. Materials should be free of lumps caused by 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: -
Specifications There shall be no large fissure cracks in the wedge, and no cracks in the thinner half of the wedge.

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

EDO:dek

SGP 0017509

April 14, 1972
Supersedes TEX-972
Dated 9/22/71

ACME, TEXAS PLANT FORMULA

READY MIX JOINT COMPOUND NO. TEX-972 (MACHINE TOOLS)

DESCRIPTION OF PRODUCT: - White Ready Mix Joint Compound used for taping, covering tape, filling corner beads and spotting nailheads.

-/ FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M.Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Nalco 71-D5	Anti-foaming agent	-	0.1	5.00 4.6
Water	Solvent	-	-	1110.00 (132 gal) 122 gal
Preplasticized PVA Emulsion	Adhesive	185	7.4	148.00 137.00
Filler TEX-970	-	-	<u>92.5</u>	<u>1841.00</u> 1700
			100.00	3104.00

-/ **One batch yields 51 $\pm$ one 5 gallon pails

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

Brabender Viscosity - ~~385 $\pm$ 20~~
305 $\pm$ 15

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. Materials should be free of lumps caused by 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 - 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.

EDO:dek

SGP 0017510

March 8, 1974
NEW FORMULA TEX 972

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND NO. TEX-972

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for taping, covering tape, filling corner beads and spotting nailheads.
To be used in 4-gallon cartons and 5-gallon pails.
To be supplied to Houston only.

<u>FORMULA</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Nalco 71-D5	Antifoaming agent	--	.25	4.60
Water	Solvent	--	--	929.60 (112 gal)
Preplasticized PVA Emulsion	Adhesive	185	5.0	92.3 (10.25 gal)
Filler TEX-974	--	--	<u>94.75</u>	<u>1749.00</u>
			100.00	2775.50

One batch yields 60 $\pm$ one 4-gallon carton or 45 $\pm$ one 5-gallon pail

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

Brabender Viscosity - 560 $\pm$ 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. Materials should be free of lumps caused by incomplete mixing.

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

CRACK RESISTANCE - 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
Specifications - Dried compound shall match color of standard sample.

WNG:elz

SGP 0017511

February 25, 1976

Formula TEX-972

NEW

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-972 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for taping, topping and texturing. (Special asbestos free formula for selective shipment only.)

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Filler TEX 974	Filler	--	93.4	1868
Elvace 1875	Adhesive	185	6.0	120 (13.5 gals.)
Nalco 71D-5	Defoamer	125	.1	2
Acrysol ASE-60	Thickener	147	.5	10
*Water	Solvent	--	--	1120 (135 gals.)
				3120**

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 4 gallons per batch.

**One batch yields 50 $\pm$ one five gallon pails or 63 $\pm$ one four gallon cartons.

SPECIAL MIXING INSTRUCTIONS

- Blend ingredients in following order:
 - 1) Water
 - 2) Elvace 1875
 - 3) Nalco
 - 4) Filler TEX 974
 - 5) Mix until filler is thoroughly dispersed
 - 6) Add Acrysol ASE-60
 - 7) Mix until Ready Mix is smooth - check viscosity and pH

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 $\pm$ 20) For machine tools add 8 gallons H₂O (365 $\pm$ 20)

pH

Minimum - 9.0

Maximum - 10.0

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....

WNG:jg

SGP 0017512

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.

WNG:jg

March 16, 1976
Supersedes Formula TEX-972
Dated 2/25/76

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-972 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for taping, topping and texturing. (Special asbestos free formula for selective shipment only.)

-/ FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Filler TEX 974	Filler	--	92.9	1858
Elvace 1875	Adhesive	185	6.5	130 (14.6 gals.)
Nalco 71D-5	Defoamer	125	.1	2
Acrysol ASE-60	Thickener	147	.5	10
*Water	Solvent	--	--	<u>1120</u> (135 gals.)
				3120**

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 4 gallons per batch.

**One batch yields 50 $\pm$ one five gallon pails or 63 $\pm$ one four gallon cartons.

SPECIAL MIXING INSTRUCTIONS

- Blend ingredients in following order:
 - 1) Water
 - 2) Elvace 1875
 - 3) Nalco
 - 4) Filler TEX 974
 - 5) Mix until filler is thoroughly dispersed
 - 6) Add Acrysol ASE-60
 - 7) Mix until Ready Mix is smooth - check viscosity and pH

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 $\pm$ 20) For machine tools add 8 gallons H₂O (365 $\pm$ 20)
pH Minimum - 9.0 Maximum - 10.0

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.

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WNG:jg

SGP 0017514

May 10, 1976
Supersedes Formula TEX-972
Dated: 3/16/76

ACME, TEXAS PLANT FORMULA
READY MIX JOINT COMPOUND TEX-972 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for taping, topping and texturing. (Special asbestos free formula for selective shipment only.)

<u>FORMULA</u> <u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
-/ Filler TEX 974	Filler	--	93.15	1863
-/ Elvace	Adhesive	185	6.25	125 (14 gals.)
Nalco 71D-5	Defoamer	125	.1	2
Acrysol ASE-60	Thickener	147	.5	10
-/ *Water	Solvent	--	--	<u>1228</u> (148 gals.)
				3228**

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 4 gallons per batch.)

-/ **One batch yields $51 \pm$ one five gallon pails or $65 \pm$ one four gallon cartons.

SPECIAL MIXING
INSTRUCTIONS

- Blend ingredients in following order:
 - 1) Water
 - 2) Elvace 1875
 - 3) Nalco
 - 4) Filler TEX 974
 - 5) Mix until filler is thoroughly dispersed
 - 6) Add Acrysol ASE-60
 - 7) Mix until Ready Mix is smooth - check viscosity and pH

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 8 gallons H₂O (365 ± 20)

pH Minimum - 9.0 Maximum - 10.0

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.

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WNG/gvp

SGP 0017515

January 14, 1977
Supersedes Formula TEX-972
Dated: 5/10/76

ACME, TEXAS PLANT FORMULA
READY MIX JOINT COMPOUND TEX-972 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for taping, topping and texturing. (Special asbestos free formula for selective shipment only.)

<u>FORMULA</u>				
<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Filler TEX-974	Filler	-	93.15	1863
Elvace EP-200	Adhesive	185	6.25	125 (14 gals.)
Nalco 71D-5	Defoamer	125	.10	2
Acrysol ASE-60	Thickener	147	.50	10
-/ Water	Solvent	-	-	<u>1038</u> (125 gals.)
				3038**

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 4 gallons per batch.)

-/ **One batch yields 49 $\pm$ one five gallon pails or 61 $\pm$ one four gallon cartons.

SPECIAL MIXING
INSTRUCTIONS

- Blend ingredients in following order:
 - 1) Water
 - 2) Elvace EP-200
 - 3) Nalco
 - 4) Filler TEX-974
 - 5) Mix until filler is thoroughly dispersed
 - 6) Add Acrysol ASE-60
 - 7) Mix until Ready Mix is smooth - check viscosity and pH.

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 $\pm$ 20) For machine tools add 8 gallons H₂O (365 $\pm$ 20)

pH Minimum - 9.0 Maximum - 10.0

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.

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WNG/gvp

SGP 0017516

**ACME FORMULA #972
ASBESTOS CONTAINING PRODUCTS**