

August 21, 1969
Supersedes Formula No. 986
Dated July 23, 1964

AKRON, NEW YORK PLANT FORMULA

LAMINATING COMPOUND #986

DESCRIPTION C. PRODUCT

- Laminating Compound is an adhesive to be used to laminate two sheets of wallboard together in Hummer System or other double layer construction.

FORMULA

<u>Raw Material</u>	<u>Source</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
-/ K. B. Flour	Adhesive		20.00	800.0
-/ Lime - High Calcium	Alkaline Source		1.60	64.0
-/ Tri-Sodium Phosphate	Buffering Agent		2.20	88.0
-/ Vancide 51Z	Fungicide	126	0.10	4.0
-/ Kaysoy 200C	Adhesive	122	3.00	120.0
-/ Casein 100M	Adhesive	10	5.50	220.0
-/ Limestone	Filler		67.425	2697.0
-/ Kerosene	Lubricant		0.10	4.0
-/ Cottonseed Oil	Lumbricant		0.025	1.0
-/ Defoamer M11	Anti-Foaming agent 196		0.05	2.0
			100.00	4000.0

SPREADING CONSISTENCY: This is a high alkalinity compound. To determine the proper consistency, mix at a rate of 100 grams to 150 cc water, adding the dry powder slowly with continuous stirring. This procedure should take from 30 to 60 seconds. The laminating compound should mix to about the consistency of a thick pour. Cover with a damp cloth and allow the mixture to soak for 10 minutes. Upon remixing, it should be of thinner consistency and more plastic. Spreading consistency is the amount of water that will allow the glue to be spread easily by means of a comb type spreader; the ridges formed by the spreader not self-leveling or sagging when the board is held in a vertical position.

SPECIFICATIONS

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
165	135	150

ALKALINITY: After the glue has been reduced to the correct consistency, test for pH by means of the Beckman pH meter. The electrodes used should be capable of accurately indicating pH readings in excess of pH 12.

pH SPECIFICATIONS

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
12.0	11.0	11.5

PLAINTIFF'S EXHIBIT

GP-437

SGP 0018345

BOND TEST: The glue shall be applied to a foot square area by means of the comb type spreader. The spreader shall have triangular notches 3/16" wide x 3/16" deep, spaced 3/4" on centers. Place two .025 shims parallel and on each side of the application 4 inches apart. A 4 inch square piece of board shall be placed backside down onto the application of glue and shims. The next day the 4 inch square piece of board shall be pryed loose by means of a broadknife. There shall be no glue failure, rather a delamination of the board paper or a fracture of the board itself to indicate satisfactory bond.

EDO:dek

-/ Denotes change in this reissue

125

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ASBESTOS CONTAINING PRODUCTS**