Also cancels Temporary Bulletins 61-2-23-W and 61-2-23-EE

Operating Division
PRODUCT PROCEDURE

Approved: MJB

PERF-A-TAPE TOPPING COMPOUND

No. 61-2-23
Date 10-20-60
Page 1 of 6
Cancels Page 1
Dated 4-8-60

PLAINTIFF'S EXHIBIT
USG-398

DESCRIPTION - Smooth applying, easy sanding compound designed for finish coats only in finishing Perf-A-Tape joints. Supplied unpigmented on specific sales order.

MANUFACTURING PLANTS - Chamblee, Gypsum, Hagersville, New Brighton, South Gate, and Sweetwater.

FORMULAS

	JF 82A New Brighton	JF 254 Hagersville	JF 147A Sweetwater	JF 200 South Gate	JF 185 Chamblee Gypsum New Brighton
Casein	2.5	3.75	2.5	3.0	2.5
Soy Protein	3.0	-	2.25	2.5	2.25
Ammonium Alginate	0.8	0.8	0.8	0.8	0.8
Hydrated Lime	As Req.	As Req.	As Req.	As Req.	As Req.
Ammonium Oxalate	1.0	1.0	1.0	1.0	1.0
Sodium Pentachlorophenate	-	-	0.2	0.2	-
Ammonium Pentaborate	1.2	1.2	-	-	1.2
Dicyandiamide	0.3	1.0	0.3	0.3	0.3
Mica J.C.	Formula V	0.6 Formula V	-	Formula V	-
Mica P-85	-	-	0.6 Formula V	-	0.6 Formula V
Asbestos - (Note 1)	As Req.	As Req.	As Req.	As Req.	As Req.
Mica Sericite - (Note 2)	15.0	-	15.0	15.0	15.0
Whiting - (Note 5)	15.0	15.0	-	-	-
Talc	-	15.0	-	-	-
Sterox CD - (Note 3)	0.1	0.1	0.1	0.1	0.1
Tributyl Phosphate - (Note 3)	0.05	0.05	0.05	0.05	0.05
Neutralizer 5050 - (Note 3)	0.003	0.003	0.003	0.003	0.003
Carbonate Filler - (Note 4)	To Make 100%	To Make 100%	To Make 100%	To Make 100%	To Make 100%
Pigments	Pigment With Ferrite Yellow and Other Lime Proof Colors As Required				

General Revision

M-5791 6/55 (Printed in U.S.A.)

OP007 1465

MJB

PERF-A-TAPE TOPPING COMPOUND

No.	61-2-23
Date	10-20-60
Page	2 of 6
Cancels	Page 2
Dated	4-8-60

FORMULA NOTES

Note 1 - Asbestos used shall be as follows:

JF 82A - 2/3 Johns Manville 7RF1; 1/3 Phillip Carey 7RF9
JF 254 - Johns Manville 7RF1
JF 147 - 2/3 Nicolet 7TG25; 1/3 Phillip Carey 7RF9
JF 200 - Phillip Carey 7RF9
JF 185 - 2/3 Johns Manville 7RF1; 1/3 Phillip Carey 7RF9

Note 2 - Sericite Mica used shall be as follows:

Gypsum and New Brighton - Ser-X
Chamblee and Sweetwater - DXW Mineralite
South Gate - M350 Sericite

Note 3 - The Sterox CD, the tributyl phosphate and neutralizer 5050 should be mixed together before adding to the other ingredients. In cold weather this mixture may be thinned with a little isopropyl alcohol if necessary to facilitate its uniform dispersion among the powder ingredients. This mixture is to be sprayed into the other ingredients while they are being mixed in a Broughton mixer. If spray equipment is not used to add the liquid mix to the dry powders in the mixer the tributyl phosphate must be increased to .1% (total liquid mix .203%) and the liquid mix dribbled slowly into the powder in the mixer.

Note 4 - Carbonate Fillers:

JF 82A and JF 254 - Bulletin 58-2-2, page 2 of 5, A or AA
JF 147A and JF 185 - Bulletin 6-24-9
JF 200 - Per Bulletin 6-24-1

Note 5 - Whiting

JF 82A Per Bulletin 6-24-7
JF 254 Per Bulletin C6-24-6

DP007 1456

RAW MATERIAL SPECIFICATIONS

Casein	Per Bulletin 6-26-4
Soy Protein	" " 6-123-1
Hydrated Lime (See below (1))	
Ammonium Oxalate	" " 6-11-5
Sodium Pentachlorophenate	" " 6-33-4
Dicyandiamide	" " 6-44-1
Mica JC	" " 6-143-1
Mica P-85	" " 6-143-3
Sericite Micas	" " 6-146-2
Asbestos	" " 6-7-1
Wetting Agent - Polyoxyethylene Ester	" " 6-135-1
Tributyl Phosphate	Lacquer Plasticizer grade, colorless with low odor.
Carbonate Fillers	Per Bulletin 6-24-1, 6-24-9, 58-2-2
Ammonium Alginate	" " 6-8-1
Whiting	" " 6-24-7, C6-24-6
Ferrite	- -
Talc	Per Bulletin C6-128-4

Ammonium pentaborate Technical grade powdered, from Pacific Coast Borax Co.
Neutralizer 5050 - from Magnus, Mabee and Reynard, Inc.
(1) Hydrated Lime - Per Bulletins 59-3-7, 6-69-1, 59-8-7 or equivalent.

PROCESSING

Weigh all materials accurately. Maximum permissible weight departure is 3% of the amount specified. Mix in a Broughton mixer, spraying the mixed liquids after mixing of the powders has started. Continue mixing for a minimum of 10 minutes after the liquids have been sprayed into the batch.

After mixing is complete pass the batch through a Mikropulverizer using a coarse (3/32" slot width) screen. It is then ready for packing.

FINISHED PRODUCT SPECIFICATIONS

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed under or over the code number. Otherwise all topping compound to be tinted to match standard sample from Research - approximately to match Sheetrock manila color. The .05% ferrite color is to be discontinued. South Gate to remain at their current degree of pigmentation, as of April 1, 1959.

OP007 1467

OPERATING DIVISION PRODUCT PROCEDURE APPROVED: MJB	PERF-A-TAPE TOPPING COMPOUND JF-265 FORMULA GYPSUM	NO. 61-2-23-CG DATE 10-11-60 PAGE 1 of 1 CANCELS Page 1 DATED 6-8-60

Gypsum to manufacture Perf-A-Tape Topping Compound - JF-265 Formula for the Cleveland District. Specifications as follows:

FORMULA

Casein		2.5
Protein		2.25
Ammonium Alginate		0.8
Hydrated Lime		0.1
Ammonium Oxalate		1.0
Ammonium Pentaborate		1.2
Dicyandiamide		0.3
Mica JC		0.6 Formula V
Asbestos P.C. 7RF9		1/3 (approx. 3.0)
Asbestos JM 7RF9		2/3 (approx. 6.0)
Sericite		15.0
Whiting		40.0
Carbonate filler		To make 100%
Ultramarine Blue		0.02
Liquid Mix		0.153
Sterox	0.100	
TBP	0.050	
Neut. 5050	0.003	

RAW MATERIALS: Same as listed in 61-2-23, except as follows:

Casein	6-26-4
Ammonium Alginate	6-8-1
Sericite	(use new light colored Ser-X)
Whiting (Snowflake F)	6-24-7
Carbonate filler	6-24-9
[illegible] Ultramarine Blue	

FINISHED PRODUCT TESTS

Consistency	62 cc - 65 cc
Applications Properties	Comparable to Standard Same from Research
Bond to Tape	2 minimum
pH	8.2 - [illegible].7
Revet Test	Normally about 1
Color	No darker than Standard Sample from Research

SHIPPING: For shipment to the Cleveland District on all orders marked "Special White" Topping Compound.

PACKAGING: Use Standard Perf-A-Tape Topping Compound Bags. Add a "C" after the regular code to denote Cleveland Compound.

[illegible] expires [illegible].

UP007 1859

Material formerly in Bulletin 61-2-23-JJ

Operating Division PRODUCT PROCEDURE	PERF-A-TAPE TOPPING COMPOUND	No. 61-2-23-1
		Date 9-24-60
		Page 1 of 2
Approved: 9M8B	SWEETWATER	Cancels
		Dated NEW

Sweetwater to manufacture and ship Perf-A-Tape Topping Compound, Formula JF 275, into the Denver District.

FORMULA JF-275

Casein		3.0
Refined soy protein		2.5
Ammonium alginate		0.8
Hydrated Lime		As Req'd. (about 0.2 in lab batches)
Ammonium Oxalate		1.1
Dowicide G		0.2
Dicyandiamide		0.3
Mica J.C.		Formula V
Asbestos-Nicolet 7TG25		2/3 of needed quantity (4% in lab batch)
Asbestos - PC 7RF9		1/3 of needed quantity (2% in lab batch)
DXW Mineralite		15.0
#9 Georgia Marble		To make 100%
Liquid Mix		0.153
Stercx CD	0.100	
TBP	0.050	
Neutralizer 5050	0.003	

RAW MATERIALS

All are the same as listed under 61-2-23.

PROCESSING

Same as for 61-2-23.

FINISHED PRODUCT SPECIFICATIONS

Color - To match the manila color of Sheetrock face paper, except on orders that specify natural white color.

CONSISTENCY Range 67-70 cc Normal 68 at a 500 Brabender Reading at 77°F.

APPLICATION PROPERTIES

To match standard sample from Research

pH 8.2 - 8.7

TP007 1960

PERF-A-TAPE TOPPING COMPOUND SWEETWATER	No. 61-2-23-1 Date 9-24-60 Page 2 of 2 Cancels Dated NEW

JM&B

BOND TO TAPE 2 minimum

PACKAGING Standard Perf-A-Tape Topping Cement Bag, except to change mixing directions to read 16 - 17 pints of water.

Use the standard SW for the code, in place of the SD designation used for JF147A.

SHIPMENT As directed by Department 144.

DR007 1959

OPERATING DIVISION		
PRODUCT PROCEDURE	PERF-A-TAPE TOPPING COMPOUND	NO. 52-3-[illegible]-TP DATE 10-25-60 PAGE 1 of 1
APPROVED: MDB	GYPSUM	CANCELS Page 1 DATED 7-19-60

Gypsum to manufacture and ship the following formulated Per-A-Tape Topping Compound to the Milwaukee Market when "Special Milwaukee Formula" is noted on the 379 order form.

PERF-A-TAPE TOPPING COMPOUND - FORMULA JF62E - For all 25# bags of Perf-A-Tape Topping Compound:

Casein	3.0
Soy Protein	2.5
Marex Alginate	.8
Hydrated Lime	.15 - .25
Ammonium Oxalate	1.0 - 1.2
Sodium Pentachlorophenate	.2
Dicyandiamide	.3
Mica JC	For Quantity V
Asbestos	As required for Normal Consistency and application properties.
M-350 Sericite Mica, DXW Mineralite or Ser-X	15.0
CCO Whiting	15.0
Sterox CD (1)	.1
Tributylphosphate	.05
Carbonate Filler	To make up 100%
Neutralizer #5050 (1)	.003

(1) The liquid wetting agents - Sterox CD, Tributylphosphate and Neutralizer #5050 are to be mixed together in proper proportions and sprayed into the batch in the Broughton Mixer. In cold weather the solution may be thinned with isopropyl alcohol if necessary to facilitate spraying.

COMPOUND IS TO BE COLORED MANILA WITH "DOUBLE" THE AMOUNT OF PIGMENT USED IN PRESENT TOPPING COMPOUND.

This Bulletin expires 3-15-61.

OP007 1852

OPERATING DIVISION PRODUCT PROCEDURE APPROVED:	PERF-A-TAPE TOPPING COMPOUND JF-228 FORMULA SWEETWATER	NO. 61-2-23-AA DATE 12-13-60 PAGE 1 of 1 CANCELS Page 1 DATED 3-22-60

Sweetwater to manufacture and ship JF-228 Topping Compound for special orders from the New Orleans District per the following specifications:

Formula	JF-228
Casein (fine ground)	3.0%
Ad Pro [illegible]	1.5%
Keltex Alginate	0.5%
Dowicide G	0.3%
Ammonium Oxalate	1.0%
Dicyandiamide	0.3%
Hyd. Lime (as req'd for normal pH)	Approx. 0.1%
Mica JC	0.6 Formula V
Philip Carey 7RF9 asbestos	Approx. 7.0% (as needed to give std. consistency)
Georgia Marble	To make 100.0%
DKW Mineralite	15.0%
Ferrite Yellow	0.1% as req'd to match SR manila color

Liquid Mix. -

Sterox	0.1%
Tributylphosphate	0.05%
Neutralizer 5050	0.003%

Raw Materials

All are present standard grades.

Finished Product Specifications

Mixing, application and bond - To match sample from Research.
Consistency - 30 to 32 cc with 50 cc normal (400 ± 20 std EB test)

Package

25 lb. std. Topping Compound bags with special code designation requested by Sales Merchandise Department.

Shipment

To be made on receipt of orders from the New Orleans District. District must indicate on face of order the word "SPECIAL", to distinguish between regular Topping Compound and this formula.

[illegible]

DP007 1821

PRODUCT PROCEDURE APPROVED:	PERF-A-TAPE TOPPING COMPOUND FORMULA JF-286 GYPSUM	NO. 61-2-23 DATE 2-3-61 PAGE 1 of 1 CANCELS page 1 DATED 9-21-60

Gypsum to manufacture Perf-A-Tape Topping Compound, Formula JF-286, for the Milwaukee market.

JF-286

Casein, 100 mesh unoiled	3.0%
Refined soy protein	2.5
Protatek A-155 alginate	0.8
Ammonium oxalate	1.0
Hydrated Lime	0.2
Sodium pentachlorophenate	0.2
Dicyandiamide	0.3
PC7X79 asbestos	As required (6-9% in lab)
Mica JC	per Formula V
Cer-X (Walker)	15.0
CCO Whiting	15.0
Huber CWF Clay	5.0
Stonelite	to make 100%
Liquid mix	0.15

Raw materials

Sodium pentachlorophenate	Per Bulletin 6-33-4
Protatek A-155 alginate	Per Bulletin
Huber CWF clay	" " 6-36-5

Other raw materials as shown in Bulletin 61-2-23.

Finished Product Tests

Consistency: 93-97 cc.
Working Properties: Comparable to standard sample submitted by Research
Bond to tape: 2 minimum
Other properties: Per Bulletin 61-2-23

Packing: Standard 25 lb. P-A-T Topping Compound bag, except to change mixing direction to read 15 to 16 pints of water.
Per Bull. 7-16-42
Also add any special identifying characters requested by Dept. No. 144.
Bags to have standard code markings with the suffix "H".

Shipment: As directed by Dept. No. 144. Plant to notify Dept. No. 144 when first batch is made so use and performance in field can be followed.

This Bulletin supersedes 6-1-61.

NP007 1879

PRODUCT PROCEDURE APPROVED: MJB	PERF-A-TAPE TOPPING COMPOUND JF-265 FORMULA GYPSUM	NO. [illegible] DATE 2-8-61 PAGE 1 of 1 CANCELS page 1 DATED 10-11-60

Gypsum to manufacture Perf-A-Tape Topping Compound - JF-265 Formula for the Cleveland District. Specifications as follows:

FORMULA

Casein		2.5
Protein		2.25
Ammonium Alginate		0.8
Hydrated Lime		0.1
Ammonium Oxalate		1.0
Ammonium Pentaborate		1.2
Dicyandiamide		0.3
Mica JC		0.6 Formula V
Asbestos P.C. 7RF9		1/3 (approx. 3.0)
Asbestos JM 7RF9		2/3 (approx. 6.0)
Sericite		15.0
Whiting		40.0
Carbonate Filler		To make 100%
Ultramarine Blue		0.02
Liquid Mix		0.153
Sterox	0.100	
TBP	0.050	
Neut. 5050	0.003	

Raw Materials: Same as listed in 61-2-23, except as follows:

Casein	6-26-4
Ammonium Alginate	6-8-1
Sericite	(use new light colored Ser-[illegible])
Whiting (Snowflake F)	6-24-7
Carbonate Filler	6-24-9
[illegible] Ultramarine Blue	

FINISHED PRODUCT TESTS

Consistency	[illegible]2 cc. - 65 cc.
Applications Properties	Comparable to Standard Same from Research
Bond to Tape	2 minimum
pH	8.2 - 8.7
Dewat Test	Normally about 1
Color	No darker than Standard Sample from Research

SHIPPING: For shipment to the Cleveland District on all orders marked "Special [illegible]" Topping Compound.

[illegible]: The Standard Perf-A-Tape Topping Compound Bags. [illegible] [illegible] code to denote Cleveland Compound.

OP007 1858

Original date of issue 3-22-60 SPECIAL BULLETIN 3rd Extension

Operating Division PRODUCT PROCEDURE Approved:	PERF-A-TAPE TOPPING COMPOUND GYPSUM	No. 61-2-23-FF Date 4-10-61 Page 1 of 1 Cancels Page 1 Dated 10-25-60

Gypsum to manufacture and ship the following formulated Perf-A-Tape Topping Compound to the Milwaukee Market when "Special Milwaukee Formula" is noted on the 379 order form.

PERF-A-TAPE TOPPING COMPOUND - FORMULA JF62E - For all 25# bags of Perf-A-Tape Topping Compound:

Casein	3.0
Soy Protein	2.5
Marex Alginate	.8
Hydrated Lime	.15 - .25
Ammonium Oxalate	1.0 - 1.2
Sodium Pentachlorophenate	.2
Dicyandiamide	.3
Mica JC	For Quantity V
Asbestos	As required for Normal Consistency and application properties.
M-350 Sericite Mica, DXW Mineralite or Ser-X	15.0
CCO Whiting	15.0
Sterox CD (1)	.1
Tributylphosphate	.05
Carbonate Filler	To make up 100%
Neutralizer #5050 (1)	.003

(1) The liquid wetting agents - Sterox CD, Tributylphosphate and Neutralizer #5050 are to be mixed together in proper proportions and sprayed into the batch in the Broughton Mixer. In cold weather the solution may be thinned with isopropyl alcohol if necessary to facilitate spraying.

COMPOUND IS TO BE COLORED MANILA WITH "DOUBLE" THE AMOUNT OF PIGMENT USED IN PRESENT TOPPING COMPOUND.

/ This Bulletin expires 1-1-62

UP007 1859

Original date of issue 12-3-59 SPECIAL BULLETIN 3rd Extension

Operating Division PRODUCT PROCEDURE Approved: JMB	PERF-A-TAPE TOPPING COMPOUND JF-228 FORMULA SWEETWATER	No. 61-2-23-AA Date 4-10-61 Page 1 of 1 Cancels Page 1 Dated 12-13-60

Sweetwater to manufacture and ship JF-228 Topping Compound for special orders from the New Orleans District per the following specifications:

Formula	JF-228
Casein (fine ground)	3.0%
Ad Pro 444	1.5%
Marex Alginate	0.5%
Dowicide G	0.3%
Ammonium Oxalate	1.0%
Dicyandiamide	0.3%
Hyd. Lime (as req'd for normal pH)	Approx. 0.1%
Mica JC	0.6 Formula V
Philip Carey 7RF9 asbestos	Approx. 7.0% (as needed to give std. consistency)
#9 Georgia Marble	To make 100.0%
DXW Mineralite	15.0%
Ferrite Yellow	0.1% as req'd to match SR manila color

Liquid Mix. -

Sterox	0.1%
Tributylphosphate	0.05%
Neutralizer 5050	0.003%

Raw Materials

All are present standard grades.

Finished Product Specifications

Mixing, application and bond - To match sample from Research.
Consistency - 59 to 62 cc with 60 cc normal (400 ± 20 std EB test)

Package

25 lb. std. Topping Compound bags with special code designation requested by Paint Merchandise Department.

Shipment

To be made on receipt of orders from the New Orleans District. District must indicate on face of order the word "SPECIAL", to distinguish between regular Topping Compound and this formula.

This bulletin expires 8-1-61.

UP0071823

Operating Division PRODUCT PROCEDURE Approved: MJB	PERF-A-TAPE TOPPING COMPOUND SWEETWATER	No. 61-2-23-1 Date 5-22-61 Page 1 of 2 Cancels page 1 Dated 9-24-60

Sweetwater to manufacture and ship Perf-A-Tape Topping Compound, Formula JF 275, into the Denver District and the Heath and Sigurd Warehouses.

FORMULA JF-275

Casein	3.0
Refined soy protein	2.5
Ammonium alginate	0.8
Hydrated Lime	As Req'd. (about 0.2 in lab batches)
Ammonium Oxalate	1.1
Dowicide G	0.2
Dicyandiamide	0.3
Mica J.C.	Formula V
Asbestos-Nicolet 7TG25	2/3 of needed quantity (4% in lab batch)
Asbestos - PC 7RF9	1/3 of needed quantity (2% in lab batch)
DXW Mineralite	15.0
#9 Georgia Marble	To make 100%
Liquid Mix	0.153

Sterox CD	0.100
TBP	0.050
Neutralizer 5050	0.003

RAW MATERIALS

All are the same as listed under 61-2-23.

PROCESSING

Same as for 61-2-23.

FINISHED PRODUCT SPECIFICATIONS

Color - To match the manila color of Sheetrock face paper, except on orders that specify natural white color.

CONSISTENCY Range 67-70 cc Normal 68 at a 500 Brabender Reading at 77°F.

APPLICATION PROPERTIES

To match standard sample from Research

pH 8.2 - 8.7

NP007 1951

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved: JMB	PERF-A-TAPE TOPPING COMPOUND NEW BRIGHTON	No. 61-2-23-PP Date 9-1-61 Page 1 of 1 Cancels Dated NEW

New Brighton to manufacture JF-316 Topping Compound per following specifications:

Formula	JF-316
Casein	4.5%
Ammonium Alginate*	0.8
Ammonium Oxalate	1.0
Ammonium pentaborate	1.2
Hydrated Lime	As required (approx. 0.1)
Dicyandiamide	0.6
Mica J.C.	0.6 Formula V
JM 7RF-1 Asbestos	Approx. 1/2 of amount required (3.5%) Lab Batch
PC 7RF-9 Asbestos	Approx. 1/2 of amount required (3.0%)
Ser-X	15.0
No. 9 Georgia Marble	to make 100%
Liq. Mix	0.153
Sterox	0.100
Tributylphosphate	0.050
Neutralizer 5050	0.003
Ferrite Yellow	0.15

Raw Materials
*Ammonium Alginate - Protatek A-155 from Croda, Inc.
Asbestos Usage - Normal range should be from 5.5 - 7.5%. If asbestos use consistently drops below 5.5% or is over 7.5%, send samples of the asbestos and compound to Research.
No. 9 Georgia Marble - per Bulletin 6-24-9
All other raw materials per Bulletin 61-2-23
Processing - per Bulletin 61-2-22

Finished Product Tests:
Consistency 60-64 cc range, normal 62 cc to give a 420 BB at 77° F.
pH - 8.2-8.5
Color - to match Sheetrock manila paper
Bond to tape - 4 minimum (77°F, 50% R.H.)
Other tests as per Bulletin 61-2-22

Packaging
Follow current packaging, except change mixing directions to read 14-1/2 to 15-1/2 pints of water.

Add a P as a suffix to the regular code for identification of this formulation.

Shipping
As directed by Department #144 for field test.

This Bulletin expires 3-1-62.

UP007 1839

SPECIAL BULLETIN

Operating Division		No. 61-2-22-C
PRODUCT PROCEDURE	PERF-A-TAPE JOINT COMPOUND	Date 9-25-61
	J-1214D FORMULA	Page 1 of 1
Approved: GMGB	GYPSUM	Cancels Page 1 Dated 8-11-61

Gypsum to manufacture and ship Perf-A-Tape Joint Compound J-1214D Formula. Specifications as follows:

MANUFACTURING MILL - Gypsum

PRODUCT - Perf-A-Tape Joint Compound

FORMULA -	J-1214D
Casein, 100 mesh uncoiled	7.0%
Protatek A-155 Alginate	0.3
Ammonium Oxalate	1.2
Ammonium Pentaborate	1.2
Hydrated Lime	about 0.15 as req'd for normal pH
Dicyandiamide	1.0
Mica T	per Formula V
JM7RF1 Asbestos	(2:1 asbestos blend as req'd
PC7RF9	(8-9% in lab batches
Ser X	15.0
750 Marble	to make 100%
Liquid Mix	0.153
Sterox CD 0.1%	
Tributylphosphate 0.05%	
Neutraliser 5050 0.003%	

RAW MATERIALS

Protatek A-155	
Mica T	Per Bulletin 6-143-2
750 Marble	Per Bulletin 6-24-9

Other Raw Materials as shown in Bulletin 61-2-22.

FINISHED PRODUCT TESTS

Consistency: 64-67 cc for 400-425 Brabender at 77°F.
Application: Comparable to standard sample submitted by Research
Other Properties: Per Bulletin 61-2-22.
Packaging: Standard 25 Lb. P-A-T Joint Compound bags except to change mixing directions to read 15 to 16 pts. of water. Also the letter "c" to follow the standard code marking on the bag to identify this formula.
Shipment: As directed By Dept. 144.

This Bulletin expires 8-1-62.

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved: JMB	PERF-A-TAPE TOPPING COMPOUND HAGERSVILLE	No. 61-2-23-QQ Date 9-25-61 Page 1 of 1 Cancels Dated NEW

Hagersville to manufacture JF-332B Topping Compound per following specifications:

Formula: JF - 332B

	%
Casein	3.75
Ammonium Alginate	1.0
Ammonium Oxalate	1.1
Hydrated Lime	0.2
Ammonium Pentaborate	1.2
Dicyandiamide	0.6
Mica P-85	(0.6 of Formula V)
M-4 Talc	15.0
PC - 7RF9 Asbestos	(As required-approx. 8.5%)
FF Limestone	15.0
A Dolomite	(to make 100%)
Liquid Mix	0.15
Ferrite Yellow Pigment	0.15

Raw Material Specifications - Per bulletin 61-2-23
Processing - Per bulletin 61-2-23
Finish Product Tests

Consistency - 64-68cc
Brabender - 400-440 at 77°F
Other tests per bulletin 61-2-23

Packaging - Regular topping compound bags, but with the letter "M" added to the end of the code for identification.
Shipment - Per Dep't #444

This Bulletin expires 1-1-62.

OP007 1872

Original date of issue 4-5-60 SPECIAL BULLETIN 4th Extension

Operating Division PRODUCT PROCEDURE Approved: JMJB	PERF-A-TAPE TOPPING COMPOUND JF-265 FORMULA GYPSUM	No. 61-2-23-GG Date 9-25-61 Page 1 of 1 Cancels Page 1 Dated 2-8-61

Gypsum to manufacture Perf-A-Tape Topping Compound - JF-265 Formula for the Cleveland District. Specifications as follows:

FORMULA

Casein		2.5
Protein		2.25
Ammonium Alginate		0.8
Hydrated Lime		0.1
Ammonium Oxalate		1.0
Ammonium Pentaborate		1.2
Dicyandiamide		0.3
Mica JC		0.6 Formula V
Asbestos P.C. 7RF9		1/3 (approx. 3.0)
Asbestos JM 7RF9		2/3 (approx. 6.0)
Sericite		15.0
Whiting		40.0
Carbonate Filler		To make 100%
Ultramarine Blue		0.02
Liquid Mix		0.153
Sterox	0.100	
TBP	0.050	
Neut. 5050	0.003	

Raw Materials: Same as listed in 61-2-23, except as follows:

Casein	6-26-4
Ammonium Alginate	6-8-1
Sericite	(use new light colored Ser-X)
Whiting (Snowflake F)	6-24-7
Carbonate Filler	6-24-9
4186 Ultramarine Blue	

FINISHED PRODUCT TESTS

Consistency	62 cc - 65 cc
Applications Properties	Comparable to Standard Same from Research
Bond To Tape	2 minimum
pH	8.2 - 8.7
Rewet Test	Normally about 1
Color	No darker than Standard Sample from Research

SHIPPING: For shipment to the Cleveland District on all orders marked "Special White" Topping Compound.

PACKAGING: Use Standard Perf-A-Tape Topping Compound Bags. Add a "C" after the regular code to denote Cleveland Compound.

/ This Bulletin expires 4-1-62.

USP007 1857

Original date of issue 3-22-60 SPECIAL BULLETIN 3rd Extension

Operating Division PRODUCT PROCEDURE Approved: MJB	PERF-A-TAPE TOPPING COMPOUND GYPSUM	No. 61-2-23-FF Date 11-21-61 Page 1 of 1 Cancels Page 1 Dated 4-10-61

Gypsum to manufacture and ship the following formula Perf-A-Tape Topping Compound to the Milwaukee Market when "Special Milwaukee Formula" is noted on the 379 order form.

Formula JF-62E

Casein		3.0%	
Soy Protein		2.5	
Marex Alginate		0.8	
Hydrated Lime	about	0.2	
Ammonium Oxalate		1.1	
Dowicide G		0.2	
Dicyandiamide		0.3	
Mica JC	per formula V		
Asbestos JM7RF1	approx.	6.0	(use 2:1 asbestos blend as needed
Asbestos PC7RF9	approx.	3.0	to give std. consistency)
Ser-X		15.0	
CCo Whiting		15.0	
Stonelite	to make up 100%		
Sterox CD		0.1	
Tributylphosphate		0.05	
Neutralizer 5050		0.003	

Compound is to be colored Manila with "Double" the amount of pigment used in present topping compound.

Finished Product Tests
Consistency 67-70cc 60cc normal (500 BB std. test)

Packaging
Use Standard Perf-A-Tape Topping Compound bags. Add "DP" after the code to denote Milwaukee Compound.

This Bulletin expires 1-1-62

TP007 1847

Operating Division PRODUCT PROCEDURE	PERF-A-TAPE TOPPING COMPOUND	No. 61-2-23-PP
		Date [illegible]
	NEW BRIGHTON	Page 1 of 1
Approved: MJB		Cancels Page 1
		Dated 3-7-62

New Brighton to manufacture JF-316 Topping Compound per following specifications:

Formula	JF-316
Casein	4.5%
Ammonium Alginate*	0.8
Ammonium Oxalate	1.0
Ammonium pentaborate	1.2
Hydrated Lime	As required (approx. 0.1)
Dicyandiamide	0.6
Mica J.C.	0.6 Formula V
JM 7RF-1 Asbestos	Approx. 1/2 of amount required (3.5%) Lab Batch
PC 7RF-9 Asbestos	Approx. 1/2 of amount required (3.0%)
Ser-X	15.0
No. 9 Georgia Marble	to make 100%
Liq. Mix	0.153
Sterox	0.100
Tributylphosphate	0.050
Neutralizer 5050	0.003
Ferrite Yellow	0.15

Raw Materials

*Ammonium Alginate - Protatek A-155 from Croda, Inc.

Asbestos Usage - Normal range should be from 5.5 - 7.5%. If asbestos use consistently drops below 5.5% or is over 7.5%, send samples of the asbestos and compound to Research.

No. 9 Georgia Marble - per Bulletin 6-24-9

All other raw materials per Bulletin 61-2-23

Processing - per Bulletin 61-2-22

Finished Product Tests:

Consistency 60-64 cc range, normal 62 cc to give a 420 BB at 77° F.

pH - 8.2-8.5

Color - to match Sheetrock manila paper

Bond to tape - 4 minimum (77°F, 50% R.H.)

Other tests as per Bulletin 61-2-22

Packaging

Follow current packaging, except change mixing directions to read 14-1/2 to 15-1/2 pints of water.

Add a P as a suffix to the regular code for identification of this formulation.

Shipping

As directed by Department #144 for field test.

This Bulletin expires 1-1-63.

M-8971 11/57 (Printed in U.S.A.) (Formerly M-6189)

/ Indicates Change

OP007 1897

Cancels Temporary Bulletin 61-2-23-FF

Operating Division PRODUCT PROCEDURE Approved: MJB	PERF-A-TAPE TOPPING COMPOUND GYPSUM	No. 61-2-23-3 Date 2-5-62 Page 1 of 1 Cancels Dated NEW

Gypsum to manufacture and ship the following formula Perf-A-Tape Topping Compound to the Milwaukee Market when "Special Milwaukee Formula" is noted on the 379 order form.

Formula JF-62E

Casein		3.0%	
Soy Protein		2.5	
Marex Alginate		0.8	
Hydrated Lime	about	0.2	
Ammonium Oxalate		1.1	
Dowicide G		0.2	
Dicyandiamide		0.3	
Mica JC		per formula V	
Asbestos JM7RF1	approx.	6.0	(use 2:1 asbestos blend as needed
Asbestos PC7RF9	approx.	3.0	to give std. consistency)
Ser-X		15.0	
CCo Whiting		15.0	
Stonelite		to make up 100%	
Sterox CD		0.1	
Tributylphosphate		0.05	
Neutralizer 5050		0.003	

Compound is to be colored Manila with "Double" the amount of pigment used in present topping compound.

Finished Product Tests

Consistency 67-70 cc 68 cc normal (500 HB standard test)
pH: 8.2 to 8.7
All other tests per Bulletin 61-2-23.

Packaging

Use Standard Perf-A-Tape Topping Compound bags. Add "DP" after the code to denote Milwaukee Compound.

UP007 1971

Cancels Bulletin 61-2-23-GG dated 9-25-61.

Operating Division PRODUCT PROCEDURE Approved: JMB	PERF-A-TAPE TOPPING COMPOUND CLEVELAND DISTRICT GYPSUM	No. 61-2-23-4 Date 2-28-62 Page 1 of 1 Cancels Dated NEW

Gypsum to manufacture Perf-A-Tape Topping Compound for the Cleveland District. Specifications as follows:

FORMULA JF-265

Casein		2.5
Protein		2.25
Ammonium Alginate		0.8
Hydrated Lime		0.1
Ammonium Oxalate		1.0
Ammonium Pentaborate		1.2
Dicyandiamide		0.3
Mica JC		0.6 Formula V
Asbestos P.C. 7RF9		1/3 (approx. 3.0)
Asbestos JM 7RF9		2/3 (approx. 6.0)
Sericite		15.0
Whiting		40.0
Carbonate Filler		To make 100%
Ultramarine Blue		0.02
Liquid Mix		0.153
Sterox	0.100	
TEP	0.050	
Neut. 5050	0.003	

Raw Materials: Same as listed in 61-2-23, except as follows:

Casein	6-26-4
Ammonium Alginate	6-8-1
Sericite	(use new light colored Ser-X)
Whiting (Snowflake F)	6-24-7
Carbonate Filler	6-24-9
4186 Ultramarine Blue	

FINISHED PRODUCT TESTS

Consistency	62 cc - 65 cc
Applications Properties	Comparable to Standard Same from Research
Bond To Tape	2 minimum
pH	8.2 - 8.7
Rewet Test	Normally about 1
Color	No darker than Standard Sample from Research

SHIPPING: For shipment to the Cleveland District on all orders marked "Special White" Topping Compound.

PACKAGING: Use Standard Perf-A-Tape Topping Compound Bags. Add a "C" after the regular code to denote Cleveland Compound.

NP007 1976

REQUEST FOR NEW OR REVISION OF OPERATING BULLETIN

GENERAL DISTRIBUTION
170-K (3 COPIES)

PLANT DISTRIBUTION ONLY
____ SEND ORIGINAL & 3 COPIES TO THE PRODUCTION MANAGER

DATE 3-2-62

BULLETIN 61-2-65 AA

SUBJECT: **Dual Purpose Compound, Formula AP-76**

PLANTS CONCERNED: **Gypsum**

DETAILS AND OBJECT OF PROPOSED PRACTICE: (INDICATE WHAT IS WANTED. IF MAJOR CHANGES, EXPLAIN WHY CHANGE IS WANTED).

1. **In title at top of page 1 of 1 delete "Formula AP-76".**
2. **In first sentence change AP-76 to read AP-88A. Also, make this change after Formula in place of AP-76.**
3. **Formula AP-88A shown on attached page.**
4. **Under RAW MATERIALS add the following: "Other raw materials per bulletin 61-2-63.**

EFFECT ON QUALITY:

The new formula successfully overcame the gelation problem encountered in cold mixing tests. It has the added advantage of more lump-free mixing.

ECONOMICS: (X) EXPECTED EFFECT ON FACTORS BELOW IF APPLICABLE TO PROPOSAL

		SOURCE OF INFORMATION PERSON	DEPT.	DATE
MILL COST	'CURRENT' 3.65/cwt * 'EXPECTED' no change *	WCA	151	3-1-62
SELLING PRICE	'CURRENT' N/A 'EXPECTED'			
SALES VOLUME	1,000,000 Lbs. Per Year	WCA	151	3-1-62
EQUIPMENT CHANGES AND CAPACITIES	None	WCA	151	3-1-62
RAW MATERIALS, CONTAINERS, LABELS OR TAPES MADE OBSOLETE *	None	WCA	151	3-1-62
FINISHED PRODUCTS OBSOLETED BY THIS PROPOSAL OR REQUIRING SPECIAL DISPOSITION ACTION				

*** Raw Materials only !**

INSTRUCTIONS:

All information requested is required to obtain approval. Mark "Not Applicable" where required. INCOMPLETE REQUESTS WILL BE RETURNED.

Use back of this sheet or additional sheets if necessary. Attach laboratory test reports, field trip reports, and copies of pertinent correspondence.

See Bulletins 1-1 & 1-2 for additional instructions. Plants to supplement request with marked-up copies (photo copy will do) of bulletin showing proposed revision.

*PLANTS WILL USE UP PRESENT STOCKS OF CONTAINERS, LABELS AND TAPES UNLESS REVISED BULLETIN INDICATES OTHERWISE.

DO NOT FILL OUT THIS SECTION — PERSONS TO APPROVE WILL BE LISTED BY DEPT. 170-K.

PLEASE SIGN BULLETIN HERE

DEPT.	NAME	INITIALS	DATE SIGNED

HAVE THE CORRESPONDING CHANGES IN OTHER COMPANY BULLETINS AND MANUALS BEEN REQUESTED?

N/A

REQUEST PREPARED BY - **W. C. Anderson**

FOR DEPARTMENT **151-Research**

9-9562 REV. 12/61 (PRINTED IN U.S.A.)

Original Date of Issue 9-1-61 SPECIAL BULLETIN 1st Extension

Operating Division PRODUCT PROCEDURE	PERF-A-TAPE TOPPING COMPOUND	No. 61-2-23-PP Date 3-7-62 Page 1 of 1
Approved: JMB	NEW BRIGHTON	Cancels Page 1 Dated 9-1-61

New Brighton to manufacture JF-316 Topping Compound per following specifications:

Formula	JF-316
Casein	4.5%
Ammonium Alginate*	0.8
Ammonium Oxalate	1.0
Ammonium pentaborate	1.2
Hydrated Lime	As required (approx. 0.1)
Dicyandiamide	0.6
Mica J.C.	0.6 Formula V
JM TRF-1 Asbestos	Approx. 1/2 of amount required (3.5%) Lab Batch
PC TRF-9 Asbestos	Approx. 1/2 of amount required (3.0%)
Ser-X	15.0
No. 9 Georgia Marble	to make 100%
Liq. Mix	0.153
Sterox	0.100
Tributylphosphate	0.050
Neutralizer 5050	0.003
Ferrite Yellow	0.15

Raw Materials
*Ammonium Alginate - Protatek A-155 from Croda, Inc.
Asbestos Usage - Normal range should be from 5.5 - 7.5%. If asbestos use consistently drops below 5.5% or is over 7.5%, send samples of the asbestos and compound to Research.
No. 9 Georgia Marble - per Bulletin 6-24-9
All other raw materials per Bulletin 61-2-23
Processing - per Bulletin 61-2-22

Finished Product Tests:
Consistency 60-64 cc range, normal 62 cc to give a 420 BB at 77° F.
pH - 8.2-8.5
Color - to match Sheetrock manila paper
Bond to tape - 4 minimm (77°F, 50% R.H.)
Other tests as per Bulletin 61-2-22

Packaging
Follow current packaging, except change mixing directions to read 14-1/2 to 15-1/2 pints of water.

Add a P as a suffix to the regular code for identification of this formulation.

Shipping
As directed by Department #144 for field test.

This Bulletin expires 9-1-62.

UP007 1888

Cancels Bulletins 61-2-23-2 and 61-2-23-FP

M-5791 6/55 (Printed in U.S.A.)

DESCRIPTION - Smooth Applying, easy sanding compound designed for finish coats only in finishing Perf-A-Tape joints. Supplied unpigmented on specific sales order.

MANUFACTURING PLANTS - Chamblee, Dallas, Gypsum, Hagerstville, New Brighton, South Gate.

FORMULAS

	JF 82A New Brighton	JF 254 Hagerstville	JF 364 Dallas	JF 200 South Gate	JF 185 Chamblee Gypsum New Brighton
Cescin	2.5	3.75	4.0	3.0	2.5
Soy Protein	3.0	-	-	2.5	2.25
Ammonium Alginate	0.8	0.8	-	0.8	0.8
Hydrated Lime	As Req.	As Req.	As Req.	As Req.	As Req.
Ammonium Oxalate	1.0	1.0	0.9	1.0	1.0
Sodium Pentechlorophenate	-	-	0.2	0.2	-
Ammonium Pentaborate	1.2	1.2	1.2	-	1.2
Dicyandiamide	0.3	1.0	0.3	0.3	0.3
Mica J.C.	Formula V	0.6 Formula V	-	Formula V	-
Mica P-85	-	-	0.8 Formula V	-	0.6 Formula V
SG-62 (Hercules Powder Co.)			0.65		
Zinc Oxide (#42 green label)			0.20		
Tetra sodium pyrophosphate (fine ground)			0.10		
Asbestos - (Note 1)	As Req.	As Req.	As Req.	As Req.	As Req.
Mica Sericite - (Note 2)	15.0	-	-	15.0	15.0
Whiting - (Note 5)	15.0	15.0	-	-	-
Talc	-	15.0	-	-	-
Sterox CD - (Note 3)	0.1	0.1	-	0.1	0.1
Tributyl Phosphate - (Note 3)	0.05	0.05	-	0.05	0.05
Neutralizer 5050 - (Note 3)	0.003	0.003	-	0.003	0.003
Carbonate Filler - (Note 4)	To Make 100%	To Make 100%	To Make 100%	To Make 100%	To Make 100%
Pigments	Pigment With Ferrite Yellow and Other Lime Proof Colors As Required				

DP007 1456

General Revision

mgB	PERF-A-TAPE TOPPING COMPOUND	No. 61-2-23 Date 6-8-62 Page 2 of 6 Cancels Page 2 Dated 10-20-60

FORMULA NOTES

Note 1 - Asbestos used shall be as follows:

D
A

JF 82A - 2/3 Johns Manville 7RF1; 1/3 Phillip Carey 7RF9
JF 254 - Johns Manville 7RF1
JF 200 - Phillip Carey 7RF9
JF 185 - 2/3 Johns Manville 7RF1; 1/3 Phillip Carey 7RF9
JF 364 - 4.0% Nicolet TT625 plus Canadian Carey TRF9 as req'd (approx. 2%)

Note 2 - Sericite Mica used shall be as follows:

/

Gypsum and New Brighton - Ser-X
Chamblee - DXW Mineralite
South Gate - M350 Sericite

Note 3 - The Sterox CD, the tributyl phosphate and neutralizer 5050 should be mixed together before adding to the other ingredients. In cold weather this mixture may be thinned with a little isopropyl alcohol if necessary to facilitate its uniform dispersion among the powder ingredients. This mixture is to be sprayed into the other ingredients while they are being mixed in a Broughton mixer. If spray equipment is not used to add the liquid mix to the dry powders in the mixer the tributyl phosphate must be increased to .1% (total liquid mix .203%) and the liquid mix dribbled slowly into the powder in the mixer.

Note 4 - Carbonate Fillers:

/
A

JF 82A and JF 254 - Bulletin 58-2-2, page 2 of 5, A or AA
JF 185 - Bulletin 6-24-9
JF 200 - Per Bulletin 6-24-1
JF 364 - #750-S Carbonate

Note 5 - Whiting

JF 82A Per Bulletin 6-24-7
JF 254 Per Bulletin C6-24-6

NP007 1457

/ Indicates Change A Indicates Addition D Indicates Deletion

FINISHED PRODUCT SPECIFICATIONS (Cont'd)

Mixing and Application Properties - To duplicate those of a standard sample to be supplied by the Research Laboratory.

Cracking - Should show no edge or check cracking in the normal bond test dried in the hot room.

Lumps - Screen 100 grams of the dry powder on a 30 mesh screen. All should pass through readily except for small amounts of asbestos. If lumps are present, examine to determine what they are, and take any steps necessary to eliminate them.

Consistency - The mixed compound is to have the specified Brabender reading (corrected to the Research Brabender value - per Bul. 9-58) using the pin paddle, one hour after mixing at a temperature of 77°F.

D	JF 82A	500 BB	66 to 70 cc (Normal 68 cc)
	JF 185	500 BB	65 to 68 cc (Normal 66 cc)
	JF 200	500 BB	66 to 69 cc (Normal 67 cc)
	JF 254	400 BB	59 to 63 cc (Normal 61 cc)
A	JF 364	650 BB	64 to 67 cc (Normal 66 cc)

pH - Determine 30 minutes after mixing, temperature of mixed compound to be 77°F. during the 30 minutes.

	JF 82A	8.1 to 8.5, ideal 8.3 to 8.4
/	JF 185, JF 200, JF 254	8.2 to 8.7, ideal 8.4 to 8.5
A	JF 364	8.2 to 8.4, ideal 8.3

Bond to Tape - Normally 2 to 4 when dried in an atmosphere below 50% RH for 18 hours. Lower at higher humidities. See page 6 of 6 for Bond Scale.

Rewet Test - Normally about 1 for all formulas.

Odor of Wet Mixed Compound - To be of same general character and no stronger than that of a standard sample of the same compound on standing a similar length of time after mixing with water.

/ Indicates Change A Indicates Addition D Indicates Deletion

UP007 1459

Operating Division PRODUCT PROCEDURE Approved: MJB	PERF-A-TAPE TOPPING COMPOUND DALLAS	No. 61-2-23-1 Date 6-8-62 Page 1 of 2 Cancels page 1 Dated 5-22-61

Dallas to manufacture and ship Perf-A-Tape topping Compound, Formula JF 275, into the Denver District and the Heath and Sigurd Warehouses.

FORMULA JF-275

Casein	3.0
Refined soy protein	2.5
Ammonium alginate	0.8
Hydrated Lime	As Req'd. (about 0.2 in lab batches)
Ammonium Oxalate	1.1
Dowicide G	0.2
Dicyandiamide	0.3
Mica J.C.	Formula V
Asbestos-Nicolet 7TG25	2/3 of needed quantity (4% in lab batch)
Asbestos - PC 7RF9	1/3 of needed quantity (2% in lab batch)
DXW Mineralite	15.0
#9 Georgia Marble	To make 100%
Liquid Mix	0.153

Sterox CD	0.100
TBP	0.050
Neutralizer 5050	0.003

RAW MATERIALS

All are the same as listed under 61-2-23.

PROCESSING

Same as for 61-2-23.

FINISHED PRODUCT SPECIFICATIONS

Color - To match the manila color of Sheetrock face paper, except on orders that specify natural white color.

CONSISTENCY Range 67-70 cc Normal 68 at a 500 Brabender Reading at 77°F.

APPLICATION PROPERTIES

To match standard sample from Research

pH 8.2 - 8.7

NP007 1914

PERF-A-TAPE TOPPING COMPOUND	No. 61-2-23-1
MGB	Date 6-8-62
DALLAS	Page 2 of 2
	Cancels Page 2
	Dated 9-24-60

BOND TO TAPE 2 minimum

PACKAGING Standard Perf-A-Tape Topping Cement Bag, except to change mixing directions to read 16 - 17 pints of water.

Use the standard SW for the code, in place of the SD designation used for JF 364

SHIPMENT As directed by Department 144.

NP007 1957

/ Indicates Change

Operating Division PRODUCT PROCEDURE Approved: JM&B	PERF A TAPE TOPPING COMPOUND	No. 61-2-23 Date 6-c-62 Page 3 of 6 Cancels Page 3 Dated 5-9-62

RAW MATERIAL SPECIFICATIONS

Casein	Per Bulletin 6-26-4
Soy Protein	" " 6-123-1
Hydrated Lime (See below (1))	
Ammonium Oxalate	" " 6-11-5
Sodium Pentachlorophenate	" " 6-33-4
Dicyandiamide	" " 6-44-1
Mica JC	" " 6-143-1
Mica P-85	" " 6-143-3
Sericite Micas	" " 6-146-2
Asbestos	" " 6-14-5
Wetting Agent - Polyoxyethylene Ester	" " 6-135-1
Tributyl Phosphate	Lacquer Plasticizer grade, colorless with low odor.
Carbonate Fillers	Per Bulletin 6-24-1, 6-24-9, 58-2-2
Ammonium Alginate	" " 6-8-1
Whiting	" " 6-24-7, C6-24-6
Ferrite	
Talc	Per Bulletin C6-128-4
A Zinc Oxide (#42 green label)	Per Bulletin 6-94-91

A Tetra sodium pyrophosphate (Monsanto fine ground, anhydrous grade, approx. 92% thru 70 mesh, 68% thru 100 mesh)

A SG-62 (Hercules Powder Co. - retarded solution, high viscosity hydroxy ethyl cellulose)

Ammonium pentaborate Technical grade powdered, from Pacific Coast Borax Co.
Neutralizer 5050 - from Magnus, Mabee and Reynard, Inc.
(1) Hydrated Lime - Per Bulletins 59-3-7, 6-69-1, 59-8-7 or equivalent.

PROCESSING

Weigh all materials accurately. Maximum permissible weight departure is 3% of the amount specified. Mix in a Broughton mixer, spraying the mixed liquids after mixing of the powders has started. Continue mixing for a minimum of 10 minutes after the liquids have been sprayed into the batch.

After mixing is complete pass the batch through a Mikropulverizer using a coarse (3/32" slot width) screen. It is then ready for packing.

FINISHED PRODUCT SPECIFICATIONS

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed under or over the code number. Otherwise all topping compound to be tinted to match standard sample from Research - approximately to match Sheetrock manila color. The .05% ferrite color is to be discontinued. South Gate to remain at their current degree of pigmentation, as of April 1, 1959.

REQUEST FOR NEW OR REVISION OF OPERATING BULLETIN

GENERAL DISTRIBUTION
~~170-K~~ (3 COPIES)

PLANT DISTRIBUTION-ONLY
____ SEND ORIGINAL & 3 COPIES TO THE PRODUCTION MANAGER

EM

DATE 5-3-62

BULLETIN 61-2-23

SUBJECT: **Perf-A-Tape Topping Compound**

PLANTS CONCERNED: **Dallas**

DETAILS AND OBJECT OF PROPOSED PRACTICE: (INDICATE *WHAT* IS WANTED, LIST MAJOR CHANGES, EXPLAIN WHY CHANGE IS WANTED).

1. Change all references to "Sweetwater" in this bulletin to "Dallas".
2. Change formula for Dallas to JF364 and cancel JF147A.
   a. In note 1, (p 2) cancel reference to JF147A.
   b. In note 2, " " " " Sweetwater.
   c. In note 4, " Sierra " " JF197A to JF364.
3. Cancel Bulletin 61-2-23-2, JF228 Special Topping for New Orleans.
4. Cancel Bulletin 61-2-23-KR, JR185 " " " " Kansas City.

EFFECT ON QUALITY: Mixing - much better than JF147A and about equal to JF185. Application - not identical with, but considered as good as present compounds. Drying shrinkage - muchless than JF147A or JF185 and as good as JF228. Eliminates browning over joints through PVAC paints (possible with JF147A & JF228). Bond, sanding, cracking resistance - close to present topping.

ECONOMICS: (EXPLAIN EFFECT ON FACTORS BELOW IF APPLICABLE TO PROPOSAL)

		SOURCE OF INFORMATION PERSON	DEPT.	DATE
MILL COST (for raw mat'ls only(per ~~cwt~~))	(CURRENT) JF147A-$3.73 (EXPECTED) JF364-$3.32	J.W.Gill	151	5-3-62
JF185-$4.10; JF228-$3.85	(EXPECTED) NA			
SALES VOLUME	9,000,000 lbs/yr			
EQUIPMENT CHANGES AND CAPACITIES	None			
RAW MATERIALS, CONTAINERS, LABELS OR TAPES MADE OBSOLETE *	None			
FINISHED PRODUCTS OBSOLETED BY THIS PROPOSAL OR REQUIRING SPECIAL DISPOSITION ACTION	None			

INSTRUCTIONS:

All information requested is required to obtain approval. Mark "Not Applicable" where required. INCOMPLETE REQUESTS WILL BE RETURNED.

Use back of this sheet or additional sheets if necessary. Attach laboratory test reports, field trip reports, and copies of pertinent correspondence.

See Bulletins 1-1 & 1-2 for additional instructions. Plants to supplement request with marked-up copies (photo copy will do) of bulletin showing proposed revision.

*PLANTS WILL USE UP PRESENT STOCKS OF CONTAINERS, LABELS AND TAPES UNLESS REVISED BULLETIN INDICATES OTHERWISE.

DO NOT FILL OUT THIS SECTION — PERSONS TO APPROVE WILL BE LISTED BY DEPT. 170-K.

PLEASE SIGN BULLETIN HERE

DEPT.	NAME	INITIALS	DATE SIGNED

HAVE THE CORRESPONDING CHANGES IN OTHER COMPANY BULLETINS AND MANUALS BEEN REQUESTED?

Bulletin 61-1-12 (shipment) being requested concurrently.

Purchase bulletins for SG-61 and TSPP in preparation.

REQUEST PREPARED BY - J.W.Gill

FOR DEPARTMENT 151

0007 1945 A

O-9562 REV. 12/61 (PRINTED IN U.S.A.)

Operating Division
PRODUCT PROCEDURE
Approved: MJB

PERF-A-TAPE TOPPING COMPOUND

No. 61-2-23
Date 7-16-62
Page 1 of 6
Cancels Page 1
Dated 6-8-62

DESCRIPTION - Smooth Applying, easy sanding compound designed for finish coats only in finishing Perf-A-Tape joints. Supplied unpigmented on specific sales order.

MANUFACTURING PLANTS - Chamblee, Dallas, Gypsum, Hagersville, New Brighton, South Gate.

FORMULAS

	JF 82A New Brighton	JF 254 Hagersville	JF 364 Dallas	JF 200 South Gate	JF 185 Chamblee Gypsum New Brighton
Casein	2.5	3.75	4.0	3.0	2.5
Soy Protein	3.0	-	-	2.5	2.25
Ammonium Alginate	0.8	0.8	-	0.8	0.8
Hydrated Lime	As Req.	As Req.	As Req.	As Req.	As Req.
Ammonium Oxalate	1.0	1.0	0.9	1.0	1.0
Sodium Pentachlorophenate	-	-	-	0.2	-
Ammonium Pentaborate	1.2	1.2	1.2	-	1.2
Dicyandiamide	0.3	1.0	0.3	0.3	0.3
Mica J. C.	Formula V	0.6 Formula V	-	Formula V	-
Mica P-85	-	-	0.8 Formula V	-	0.6 Formula V
SG-62 (Hercules Powder Co.)			0.65		
Zinc Oxide (#42 green label)			0.20		
Tetra sodium pyrophosphate (fine ground)			0.10		
Asbestos - (Note 1)	As Req.	As Req.	As Req.	As Req.	As Req.
Mica Sericite - (Note 2)	15.0	-	-	15.0	15.0
Whiting - (Note 5)	15.0	15.0	-	-	-
Talc	-	15.0	-	-	-
Sterox CD - (Note 3)	0.1	0.1	-	0.1	0.1
Tributyl Phosphate - (Note 3)	0.05	0.05	-	0.05	0.05
Neutralizer 5050 - (Note 3)	0.003	0.003	-	0.003	0.003
Carbonate Filler - (Note 4)	To Make 100%	To Make 100%	To Make 100%	To Make 100%	To Make 100%
Pigments	Pigment With Ferrite Yellow and Other Lime Proof Colors As Required				

K-5791 6/55 (Printed in U.S.A.)

UP007 1452

FORMULA NOTES

Note 1 - Asbestos used shall be as follows:

JF 82A - 2/3 Johns Manville 7RF1; 1/3 Phillip Carey 7RF9
JF 254 - Johns Manville 7RF1
JF 200 - Phillip Carey 7RF9
JF 185 - 2/3 Johns Manville 7RF1; 1/3 Phillip Carey 7RF9
/ JF 364 - 4.0% Nicolet T7G25 plus Canadian Carey 7RF9 as req'd (approx. 2%)

Note 2 - Sericite Mica used shall be as follows:

Gypsum and New Brighton - Ser-X
Chamblee - DXW Mineralite
South Gate - M350 Sericite

Note 3 - The Sterox CD, the tributyl phosphate and neutralizer 5050 should be mixed together before adding to the other ingredients. In cold weather this mixture may be thinned with a little isopropyl alcohol if necessary to facilitate its uniform dispersion among the powder ingredients. This mixture is to be sprayed into the other ingredients while they are being mixed in a Broughton mixer. If spray equipment is not used to add the liquid mix to the dry powders in the mixer the tributyl phosphate must be increased to .1% (total liquid mix .203%) and the liquid mix dribbled slowly into the powder in the mixer.

Note 4 - Carbonate Fillers:

JF 82A and JF 254 - Bulletin 58-2-2, page 2 of 5, A or AA
JF 185 - Bulletin 6-24-9
JF 200 - Per Bulletin 6-24-1
/ JF 364 - #750-S Carbonate per Bulletin 6-24-9

Note 5 - Whiting

JF 82A Per Bulletin 6-24-7
JF 254 Per Bulletin C6-24-6

TP007 1453

FINISHED PRODUCT SPECIFICATIONS (Cont'd)

Mixing and Application Properties - To duplicate those of a standard sample to be supplied by the Research Laboratory.

Cracking - Should show no edge or check cracking in the normal bond test dried in the hot room.

Lumps - Screen 100 grams of the dry powder on a 30 mesh screen. All should pass through readily except for small amounts of asbestos. If lumps are present, examine to determine what they are, and take any steps necessary to eliminate them.

Consistency - The mixed compound is to have the specified Brabender reading (corrected to the Research Brabender value - per Bul. 9-58) using the pin paddle, one hour after mixing at a temperature of 77° F.

JF 82A	500 BB	66 to 70 cc (Normal 68 cc)
JF 185	500 BB	65 to 68 cc (Normal 66 cc)
JF 200	500 BB	66 to 69 cc (Normal 67 cc)
JF 254	400 BB	59 to 63 cc (Normal 61 cc)
JF 364	650 BB *	64 to 67 cc (Normal 66 cc)

/ /

* Direct reading on C. W. Brabender Visco Corder with 250 cm. gm. head, pin paddle, and 75 RPM speed.

pH - Determine 30 minutes after mixing, temperature of mixed compound to be 77° F. during the 30 minutes.

JF 82A	8.1 to 8.5, ideal 8.3 to 8.4
JF 185, JF 200, JF 254	8.2 to 8.7, ideal 8.4 to 8.5
JF 364	8.2 to 8.4, ideal 8.3

Bond to Tape - Normally 2 to 4 when dried in an atmosphere below 50% RH for 18 hours. Lower at higher humidities. See page 6 of 6 for Bond Scale.

Rewet Test - Normally about 1 for all formulas.

Odor of Wet Mixed Compound - To be of same general character and no stronger than that of a standard sample of the same compound on standing a similar length of time after mixing with water.

UP007 1441

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved:	TOPPING COMPOUND FORMULA JF-373I DALLAS	No. 61-2-23-TT Date 9-24-62 Page 1 of 1 Cancels Dated NEW

Dallas to manufacture a new, low shrinkage Topping Compound, Formula JF-373I, for field trials in Denver. Shipments to be as directed by Merchandising Dept. 144. Specifications as follows:

Formula:

Fine ground, unoiled casein	4.443%
SG-62	.5
Hydrated Lime	.15 - .3 (.25 in lab batch)
Zinc oxide (#42 green label)	.2
Tetra Sodium pyrophosphate	.1
Ammonium oxalate	.9
Ammonium pentaborate	1.2
Dicyandiamide	.3
P-85 Mica	1/2 Formula V quantity
Mica JC	1/2 Formula V quantity
Nicolet asbestos 7TG25	1.667
Carey asbestos 7RF9	As required (1.667 in lab batch)
No. 750-S Marble	To make 100%
Sterox CD-TBP mix, 2:1 (No neutralizer)	.15
Ferrite yellow	.07

Raw Materials: Per bulletin 61-2-23 (6-8-62) p.3

Processing: Per bulletin 61-2-23

Consistency: 61-64cc at 650 BB, 77F. (VC-3 direct reading)

Packing: Standard 25-lb topping compound bags. Change water requirement under mixing directions to approximately 15 pints per 25 lbs. Add letters LS-F to code.

Other specifications per bulletin 61-2-23.

This bulletin expires 1-1-63.

MP007 1902

K-5791 6/55 (Printed in U.S.A.)

Operating Division
PRODUCT PROCEDURE
Approved: MRB

PERF-A-TAPE TOPPING COMPOUND

No. 61-2-23
Date 10-23-62
Page 1 of 6
Cancels Page 1
Dated 7-16-62

DESCRIPTION - Smooth Applying, easy sanding compound designed for finish coats only in finishing Perf-A-Tape joints. Supplied unpigmented on specific sales order.

MANUFACTURING PLANTS - Chamblee, Dallas, Gypsum, Hagersville, New Brighton, South Gate.

FORMULAS

	JF 82A New Brighton	JF 254 Hagersville	JF 364 Dallas	JF 200 South Gate	JF 185 Chamblee (1) Gypsum New Brighton
Casein	2.5	3.75	4.0	3.0	2.5
Soy Protein	3.0	-	-	2.5	2.25
Ammonium Alginate	0.8	0.8	-	0.8	0.8
Hydrated Lime	As Req.	As Req.	As Req.	As Req.	As Req.
Ammonium Oxalate	1.0	1.0	0.9	1.0	1.0
Sodium Pentachlorophenate	-	-	-	0.2	-
Ammonium Pentaborate	1.2	1.2	1.2	-	1.2
Dicyandiamide	0.3	1.0	0.3	0.3	0.3
Mica J. C.	Formula V	0.6 Formula V	-	Formula V	-
Mica P-85	-	-	0.8 Formula V	-	0.6 Formula V
SG-62 (Hercules Powder Co.)			0.65		
Zinc Oxide (#42 green label)			0.20		
Tetra sodium pyrophosphate (fine ground)			0.10		
Asbestos - (Note 1)	As Req.	As Req.	As Req.	As Req.	As Req.
Mica Sericite - (Note 2)	15.0	-	-	15.0	15.0
Whiting - (Note 5)	15.0	15.0	-	-	-
Talc	-	15.0	-	-	-
Sterox CD - (Note 3)	0.1	0.1	-	0.1	0.1
Tributyl Phosphate - (Note 3)	0.05	0.05	-	0.05	0.05
Neutralizer 5050 - (Note 3)	0.003	0.003	-	0.003	0.003
Carbonate Filler - (Note 4)	To Make 100%	To Make 100%	To Make 100%	To Make 100%	To Make 100%
Pigments	Pigment With Ferrite Yellow and Other Lime Proof Colors As Required				

A (1) Chamblee to use sodium alginate instead of ammonium alginate

A Indicates Addition / Indicates Change

Operating Division PRODUCT PROCEDURE Approved: JMB	PERF-A-TAPE TOPPING COMPOUND	No. 61-2-23 Date 10-23-62 Page 3 of 6 Cancels Page 3 Dated 6-8-62

RAW MATERIAL SPECIFICATIONS

Casein	Per Bulletin 6-26-4
Soy Protein	" " 6-123-1
Hydrated Lime (See below (1))	
Ammonium Oxalate	" " 6-11-5
Sodium Pentachlorophenate	" " 6-33-4
Dicyandiamide	" " 6-44-1
Mica JC	" " 6-143-1
Mica P-85	" " 6-143-3
Sericite Micas	" " 6-146-2
Asbestos	" " 6-14-5
Wetting Agent - Polyoxyethylene Ester	" " 6-135-1
Tributyl Phosphate	Lacquer Plasticizer grade, colorless with low odor.
Carbonate Fillers	Per Bulletin 6-24-1, 6-24-9, 58-2-2
Ammonium Alginate	" " 6-8-1
Whiting	" " 6-24-7, C6-24-6
Ferrite	- -
Talc	Per Bulletin C6-128-4
A Sodium Alginate	Per Bulletin
Zinc Oxide (#42 green label)	Per Bulletin 6-94-91

Tetra sodium pyrophosphate (Monsanto fine ground, anhydrous grade, approx. 92% thru 70 mesh, 68% thru 100 mesh)

SG-62 (Hercules Powder Co. - retarded solution, high viscosity hydroxy ethyl cellulose)

Ammonium pentaborate Technical grade powdered, from Pacific Coast Borax Co.
Neutralizer 5050 - from Magnus, Mabee and Reynard, Inc.
(1) Hydrated Lime - Per Bulletins 59-3-7, 6-69-1, 59-8-7 or equivalent.

PROCESSING

Weigh all materials accurately. Maximum permissible weight departure is 3% of the amount specified. Mix in a Broughton mixer, spraying the mixed liquids after mixing of the powders has started. Continue mixing for a minimum of 10 minutes after the liquids have been sprayed into the batch.

After mixing is complete pass the batch through a Mikropulverizer using a coarse (3/32" slot width) screen. It is then ready for packing.

FINISHED PRODUCT SPECIFICATIONS

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed under or over the code number. Otherwise all topping compound to be tinted to match standard sample from Research - approximately to match Sheetrock manila color. The .05% ferrite color is to be discontinued. South Gate to remain at their current degree of pigmentation, as of April 1, 1959

REQUEST FOR NEW OR REVISION OF OPERATING BULLETIN

GENERAL DISTRIBUTION
170-K (3 COPIES)

PLANT DISTRIBUTION-ONLY
174-P SEND ORIGINAL & 3 COPIES TO THE PRODUCTION MANAGER

Maynard

DATE 10-29-62

BULLETIN 61-2-23TT

SUBJECT: Topping Compound, Formula JF384A

PLANTS CONCERNED: Dallas

DETAILS AND OBJECT OF PROPOSED PRACTICE: (INDICATE WHAT IS WANTED, LIST MAJOR CHANGES, EXPLAIN WHY CHANGE IS WANTED).

This new topping compound, essentially the same as the JF373A and JF373I compounds, field tested in Denver 10-15-25-62, is to be made in natural white color, to replace both the present topping compounds shipped to Denver (JF364 per bulletin 61-2-23 and JF275 per bulletin 61-2-23-1. Bulletin 61-2-23-1 may be cancelled.).

This bulletin expires 7-1-63.

EFFECT ON QUALITY: In the opinion of most Denver applicators who tried the new compounds both were improved in application properties compared to both present compounds. Drying shrinkage is lower than for either of the present compounds and resistance to check cracking is equal to that of JF275.

ECONOMICS: [illegible] (for raw mats only) JF275-$3.90

			SOURCE OF INFORMATION PERSON	DEPT.	DATE
MILL COST	(CURRENT) JF364-$3.31	(EXPECTED) ~~$3.34 per cwt.~~	JWGill	151	10-29-62
SELLING PRICE	(CURRENT)	(EXPECTED)			
SALES VOLUME	~~Check with Dept. 144~~				
EQUIPMENT CHANGES AND CAPACITIES	None				
RAW MATERIALS, CONTAINERS, LABELS OR TAPES MADE OBSOLETE *	None				
FINISHED PRODUCTS OBSOLETED BY THIS PROPOSAL OR REQUIRING SPECIAL DISPOSITION ACTION					

INSTRUCTIONS:

All information requested is required to obtain approval. Mark "Not Applicable" where required. INCOMPLETE REQUESTS WILL BE RETURNED.

Use back of this sheet or additional sheets if necessary. Attach laboratory test reports, field trip reports, and copies of pertinent correspondence.

See Bulletins 1-1 & 1-2 for additional instructions. Plants to supplement request with marked-up copies (photo copy will do) of bulletin showing proposed revision.

*PLANTS WILL USE UP PRESENT STOCKS OF CONTAINERS, LABELS AND TAPES UNLESS REVISED BULLETIN INDICATES OTHERWISE.

DO NOT FILL OUT THIS SECTION — PERSONS TO APPROVE WILL BE LISTED BY DEPT. 170-K.

PLEASE SIGN BULLETIN HERE

DEPT.	NAME	INITIALS	DATE SIGNED

HAVE THE CORRESPONDING CHANGES IN OTHER COMPANY BULLETINS AND MANUALS BEEN REQUESTED?

N.A.

REQUEST PREPARED BY - J. W. Gill

FOR DEPARTMENT #151

0-9562 REV. 12/61 (PRINTED IN U.S.A.)

0P007 1702A

Also cancels Bulletin 61-2-23-TT and Bulletin 61-2-23-1

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved:	PERF-A-TAPE TOPPING COMPOUND JF384A DALLAS	No. 61-2-23-WW Date 11-15-62 Page 1 of 2 Cancels Dated NEW

Dallas to manufacture and ship a new, low shrinkage Topping Compound Formula JF384A per the following:

Formula JF384A

Fine Ground, uncoiled casein	4.443%
SG-62	.5
Hydrated lime	.15 to .3 (to control pH)
Zinc Oxide (42 green label)	.2
Tetra sodium pyrophosphate	.1
Ammonium oxalate	.9
" pentaborate	1.2
Dicyandiamide	.3
P85 mica*	.5 formula V quantity
JC " *	.5 " "
Nicolet asbestos 7TG25**	1.667%
Canadian Carey asbestos 7RF9**	as req'd (1.667% in lab batch)
#750S Marble	to make 100%
Liquid Mix:	.15%

1 gal - Polyglycol P1200
1 gal - Tributyl Phosphate
2 oz. - Neutralizer 5050

* Note 1 - 1/2 formula V quantity of each mica is considered standard for this formula. If necessary to maintain smoothness in the product, the P85 mica may be increased to .6 formula V quantity with concurrent reduction of JC mica to .4 formula V quantity.

** Note 2 - This blend of asbestoses is selected to give a mix with approximately 9 to 11% plus 325 mesh, based on a norm of about 14% plus 325 for Nicolet asbestos and 5-6% for 7RF9 asbestos. If the 7RF9 asbestos should run coarser than this norm, submit a 2 lb. sample of it to Research for test and decision on reducing Nicolet asbestos with increase in Canadian Carey asbestos.

TP007 1957

9183	PERF-A-TAPE TOPPING COMPOUND JP384A DALLAS	No. 61-2-23-WW Date 11-15-62 Page 2 of 2 Cancels Dated NEW

Raw Materials - per bulletin 61-2-23, p. 3.

Processing - Per bulletin 61-2-23.

Finished Product Tests - Methods per bulletin 61-2-23.
Color - Natural White.
Mixing and application properties - Should closely match those of the 09132D21LS topping field tested at Denver, especially with respect to smoothness or freedom from graininess of joints and on heavy fills, i.e., on corner bead fills. Better smoothness was the main reason most Denver applicators preferred this trial batch to the 09182D1 LSF batch field tested at the same time.

Consistency - 61-64cc @ 650 RB, 77°F (VC-3 direct reading).
pH - 8.1 to 8.4, ideal 8.3
Bond to Perf-A-Tape - 3-5 (at humidities below 50%)
Rewet Test - 1 to 2
Odor - very mild - perfume plus very slight ammonia.
Lumps - per Bulletin 61-2-23.

Packaging - In standard 25 lb. Topping Compound bags. Stamp- "Use approximately 15 pints water per 25 lbs. compound" adjacent to the printed water requirement on the bags. Code with LS W in addition to date and mill code.

Shipping - As directed by Dept. 144 - tentatively on all Topping Compound orders to the Denver District.

Other specifications per Bulletin 61-2-23.

This Bulletin expires 7-1-63.

DEC 07 1953

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved: 1/15/63	PERF-A-TAPE TOPPING COMPOUND CLEVELAND DISTRICT GYPSUM	No. 61-2-23-XX Date 1-22-63 Page 1 of 1 Cancels Dated NEW

Gypsum to manufacture Perf-A-Tape Topping Compound for the Cleveland District. Specifications as follows:

Formula	JF-391
Fine Ground Uncoiled Casein	4.5
Protatek A-155 Alginate	0.8
Hydrated Lime	about 0.1%
Ammonium Oxalate	1.0
Ammonium Pentaborate	1.2
Dicyandiamide	0.3
Mica JC	0.4 formula V
P-85 Mica	0.4 formula V
JM7RF1 Asbestos	2/3 (approx. 6.0)
FC7RF9 Asbestos	1/3 (approx. 3.0)
Snowflake F (Whiting)	40.0
750 Marble	to make 100#
Glomax LL	5.0
Liquid Mix	0.153

Raw Materials - Same as listed in 61-2-23, except as follows:
Glomax LL - Georgia Kaolin Co.
pH of 20% aqueous slurry = 5.0-6.0
99.5% minus 325 mesh minimum

Finished Product Tests
Consistency 65-68cc for 400 ± 20 Brabender
Application Properties - Comparable to std. samples from Research
Bond to Tape - 2 minimum
pH 8.0-8.5
Rewet Normally about 1
Color No darker than std. sample from Research

Packaging and Identification
Pack in 25 lb. Topping Compound bags. After code add the letter C to denote Cleveland compound.

Other specifications per Bulletin 61-2-23.

This bulletin expires 1-15-64.

NP007 1914

Operating Division PRODUCT PROCEDURE Approved: JMB	PERF-A-TAPE TOPPING COMPOUND GYPSUM	No. 61-2-23-3 Date 3-11-63 Page 1 of 1 Cancels Page 1 Dated 2-5-62

Gypsum to manufacture and ship the following formula Perf-A-Tape Topping Compound to the Milwaukee Market when "Special Milwaukee Formula" is noted on the 379 order form.

Formula JF-62E

Casein		3.0%	
Soy Protein		2.5	
/ Ammonium Alginate *		0.8	
Hydrated Lime	about	0.2	
Ammonium Oxalate		1.1	
Dowicide G		0.2	
Dicyandiamide		0.3	
Mica JC		per formula V	
Asbestos JM7RF1	approx.	6.0	(use 2:1 asbestos blend as needed
Asbestos PC7RF9	approx.	3.0	to give std. consistency)
Ser-X		15.0	
CCo Whiting		15.0	
Stonelite	to make up	100%	
Sterox CD		0.1	
Tributylphosphate		0.05	
Neutralizer 5050		0.003	

A * Marex or Collatex AS/KK

Compound is to be colored Manila with "Double" the amount of pigment used in present topping compound.

Finished Product Tests

Consistency 67-70 cc 68 cc normal (500 HB standard test)
pH: 8.2 to 8.7
All other tests per Bulletin 61-2-23.

Packaging

Use Standard Perf-A-Tape Topping Compound bags. Add "DP" after the code to denote Milwaukee Compound.

DP007 1917

MGB	PERF-A-TAPE TOPPING COMPOUND	No. 61-2-23 Date 4-24-63 Page 2 of 6 Cancels Page 2 Dated 7-16-62

FORMULA NOTES

Note 1 - Asbestos used shall be as follows:

JF 82A - 2/3 Johns Manville 7RF1; 1/3 Phillip Carey 7RF9
JF 254 - Johns Manville 7RF1
JF 200 - Phillip Carey 7RF9
JF 185 - 2/3 Johns Manville 7RF1; 1/3 Phillip Carey 7RF9
JF 364 - 4.0% Nicolet T7G25 plus Canadian Carey 7RF9 as req'd (approx. 2%)

Note 2 - Sericite Mica used shall be as follows:

Gypsum and New Brighton - Ser-X
Chamblee - DXW Mineralite
South Gate - M350 Sericite

Note 3 - The Sterox CD, the tributyl phosphate and neutralizer 5050 should be mixed together before adding to the other ingredients. In cold weather this mixture may be thinned with a little isopropyl alcohol if necessary to facilitate its uniform dispersion among the powder ingredients. This mixture is to be sprayed into the other ingredients while they are being mixed in a Broughton mixer. If spray equipment is not used to add the liquid mix to the dry powders in the mixer the tributyl phosphate must be increased to .1% (total liquid mix .203%) and the liquid mix dribbled slowly into the powder in the mixer.

Note 4 - Carbonate Fillers:

JF 82A and JF 254 - Bulletin 58-2-2, page 2 of 5, A or AA
JF 185 - Bulletin 6-24-9
JF 200 - Per Bulletin 6-24-1
JF 364 - #750-S Carbonate per Bulletin 6-24-9

Note 5 - Whiting

JF 82A Per Bulletin 6-24-7
JF 254 Per Bulletin C6-24-6

A Note 6 - Gypsum, Hagersville and New Brighton may substitute Collatex AS/KK Alginate in place of Marex Alginate.

NP0071445

A Indicates Addition

Also cancels Bulletin 61-2-23-4 dated 2-28-62

Original date of issue 1-22-63 SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved: [signature]	PERF-A-TAPE TOPPING COMPOUND CLEVELAND DISTRICT GYPSUM	No. 61-2-23-XX Date 4-29-63 Page 1 of 1 Cancels Page 1 Dated 1-22-63

Gypsum to manufacture Perf-A-Tape Topping Compound for the Cleveland District. Specifications as follows:

Formula	JF-391
Fine Ground Uncoiled Casein	4.5
Protatek A-155 Alginate	0.8
Hydrated Lime	about 0.1 %
Ammonium Oxalate	1.0
Ammonium Pentaborate	1.2
Dicyandiamide	0.3
Mica JC	0.4 formula V
P-85 Mica	0.4 formula V
JM7RF1 Asbestos	2/3 (approx. 6.0)
JC7RF9 Asbestos	1/3 (approx. 3.0)
Snowflake F (Whiting)	40.0
750 Marble	to make 100%
Glomax LL	5.0
Liquid Mix	0.153

Raw Materials - Same as listed in 61-2-23, except as follows:
Glomax LL - Georgia Kaolin Co.
pH of 20% aqueous slurry = 5.0-6.0
99.5% minus 325 mesh minimum

Finished Product Tests

Consistency	65-68cc for 400 ± 20 Brabender
Application Properties	- Comparable to std. samples from Research
Bond to Tape	- 2 minimum
pH	8.0-8.5
Rewet	Normally about 1
Color	No darker than std. sample from Research

Packaging and Identification
Pack in 25 lb. Topping Compound bags. After code add the letters "CX" to denote Cleveland compound.

Other specifications per Bulletin 61-2-23.

This bulletin expires 1-15-64.

TP007 1911

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved: JMB	PERF-A-TAPE TOPPING COMPOUND JF-403B GYPSUM	No. 61-2-23-YY Date 6-12-63 Page 1 of 2 Cancels Dated NEW

Gypsum to manufacture Perf-A-Tape Topping Compound, Formula JF-403B, for field trials and subsequent sale as directed by Dept. 147-5. Specifications as follows:

Formula: JF-403B

Raw Materials:

Casein, FG uncoiled	4.5%
Natrosol SG-62	0.7
Zinc oxide	0.2
Ammonium oxalate	1.0
Ammonium pentaborate	1.2
Dicyandiamide	0.3
Hydrated lime	As required (0.25 used in lab)
Mica JC	Formula V
JM7RF1 asbestos	As required(2.25 used in lab)
PC7RF9 asbestos	" " " " " "
Tetrasodium pyrophosphate	0.1
Glomax LL clay	5.0
No. 750 Marble	To make 100%
Ferrite Yellow	0.1 approx.

Raw Material Specifications:

Per Bulletin 61-2-23	
Ammonium pentaborate	per Bulletin 6-74-2
Glomax LL clay	per Bulletin 61-2-23-XX

Finished Product Specifications:

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match Sheetrock manila color.

NP007 1915

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved: JMB	PERF-A-TAPE TOPPING COMPOUND JF-403B GYPSUM	No. 61-2-23-YY Date 6-12-63 Page 1 of 2 Cancels Dated NEW

Gypsum to manufacture Perf-A-Tape Topping Compound, Formula JF-403B, for field trials and subsequent sale as directed by Dept. 147-5. Specifications as follows:

Formula: JF-403B

Raw Materials:

Casein, FG uncoiled	4.5%
Natrosol SG-62	0.7
Zinc oxide	0.2
Ammonium oxalate	1.0
Ammonium pentaborate	1.2
Dicyandiamide	0.3
Hydrated lime	As required (0.25 used in lab)
Mica JC	Formula V
JM7RF1 asbestos	As required (2.25 used in lab)
PC7RF9 asbestos	" " " " " "
Tetrasodium pyrophosphate	0.1
Glomax LL clay	5.0
No. 750 Marble	To make 100%
Ferrite Yellow	0.1 approx.

Raw Material Specifications:

Per Bulletin 61-2-23	
Ammonium pentaborate	per Bulletin 6-74-2
Glomax LL clay	per Bulletin 61-2-23-XX

Finished Product Specifications:

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match Sheetrock manila color.

Original date of issue 1-22-63 SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved:	PERF-A-TAPE TOPPING COMPOUND CLEVELAND DISTRICT GYPSUM	No. 61-2-23-CX Date 8-5-63 Page 1 of 1 Cancels Page 1 Dated 4-29-63

Gypsum to manufacture Perf-A-Tape Topping Compound for the Cleveland District. Specifications as follows:

Formula	JF-391
Fine Ground Uncoiled Casein	4.5
Protatek A-155 Alginate	0.8
Hydrated Lime	about 0.1%
Ammonium Oxalate	1.0
Ammonium Pentaborate	1.2
Dicyandiamide	0.3
Mica JC	0.4 formula V
P-85 Mica	0.4 formula V
JM7RF1 Asbestos	2/3 (approx. 6.0)
PC7RF9 Asbestos	1/3 (approx. 3.0)
Snowflake F (Whiting)	40.0
750 Marble	to make 100%
Glomax LL	5.0
Liquid Mix	0.153

Raw Materials - Same as listed in 61-2-23, except as follows:
Glomax LL - Per PMS Bul. 6-36-10.

Finished Product Tests

Consistency	65-68cc for 400 ± 20 Brabender
Application Properties	- Comparable to std. samples from Research
Bond to Tape	- 2 minimum
pH	8.0-8.5
Rewet	Normally about 1
Color	No darker than std. sample from Research

Packaging and Identification
Pack in 25 lb. Topping Compound bags. After code add the letters "CX" to denote Cleveland compound.

Other specifications per Bulletin 61-2-23.

This bulletin expires 1-15-64.

USP007 1912

Operating Division PRODUCT PROCEDURE Approved:	PERF-A-TAPE TOPPING COMPOUND GYPSUM	No. 61-2-23-3 Date 8-8-63 Page 1 of 1 Cancels Page 1 Dated 3-11-63

Gypsum to manufacture and ship the following formula Perf-A-Tape Topping Compound to the Milwaukee Market when "Special Milwaukee Formula" is noted on the 379 order form.

Formula JF-62E

Casein		3.0%	
Soy Protein		2.5	
Ammonium Alginate *		0.8	
Hydrated Lime	about	0.2	
Ammonium Oxalate		1.1	
Dowicide G		0.2	
Dicyandiamide		0.3	
Mica JC		per formula V	
Asbestos JM7RF1	approx.	6.0	(use 2:1 asbestos blend as needed
Asbestos PC7RF9	approx.	3.0	to give std. consistency)
Ser-X		15.0	
Snowflake F		15.0	
Stonelite		to make up 100%	
Sterox CD		0.1	
Tributylphosphate		0.05	
Neutralizer 5050		0.003	

* Marex or Collatex AS/KK

Compound is to be colored Manila with "Double" the amount of pigment used in present topping compound.

Finished Product Tests

Consistency 67-70 cc 68 cc normal (500 HB standard test)
pH: 8.2 to 8.7
All other tests per Bulletin 61-2-23.

Packaging

Use Standard Perf-A-Tape Topping Compound bags. Add "DP" after the code to denote Milwaukee Compound.

TP007 1963

/ Indicates Change

Operating Division PRODUCT PROCEDURE	PERF-A-TAPE TOPPING COMPOUND	No. 61-2-23-4
		Date 8-13-63
		Page 1 of 2
Approved: JMGB	GYPSUM	Cancels
		Date Reinstatement

DESCRIPTION:
This dry powder topping compound is designed for both joint finishing and texturing for use in the Cleveland district. This product is very white as it is the market practice to leave the textured surface unpainted.

MANUFACTURING MILL: Gypsum

FINISHED PRODUCT SPECIFICATIONS:
Color: White, no darker than Research sample.

Consistency: 65-68 cc water per 100 g. dry powder.

Viscosity: 530 ± 25 Brabender units when tested at 75-77F and using a viscometer operating at 75 revolutions per minute and having a 250 gram - centimeter torsion head.

Mixing and Application Properties: To match Research sample on initial batch and mill retained standard thereafter.

P H: 8.0 - 8.5
Cracking: Per Bulletin 61-2-23
Lumps: Per Bulletin 61-2-23
Bond to tape: Per bulletin 61-2-23
Reuet test: Per Bulletin 61-2-23
Odor of wet mixed compound: Per Bulletin 61-2-23

FORMULA JF-391		
Fine Ground Uncoiled Casein		4.5%
Protatek A-155 Alginate		0.8
Hydrated Lime (as needed for PH)	approx.	0.1
Ammonium Oxalate		1.0
Ammonium Pentaborate		1.2
Dicyandiamide		0.3
Mica JC	0.4 X Formula V	
P-85 Mica	0.4 X Formula V	
JM 7RF1 Asbestos*	approx.	6.0
PC 7RF9 Asbestos*	approx.	3.0
Snowflake F (Whiting)		40.0
Glomax LL clay		5.0
Liquid Mix		0.153
No. 750 Marble	to make	100%

NP007 197

No. 61-2-23-4 Date 8-13-63 Page 2 of 2 Cancels Dated Reinstatement	PERF-A-TAPE TOPPING COMPOUND GYPSUM

* Asbestos to be used as required to give proper consistency. Two parts of JM 7RF1 to one part of PC 7RF9 is the desired proportion.

RAW MATERIALS: As listed in Bulletin 61-2-23, except as follows:
Protatek A-155 - Croda Inc.
Glomax LL clay - Georgia Kaolin Company
PH of 20% aqueous slurry is 5.0 - 6.0

99.5% minus 325 mesh, minimum

Snowflake F - per bulletin 6-24-7

MANUFACTURING PROCEDURE: Per Bulletin 61-2-23

QUALITY CONTROL: Mill to test compound batches to make sure they meet finished product specifications.

IDENTIFICATION AND PACKAGING: Pack in 25-lb. Topping Compound bags. After code add the letters "CK" to denote Cleveland compound.

Operating Division PRODUCT PROCEDURE	PERF-A-TAPE TOPPING COMPOUND	No. 61-2-23-1
Approved: MJB	DALLAS	Date 10-2-63
		Page 1 of 2
		Cancels Page 1 Dated 7-23-63

Dallas to manufacture and ship Perf-A-Tape topping Compound, Formula JF 275, into the Denver District and the Heath and Sigurd Warehouses.

FORMULA JF-275

Casein	3.0
Refined soy protein	2.5
Sodium alginate	0.8
Hydrated Lime	As Req'd. (about 0.2 in lab batches)
Ammonium Oxalate	1.1
Dowicide G	0.2
Dicyandiamide	0.3
Mica J.C.	Formula V
Asbestos-Nicolet 7TG25	2/3 of needed quantity (4% in lab batch)
Asbestos - PC 7RF9	1/3 of needed quantity (2% in lab batch)
DXW Mineralite	15.0
#9 Georgia Marble	To make 100%
Liquid Mix	0.153

Sterox CD	0.100
TBP	0.050
Neutralizer 5050	0.003

RAW MATERIALS

All are the same as listed under 61-2-23.

PROCESSING

Same as for 61-2-23.

FINISHED PRODUCT SPECIFICATIONS

Color - To match the manila color of Sheetrock face paper, except on orders that specify natural white color.

CONSISTENCY Range 67-70 cc Normal 68 at a 650*Brabender Reading at 77°F.

APPLICATION PROPERTIES

To match standard sample from Research

pH 8.2 - 8.7

* Run on C. W. Brabender Visco Corder with 250 cm. gm. head, pin paddle, 1/2 pint cup container; pin paddle and 75 RPM at 75-77°.

Operating Division PRODUCT PROCEDURE Approved: MGB	PERF-A-TAPE TOPPING COMPOUND DALLAS	No. 61-2-23-1 Date 10-10-63 Page 1 of 2 Cancels Page 1 Dated 10-2-63

Dallas to manufacture and ship Perf-A-Tape Topping Compound, Formula JF 275, into the Denver District and the Heath and Sigurd Warehouses.

FORMULA JF-275

Casein	3.0
Refined soy protein	2.5
Sodium alginate	0.8
Hydrated Lime	As Req'd. (about 0.2 in lab batches)
Ammonium Oxalate	1.1
Dowicide G	0.2
Dicyandiamide	0.3
Mica J.C.	Formula V
Asbestos-Nicolet 7TG25	2/3 of needed quantity (4% in lab batch)
Asbestos - PC 7RF9	1/3 of needed quantity (2% in lab batch)
✓ DXW Mineralite	10.0
#9 Georgia Marble	To make 100%
Liquid Mix	0.153

Sterox CD	0.100
TBP	0.050
Neutralizer 5050	0.003

RAW MATERIALS
All are the same as listed under 61-2-23.

PROCESSING
Same as for 61-2-23.

FINISHED PRODUCT SPECIFICATIONS
Color - To match the manila color of Sheetrock face paper, except on orders that specify natural white color.

CONSISTENCY Range 67-70 cc Normal 68 at a 650*Brabender Reading at 77°F.

APPLICATION PROPERTIES
To match standard sample from Research.

pH 8.2 - 8.7

* Run on C. W. Brabender Visco Corder with 250 cm. gm. head, pin paddle, 1/2 pint cup container; pin paddle and 75 RPM at 75-77°.

M-5791 1/63 (Printed in U.S.A.) ✓ Indicates Change

OP007 1948

Operating Division
PRODUCT PROCEDURE

Approved: MJB

PERF-A-TAPE TOPPING COMPOUND

No. 61-2-23
Date 12-10-63
Page 1 of 6
Cancels Page 1
Dated 10-23-62

N-5791 1/63 (Printed in U.S.A.)

DESCRIPTION - Smooth Applying, easy sanding compound designed for finish coats only in finishing Perf-A-Tape joints. Supplied unpigmented on specific sales order.

MANUFACTURING PLANTS - Chamblee, Dallas, Gypsum, Hagersville, New Brighton, South Gate.

FORMULAS

	JF-418C New Brighton	JF 254 Hagersville	JF 364 Dallas	JF 200 South Gate	JF 185 Chamblee (1) Gypsum New Brighton
Casein	2.5	3.75	4.0	3.0	2.5
Soy Protein	3.0	-	-	2.5	2.25
Ammonium Alginate	0.3	0.8	-	0.8	0.8
Hydrated Lime	As Req.	As Req.	As Req.	As Req.	As Req.
Ammonium Oxalate	1.0	1.0	0.9	1.0	1.0
Sodium Pentachlorophenate	-	-	-	0.2	-
Ammonium Pentaborate	1.2	1.2	1.2	-	1.2
Dicyandiamide	0.3	1.0	0.3	0.3	0.3
Mica J.C.	Formula V	0.6 Formula V	-	Formula V	-
Mica P-85	-	-	0.8 Formula V	-	0.6 Formula V
20-62 (Hercules Powder Co.)			0.65		
Zinc Oxide (#42 green label)			0.20		
Tetra sodium pyrophosphate (Fine ground)			0.10		
Asbestos - (Note 1)	As Req.	As Req.	As Req.	As Req.	As Req.
Mica Sericite - (Note 2)	15.0	-	-	15.0	15.0
Whiting - (Note 5)	-	15.0	-	-	-
Talc	-	15.0	-	-	-
Starox CD - (Note 3)	0.1	0.1	-	0.1	0.1
Tributyl Phosphate - (Note 3)	0.05	0.05	-	0.05	0.05
Neutralizer 5050 - (Note 3)	0.003	0.003	-	0.003	0.003
Carbonate Filler - (Note 4)	To Make 100%	To make 100%	To make 100%	To Make 100%	To Make 100%
Pigments	Pigment with Ferrite Yellow and Other Lime Proof Colors as Required				

(1) Chamblee to use sodium alginate instead of ammonium alginate

0p007 1473

No. 61-2-23 Date 12-10-63 Page 2 of 6 Cancels Page 2 Dated 4-24-63	PERF-A-TAPE TOPPING COMPOUND

FORMULA NOTES

Note 1 - Asbestos used shall be as follows:

JF-418C - 2/3 Johns Manville 7RF1; 1/3 Phillip Carey 7RF9
JF 254 - Johns Manville 7RF1
JF 200 - Phillip Carey 7RF9
JF 185 - 2/3 Johns Manville 7RF1; 1/3 Phillip Carey 7RF9
JF 364 - 4.0% Nicolet T7G25 plus Canadian Carey 7RF9 as req'd (approx. 2%)

Note 2 - Sericite Mica used shall be as follows:

Gypsum and New Brighton - Ser-X
Chamblee - DXW Mineralite
South Gate - M350 Sericite

Note 3 - The Sterox CD, the tributyl phosphate and neutralizer 5050 should be mixed together before adding to the other ingredients. In cold weather this mixture may be thinned with a little isopropyl alcohol if necessary to facilitate its uniform dispersion among the powder ingredients. This mixture is to be sprayed into the other ingredients while they are being mixed in a Broughton mixer. If spray equipment is not used to add the liquid mix to the dry powders in the mixer the tributyl phosphate must be increased to .1% (total liquid mix .203%) and the liquid mix dribbled slowly into the powder in the mixer.

Note 4 - Carbonate Fillers:

JF 254 - Bulletin 58-2-2, page 2 of 5, A or AA
JF 185 - Bulletin 6-24-9
JF 200 - Per Bulletin 6-24-1
JF 364 - #750-S Carbonate per Bulletin 6-24-9
JF 418C - 30.0% Rambo #4 per PMS 6-24-9; A Dolomite per Bul. 58-2-2 to make 100%.

Note 5 - Whiting

JF 254 per Bulletin C6-24-6

Note 6 - Gypsum, Hagersville and New Brighton may substitute Collatex AS/KK Alginate in place of Marex Alginate.

/ Indicates Change
A Indicates Addition D Indicates Deletion

DP007 1439

PERF-A-TAPE TOPPING COMPOUND

JF

FINISHED PRODUCT SPECIFICATIONS (Cont'd)

Mixing and Application Properties - To duplicate those of a standard sample to be supplied by the Research Laboratory.

Cracking - Should show no edge or check cracking in the normal bond test dried in the hot room.

Lumps - Screen 100 grams of the dry powder on a 30 mesh screen. All should pass through readily except for small amounts of asbestos. If lumps are present, examine to determine what they are, and take any steps necessary to eliminate them.

Consistency - The mixed compound is to have the specified Brabender reading using the pin paddle, one hour after mixing at a temperature of 77° F.

JF 418C 650 BB	66 to 70 cc (Normal 68 cc)
JF 185 650 BB	65 to 68 cc (Normal 66 cc)
JF 200 650 BB	66 to 69 cc (Normal 67 cc)
JF 254 400 BB*	59 to 63 cc (Normal 61 cc)
JF 364 650 BB	64 to 67 cc (Normal 66 cc)

Direct reading on C. W. Brabender Visco Corder with 250 cm. gm. head, pin paddle, and 75 RPM speed.

* Corrected reading on "old" Brabender viscometer with heavy spring, pin paddle and 72 ± 2 r.p.m. speed at 77F.

pH - Determine 30 minutes after mixing, temperature of mixed compound to be 77° F. during the 30 minutes.

JF 418C	8.1 to 8.5, ideal 8.3 to 8.4
JF 185, JF 200, JF 254	8.2 to 8.7, ideal 8.4 to 8.5
JF 364	8.2 to 8.4, ideal 8.3

Bond to Tape - Normally 2 to 4 when dried in an atmosphere below 50% RH for 18 hours. Lower at higher humidities. See page 6 of 6 for Bond Scale.

Rewet Test - Normally about 1 for all formulas.

Odor of Wet Mixed Compound - To be of same general character and no stronger than that of a standard sample of the same compound on standing a similar length of time after mixing with water.

DP007 1425

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved:	PERF-A-TAPE TOPPING COMPOUND JF-403B CHAMBLEE, GYPSUM & NEW BRIGHTON	No. 61-2-23-YY Date 1-6-64 Page 1 of 2 Cancels Page 1 Dated 6-12-63

Chamblee, Gypsum, and New Brighton to manufacture Perf-A-Tape Topping Compound, Formula JF-403B, for field trials and subsequent sale as directed by Dept. 147-2. Specifications as follows:

Formula: JF-403B

Raw Materials:

Casein, FG uncoiled	4.5%
Natrosol SG-62	0.7
Zinc Oxide (No. 42 Green Label)	0.1
Ammonium oxalate	1.0
Ammonium pentaborate	1.2
Dicyandiamide	0.3
Hydrated lime	As req'd (0.25 used in lab)
Mica JC	Formula V
JM7RF1 asbestos	As req'd (2.25 used in lab)
PC7RF9 asbestos	As req'd (2.25 used in lab)
Tetrasodium pyrophosphate	0.1
Glomax LL clay	5.0
No. 750 Marble	To make 100%
Ferrite Yellow	0.1 approx.

Raw Material Specifications:

Per Bulletin 61-2-23	
Ammonium pentaborate	per Bulletin 6-74-2
Glomax LL clay	per Bulletin 61-2-23-XX
Alternate Carbonate Filler-Rambo #4	per Bulletin 6-24-9.

Finished Product Specifications:

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match Sheetrock manila color.

NP007 1911

No. 61-2-23-XX Date 1-6-64 Page 2 of 2 Cancels Page 2 Dated 11-14-63	PERF-A-TAPE TOPPING COMPOUND JF-403B CHAMBLEE, GYPSUM & NEW BRIGHTON	MGB

Mixing and Application - To equal those of a standard Research sample.

Cracking - per Bulletin 61-2-23

Lumps - Per Bulletin 61-2-23

Consistency - 66-70 cc (normal:68) per 100 grams of dry powder.

Brabender - 525 units when tested at 77F on a viscometer operating at 75 rpm and having a 250 gram-centimeter torsion head.

Other specifications per Bulletin 61-2-23.

Packaging: 25 lb. Perf-A-Tape Topping Compound bag; layout 7-16-42.

Code: Regular code to be followed by the letters "CR". Exception: Chamblee will use the letter "C".

Shipment: As directed by Mdse. 147-2.

This bulletin expires 6-15-64.

/ Indic Change

NP007 1912

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved:	PERF-A-TAPE TOPPING COMPOUND JF-403B CHAMBLEE, GYPSUM & NEW BRIGHTON	No. 61-2-23-YY Date 2-24-64 Page 1 of 2 Cancels Page 1 Dated 1-6-64

Chamblee, Gypsum, and New Brighton to manufacture Perf-A-Tape Topping Compound, Formula JF-403B. Specifications as follows:

Formula: JF-403B

Raw Materials:

Casein, FG unoiled	4.5%
Natrosol SG-62	0.7
Zinc Oxide (No. 42 Green Label)	0.1
Ammonium oxalate	1.0
Ammonium pentaborate	1.2
Dicyandiamide	0.3
Hydrated lime	As req'd (0.25 used in lab)
Mica JC	Formula V
JM7RF1 asbestos	As req'd (2.25 used in lab)
PC7RF9 asbestos	As req'd (2.25 used in lab)
Tetrasodium pyrophosphate	0.1
Glomax LL clay	5.0
No. 750 Marble	To make 100%
Ferrite Yellow	0.1 approx.

Raw Material Specifications:

Per Bulletin 61-2-23	
Ammonium pentaborate	per Bulletin 6-74-2
Glomax LL clay	per Bulletin 61-2-23-XX
Alternate Carbonate Filler-Rambo #4	per Bulletin 6-24-9.

Finished Product Specifications:

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match Sheetrock manila color.

NP0017 1923

No. 61-2-23-YY Date 2-24-64 Page 2 of 2 Cancels Page 2 Dated 1-6-64	PERF-A-TAPE TOPPING COMPOUND JF-403B CHAMBLEE, GYPSUM & NEW BRIGHTON

Mixing and Application - To equal those of a standard Research sample.

Cracking - per Bulletin 61-2-23

Lumps - Per Bulletin 61-2-23

Consistency - 66-70 cc (normal:68) per 100 grams of dry powder.

Brabender - 525 units when tested at 77F on a viscometer operating at 75 rpm and having a 250 gram-centimeter torsion head.

Other specifications per Bulletin 61-2-23.

Packaging: 25 lb. Perf-A-Tape Topping Compound bag; layout 7-16-42.

/ Code: Regular code to be followed by the letters "CR".

/ Shipment: Mill Area when order designates - Perf-A-Tape Topping Compound C.R.

This bulletin expires 6-15-64.

NP007 1913

M-8971 (Back)

/ Indicates Change

Operating Division PRODUCT PROCEDURE Approved:	ALL PURPOSE READY MIXED PERF-A-TAPE JOINT COMPOUND CHAMBLEE	No. 61-2-24-1 Date 2-28-64 Page 1 of 3 Cancels Page 1 Dated 3-2-61

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

MANUFACTURING MILL: Chamblee

FORMULA: Je-217

	% Non-Volatile	Lbs. (for 100 gal. batch approx.)
Mica JC	(2/3 Formula V)	80 approx.
DXW Mineralite	30.0	240
Asbestos Floats	(as required)	24 approx.
Huber CWF Clay	10.0	80
Methocel 65 HG	0.8	6 - 6 oz.
Ferrite Yellow	(to match manila color of Sheetrock face paper)	
#9 Marble	(to make 100%)	(to make 800 lbs. total non-volatile)
Plasticized WC-130*	5.5	77
Carbitol	-	7
PMA Preservative	-	4 oz.
Water	-	53 gals. approx.

* Contains 5.0 WC-130 solids and 0.5 dibutyl phthalate.

RAW MATERIALS

Resin	Per	Bulletin	T6-104-55
Methocel HG,4000 cps.	"	"	6-16-5
Dibutyl Phthalate	"	"	6-98-1
Solvent	"	"	6-149-3
Mica	"	"	6-143-1
DXW Mineralite	"	"	6-146-2
Asbestos	"	"	6-7-1
Nuodex PMA-18	"	"	6-100-2
Troysan PMA-30	"	"	6-100-3
Huber CWF Clay	"	"	6-36-5
#9 Georgia Marble	"	"	6-24-9
Ferrite Yellow	"	"	

OP009 1421

/ Indicates Change

Also cancels temporary bulletin 61-2-22-4-A, dated 2-12-63

Operating Division PRODUCT PROCEDURE Approved:	PERF-A-TAPE COMPOUND FORMULA J-1267D CHAMBLEE	No. 61-2-22-4 Date 3-17-64 Page 1 of 1 Cancels Page 1 Dated 3-11-63

Chamblee to manufacture and ship Formula J-1267D Perf-A-Tape Compound to the Dixie Drywall Co., in Atlanta, Georgia.

PERF-A-TAPE COMPOUND - FORMULA J-1267D For all 25# bags of Perf-A-Tape Compound and 18# bags Perf-A-Tape Joint System.

Casein 100 M, unciled	7.0
Sodium Pentachlorophenate	0.25
Ammonium Oxalate	1.25 - 1.4
Hydrated Lime to give normal pH & solution rate	.1 - .3 (.15 used in lab)
Dicyandiamide	0.5
Asbestos JM-7RF1	As required to give normal consistency approx. range 6-7% based on lab results.
DXW Mineralite	15.0
Mica JC	Formula V x 1.1
No. 750 Marble	To make up 100%
Neutralizer #5050 (1)	.003
KELSIZE LV Alginate	0.3
Sterox CD	.1%
Tributylphosphate (1)	.05

(1) The liquid wetting agents - Sterox CD, Tributylphosphate and Neutralizer #5050 are to be mixed together in proper proportions and sprayed into the batch in the Broughton Mixer. In cold weather, the solution may be thinned with isopropyl alcohol if necessary to facilitate spraying.

COMPOUND TO BE COLORED MANILA COLOR SLIGHTLY DEEPER THAN PRESENT TOPPING COMPOUND.

Finished Product Tests

Consistency 68-72 cc normal 70 cc for a Brabender reading of 665 ± 25 at 77°F. ("New" machine values.)

Other tests per Bulletin 61-2-22.

TP007 1335

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved:	PERF-A-TAPE TOPPING COMPOUND JF-403B CHAMBLEE, GYPSUM & NEW BRIGHTON	No. 61-2-23-YY Date 3-17-64 Page 1 of 2 Cancels Page 1 Dated 2-24-64

Chamblee, Gypsum, and New Brighton to manufacture Perf-A-Tape Topping Compound, Formula JF-403B. Specifications as follows:

Formula: JF-403B

Raw Materials:

Casein, FG unoiled	4.5%
Natrosol SG-61	0.7
Zinc Oxide (No. 42 Green Label)	0.1
Ammonium oxalate	1.0
Ammonium pentaborate	1.2
Dicyandiamide	0.3
Hydrated lime	As req'd (0.25 used in lab)
Mica JC	Formula V
JM7RF1 asbestos	As req'd (2.25 used in lab)
PC7RF9 asbestos	As req'd (2.25 used in lab)
Tetrasodium pyrophosphate	0.1
Glomax LL clay	5.0
No. 750 Marble	To make 100%
Ferrite Yellow	0.1 approx.

Raw Material Specifications:

Per Bulletin 61-2-23	
Ammonium pentaborate	per Bulletin 6-74-2
Glomax LL clay	per Bulletin 61-2-23-XX
Alternate Carbonate Filler-Rambo #4	per Bulletin 6-24-9.

Finished Product Specifications:

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match Sheetrock manila color.

NPO01 1971

DESCRIPTION - Smooth Applying, easy sanding compound designed for finish coats only in finishing Perf-A-Tape joints. Supplied unpigmented on specific sales order.

MANUFACTURING PLANTS - Chamblee, Dallas, Gypsum, Hagersville, New Brighton, South Gate.

FORMULAS

	JF-418C New Brighton	JF 254 Hagersville	JF 364 Dallas	JF 200 South Gate	JF 185 Chamblee (1) Gypsum New Brighton
Casein	2.5	3.75	4.0	3.0	2.5
Soy Protein	3.0	-	-	2.5	2.25
Ammonium Alginate	0.8	0.8	-	0.8	0.8
Hydrated Lime	As Req.	As Req.	As Req.	As Req.	As Req.
Ammonium Oxalate	1.0	1.0	0.9	1.0	1.0
Sodium Pentachlorophenate	-	-	-	0.2	-
Ammonium Pentaborate	1.2	1.2	1.2	-	1.2
Dicyandiamide	0.3	1.0	0.3	0.3	0.3
Mica J.C.	Formula V	0.6 Formula V	-	Formula V	-
Mica P-85	-	-	0.8 Formula V	-	0.6 Formula V
SG-62 (Hercules Powder Co.)			0.65		
Zinc Oxide (#42 green label)			0.20		
Tetra sodium pyrophosphate (Fine ground)			0.10		
Asbestos - (Note 1)	As Req.	As Req.	As Req.	As Req.	As Req.
Mica Sericite - (Note 2)	15.0	-	-	15.0	15.0
Whiting - (Note 5)	-	15.0	-	-	-
Talc	-	15.0	-	-	-
Polyglycol P1200 (Note 3)	0.150	0.150	-	0.150	0.150
Neutralizer 5050 - (Note 3)	0.003	0.003	-	0.003	0.003
Carbonate Filler - (Note 4)	To Make 100%	To make 100%	To make 100%	To Make 100%	To Make 100%
Pigments	Pigment with Ferrite Yellow and Other Lime Proof Colors as Required				

(1) Chamblee to use sodium alginate instead of ammonium alginate

PERF-A-TAPE TOPPING COMPOUND

FORMULA NOTES

Note 1 - Asbestos used shall be as follows:

JF-418C - 2/3 Johns Manville 7RF1; 1/3 Phillip Carey 7RF9
JF 254 - Johns Manville 7RF1
JF 200 - Phillip Carey 7RF9
JF 185 - 2/3 Johns Manville 7RF1; 1/3 Phillip Carey 7RF9
JF 364 - 4.0% Nicolet T7G25 plus Canadian Carey 7RF9 as req'd (approx. 2%)

Note 2 - Sericite Mica used shall be as follows:

Gypsum and New Brighton - Ser-X
Chamblee - DXW Mineralite
South Gate - M350 Sericite

Note 3 - The Polyglycol P1200 and neutralizer 5050 should be mixed together before adding to the other ingredients. In cold weather this mixture may be thinned with a little isopropyl alcohol if necessary to facilitate its uniform dispersion among the powder ingredients. This mixture is to be sprayed into the other ingredients while they are being mixed in a Broughton mixer. If spray equipment is not used to add the liquid mix to the dry powders in the mixer the tributyl phosphate must be increased to .1% (total liquid mix .203%) and the liquid mix dribbled slowly into the powder in the mixer.

Note 4 - Carbonate Fillers:

JF 254 - Bulletin 58-2-2, page 2 of 5, A or AA
JF 185 - Bulletin 6-24-9
JF 200 - Per Bulletin 6-24-1
JF 364 - #750-S Carbonate per Bulletin 6-24-9
JF 418C - 30.0% Rambo #4 per PMS 6-24-9; A Dolomite per Bul. 58-2-2 to make 100%.

Note 5 - Whiting

JF 254 per Bulletin C6-24-6

Note 6 - Gypsum, Hagersville and New Brighton may substitute Collatex AS/KK Alginate in place of Marex Alginate.

# Indicates Change

OP007 1427

RAW MATERIAL SPECIFICATIONS

Casein	Per Bulletin 6-26-4
Soy Protein	" " 6-123-1
Hydrated Lime (See below (1))	
Ammonium Oxalate	" " 6-11-5
Sodium Pentachlorophenate	" " 6-33-4
Dicyandiamide	" " 6-44-1
Mica JC	" " 6-143-1
Mica P-85	" " 6-143-3
Sericite Micas	" " 6-146-2
Asbestos	" " 6-14-5
/ D Wetting Agent - Polyglycol P1200	Dow Chemical Co.
Carbonate Fillers	Per Bulletin 6-24-1, 6-24-9, 58-2-2
Ammonium Alginate	" " 6-8-1
Whiting	" " 6-24-7, C6-24-6
Ferrite	- -
Talc	Per Bulletin C6-128-4
Sodium Alginate	Per Bulletin 6-8-4
Zinc Oxide (#42 green label)	Per Bulletin 6-94-91
Tetra sodium pyrophosphate	Per Bulletin 6-129-1

SG-62 (Hercules Powder Co. - retarded solution, high viscosity hydroxy ethyl cellulose)

Ammonium pentaborate Technical grade powdered, from Pacific Coast Borax Co.
Neutralizer 5050 - from Magnus, Mabee and Reynard, Inc.
(1) Hydrated Lime - Per Bulletins 59-3-7, 6-69-1, 59-8-7 or equivalent.

PROCESSING

Weigh all materials accurately. Maximum permissible weight departure is 3% of the amount specified. Mix in a Broughton mixer, spraying the mixed liquids after mixing of the powders has started. Continue mixing for a minimum of 10 minutes after the liquids have been sprayed into the batch.

After mixing is complete pass the batch through a Micropulverizer using a coarse (3/32" slot width) screen. It is then ready for packing.

FINISHED PRODUCT SPECIFICATIONS

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed under or over the code number. Otherwise all topping compound to be tinted to match standard sample from Research - approximately to match Sheetrock manila color. The .05% ferrite color is to be discontinued. South Gate to remain at their current degree of pigmentation, as of April 1, 1959.

OP007 1433

Operating Division PRODUCT PROCEDURE Approved:	PERF-A-TAPE TOPPING COMPOUND GYPSUM	No. 61-2-23-3 Date 4-22-64 Page 1 of 1 Cancels Page 1 Dated 8-8-63

Gypsum to manufacture and ship the following formula Perf-A-Tape Topping Compound to the Milwaukee Market when "Special Milwaukee Formula" is noted on the 379 order form.

Formula JF-62E

Casein		3.0%	
Soy Protein		2.5	
Ammonium Alginate*		0.8	
Hydrated Lime	about	0.2	
Ammonium Oxalate		1.1	
Dowicide G		0.2	
Dicyandiamide		0.3	
Mica JC	per formula V		
Asbestos JM/RF1	approx.	6.0	(use 2:1 asbestos blend as needed
Asbestos PC7RF9	approx.	3.0	to give std. consistency)
Ser-X		15.0	
Snowflake F		15.0	
Stonelite	to make up 100%		
Polyglycol P1200		0.150	
Neutralizer 5050		0.003	

* Marex or Collatex AS/KK

Compound is to be colored Manila with "Double" the amount of pigment used in present topping compound.

Finished Product Tests

Consistency 67-70 cc 68 cc normal (500 BB standard test)
pH: 8.2 to 8.7
All other tests per Bulletin 61-2-23.

Packaging

Use Standard Perf-A-Tape Topping Compound bags. Add "DP" after the code to denote Milwaukee Compound.

OP007 1963

Operating Division PRODUCT PROCEDURE Approved: JF	PERF-A-TAPE TOPPING COMPOUND DALLAS	No. 61-2-23-1 Date 4-22-64 Page 1 of 2 Cancels Page 1 Dated 10-10-63

Dallas to manufacture and ship Perf-A-Tape Topping Compound, Formula JF 275, into the Denver District and the Heath and Sigurd Warehouses.

FORMULA JF-275

Casein	3.0
Refined soy protein	2.5
Sodium alginate	0.8
Hydrated Lime	As Req'd. (about 0.2 in lab batches)
Ammonium Oxalate	1.1
Dowicide G	0.2
Dicyandiamide	0.3
Mica J.C.	Formula V
Asbestos-Nicolet 7TG25	2/3 of needed quantity (4% in lab batch)
Asbestos - PC 7RF9	1/3 of needed quantity (2% in lab batch)
DXW Mineralite	10.0
#9 Georgia Marble	To make 100%
Liquid Mix	0.153
Polyglycol P1200	0.150
Neutralizer 5050	0.003

RAW MATERIALS
All are the same as listed under 61-2-23.

PROCESSING
Same as for 61-2-23.

FINISHED PRODUCT SPECIFICATIONS
Color - To match the manila color of Sheetrock face paper, except on orders that specify natural white color.

CONSISTENCY Range 67-70 cc Normal 68 at a 650*Brabender Reading at 77°F.

APPLICATION PROPERTIES
To match standard sample from Research.

pH 8.2 - 8.7

* Run on C. W. Brabender Visco Corder with 250 cm. gm. head, pin paddle, 1/2 pint cup container; pin paddle and 75 RPM at 75-77°.

APR 07 1964

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved: JF	PERF-A-TAPE TOPPING COMPOUND (JF-394D) CHAMBLEE, GYPSUM AND NEW BRIGHTON	No. 61-2-23-A Date 6-8-64 Page 1 of 1 Cancels Dated NEW

Chamblee, Gypsum and New Brighton to manufacture and ship a modified C. R. Topping Compound Formula J. F. - 394D. Specifications as follows:

FINISHED PRODUCT SPECIFICATIONS

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match Sheetrock manila color.

Consistency - Consistency to be 68-72cc (normal 70cc) per 100 gms.

FORMULA	JF-394D
Casein, FG uncoiled	4.5
Natrosol SG-61	0.8
Zinc Oxide	0.1
Ammonium Oxalate	1.0
" Pentaborate	1.2
Dicyandiamide	0.3
Hydrated Lime	(as required)
P-85 Mica	Formula V
JM-7RF1 Asbestos	(as required - about 2.0%)
PC-7RF9 "	(as required - about 2.0%)
TSPP	0.1
No. 750 Marble(New Brighton use Rambo #4)	To make 100%
Ferrite Yellow	0.1 approx.
Liquid Mix	0.153

RAW MATERIALS - Per Bul. 61-2-23.

Ammonium pentaborate	Per Bull. 6-74-2
Alternate Carbonate Filler-Rambo #4	" " 6-24-9

CODE - Regular code to be followed by letters CS for Lakeland District orders only - All other orders will continue to show C. R. after regular code number.

PACKAGING - 25 lb. Perf-A-Tape Topping Compound bag; layout 7-16-42.

Other specifications per Bulletin 61-2-23.

This bulletin expires 12-15-64.

DP007 1593

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE	PERF-A-TAPE TOPPING COMPOUND JF-403B	No. 61-2-23-YY
Approved: JP	CHAMBLEE, GYPSUM & NEW BRIGHTON	Date 6-25-64
		Page 1 of 2
		Cancels Page 1 Dated 3-17-64

Chamblee, Gypsum, and New Brighton to manufacture Perf-A-Tape Topping Compound, Formula JF-403B. Specifications as follows:

Formula: JF-403B

Raw Materials:

Casein, FG unoiled	4.5%
Natrosol SG-61	0.7
Zinc Oxide (No. 42 Green Label)	0.1
Ammonium oxalate	1.0
Ammonium pentaborate	1.2
Dicyandiamide	0.3
Hydrated lime	As req'd (0.25 used in lab)
Mica JC	Formula V
JM7RF1 asbestos	As req'd (2.25 used in lab)
PC7RF9 asbestos	As req'd (2.25 used in lab)
Tetrasodium pyrophosphate	0.1
Glomax LL clay	5.0
No. 750 Marble	To make 100%
Ferrite Yellow	0.1 approx.

Raw Material Specifications:

Per Bulletin 61-2-23	
Ammonium pentaborate	per PMS 6-74-2
Glomax LL clay	per PMS 6-36-10
Alternate Carbonate Filler-Rambo #4	per PMS 6-24-9

Finished Product Specifications:

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match Sheetrock manila color.

DP007 1933

Original date of issue 6-12-63. 1st Extension

No. 61-2-23-YY Date 6-25-64 Page 2 of 2 Cancels Page 2 Dated 2-24-64	PERF-A-TAPE TOPPING COMPOUND JF-403B CHAMBLEE, GYPSUM & NEW BRIGHTON

Mixing and Application - To equal those of a standard Research sample.

Cracking - per Bulletin 61-2-23

Lumps - Per Bulletin 61-2-23

Consistency - 66-70 cc (normal:68) per 100 grams of dry powder.

Brabender - 525 units when tested at 77F on a viscometer operating at 75 rpm and having a 250 gram-centimeter torsion head.

Other specifications per Bulletin 61-2-23.

Packaging: 25 lb. Perf-A-Tape Topping Compound bag; layout 7-16-42.

Code: Regular code to be followed by the letters "CR".

Shipment: Mill Area when order designates - Perf-A-Tape Topping Compound C.R.

This bulletin expires 12-15-64.

NP007 1925

M-8971 (Back)

/ Indicates Change

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved: JP	PERF-A-TAPE TOPPING COMPOUND (JF-394D) GYPSUM	No. 61-2-23-A Date 7-24-64 Page 1 of 1 Cancels Page 1 Dated 6-8-64

Gypsum to manufacture and ship C.S. Topping Compound Formula J.F. - 394D.

FINISHED PRODUCT SPECIFICATIONS

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match Sheetrock manila color.

Consistency - Consistency to be 68-72cc (normal 70cc) per 100 gms.

FORMULA	JF-394D
Casein, FG uncoiled	4.5
Natrosol SG-61	0.8
Zinc Oxide	0.1
Ammonium Oxalate	1.0
" Pentaborate	1.2
Dicyandiamide	0.3
Hydrated Lime	(as required)
P-85 Mica	Formula V
JM-7RF1 Asbestos	(as required - about 2.0%)
PC-7RF9 "	(as required - about 2.0%)
TSPP	0.1
No. 750 Marble	To make 100%
Ferrite Yellow	0.1 approx.
Liquid Mix	0.153

RAW MATERIALS - Per Bul. 61-2-23.

Ammonium pentaborate	Per Bulletin 6-74-2

CODE - Regular code to be followed by letters CS for all shipments.

PACKAGING - 25 lb. & 32 lb. Perf-A-Tape Topping Compound bag; layout 7-16-42.

Other specifications per Bulletin 61-2-23.

SHIPPING INSTRUCTIONS

Limitations - Restricted to specific orders for "CS" from the Lakeland and South Shore Districts and all transfer shipments to Hermosa.

This bulletin expires 12-15-64.

USP007 1582

Operating Division
PRODUCT PROCEDURE

Approved:

PERF-A-TAPE TOPPING COMPOUND

No. 61-2-23
Date 8-6-64
Page 1 of 6
Cancels Page 1
Dated 4-22-64

DESCRIPTION - Smooth Applying, easy sanding compound designed for finish coats only in finishing Perf-A-Tape joints. Supplied unpigmented on specific sales order.

MANUFACTURING PLANTS - Chamblee, Dallas, Gypsum, Hagersville, New Brighton, South Gate.

FORMULAS

	JF-418C New Brighton	JF 254 Hagersville	JF 364 Dallas	JF 200 South Gate(1)	JF 185 Chamblee (1) Gypsum New Brighton
Casein	2.5	3.75	4.0	3.0	2.5
Soy Protein	3.0	-	-	2.5	2.25
Ammonium Alginate	0.8	0.8	-	0.8	0.8
Hydrated Lime	As Req.	As Req.	As Req.	As Req.	As Req.
Ammonium Oxalate	1.0	1.0	0.9	1.0	1.0
Sodium Pentachlorophenate	-	-	-	0.2	-
Ammonium Pentaborate	1.2	1.2	1.2	-	1.2
Dicyandiamide	0.3	1.0	0.3	0.3	0.3
Mica J.C.	Formula V	0.6 Formula V	-	Formula V	-
Mica P-85	-	-	0.8 Formula V	-	0.6 Formula V
SG-62 (Hercules Powder Co.)			0.65		
Zinc Oxide (#42 green label)			0.20		
Tetra sodium pyrophosphate (Fine ground)			0.10		
Asbestos - (Note 1)	As Req.	As Req.	As Req.	As Req.	As Req.
Mica Sericite - (Note 2)	15.0	-	-	15.0	15.0
Whiting - (Note 5)	-	15.0	-	-	-
Talc	-	15.0	-	-	-
Polyglycol P1200 (Note 3)	0.150	0.150	-	0.150	0.150
Neutralizer 5050 - (Note 3)	0.003	0.003	-	0.003	0.003
Carbonate Filler - (Note 4)	To Make 100%	To make 100%	To make 100%	To Make 100%	To Make 100%
Pigments	Pigment with Ferrite Yellow and Other Lime Proof Colors as Required				

(1) Chamblee and South Gate to use sodium alginate instead of ammonium alginate.

/ Indicates Change

M-5791 1/63 (Printed in U.S.A.)

DP007 1429

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved: JP	P.A.T. TOPPING COMPOUND (JF-460F) CHAMBLEE	No. 61-2-23-D Date 8-11-64 Page 1 of 1 Cancels Dated NEW

Chamblee to manufacture and ship JF-460F Topping Compound for field trials and sales as directed by Dept. 147-2 per the following specifications:

FINISHED PRODUCT SPECIFICATIONS:

pH 8.4 - 8.8

FORMULA	JF-460F
Casein, FG uncoiled	2.5%
Pro-Cote U	2.25
Kelsize LV	0.8
Hydrated lime	0-0.1 (as req'd for pH)
Ammonium oxalate	1.0
Advacide TJP	0.1
Dicyandiamide	1.0
P-85 Mica	0.6 X Formula V
JM 7RF1 Asbestos	As req'd (5.0% in lab)
PC 7RF9 Asbestos	As req'd (2.5% in lab)
DXW Mineralite	15.0
No. 750 Marble	to make 100%
Polyglycol P-1200	0.1
Tributyl phosphate	0.05
Neutralizer 5050	0.003

RAW MATERIALS:

Advacide TJP - A tributyl tin oxide type fungicide containing approximately 10% active ingredient dispersed on 90% fine calcium carbonate. Source: Advance Division, Carlisle Chemical Works, New Brunswick, N. J.

IDENTIFICATION:

The letter "H" to follow normal code.

Other specifications per Bulletin 61-2-23.

This bulletin expires 8-15-65.

NP002 1611

DESCRIPTION - Smooth Applying, easy sanding compound designed for finish coats only in finishing Perf-A-Tape joints. Supplied unpigmented on specific sales order.

MANUFACTURING PLANTS - Chamblee; Dallas, Gypsum, Hagersville, New Brighton, South Gate.

FORMULAS

	JF-418C New Brighton	JF 254 Hagersville	JF 364 Dallas	JF 200 South Gate(1)	JF 185 Chamblee (1) Gypsum New Brighton
Casein	2.5	3.75	4.0	3.0	2.5
Soy Protein	3.0	-	-	2.5	2.25
Ammonium Alginate	0.8	0.8	-	0.8	0.8
Hydrated Lime	As Req.	As Req.	As Req.	As Req.	As Req.
Ammonium Oxalate	1.0	1.0	0.9	1.0	1.0
Sodium Pentachlorophenate	-	-	-	0.2	-
Ammonium Pentaborate	1.2	1.2	1.2	-	1.2
Dicyandiamide	0.3	1.0	0.3	0.3	0.3
Mica J.C.	Formula V	0.6 Formula V	-	Formula V	-
Mica P-85	-	-	0.8 Formula V	-	0.6 Formula V
SG-61			0.65		
Zinc Oxide (#42 green label)			0.20		
Tetra sodium pyrophosphate (Fine ground)			0.10		
Asbestos - (Note 1)	As Req.	As Req.	As Req.	As Req.	As Req.
Mica Sericite - (Note 2)	15.0	-	-	15.0	15.0
Whiting - (Note 5)	-	15.0	-	-	-
Talc	-	15.0	-	-	-
Polyglycol P1200 (Note 3)	0.150	0.150	-	0.150	0.150
Neutralizer 5050 - (Note 3)	0.003	0.003	-	0.003	0.003
Carbonate Filler - (Note 4)	To Make 100%	To make 100%	To make 100%	To Make 100%	To Make 100%
Pigments	Pigment with Ferrite Yellow and Other Lime Proof Colors as Required				

(1) Chamblee and South Gate to use sodium alginate instead of ammonium alginate.

M-5791 1/63 (Printed in U.S.A.)

DP007 1426

Operating Division PRODUCT PROCEDURE Approved: JP	PERF-A-TAPE TOPPING COMPOUND	No. 61-2-23 Date 8-17-64 Page 3 of 6 Cancels Page 3 Dated 4-22-64

RAW MATERIAL SPECIFICATIONS

Casein	Per Bulletin 6-26-4
Soy Protein	" " 6-123-1
Hydrated Lime (See below (1))	
Ammonium Oxalate	" " 6-11-5
Sodium Pentachlorophenate	" " 6-33-4
Dicyandiamide	" " 6-44-1
Mica JC	" " 6-143-1
Mica P-85	" " 6-143-3
Sericite Micas	" " 6-146-2
Asbestos	" " 6-14-5
Wetting Agent - Polyglycol P1200	Dow Chemical Co.
Carbonate Fillers	Per Bulletin 6-24-1, 6-24-9, 58-2-2
Ammonium Alginate	" " 6-8-1
Whiting	" " 6-24-7, C6-24-6
Ferrite	- -
Talc	Per Bulletin C6-128-4
Sodium Alginate	Per Bulletin 6-8-4
Zinc Oxide (#42 green label)	Per Bulletin 6-94-91
Tetra sodium pyrophosphate	Per Bulletin 6-129-1

SG-61 (Hercules Powder Co. - retarded solution, high viscosity hydroxy ethyl cellulose)

Ammonium pentaborate Technical grade powdered, from Pacific Coast Borax Co.
Neutralizer 5050 - from Magnus, Mabee and Reynard, Inc.
(1) Hydrated Lime - Per Bulletins 59-3-7, 6-69-1, 59-8-7 or equivalent.

PROCESSING

Weigh all materials accurately. Maximum permissible weight departure is 3% of the amount specified. Mix in a Broughton mixer, spraying the mixed liquids after mixing of the powders has started. Continue mixing for a minimum of 10 minutes after the liquids have been sprayed into the batch.

After mixing is complete pass the batch through a Mikropulverizer using a coarse (3/32" slot width) screen. It is then ready for packing.

FINISHED PRODUCT SPECIFICATIONS

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed under or over the code number. Otherwise all topping compound to be tinted to match standard sample from Research - approximately to match Sheetrock manila color. The .05% ferrite color is to be discontinued. South Gate to remain at their current degree of pigmentation, as of April 1, 1959.

OP007 1424

/ Indicates Change

Also cancels 61-2-23-YY dated SPECIAL BULLETIN 6-25-64.

Operating Division PRODUCT PROCEDURE Approved: JJP	PERF-A-TAPE TOPPING COMPOUND (JF-394D) GYPSUM	No. 61-2-23-A Date 10-27-64 Page 1 of 1 Cancels Page 1 Dated 7-24-64

Gypsum, New Brighton and Chamblee to manufacture and ship C.S. Topping Compound Formula J.F. - 394D.

FINISHED PRODUCT SPECIFICATIONS

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match Sheetrock manila color.

Consistency - Consistency to be 68-72cc (normal 70cc) per 100 gms.

FORMULA	JF-394D
Casein, FG uncoiled	4.5
Natrosol SG-61	0.8
Zinc Oxide	0.1
Ammonium Oxalate	1.0
" Pentaborate	1.2
Dicyandiamide	0.3
Hydrated Lime	(as required)
P-85 Mica	Formula V
JM-7RF1 Asbestos	(as required - about 2.0%)
FC-7RF9 "	(as required - about 2.0%)
TSPP	0.1
/ No. 750 Marble or Rambo #4	To make 100%
Ferrite Yellow	0.1 approx.
D	

RAW MATERIALS - Per Bul. 61-2-23.

Ammonium pentaborate	Per Bulletin 6-74-2

CODE - Regular code to be followed by letters CS for all shipments.

PACKAGING - 25 lb. & 32 lb. Perf-A-Tape Topping Compound bag; layout 7-16-42.

Other specifications per Bulletin 61-2-23.

/ SHIPPING INSTRUCTIONS - To be shipped on all orders for either CR or CS topping compound, and all transfer shipments to Hermosa.

Shipments to Florida are to be made only with approval of Dept. 147-2.

This bulletin expires 12-15-64.

UP007 1591

Originally issued 6-8-64 SPECIAL BULLETIN 1st Extension

Operating Division PRODUCT PROCEDURE Approved: JJP	PERF-A-TAPE TOPPING COMPOUND (JF-394D) GYPSUM	No. 61-2-23-A Date 12-23-64 Page 1 of 1 Cancels Page 1 Dated 10-27-64

Gypsum, New Brighton and Chamblee to manufacture and ship C.S. Topping Compound Formula J.F. - 394D.

FINISHED PRODUCT SPECIFICATIONS

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match Sheetrock manila color.

Consistency - Consistancy to be 68-72cc (normal 70cc) per 100 gms.

FORMULA	JF-394D
Casein, FG uncoiled	4.5
Natrosol SG-61	0.8
Zinc Oxide	0.1
Ammonium Oxalate	1.0
" Pentaborate	1.2
Dicyandiamide	0.3
Hydrated Lime	(as required)
P-85 Mica	Formula V
JM-7RF1 Asbestos	(as required - about 2.0%)
PC-7RF9 "	(as required - about 2.0%)
TSPP	0.1
No. 750 Marble or Rambo #4	To make 100%
Ferrite Yellow	0.1 approx.

RAW MATERIALS - Per Bul. 61-2-23.

Ammonium pentaborate	Per Bulletin 6-74-2

CODE - Regular code to be followed by letters CS for all shipments.

PACKAGING - 25 lb. & 32 lb. Perf-A-Tape Topping Compound bag; layout 7-16-42.

Other specifications per Bulletin 61-2-23.

SHIPPING INSTRUCTIONS - To be shipped on all orders for either CR or CS topping compound, and all transfer shipments to Hermosa.

Shipments to Florida are to be made only with approval of Dept. 147-2.

/ This bulletin expires 6-15-65.

DP007 1530

Operating Division PRODUCT PROCEDURE Approved: JE	PERF-A-TAPE TOPPING COMPOUND	No. 61-2-23 Date 2-3-65 Page 1 of 7 Cancels Page 1 Dated 8-17-64

DESCRIPTION

Smooth Applying, easy sanding compound designed for finish coats only in finishing Perf-A-Tape joints. Supplied unpigmented on specific sales order.

MANUFACTURING PLANTS

Chamblee, Dallas, Gypsum, Hagersville, New Brighton and South Gate.

FINISHED PRODUCT SPECIFICATIONS

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed under or over the code number. Otherwise all topping compound to be tinted to match standard sample from Research - approximately to match Sheetrock manila color. The .05% ferrite color is to be discontinued. South Gate to remain at their current degree of pigmentation, as of April 1, 1959.

UP007 1416

Contains material formerly on page 4, dated 12-10-63

No. 61-2-23 Date 2-3-65 Page 2 of 7 Cancels Page 2 Dated 4-22-64	PERF-A-TAPE TOPPING COMPOUND

FINISHED PRODUCT SPECIFICATIONS (Cont'd)

Mixing and Application Properties - To duplicate those of a standard sample to be supplied by the Research Laboratory.

Cracking - Should show no edge or check cracking in the normal bond test dried in the hot room.

Lumps - Screen 100 grams of the dry powder on a 30 mesh screen. All should pass through readily except for small amounts of asbestos. If lumps are present, examine to determine what they are, and take any steps necessary to eliminate them.

Consistency - The mixed compound is to have the specified Brabender reading using the pin paddle, one hour after mixing at a temperature of 77° F.

JF 418C 650 BB	66 to 70 cc (Normal 68 cc)
JF 185 650 BB	65 to 68 cc (Normal 66 cc)
JF 200 650 BB	66 to 69 cc (Normal 67 cc)
JF 254 400 BB*	59 to 63 cc (Normal 61 cc)
JF 364 650 BB	64 to 67 cc (Normal 66 cc)

Direct reading on C. W. Brabender Visco Corder with 250 cm. gm. head, pin paddle, and 75 RPM speed.

* Corrected reading on "old" Brabender viscometer with heavy spring, pin paddle and 72 ± 2 r.p.m. speed at 77F.

pH - Determine 30 minutes after mixing, temperature of mixed compound to be 77° F. during the 30 minutes.

JF 418C	8.1 to 8.5, ideal 8.3 to 8.4
JF 185, JF 200, JF 254	8.2 to 8.7, ideal 8.4 to 8.5
JF 364	8.2 to 8.4, ideal 8.3

Bond to Tape - Normally 2 to 4 when dried in an atmosphere below 50% RH for 18 hours. Lower at higher humidities. See page 6 of 6 for Bond Scale.

Rewet Test - Normally about 1 for all formulas.

Odor of Wet Mixed Compound - To be of same general character and no stronger than that of a standard sample of the same compound on standing a similar length of time after mixing with water.

Contains material formerly on page 1, dated 8-17-64

Operating Division
PRODUCT PROCEDURE

PERF-A-TAPE TOPPING COMPOUND

Approved: [signature]

No. 61-2-23
Date 2-3-65
Page 3 of 7
Cancels Page 3
Dated 8-17-64

FORMULAS

	JF-418C New Brighton	JF 254 Hagersville	JF 364 Dallas	JF 200 South Gate	JF 185 Chamblee Gypsum New Brighton
Casein	2.5	3.75	4.0	3.0	2.5
Soy Protein	3.0	-	-	2.5	2.25
Ammonium Alginate (Note 6)	0.8	0.8	-	0.8	0.8
Hydrated Lime	As Req.	As Req.	As Req.	As Req.	As Req.
Ammonium Oxalate	1.0	1.0	0.9	1.0	1.0
Sodium Pentachlorophenate	-	-	-	0.2	-
Ammonium Pentaborate	1.2	1.2	1.2	-	1.2
Dicyandiamide	0.3	1.0	0.3	0.3	0.3
Mica J.C.	Formula V	0.6 Formula V	-	Formula V	-
Mica P-85	-	-	0.8 Formula V	-	0.6 Formula V
SG-61			0.65		
Zinc Oxide (#42 green label)			0.20		
Tetra sodium pyrophosphate (Fine ground)			0.10		
Asbestos - (Note 1)	As Req.	As Req.	As Req.	As Req.	As Req.
Mica Sericite - (Note 2)	15.0	-	-	15.0	15.0
Whiting - (Note 5)	-	15.0	-	-	-
Talc	-	15.0	-	-	-
Polyglycol P1200 (Note 3)	0.150	0.150	-	0.150	0.150
Neutralizer 5050 - (Note 3)	0.003	0.003	-	0.003	0.003
Carbonate Filler - (Note 4)	To Make 100%	To make 100%	To make 100%	To Make 100%	To Make 100%
Pigments	Pigment with Ferrite Yellow and Other Lime Proof Colors as Required				

General Revision

N-5791 1/63 (Printed in U.S.A.)

Contains material formerly on page 2, dated 4-22-64

No. 61-2-23 Date 2-3-65 Page 4 of 7	PERF-A-TAPE TOPPING COMPOUND
Cancels Page 4 Dated 12-10-63	

FORMULA NOTES

Note 1 - Asbestos used shall be as follows:

JF-418C - 2/3 Johns Manville 7RF1; 1/3 Phillip Carey 7RF9
JF 254 - Johns Manville 7RF1
JF 200 - Phillip Carey 7RF9
JF 185 - 2/3 Johns Manville 7RF1; 1/3 Phillip Carey 7RF9
JF 364 - 4.0% Nicolet T7G25 plus Canadian Carey 7RF9 as req'd (approx. 2%)

Note 2 - Sericite Mica used shall be as follows:

Gypsum and New Brighton - Ser-X
Chamblee - DXW Mineralite
South Gate - M350 Sericite

Note 3 - Chamblee to replace .050 of Polyglycol P1200 with .050 of Tributyl-phosphate. The Polyglycol P1200 and neutralizer 5050 should be mixed together before adding to the other ingredients. In cold weather this mixture may be thinned with a little isopropyl alcohol if necessary to facilitate its uniform dispersion among the powder ingredients. This mixture is to be sprayed into the other ingredients while they are being mixed in a Broughton mixer. If spray equipment is not used to add the liquid mix to the dry powders in the mixer the tributyl phosphate must be increased to .1% (total liquid mix .203%) and the liquid mix dribbled slowly into the powder in the mixer.

Note 4 - Carbonate Fillers:

JF 254 - Bulletin 58-2-2, page 2 of 5, A or AA
JF 185 - Bulletin 6-24-9
JF 200 - Per Bulletin 6-24-1
JF 364 - #750-S Carbonate per Bulletin 6-24-9
JF 418C - 30.0% Rambo #4 per PMS 6-24-9; A Dolomite per Bul. 58-2-2 to make 100%.

Note 5 - Whiting

JF 254 per Bulletin C6-24-6

Note 6 - Gypsum, Hagersville and New Brighton may substitute Collatex AS/KK Alginate in place of Marex Alginate.

Chamblee and South Gate to use Sodium Alginate instead of Ammonium Alginate.

MP001 1419

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved: JP	PERF-A-TAPE TOPPING COMPOUND CHAMBLEE	No. 61-2-23-H Date 2-5-65 Page 1 of 1 Cancels Dated NEW

Chamblee to manufacture JF-185 topping compound substituting high viscosity PRO-COTE U soy protein for the regularly used viscosity grade. The plant to be authorized to use one carload of the high viscosity PRO-COTE U.

MANUFACTURING PLANT: Chamblee

FINISHED PRODUCT SPECIFICATIONS:

Per Bulletin 61-2-23

FORMULA:

Casein, FG uncoiled	3.25%
PRO-COTE U	1.5 %

Other ingredients per Bulletin 61-2-23
All other specifications per Bulletin 61-2-23.

This bulletin expires 8-1-65.

UP007 1650

Originally issued 6-8-64 SPECIAL BULLETIN 1st Extension

Operating Division PRODUCT PROCEDURE Approved: JF	PERF-A-TAPE TOPPING COMPOUND (JF-394D) GYPSUM	No. 61-2-23-A Date 2-18-65 Page 1 of 1 Cancels Page 1 Dated 12-23-64

Gypsum, New Brighton and Chamblee to manufacture and ship C.S. Topping Compound Formula J.F. - 394D.

FINISHED PRODUCT SPECIFICATIONS

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match Sheetrock manila color.

Consistency - Consistency to be 68-72cc (normal 70cc) per 100 gms.

FORMULA	JF-394D
Casein, FG uncoiled	4.5
Natrosol SG-61	0.8
Zinc Oxide	0.1
Ammonium Oxalate	1.0
" Pentaborate	1.2
Dicyandiamide	0.3
Hydrated Lime	(as required)
P-85 Mica	Formula V
JM-7RF1 Asbestos	(as required - about 2.0%)
PC-7RF9 "	(as required - about 2.0%)
TSPP	0.1
No. 750 Marble or Rambo #4	To make 100%
Ferrite Yellow	0.1 approx.

RAW MATERIALS - Per Bul. 61-2-23.

Ammonium pentaborate — Per Bulletin 6-74-2

CODE - Regular code to be followed by letters CS for all shipments.

PACKAGING - 25 lb. & 32 lb. Perf-A-Tape Topping Compound bag; layout 7-16-42.

Other specifications per Bulletin 61-2-23.

SHIPPING INSTRUCTIONS - To be shipped on all orders for either CR or CS topping compound, and on all topping compound orders to the Chicago, Lakeland, South Shore, Northern Illinois, and Hermosa Plant. The only exception on the districts specified will be orders which specifically request a formula, other than "CS".

Shipments to Florida are to be made only with approval of Dept. 147-2.

This bulletin expires 6-15-65.

DP007 1579

M-8971 Rev. 1/63 (Printed in U.S.A.) / Indicates Change

Originally issued 6-8-64 SPECIAL BULLETIN 1st Extension

Operating Division PRODUCT PROCEDURE Approved: JP	PERF-A-TAPE TOPPING COMPOUND (JF-394D) GYPSUM	No. 61-2-23-A Date 3-10-65 Page 1 of 1 Cancels Page 1 Dated 2-18-65

Gypsum, New Brighton and Chamblee to manufacture and ship C.S. Topping Compound Formula J.F. - 394D.

FINISHED PRODUCT SPECIFICATIONS

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match Sheetrock manila color.

Consistency - Consistency to be 68-72cc (normal 70cc) per 100 gms.

FORMULA	JF-394D
Casein, FG uncoiled	4.5
Natrosol 8G-61	0.8
Zinc Oxide	0.1
Ammonium Oxalate	1.0
" Pentaborate	1.2
Dicyandiamide	0.3
Hydrated Lime	(as required)
P-85 Mica	Formula V
JM-7RF1 Asbestos	(as required - about 2.0%)
PC-7RF9 "	(as required - about 2.0%)
TSPP	0.1
No. 750 Marble or Rambo #4	To make 100%
Ferrite Yellow	0.1 approx.

RAW MATERIALS - Per Bul. 61-2-23.

Ammonium pentaborate	Per Bulletin 6-74-2

CODE - Regular code to be followed by letters CS for all shipments.

PACKAGING - 25 lb. & 32 lb. Perf-A-Tape Topping Compound bag; layout 7-16-42.

Other specifications per Bulletin 61-2-23.

SHIPPING INSTRUCTIONS - To be shipped on all orders for either CR or CS topping compound. and on all topping compound orders to the Chicago, Lakeland, South Shore, Northern Illinois, Central Paint Districts, and Hermosa Plant. The only exception on the districts specified will be orders which specifically request a formula, other than "CS".

Shipments to Florida are to be made only with approval of Dept. 147-2.

This bulletin expires 6-15-65.

DP007 1573

Originally issued 6-8-64. SPECIAL BULLETIN 1st Extension

Operating Division PRODUCT PROCEDURE Approved:	PERF-A-TAPE TOPPING COMPOUND (JF-394D) GYPSUM	No. 61-2-23-A Date 5-24-65 Page 1 of 2 Cancels Page 1 Dated 3-10-65

/ Chamblee, Gypsum, Hagersville*, and New Brighton to manufacture and ship C.S. Topping Compound Formula J.F. - 394D.

FINISHED PRODUCT SPECIFICATIONS

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match Sheetrock manila color.

A Viscosity - 530 ± 30 BB units on VC-3 at 77°F, 400 ± 20 BB units of old BB at 77°F.

Consistency - Consistency to be 68-72cc (normal 70cc) per 100 gms.

A pH - 8.1 to 8.5 (8.3 normal)

FORMULA	JF-394D
Casein, FG unoiled	4.5
Natrosol SG-61	0.8
Zinc Oxide	0.1
Ammonium Oxalate	1.0
Ammonium Pentaborate	1.2
Dicyandiamide	0.3
Hydrated Lime	(as required)
P-85 Mica	Formula V
JM-7RF1 Asbestos	(as required - about 2.0%)
PC-7RF9 Asbestos	(as required - about 2.0%)
TSPP	0.1
Carbonate Filler - (Note 1)	To make 100%
Ferrite Yellow	0.1 approx.

Formula Note

Chamblee, Gypsum, New Brighton	#750 Marble or Rambo #4
Hagersville	15% FF Limestone; A Dolomite to make 100%

A *To be shipped for field trials and subsequent shipments as authorized by Canadian Merchandising.

NP007 1516

PERF-A-TAPE TOPPING COMPOUND

FORMULA NOTES

Note 1 - Asbestos used shall be as follows:

JF-418C - 2/3 Johns Manville 7RF1; 1/3 Phillip Carey 7RF9
JF 254 - Johns Manville 7RF1
JF 200 - Phillip Carey 7RF9
JF 185 - 2/3 Johns Manville 7RF1; 1/3 Phillip Carey 7RF9
JF 364 - 4.0% Nicolet T7G25 plus Canadian Carey 7RF9 as req'd (approx. 2%)

Note 2 - Sericite Mica used shall be as follows:

Gypsum and New Brighton - Ser-X
Chamblee - DXW Mineralite
South Gate - M350 Sericite

Note 3 - Chamblee to replace .050 of Polyglycol P1200 with .050 of Tributyl-phosphate. The Polyglycol P1200 and neutralizer 5050 should be mixed together before adding to the other ingredients. In cold weather this mixture may be thinned with a little isopropyl alcohol if necessary to facilitate its uniform dispersion among the powder ingredients. This mixture is to be sprayed into the other ingredients while they are being mixed in a Broughton mixer. If spray equipment is not used to add the liquid mix to the dry powders in the mixer the tributyl phosphate must be increased to .1% (total liquid mix .203%) and the liquid mix dribbled slowly into the powder in the mixer.

Note 4 - Carbonate Fillers:

JF 254 - Bulletin 58-2-2, page 2 of 5, A or AA
JF 185 - Bulletin 6-24-9
JF 200 - Per Bulletin 6-24-1
JF 364 - #750-S Carbonate per Bulletin 6-24-9
JF 418C - 30.0% Rambo #4 per PMS 6-24-9; A Dolomite per Bul. 58-2-2 to make 100%.

Note 5 - Whiting

JF 254 per Bulletin C6-24-6

Note 6 - Gypsum, Hagersville and New Brighton may substitute Collatex AS/KK Alginate in place of Marex Alginate.

/ South Gate to use Sodium Alginate instead of Ammonium Alginate.

UP007 1415

/ Indicates Change

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved: JP	CONFIDENTIAL DO NOT REPRODUCE OR COPY PERF-A-TAPE TOPPING COMPOUND FORMULA FE-54A GYPSUM	No. [illegible]-J Date [illegible]-65 Page 2 Cancels Dated NEW

FORMULA FE - 54A

Gelva Powder GP-702	2.5%
Santicizer #9 (-60 mesh)	0.25
BS-3 (-60 mesh)	2.5
Vancide 51-Z	0.1
JM7RF02 asbestos	About 6.0% (as req'd for normal consistency)
Mica JC	2/3 formula V
Narvon CF-2 Sericite	15.0
Stonelite	to make 100%
GM-65 (-60 mesh)	0.5
Ferrite Yellow	About 0.1

RAW MATERIALS

1. Gelva Powder GP-702	Shawinigan Resins Corp. Springfield, Mass.
2. BS-3 (-60 mesh)	A.E. Staley Mfg. Co. Decatur, Ill.
3. GM-65 (-60 mesh)	A special methyl Cellulose from Dow Chem. Co.

MANUFACTURING PROCEDURE

Per bulletin 61-2-23 except a thorough brushing down, followed by a clean-out charge of Stonelite must be done before this product is made. (No clean-out is necessary afterwards as this product will not contaminate regular casein compounds.)

End

UP007 1651

Operating Division PRODUCT PROCEDURE Approved: JP	PERF-A-TAPE TOPPING COMPOUND P-A-T (JF-394D) DUAL PURPOSE GYPSUM	No. 61-2-23-6 Date 6-3-65 Page 1 of 2 Cancels Dated NEW

DESCRIPTION:
A topping compound for Perf-A-Tape with superior mixing properties (with much less tendency to over-dilute in cold water), lower shrinkage, and equal bond strength to Dual-Purpose Compounds.

MANUFACTURING PLANT: Gypsum

FINISHED PRODUCT SPECIFICATIONS

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match Sheetrock manila color.

Consistency - Consistency to be 68-72cc (normal 70cc) per 100 gms.

FORMULA:	JF-394D
Casein, FG uncoiled	4.5
Natrosol SG-61	0.8
Zinc Oxide	0.1
Ammonium Oxalate	1.0
Ammonium Pentaborate	1.2
Dicyandiamide	0.3
Hydrated Lime	(as required)
P-85 Mica	Formula V
JM-7RF1 Asbestos	(as required - about 2.0%)
PC-7RF9 Asbestos	(as required - about 2.0%)
TSPP	0.1
No. 750 Marble	To make 100%
Ferrite Yellow*	0.1 Approx.

*Omit Ferrite Yellow on all orders for Dual Purpose Compound.

USG 00072013

Operating Division PRODUCT PROCEDURE	PERF-A-TAPE TOPPING COMPOUND P-A-T (JF-394D) DUAL PURPOSE	No. 61-2-23-6 Date 6-28-65 Page 1 of 2
Approved: JP		Cancels Page 1 Dated 6-3-65

DESCRIPTION:

A topping compound for Perf-A-Tape with superior mixing properties (with much less tendency to over-dilute in cold water), lower shrinkage, and equal bond strength to Dual-Purpose Compounds.

/ MANUFACTURING PLANTS: Chamblee, Gypsum and New Brighton

FINISHED PRODUCT SPECIFICATIONS

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match Sheetrock manila color.

A Viscosity - 530 / 30 BB units on VC-3 at 77°F, 400 / 20 BB Units of old BB at 77°F.

Consistency - Consistency to be 68-72cc (normal 70cc) per 100 gms.

A pH - 8.1 to 8.5 (8.3 Normal)

FORMULA:	JF-394D
Casein, FG unoiled	4.5
Natrosol SG-61	0.8
Zinc Oxide	0.1
Ammonium Oxalate	1.0
Ammonium Pentaborate	1.2
Dicyandiamide	0.3
Hydrated Lime	(as required)
P-85 Mica	Formula V
JM-7RF1 Asbestos	(as required - about 2.0%)
PC-7RF9 Asbestos	(as required - about 2.0%)
TSPP	0.1
/ Carbonate Filler (Note 1)	To make 100%
Ferrite Yellow*	0.1 Approx.

*Omit Ferrite Yellow on all orders for Dual Purpose Compound.

A Note 1:

Gypsum and New Brighton	- #750 Marble or Rambo #4
Chamblee	- #750 Marble

NP007 2079

No. 61-2-23-6 Date 6-28-65 Page 2 of 2 Cancels Page 2 Dated 6-3-65	PERF-A-TAPE TOPPING COMPOUND P-A-T (JF394D) DUAL PURPOSE

RAW MATERIALS:

Per Bulletin 61-2-23
Ammonium Pentaborate - Per Bulletin 6-74-2

CODE - Regular code to be followed by letters CS for all shipments.

PACKAGING:

25 lb. and 32 lb. P-A-T Topping Compound bag; layout 7-16-42
25 lb. and 32 lb. P-A-T Dual-Purpose Compound bag; layout 7-16-32-3 (Gypsum Only)
5 lb. carton per PMS 8-10-10. Packed 10 per master carton
60 ft. System per PMS 8-13-2 (with knives)
250 ft. System - Cartons per Bulletin 7-16-36.

SHIPPING INSTRUCTIONS - To be shipped on all orders for either CR or CS topping compound, and on all topping compound orders to the Chicago, Lakeland, South Shore, Northern Illinois, Central Paint Districts, and Hermosa Plant. The only exception on the districts specified will be orders which specifically request a formula, other than "CS".

Shipments to Florida are to be made only with approval of Dept. 147-2.

Also to be shipped by Gypsum on all orders for Dual Purpose Joint Compound in Dual Purpose bags, but omit the letters "D" and "M" after the code. (Do not add the letters "CS" on the Dual Purpose Bags.)

NPD07 2029

Operating Division PRODUCT PROCEDURE Approved: JJ	PERF-A-TAPE TOPPING COMPOUND (JF-394D) HAGERSVILLE	No. 61-2-23-A Date 6-28-65 Page 1 of 2 Cancels Page 1 Dated 6-3-65

Hagersville to manufacture and ship C. S. Topping Compound Formula J.F. - 394D. To be shipped for field trials and subsequent shipments as authorized by Canadian Merchandising.

FINISHED PRODUCT SPECIFICATIONS

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match Sheetrock manila color.

Viscosity - 530 ± 30 BB units on VC-3 at 77°F, 400 ± 20 BB units of old BB at 77°F.

Consistency - Consistency to be 68-72cc (normal 70cc) per 100 gms.

pH - 8.1 to 8.5 (8.3 normal)

FORMULA	JF-394D
Casein, FG uncoiled	4.5
Natrosol SG-61	0.8
Zinc Oxide	0.1
Ammonium Oxalate	1.0
Ammonium Pentaborate	1.2
Dicyandiamide	0.3
Hydrated Lime	(as required)
P-85 Mica	Formula V
JM-7RF1 Asbestos	(as required - about 2.0%)
PC-7RF9 Asbestos	(as required - about 2.0%)
TSPP	0.1
Carbonate Filler - (Note)	To make 100%
Ferrite Yellow	0.1 approx.

Formula Note

15% FF Limestone; A Dolomite to make 100%

No. 61-2-23-A Date 6-28-65 Page 2 of 2 Cancels Page 2 Dated 5-24-65	PERF-A-TAPE TOPPING COMPOUND (JF-394D) HAGERSVILLE

RAW MATERIALS

Per Bulletin 61-2-23.

Ammonium pentaborate - per Bulletin 6-74-2.

CODE

Regular code to be followed by letters CS for all shipments.

PACKAGING

25 Lb. and 32 Lb. Perf-A-Tape Topping Compound bag; layout 7-16-42.

D

Other specifications per Bulletin 61-2-23.

This bulletin expires 6-15-66.

NP007 1573

M-8971 (Back)

Original date of issue 6-13-63. SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved: JP	PERF-A-TAPE TOPPING COMPOUND JF-4038 GYPSUM	No. 61-2-23-YY Date 8-19-65 Page 1 Cancels Dated REINSTATED

This Bulletin expires 8-15-66.

Gypsum, to manufacture Perf-A-Tape Topping Compound, Formula JF-403B for Modern Wall, Inc., on order only. Specifications per 61-2-23 except as follows:

PACKAGING: 25 lb. & 32 lb. Perf-A-Tape Topping Compound bag; layout 7-16-42.

CODE: Regular code to be followed by the letters "CR".

SHIPMENT: This formula to be shipped only to Modern Wall, Inc., in carload lots.

FINISHED PRODUCT SPECIFICATIONS:

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match Sheetrock manila color.

Mixing and Application - To equal those of a standard Research sample.

Cracking - per Bulletin 61-2-[illegible]

Lumps - per Bulletin 61-2-23

Consistency - 66-70 cc (normal:68) per 100 grams of dry powder.

Brabender - 525 units when tested at 77F on a viscometer operating at 75 rpm and having a 250 gram-centimeter torsion head.

- 0-

NP007 1917

Operating Division PRODUCT PROCEDURE Approved: JF	CONFIDENTIAL DO NOT REPRODUCE OR COPY PERF-A-TAPE TOPPING COMPOUND JF-403B GYPSUM	No. 61-2-23-YY Date 8-19-65 Page 2 Cancels Dated REINSTATED

RAW MATERIAL SPECIFICATIONS:

Per Bulletin 61-2-23

Ammonium pentaborate	per PMS 6-74-2
Glomax LL clay	per PMS 6-36-10
Alternate Carbonate Filler-Rambo #4	per PMS 6-24-9

FORMULA: JF-403B

Casein, FG uncoiled	4.5%
Natrosol SG-61	0.7
Zinc Oxide (No. 42 Green Label)	0.1
Ammonium oxalate	1.0
Ammonium pentaborate	1.2
Dicyandiamide	0.3
Hydrated lime	As req'd (0.25 used in lab)
Mica JC	Formula V
JM7RF1 asbestos	As req'd (2.25 used in lab)
PC7RF9 asbestos	As req'd (2.25 used in lab)
Tetrasodium pyrophosphate	0.1
Glomax LL clay	5.0
No. 750 Marble	To make 100%
Ferrite Yellow	0.1 approx.

End.

NP007 1971

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved:	**CONFIDENTIAL** **DO NOT REPRODUCE OR COPY** PERF-A-TAPE TOPPING COMPOUND (PE65E) DALLAS	No. 61-2-23-M Date 12-14-65 Page 2 Cancels Dated NEW

FORMULA	PE 65 E
GP 702	2.0%
Santicizer 9	.2%
BS-3	2.5%
GM-65	.65%
Vancide 51-Z	.15%
P85 Mica	2/3 Formula V quantity
JM7RF02 asbestos	As req'd for consistency control (4% in lab. batch)
PC7RF9 asbestos	3.0%
Flo Float JF	To make 100%

RAW MATERIALS - Standard joint compound or Durabond raw materials with the additions:

BS-3 - A. E. Staley Co. Should be 100% - 40 mesh and preferable 100% -60 mesh as received.

GM-65 - Dow Chemical Co. - 60 mesh and retarded to about 10' hydration time.

Above are experimental raw materials - contact Research in event they do not meet above requirements.

MANUFACTURING PROCEDURE

Processing - Do not run this compound immediately after making any of the borate containing compounds. Run after AP 100 or similar compound after a thorough brush down. Mixing, weighing and Mikropulverizing - Same as present joint compounds.

End

DP007 1669

Operating Division PRODUCT PROCEDURE Approved: JF	PERF-A-TAPE TOPPING COMPOUND P-A-T (JF-394D) DUAL PURPOSE	No. 61-2-23-6 Date 12-28-65 Page 1 Cancels Page 1 Dated 6-28-65

DESCRIPTION:

A topping compound for Perf-A-Tape with superior mixing properties (with much less tendency to over-dilute in cold water), lower shrinkage, and equal bond strength to Dual-Purpose Compounds.

MANUFACTURING PLANTS: Chamblee, Gypsum and New Brighton

IDENTIFICATION AND PACKAGING:

25 lb. and 32 lb. P-A-T Topping Compound bag; layout 7-16-42
25 lb. and 32 lb. P-A-T Dual-Purpose Compound bag; layout 7-16-32-3 (Gypsum Only)
5 lb. carton per PMS 8-10-10. Packed 10 per master carton
60 ft. System per PMS 8-13-2 (with knives)
250 ft. System - Cartons per Bulletin 7-16-36.

Shipping Instructions - To be shipped on all orders for either CR or CS topping compound.

Shipments to Florida are to be made only with approval of Dept. 147-2.

Gypsum - On any order for Topping Compound, the following formula must be shipped, unless said order specifically requests non-"CS", regular, or other desgination which might indicate a formula other than "CS".

Bags of pigmented CS topping for Fleming Materials are to be identified by printing the word "pigmented" over the code number.

CODING - Regular code to be followed by letters CS for all shipments.

FINISHED PRODUCT SPECIFICATIONS:

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match Sheetrock manila color.

Viscosity - 530 ± 30 BB units on VC-3 at 77°F, 400 ± 20 BB Units of old BB at 77°F.

Consistency - Consistency to be 68-72cc (normal 70cc) per 100 gms.

pH - 8.1 to 8.5 (8.3 Normal)

- 0 -

DP001 202

Operating Division PRODUCT PROCEDURE Approved: JB	CONFIDENTIAL DO NOT REPRODUCE OR COPY PERF-A-TAPE TOPPING COMPOUND P-A-T (JF-394D) DUAL PURPOSE	No. 61-2-23-6 Date 12-28-65 Page 2 Cancels Page 2 Dated 7-26-65

FORMULA:

	JF-394D
Casein, FG uncoiled	4.5
Natrosol SG-61	0.8
Zinc Oxide	0.1
Ammonium Oxalate	1.0
Ammonium Pentaborate	1.2
Dicyandiamide	0.3
Hydrated Lime	(as required)
P-85 Mica	Formula V
JM-7RF1 Asbestos	(as required - about 2.0%)
PC-7RF9 Asbestos	(as required - about 2.0%)
TSPP	0.1
Carbonate Filler (Note 1)	To make 100%
Ferrite Yellow*	0.1 Approx.

*Omit Ferrite Yellow on all orders for Dual Purpose Compound.

Note 1:

Gypsum and New Brighton	-#750 Marble or Rambo #4
Chamblee	-#750 Marble

RAW MATERIALS:

Per Bulletin 61-2-23
Ammonium Pentaborate - Per Bulletin 6-74-2

CODE - Regular code to be followed by letters CS for all shipments.

End

NP007 2075

Operating Division PRODUCT PROCEDURE	PERF-A-TAPE TOPPING COMPOUND	No. 61-2-23-6 Date 1-12-66 Page 1
Approved: JF	P-A-T (JF-394D)	Cancels Page 1 Dated 12-28-65

C

DESCRIPTION:

A topping compound for Perf-A-Tape with superior mixing properties (with much less tendency to over-dilute in cold water), lower shrinkage, and equal bond strength to Dual-Purpose Compounds.

MANUFACTURING PLANTS: Chamblee, Gypsum and New Brighton

IDENTIFICATION AND PACKAGING:

25 lb. and 32 lb. P-A-T Topping Compound bag; layout 7-16-42

D

Shipping Instructions - To be shipped on all orders for either CR or CS topping compound.

Shipments to Florida are to be made only with approval of Dept. 147-2.

Gypsum - On any order for Topping Compound, the following formula must be shipped, unless said order specifically requests non-"CS", regular, or other designation which might indicate a formula other than "CS".

Bags of pigmented CS topping for Fleming Materials are to be identified by printing the word "pigmented" over the code number.

CODING - Regular code to be followed by letters CS for all shipments.

FINISHED PRODUCT SPECIFICATIONS:

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match Sheetrock manila color.

Viscosity - 530 ± 30 BB units on VC-3 at 77°F, 400 ± 20 BB Units of old BB at 77°F.

Consistency - Consistency to be 68-72cc (normal 70cc) per 100 gms.

pH - 8.1 to 8.5 (8.3 Normal)

- 0 -

JP007 7027

Operating Division PRODUCT PROCEDURE Approved: JB	**CONFIDENTIAL** **DO NOT REPRODUCE OR COPY** PERF-A-TAPE TOPPING COMPOUND P-A-T (JF-394D)	No. 61-2-23-6 Date 1-12-66 Page 2 Cancels Page 2 Dated 12-28-65

FORMULA:	JF-394D
Casein, FG unoiled	4.5
Natrosol SG-61	0.8
Zinc Oxide	0.1
Ammonium Oxalate	1.0
Ammonium Pentaborate	1.2
Dicyandiamide	0.3
Hydrated Lime	(as required)
P-85 Mica	Formula V
JM-7RF1 Asbestos	(as required - about 2.0%)
PC-7RF9 Asbestos	(as required - about 2.0%)
TSPP	0.1
Carbonate Filler (Note 1)	To make 100%
Ferrite Yellow*	0.1 Approx.

*Omit Ferrite Yellow on all orders for Dual Purpose Compound.

Note 1:

Gypsum and New Brighton	-#750 Marble or Rambo #4
Chamblee	-#750 Marble

RAW MATERIALS:

Per Bulletin 61-2-23
Ammonium Pentaborate - Per Bulletin 6-74-2

CODE - Regular code to be followed by letters CS for all shipments.

End

Operating Division PRODUCT PROCEDURE Approved: JP	PERF-A-TAPE TOPPING COMPOUND	No. 61-2-23 Date 5-19-66 Page 1 Cancels Page 1 Dated 2-3-65

DESCRIPTION

Smooth Applying, easy sanding compound designed for finish coats only in finishing Perf-A-Tape joints. Supplied unpigmented on specific sales order.

MANUFACTURING PLANTS

Chamblee, Dallas, Gypsum, Hagerstville, New Brighton, South Gate and Montreal

IDENTIFICATION AND PACKAGING

JF 418C - 25 and 32 Lb. Perf-A-Tape Topping Compound Bag; Layout 7-16-42

JF 254 - 25 lb. Perf-A-Tape Topping Compound Bag; Canadian Only - layout 8-103-3

JF 364 - 25 and 32 lb. Perf-A-Tape Topping Compound Bag; layout 7-16-42

JF 200 - 25 and 32 lb. Perf-A-Tape Finishing Compound Bag; layout 7-16-43
- 50 lb. Perf-A-Tape Finishing Compound Bag; layout 7-16-43-1

JF 185 - 25 and 32 lb. Perf-A-Tape Topping Compound Bag; layout 7-16-42

SHIPPING DISTRIBUTION

Per Bulletin 61-1-12.

FINISHED PRODUCT SPECIFICATIONS

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed under or over the code number. Otherwise all topping compound to be tinted to match standard sample from Research - approximately to match Sheetrock manila color. The .05% ferrite color is to be discontinued. South Gate to remain at their current degree of pigmentation, as of April 1, 1959.

DP007 1411

Operating Division
PRODUCT PROCEDURE

Approved: JS

CONFIDENTIAL
DO NOT REPRODUCE OR COPY

PERF-A-TAPE TOPPING COMPOUND

No. 61-2-23
Date 5-19-66
Page 3

Cancels Page 3
Dated 2-3-65

FORMULAS

	JF-418C	JF 254	JF 364	JF 200	JF 185
	New Brighton	Montreal Hagersville	Dallas	South Gate	Chamblee Gypsum New Brighton
Casein	2.5	3.75	4.0	3.0	2.5
Soy Protein	3.0	-	-	2.5	2.25
Ammonium Alginate (Note 6)	0.8	0.8	-	0.8	0.8
Hydrated Lime	As Req.	As Req.	As Req.	As Req.	As Req.
Ammonium Oxalate	1.0	1.0	0.9	1.0	1.0
Sodium Pentachlorophenate	-	-	-	0.2	-
Ammonium Pentaborate	1.2	1.2	1.2	-	1.2
Dicyandiamide	0.3	1.0	0.3	0.3	0.3
Mica J.C.	Formula V	0.6 Formula V	-	Formula V	-
Mica P-85	-	-	0.8 Formula V	-	0.6 Formula V
80-61			0.65		
Zinc Oxide (#42 green label)			0.20		
Tetra sodium pyrophosphate (Fine ground)			0.10		
Asbestos - (Note 1)	As Req.	As Req.	As Req.	As Req.	As Req.
Mica Sericite - (Note 2)	15.0	-	-	15.0	15.0
Whiting - (Note 5)	-	15.0	-	-	-
Talc	-	15.0	-	-	-
Polyglycol P1200 (Note 3)	0.150	0.150	-	0.150	0.150
Neutralizer 5050 - (Note 3)	0.003	0.003	-	0.003	0.003
Carbonate Filler - (Note 4)	To Make 100%	To make 100%	To make 100%	To Make 100%	To Make 100%
Pigments	Pigment with Ferrite Yellow and Other Lime Proof Colors as Required				

M-5791-C 7/65 (Printed in U.S.A.)

General Revision

No. 61-2-23 Date 5-19-66 Page 4 Cancels Page 4 Dated 5-28-65	**CONFIDENTIAL** **DO NOT REPRODUCE OR COPY** PERF-A-TAPE TOPPING COMPOUND

FORMULA NOTES

Note 1 - Asbestos used shall be as follows:

JF-418C - JM 7RF02
JF 254 - Johns Manville 7RF1
JF 200 - Phillip Carey 7RF9
JF 185 - 2/3 Johns Manville 7RF1; 1/3 Phillip Carey 7RF9
JF 364 - 4.0% Nicolet T7G25 plus Canadian Carey 7RF9 as req'd (approx. 2%)

Note 2 - Sericite Mica used shall be as follows:

Gypsum and New Brighton - Ser-X
Chamblee - DXW Mineralite
South Gate - M350 Sericite

Note 3 - Chamblee to replace .050 of Polyglycol P1200 with .050 of Tributyl-phosphate. The Polyglycol P1200 and neutralizer 5050 should be mixed together before adding to the other ingredients. In cold weather this mixture may be thinned with a little isopropyl alcohol if necessary to facilitate its uniform dispersion among the powder ingredients. This mixture is to be sprayed into the other ingredients while they are being mixed in a Broughton mixer. If spray equipment is not used to add the liquid mix to the dry powders in the mixer the tributyl phosphate must be increased to .1% (total liquid mix .203%) and the liquid mix dribbled slowly into the powder in the mixer.

Note 4 - Carbonate Fillers:

JF 254 - Bulletin 58-2-2, page 2 of 5, A or AA or Bulletin 6-24-2
JF 185 - Bulletin 6-24-9
JF 200 - Per Bulletin 6-24-1
JF 364 - #750-S Carbonate per Bulletin 6-24-9
JF 418C - 30.0% Rambo #4 per FMS 6-24-9; A Dolomite per Bul. 58-2-2 to make 100%.

Note 5 - Whiting

JF 254 per Bulletin C6-24-6

Note 6 - Gypsum, Montreal and New Brigaton may substitute Collatex AS/KK Alginate in place of Marex Alginate.

South Gate to use Sodium Alginate instead of Ammonium Alginate.

Hagersville to use Protamon S-120 in place of Marex Alginate

NP007 1410

Operating Division PRODUCT PROCEDURE Approved:	CONFIDENTIAL DO NOT REPRODUCE OR COPY PERF-A-TAPE TOPPING COMPOUND	No. 61-2-23 Date 5-19-66 Page 5 Cancels Page 5 Dated 2-3-65

RAW MATERIAL SPECIFICATIONS

Casein	Per Bulletin 6-26-4
Soy Protein	" " 6-123-1
Hydrated Lime	" 6-69-1, 59-3-7, 59-8-7 or equiv.
Ammonium Oxalate	" " 6-11-5
Sodium Pentachlorophenate	" " 6-33-4
Dicyandiamide	" " 6-44-1
Mica JC	" " 6-143-1
Mica P-85	" " 6-143-3
Sericite Micas	" " 6-146-2
Asbestos	" " 6-14-5
Wetting Agent - Polyglycol P1200	Dow Chemical Co.
Carbonate Fillers	Per Bulletin 6-24-1, 6-24-9, 58-2-2
Ammonium Alginate	" " 6-8-1
Whiting	" " 6-24-7, C6-24-6
Ferrite	- -
Talc	Per Bulletin C6-128-4
Sodium Alginate	Per Bulletin 6-8-4
Zinc Oxide (#42 green label)	Per Bulletin 6-94-91
Tetra sodium pyrophosphate	Per PMS 6-177-4
Tributyl Phosphate	Per Bulletin _____

SG-61 (Hercules Powder Co. - retarded solution, high viscosity hydroxy ethyl cellulose)

Ammonium pentaborate Technical grade powdered, per PMS 6-74-2.
Neutralizer 5050 - from Magnus, Mabee and Reynard, Inc.

MANUFACTURING PROCEDURE

Weigh all materials accurately. Maximum permissible weight departure is 3% of the amount specified. Mix in a Broughton mixer, spraying the mixed liquids after mixing of the powders has started. Continue mixing for a minimum of 10 minutes after the liquids have been sprayed into the batch.

After mixing is complete pass the batch through a Mikropulverizer using a coarse (3/32" slot width) screen. It is then ready for packing.

TP004 1417

Also cancels page 7 dated 2-3-65

No. 61-2-23
Date 5-19-66
Page 6
Cancels Page 6
Dated 8-6-65

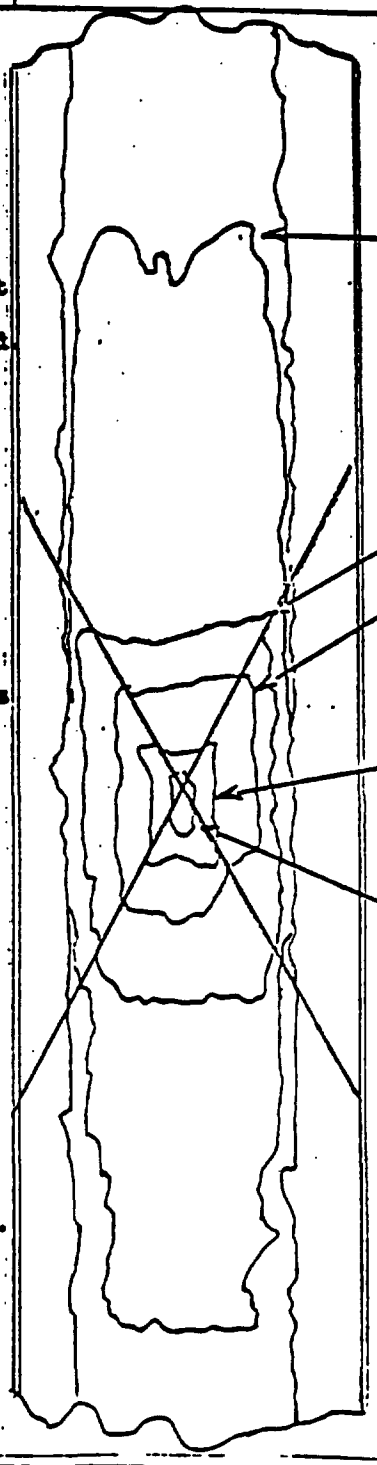
CONFIDENTIAL

DO NOT REPRODUCE OR COPY

PERF-A-TAPE TOPPING COMPOUND

QUALITY CONTROL

BOND SCALE



0. Tape lifts itself off cement as joint dries. Little or no pulling required.

1. Very Poor, Tape pulls clean from cement in center portion and only slight amount of sanded edge area is bonded enough to pull fibers from tape.

2. Poor, Tape pulls clean from cement, but is well bonded along sanded edges.

3. Moderately poor, Center portion of tape peels clean from cement over distances indicated from X-cut points.

4. Fair

5. Moderately Good

6. Good

7. Excellent, Tape sticks tightly to cement except where cement is crushed by the knife inserted under the points of the X-cut to lift off the tape.

End

NP007 1392

M-5791-C (Back)

Rearrangement Only

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved: JP	**CONFIDENTIAL** **DO NOT REPRODUCE OR COPY** PERF-A-TAPE TOPPING COMPOUND (JF-394D) HAGERSVILLE AND MONTREAL	No. 61-2-23-A Date 5-19-66 Page 3 Cancels Dated NEW

FORMULA	JF-394D
Casein, FG uncoiled	4.5
Natrosol SG-61	0.8
Zinc Oxide	0.1
Ammonium Oxalate	1.0
Ammonium Pentaborate	1.2
Dicyandiamide	0.3
Hydrated Lime	(as required)
P-85 Mica	Formula V
JM-7RF1 Asbestos	(as required - about 2.0%)
PC-7RF9 Asbestos	(as required - about 2.0%)
TSPP	0.1
Carbonate Filler - (Note)	To make 100%
Ferrite Yellow	0.1 approx.

Formula Note
15% FF Limestone; A Dolomite
to make 100%

RAW MATERIALS

Per Bulletin 61-2-23.

Ammonium pentaborate - per Bulletin 6-74-2.

End

UP007 1571

CONFIDENTIAL

DO NOT REPRODUCE OR COPY

PERF-A-TAPE TOPPING COMPOUND

FORMULA NOTES

Note 1 - Asbestos used shall be as follows:

JF-418C - JM 7RF02
JF 254 - Johns Manville 7RF1
JF 200 - Phillip Carey 7RF9
JF 185 - 2/3 Johns Manville 7RF1; 1/3 Phillip Carey 7RF9
JF 364 - 4.0% Nicolet T7G25 plus Canadian Carey 7RF9 as req'd (approx. 2%)

Note 2 - Sericite Mica used shall be as follows:

Gypsum and New Brighton - Ser-X
Chamblee - DXW Mineralite
South Gate - M350 Sericite

Note 3 - Chamblee to replace .050 of Polyglycol P1200 with .050 of Tributyl-phosphate. The Polyglycol P1200 and neutralizer 5050 should be mixed together before adding to the other ingredients. In cold weather this mixture may be thinned with a little isopropyl alcohol if necessary to facilitate its uniform dispersion among the powder ingredients. This mixture is to be sprayed into the other ingredients while they are being mixed in a Broughton mixer. If spray equipment is not used to add the liquid mix to the dry powders in the mixer the tributyl phosphate must be increased to .1% (total liquid mix .203%) and the liquid mix dribbled slowly into the powder in the mixer.

Note 4 - Carbonate Fillers:

JF 254 - Bulletin 58-2-2, page 2 of 5, A or AA or Bulletin 6-24-2
JF 185 - Bulletin 6-24-9
JF 200 - Per Bulletin 6-24-1
JF 364 - #750-S Carbonate per Bulletin 6-24-9
JF 418C - 30.0% Rambo #4 per PMS 6-24-9; A Dolomite per Bul. 58-2-2 to make 100%.

Note 5 - Whiting

JF 254 per Bulletin C6-24-6

Note 6 - Gypsum, Montreal and New Brighton may substitute Collatex AS/KK Alginate in place of Marex Alginate.

South Gate to use Sodium Alginate instead of Ammonium Alginate.

D

NP007 1406

Operating Division PRODUCT PROCEDURE Approved:	**CONFIDENTIAL** **DO NOT REPRODUCE OR COPY** PERF-A-TAPE TOPPING COMPOUND JF-403B GYPSUM	No. 61-2-23-7 Date 7-21-66 Page 2 Cancels Dated NEW

RAW MATERIAL SPECIFICATIONS:

Per Bulletin 61-2-23

Ammonium pentaborate	per PMS 6-74-2
Glomax LL clay	per PMS 6-36-10
Alternate Carbonate Filler-Rambo #4	per PMS 6-24-9

FORMULA: JF-403B

Casein, FG uncilled	4.5%
Natrosol SG-61	0.7
Zinc Oxide (No. 42 Green Label)	0.1
Ammonium oxalate	1.0
Ammonium pentaborate	1.2
Dicyandiamide	0.3
Hydrated lime	As req'd (0.25 used in lab)
Mica JC	Formula V
JM7RF1 asbestos	As req'd (2.25 used in lab)
PC7RF9 asbestos	As req'd (2.25 used in lab)
Tetrasodium pyrophosphate	0.1
Glomax LL clay	5.0
No. 750 Marble	To make 100%
Ferrite Yellow	0.1 approx.

End

Operating Division PRODUCT PROCEDURE Approved: JP	PERF-A-TAPE TOPPING COMPOUND P-A-T (JF-394D)	No. 61-2-23-6 Date 10-24-66 Page 1 Cancels Page 1 Dated 1-12-66

DESCRIPTION:

A topping compound for Perf-A-Tape with superior mixing properties (with much less tendency to over-dilute in cold water), lower shrinkage, and equal bond strength to Dual-Purpose Compounds.

C MANUFACTURING PLANTS: Chamblee, Gypsum

IDENTIFICATION AND PACKAGING:

25 lb. and 32 lb. P-A-T Topping Compound bag; layout 7-16-42

Shipping Instructions - To be shipped on all orders for either CR or CS topping compound.

Shipments to Florida are to be made only with approval of Dept. 147-2.

Gypsum - On any order for Topping Compound, the following formula must be shipped, unless said order specifically requests non-"CS", regular, or other designation which might indicate a formula other than "CS".

Bags of pigmented CS topping for Flaming Materials are to be identified by printing the word "pigmented" over the code number.

CODING - Regular code to be followed by letters CS for all shipments.

FINISHED PRODUCT SPECIFICATIONS:

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match Sheetrock manila color.

Viscosity - 530 ± 30 BB units on VC-3 at 77°F, 400 ± 20 BB Units of old BB at 77°F.

Consistency - Consistency to be 68-72cc (normal 70cc) per 100 gms.

pH - 8.1 to 8.5 (8.3 Normal)

- 0 -

NP007 2021

Operating Division PRODUCT PROCEDURE Approved: JJ	**CONFIDENTIAL** **DO NOT REPRODUCE OR COPY** PERF-A-TAPE TOPPING COMPOUND P-A-T (JF-394D)	No. 61-2-23-6 Date 10-24-66 Page 2 Cancels Page 2 Dated 1-12-66

FORMULA:	JF-394D
Casein, FG unoiled	4.5
C Natrosol	0.8
Zinc Oxide	0.1
Ammonium Oxalate	1.0
Ammonium Pentaborate	1.2
Dicyandiamide	0.3
Hydrated Lime	(as required)
P-85 Mica	Formula V
JM-7RF1 Asbestos	(as required - about 2.0%)
PC-7RF9 Asbestos	(as required - about 2.0%)
TSPP	0.1
Carbonate Filler	To make 100%
Ferrite Yellow*	0.1 Approx.

*Omit Ferrite Yellow on all orders for Dual Purpose Compound.

D

D

RAW MATERIALS: per 61-2-23 and :

Ammonium Pentaborate - Per Bulletin 6-74-2

Carbonate Filler

Gypsum	#750 Marble or Rambo #4
Chamblee	#750 Marble

Natrosol

Chamblee	SG-61
Gypsum	SG-66

End

OP007 2022

C Indicates Change
D Indicates Deletion

No. 61-2-23 Date 11-7-66 Page 4 Cancels Page 4 Dated 7-21-66	**CONFIDENTIAL** **DO NOT REPRODUCE OR COPY** PERF-A-TAPE TOPPING COMPOUND

FORMULA NOTES

Note 1 - Asbestos used shall be as follows:

JF-418C - JM 7RF02
JF 254 - Johns Manville 7RF1
JF 200 - Phillip Carey 7RF9
C JF 185 - 2/3 Johns Manville 7RF02; 1/3 Phillip Carey 7RF9
JF 364 - 4.0% Nicolet T7G25 plus Canadian Carey 7RF9 as req'd (approx. 2%)

Note 2 - Sericite Mica used shall be as follows:

Gypsum and New Brighton - Ser-X
Chamblee - DXW Mineralite
South Gate - M350 Sericite

Note 3 - Chamblee to replace .050 of Polyglycol P1200 with .050 of Tributyl-phosphate. The Polyglycol P1200 and neutralizer 5050 should be mixed together before adding to the other ingredients. In cold weather this mixture may be thinned with a little isopropyl alcohol if necessary to facilitate its uniform dispersion among the powder ingredients. This mixture is to be sprayed into the other ingredients while they are being mixed in a Broughton mixer. If spray equipment is not used to add the liquid mix to the dry powders in the mixer the tributyl phosphate must be increased to .1% (total liquid mix .203%) and the liquid mix dribbled slowly into the powder in the mixer.

Note 4 - Carbonate Fillers:

JF 254 - Bulletin 58-2-2, page 2 of 5, A or AA or Bulletin 6-24-2
JF 185 - Bulletin 6-24-9
JF 200 - Per Bulletin 6-24-1
JF 364 - #750-S Carbonate per Bulletin 6-24-9
JF 418C - 30.0% Rambo #4 per PMS 6-24-9; A Dolomite per Bul. 58-2-2 to make 100%.

Note 5 - Whiting

JF 254 per Bulletin C6-24-6

Note 6 - Gypsum, Montreal and New Brighton may substitute Collatex AS/KK Alginate in place of Marex Alginate.

South Gate to use Sodium Alginate instead of Ammonium Alginate.

UP007 1432

Operating Division PRODUCT PROCEDURE Approved: JB	CONFIDENTIAL DO NOT REPRODUCE OR COPY PERF-A-TAPE TOPPING COMPOUND P-A-T (JF-394D)	No. 61-2-23-6 Date 11-7-66 Page 2 Cancels page 2 Dated 10-24-66

FORMULA:	JF-394D
Casein, FG unoiled	4.5
Natrosol	0.8
Zinc Oxide	0.1
Ammonium Oxalate	1.0
Ammonium Pentaborate	1.2
Dicyandiamide	0.3
Hydrated Lime	(as required)
P-85 Mica	Formula V
C JM-7RF1 Asbestos (Note 1)	(as required - about 2.0%)
PC-7RF9 Asbestos	(as required - about 2.0%)
TSPP	0.1
Carbonate Filler	To make 100%
Ferrite Yellow*	0.1 Approx.

*Omit Ferrite Yellow on all orders for Dual Purpose Compound.

A Note 1:
Chamblee only — JM7RF02 Asbestos

RAW MATERIALS: per 61-2-23 and:

Ammonium Pentaborate - Per Bulletin 6-74-2

Carbonate Filler

Gypsum	#750 Marble or Rambo #4
Chamblee	#750 Marble

Natrosol

Chamblee	SG-61
Gypsum	SG-66

End

TP007 2017

Operating Division PRODUCT PROCEDURE Approved:	PERF-A-TAPE JOINT COMPOUND - ALL PURPOSE CHAMBLEE	No. 61-2-26-2 Date 5-18-67 Page 1 Cancels Page 1 Dated 11-23-66

Chamblee to manufacture All-Purpose Joint Compound per the following specifications.

Formula AP-12

Casein		5.5
Ammonium Alginate		0.7
Ammonium oxalate		1.6
Hydrated lime		As required for pH (app. 0.1)
Ammonium pentaborate		1.2
Dicyandiamide		1.0
7RF02 Asbestos		(app. 8.5)
Mica J.C.		0.6 formula V
DXW Mineralite		15.0
No. 9 NCS		To make 100%
Liquid Mix		0.153
Polyglycol P 1200	0.100	
Tributyl Phosphate	0.050	
Neutralizer #50-50	0.003	

RAW MATERIALS Same as listed under 61-2-22 and 61-2-23.

FINISHED PRODUCT TESTS

Consistency: 65-69 cc (67 preferred) at a 530 ± 25 Brabender Reading on VC-3 Brabender at 77°F.

pH 8.1 - 8.5

Other tests as per Bulletin 61-2-22.

C PACKAGING: Use "All Purpose Joint Compound" bags as per layout 7-16-13-1.

D

SHIPMENT As per Bulletin 61-1-12.

Memphis Formula - To be shipped on all orders for Casein Dual or All Purpose for Memphis area only.

End

NP009 0243

Originally issued 5-29-64 SPECIAL BULLETIN 4th Extension

Operating Division PRODUCT PROCEDURE Approved: J.P.	PERF-A-TAPE JOINT COMPOUND TOPPING (JF445D) SOUTH GATE	No. 61-2-23-2 Date 5-29-67 Page 1 Cancels Page 1 Dated 5-11-66

This Bulletin expires 7-1-67.

South Gate to manufacture PERF-A-TAPE JOINT COMPOUND - Topping (JF445D) for shipment as directed by Department 147-2 meeting the following specifications:

IDENTIFICATION AND PACKAGING

Per Bulletin 7-16-13-2. Code with the letter "K" in addition to the date-mill-batch code.

Other Specifications per Bulletin 61-2-23.

TP007 1630

No. 61-2-23-C Date 5-29-67 Page 2 Cancels Page 2 Dated 5-11-66	PERF-A-TAPE JOINT COMPOUND - TOPPING (JP448D) SOUTH GATE

C

FINISHED PRODUCT SPECIFICATIONS

Color - Tint to normal light cream color for finishing compound.

Consistency - 67 to 69 cc at 550 Brabender pin paddle, 250 cmg torque head, 75 rpm, 77°F one hour after mixing.

Bond to Perf-A-Tape - 3 minimum when dried at relative humidities below 50%. Other tests per Bulletin 61-2-23.

- 0 -

C Indicates Change

UP007 1691

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved:	CONFIDENTIAL DO NOT REPRODUCE OR COPY PERF-A-TAPE JOINT COMPOUND - TOPPING (JF448D) - SOUTH GATE	No. 61-2-23-C Date 5-29-67 Page 3 Cancels Page 3 Dated 5-11-66

FORMULA	JF448D
Casein, fine grind uncilled	4.0%
SG-61	.8
Dicyandiamide	.3
Ammonium pentaborate	1.2
Ammonium oxalate	0.50%
Tetra sodium pyrophosphate	.1
Zinc oxide	.2
Canadian Carey 7RF9 Asbestos	2.0
C Johns-Manville 7RF02 Asbestos as req'd for st'd consistency	(3% in lab. batches)
WMC P-85 Mica	0.8 formula V value (about 14%)
Alba car 45-3 or Marble White 325	to make 100%
Pigment	As req'd

RAW MATERIALS

Per Bulletin 61-2-23 with the addition of SG-61 (Hercules Powder Co.)

MANUFACTURING PROCEDURE

Per Bulletin 61-2-23. Note - No liquid mix is used in JF448D.

End

tb007 1032

PERF-A-TAPE JOINT COMPOUND - TOPPING

FINISHED PRODUCT SPECIFICATIONS (Cont'd)

Mixing and Application Properties - To duplicate those of a standard sample to be supplied by the Research Laboratory.

Cracking - Should show no edge or check cracking in the normal bond test dried in the hot room.

Lumps - Screen 100 grams of the dry powder on a 30 mesh screen. All should pass through readily except for small amounts of asbestos. If lumps are present, examine to determine what they are, and take any steps necessary to eliminate them.

Consistency - The mixed compound is to have the specified Brabender reading using the pin paddle, one hour after mixing at a temperature of 77°F.

JF 418C 650 BB	66 to 70 cc (Normal 68 cc)
C JF 185 650 BB	65 to 68 cc (Normal 66 cc) (Chamblee and New Brighton)
A JF 185 430-630 BB at 67 cc (Gypsum Only)	
JF 200 650 BB	66 to 69 cc (Normal 67 cc)
JF 254 360-560 BB at 61 cc	
JF 364 650 BB	64 to 67 cc (Normal 66 cc)

Direct reading on C. W. Brabender Visco Corder with 250 cm. gm. head, pin paddle, and 75 RPM speed.

pH - Determine 30 minutes after mixing, temperature of mixed compound to be 77°F. during the 30 minutes.

JF 418C	8.1 to 8.5 ideal 8.3 to 8.4
JF 185, JF 200, JF 254	8.2 to 8.7 ideal 8.4 to 8.5
JF 364	8.2 to 8.4 ideal 8.3

Bond to Tape - Normally 2 to 4 when dried in an atmosphere below 50% RH for 18 hours. Lower at higher humidities. See page 6 for Bond Scale.

Rewet Test - Normally about 1 for all formulas.

Odor of Wet Mixed Compound - To be of same general character and no stronger than that of a standard sample of the same compound on standing a similar length of time after mixing with water.

-0-

A Indicates Addition
C Indicates Change

NP007 1393

No. 61-2-23 Date 6-5-67 Page 4 Cancels Page 4 Dated 11-7-66	**CONFIDENTIAL** **DO NOT REPRODUCE OR COPY** PERF-A-TAPE TOPPING COMPOUND

FORMULA NOTES

Note 1 - Asbestos used shall be as follows:

JF-418C - JM 7RF02
JF 254 - Johns Manville 7RF1
JF 200 - Phillip Carey 7RF9
C JF 185 - 2/3 Johns Manville 7RF02; 1/3 Phillip Carey 7RF9 (Chamblee Only)
JF 364 - 4.0% Nicolet T7G25 plus Canadian Carey 7RF9 as req'd (approx. 2%)
A JF 185 - JM7RF02 (Gypsum and New Brighton)

Note 2 - Sericite Mica used shall be as follows:

C Gypsum and New Brighton - Ser-X or Narvon CE-F-1
Chamblee - DXW Mineralite
South Gate - M350 Sericite

Note 3 - Chamblee to replace .050 of Polyglycol P1200 with .050 of Tributyl-phosphate. The Polyglycol P1200 and neutralizer 5050 should be mixed together before adding to the other ingredients. In cold weather this mixture may be thinned with a little isopropyl alcohol if necessary to facilitate its uniform dispersion among the powder ingredients. This mixture is to be sprayed into the other ingredients while they are being mixed in a Broughton mixer. If spray equipment is not used to add the liquid mix to the dry powders in the mixer the tributyl phosphate must be increased to .1% (total liquid mix .203%) and the liquid mix dribbled slowly into the powder in the mixer.

Note 4 - Carbonate Fillers:

JF 254 - Bulletin 58-2-2, page 2 of 5, A or AA or Bulletin 6-24-2
JF 185 - Bulletin 6-24-9
JF 200 - Per Bulletin 6-24-1
JF 364 - #750-S Carbonate per Bulletin 6-24-9
JF 418C - 30.0% Rambo #4 per PMS 6-24-9; A Dolomite per Bul. 58-2-2 to make 100%.

Note 5 - Whiting

JF 254 per Bulletin C6-24-6

Note 6 - Gypsum, Montreal and New Brighton may substitute Collatex AS/KK Alginate in place of Marex Alginate.

South Gate to use Sodium Alginate instead of Ammonium Alginate.

A Indicates Addition C Indicates Change

NP0007 1396

No. 61-2-23-C Date 5-7-67 Page 2 Cancels Dated Reinstated	PERF-A-TAPE JOINT COMPOUND - TOPPING (JT-+8D) SOUTH GATE

FINISHED PRODUCT SPECIFICATIONS

Color - Tint to normal light cream color for finishing compound.

Consistency - 67 to 69 cc at 550 Brabender pin paddle, 250 cmg n. torque head, 75 rpm, 77°F one hour after mixing.

Bond to Perf-A-Tape - 3 minimum when dried at relative humidities below 50%. Other tests per Bulletin 61-2-23.

- 0 -

SPECIAL BULLETIN

Operating Division	CONFIDENTIAL	No. 61-2-23-C
PRODUCT PROCEDURE	DO NOT REPRODUCE OR COPY	Date 8-7-67
Approved:	PERF-A-TAPE JOINT COMPOUND - TOPPING (JF448D) - SOUTH GATE	Page 3
		Cancels Dated Reinstated

FORMULA	JF448D
Casein, fine grind uncoiled	4.0%
SG-61	.8
Dicyandiamide	.3
Ammonium pentaborate	1.2
Ammonium oxalate	0.50%
Tetra sodium pyrophosphate	.1
Zinc oxide	.2
Canadian Carey 7RF9 Asbestos	2.0
Johns-Manville 7RF02 Asbestos as req'd for st'd consistency	(3% in lab. batches)
WMC P-85 Mica	0.8 formula V value (about 14%)
Alba car 45-3 or Marble White 325	to make 100%
Pigment	As req'd

RAW MATERIALS

Per Bulletin 61-2-23 with the addition of SG-61 (Hercules Powder Co.)

MANUFACTURING PROCEDURE

Per Bulletin 61-2-23. Note - No liquid mix is used in JF448D.

End

TP007 1579

No. 61-2-23 Date 6-20-67 Page 4 Cancels Page 4 Dated 6-5-67	**CONFIDENTIAL** **DO NOT REPRODUCE OR COPY** PERF-A-TAPE TOPPING COMPOUND

FORMULA NOTES

Note 1 - Asbestos used shall be as follows:

JF-418C - JM 7RF02
JF 254 - Johns Manville 7RF1
JF 200 - Phillip Carey 7RF9
JF 185 - 2/3 Johns Manville 7RF02; 1/3 Phillip Carey 7RF9 (Chamblee Only)
JF 364 - 4.0% Nicolet T7G25 plus Canadian Carey 7RF9 as req'd (approx. 2%)
JF 185 - JM7RF02 (Gypsum and New Brighton)

Note 2 - Sericite Mica used shall be as follows:

Gypsum and New Brighton - Ser-X or Narvon CE-F-1
C Chamblee - DXW Mineralite in white Topping; Ser-X or CE-F-1 in pigmented Topping.
South Gate - M350 Sericite

Note 3 - Chamblee to replace .050 of Polyglycol P1200 with .050 of Tributyl-phosphate. The Polyglycol P1200 and neutralizer 5050 should be mixed together before adding to the other ingredients. In cold weather this mixture may be thinned with a little isopropyl alcohol if necessary to facilitate its uniform dispersion among the powder ingredients. This mixture is to be sprayed into the other ingredients while they are being mixed in a Broughton mixer. If spray equipment is not used to add the liquid mix to the dry powders in the mixer the tributyl phosphate must be increased to .1% (total liquid mix .203%) and the liquid mix dribbled slowly into the powder in the mixer.

Note 4 - Carbonate Fillers:

JF 254 - Bulletin 58-2-2, page 2 of 5, A or AA or Bulletin 6-24-2
JF 185 - Bulletin 6-24-9
JF 200 - Per Bulletin 6-24-1
JF 364 - #750-S Carbonate per Bulletin 6-24-9
JF 418C - 30.0% Rambo #4 per PMS 6-24-9; A Dolomite per Bul. 58-2-2 to make 100%.

Note 5 - Whiting

JF 254 per Bulletin C6-24-6

Note 6 - Gypsum, Montreal and New Brighton may substitute Collatex AS/KK Alginate in place of Marex Alginate.

South Gate to use Sodium Alginate instead of Ammonium Alginate.

C Indicates Change

UP0007 1394

SPECIAL BULLETIN

Operating Division		No. 63-2-13-R
PRODUCT PROCEDURE	CALENDAR STARCH TRIALS	Date 11-2-67
Approved:		Page 1
		Cancels
		Dated NEW

This Bulletin expires 11-1-68.

MANUFACTURING PLANTS

Galena Park, Gypsum, No. Kansas City, Oakfield and South Gate.

Plants to conduct trials using Flosize 80, (National Starch and Chemical Co.) as a liner finish in place of Kofilm 80 in the manufacture of Manila and Newslined paper.

Paper meeting normal specifications to be shipped.

All other specifications per bulletins 63-2-13 and 63-2-14.

If trials are successful, plants to request issuance on a permanent basis.

-0-

End

OP007 0222

Operating Division PRODUCT PROCEDURE Approved:	PERF-A-TAPE TOPPING COMPOUND P-A-T (JF-394D)	No. 61-2-23-6 Date 1-15-68 Page 1 Cancels Page 1 Dated 10-24-66

DESCRIPTION:

A topping compound for Perf-A-Tape with superior mixing properties (with much less tendency to over-dilute in cold water), lower shrinkage, and equal bond strength to Dual-Purpose Compounds.

C MANUFACTURING PLANTS: Gypsum

IDENTIFICATION AND PACKAGING:

C 25 lb. P-A-T Topping Compound bag; layout 7-16-13-2 (2/MIL P.E. VP Barrier).

Shipping Instructions - To be shipped on all orders for either CR or CS topping compound.

Shipments to Florida are to be made only with approval of Dept. 147-2.

Gypsum - On any order for Topping Compound, the following formula must be shipped, unless said order specifically requests non-"CS", regular, or other designation which might indicate a formula other than "CS".

Bags of pigmented CS topping for Fleming Materials are to be identified by printing the word "pigmented" over the code number.

CODING - Regular code to be followed by letters CS for all shipments.

FINISHED PRODUCT SPECIFICATIONS:

Color - Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match Sheetrock manila color.

Viscosity - 530 ± 30 BB units on VC-3 at 77°F, 400 ± 20 BB Units of old BB at 77°F.

Consistency - Consistency to be 68-72cc (normal 70cc) per 100 gms.

pH - 8.1 to 8.5 (8.3 Normal)

- 0 -

USP007 2013

Operating Division PRODUCT PROCEDURE Approved:	CONFIDENTIAL DO NOT REPRODUCE OR COPY PERF-A-TAPE TOPPING COMPOUND P-A-T (JF-394D)	No. 61-2-23-6 Date 1-15-68 Page 2 Cancels page 2 Dated 11-7-66

FORMULA: JF-394D

Casein, FG uncoiled	4.5
Natrosol	0.8
Zinc Oxide	0.1
Ammonium Exalate	1.0
Ammonium Pentaborate	1.2
Dicyandiamide	0.3
Hydrated Lime	(as required)
P-85 Mica	Formula V
C JM-7RF1 Asbestos	(as required - about 2.0%)
PC-7RF9 Asbestos	(as required - about 2.0%)
TSPP	0.1
Carbonate Filler	To make 100%
Ferrite Yellow*	0.1 Approx.

*Omit Ferrite Yellow on all orders for Dual Purpose Compound.

D

RAW MATERIALS: per 61-2-23 and:

Ammonium Pentaborate - Per Bulletin 6-74-2

Carbonate Filler

Gypsum	#750 Marble or Rambo #4

D

Natrosol

D

Gypsum	SG-66

End

NP007 2019

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved:	**CONFIDENTIAL** **DO NOT REPRODUCE OR COPY** PERF-A-TAPE JOINT COMPOUND TOPPING - (JF-254)	No. 61-2-23-T Date 3-4-68 Page 2 Cancels NEW Dated

FORMULA	JF-254
F. G. Casein	2.0%
Soy Protein	2.0
Amm. Oxalate	1.0
Amm. Pentaborate	1.2
Amm. Alginate	0.8
Hyd. Lime	About 0.15
Dicyandiamide	1.0
JMTRF02	About 4.0
Mica JC	0.6 Formula V
M-4 Talc	15.0
FF Limestone	15.0
A-Dolomite	To Make 100%
Ferrite Yellow	About 0.15
Liquid Mix	0.153

RAW MATERIALS

Per Bulletin 61-2-23 except refined soy protein per PMS 6-123-1.

MANUFACTURING PROCEDURE

Per Bulletin 61-2-23.

End

mp007 1711

Also Cancels Special Bulletin 61-2-23-6-B, Dated 1-30-67

Operating Division PRODUCT PROCEDURE Approved:	PERF-A-TAPE TOPPING COMPOUND P-A-T (JF-394D)	No. 61-2-23-6 Date 3-11-68 Page 1 Cancels Page 1 Dated 1-15-68

DESCRIPTION

A topping compound for PERF-A-TAPE with superior mixing properties (with much less tendency to over-dilute in cold water), lower shrinkage, and generally equal bond strength to Dual-Purpose Compounds, when used over metal bead or trim.

MANUFACTURING PLANTS

Gypsum

IDENTIFICATION AND PACKAGING

25 lb. P-A-T Topping Compound bag; layout 7-16-13-2 (2/MIL P.E. VP Barrier).

Under the code there should be a statement to the effect that "THIS PRODUCT MAY BE USED DIRECT OVER USG METAL BEAD".

Shipping Instructions

To be shipped on all orders for either ES or CS topping compound.

Shipments to Florida are to be made only with approval of Department 981.

Gypsum - On any order for "CS" or "ES" Topping Compound, the following formula must be shipped.

Bags of pigmented "CS" or "ES" topping for Fleming Materials are to be identified by printing the word "pigmented" over the code number.

CODING

Regular code to be followed by letters "CS" or "ES" for all shipments, depending on what is ordered.

nDOO7 7015

No. 61-2-23-6 Date 3-11-68 Page 2	PERF-A-TAPE TOPPING COMPOUND
Cancels Page 2 Dated 1-15-68	P-A-T (JF-394D)

FINISHED PRODUCT SPECIFICATIONS

Color

Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match SHEETROCK manila color.

Viscosity

530 ± 30 BB units on VC-3 at 77°F, 400 ± 20 BB Units of old BB at 77°F.

Consistency

Consistency to be 68-72 cc (normal 70 cc) per 100 gms.

pH

8.1 to 8.5 (8.3 normal).

- 0 -

Rearrangement Only

Contains Material Formerly On Page 2, Dated 1-15-68

Operating Division PRODUCT PROCEDURE Approved:	CONFIDENTIAL DO NOT REPRODUCE OR COPY PERF-A-TAPE TOPPING COMPOUND	No. 61-2-23-c Date 3-11-68 Page 3 Cancels NEW Dated

P-A-T (JF-394D)

FORMULA	JF-394D
Casein, FG uncoiled	3.5
Natrosol	0.8
Zinc Oxide	0.1
Ammonium Oxalate	0.8
Ammonium Pentaborate	1.2
Dicyandiamide	0.3
Hydrated Lime	(As Required)
P-85 Mica	Formula V
JF-7RF02	(As Required - About 4%)
TSPP	0.1
Carbonate Filler	To make 100%
Ferrite Yellow*	0.1 Approx.

* Omit Ferrite Yellow on all orders for Dual Purpose Compound.

RAW MATERIALS

Per 61-2-23 and:

Ammonium Pentaborate - Per Bulletin 6-74-2.

Carbonate Filler
Gypsum #9NCS

Natrosol
Gypsum SG-61 (Oct. 1st to April 30)
SG-67 (May 1st to Sept. 30)

End

Originally Issued 5-29-64 SPECIAL BULLETIN For Extension

Operating Division	PERF-A-TAPE JOINT COMPOUND TOPPING	No. 61-16-13-2
PRODUCT PROCEDURE	(JF448D) SOUTH GATE	Date 4-2-68
Approved:		Page 1
		Cancels Page 1
		Dated 8-7-67

This Bulletin expires 7-1-68.

South Gate to manufacture PERF-A-TAPE JOINT COMPOUND - Topping (JF448D) for shipment as directed by L.A. Department 961 meeting the following specifications:

IDENTIFICATION AND PACKAGING

Per Bulletin 7-16-13-2. Code with the letter "K" in addition to the date-mill-batch code. Shipments reaching dealers from May 1 through Sept. 30 to be summer formula coded with letters "KS". Shipments restricted to San Joaquin Valley (Calif), Sacramento District, Salt Lake City District and South Pacific Division.

of summer formula

Other specifications per Bulletin 61-2-23.

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved:	CONFIDENTIAL DO NOT REPRODUCE OR COPY PERF-A-TAPE JOINT COMPOUND - TOPPING (JF448D) - SOUTH GATE	No. 61-2-23-C Date 4-24-68 Page 3 Cancels Page 3 Dated 8-7-67

	FORMULA	JF448D
	Casein, fine grind uncoiled	4.0%
C	SG-61*	.8
	Dicyandiamide	.3
	Ammonium pentaborate	1.2
	Ammonium oxalate	0.50%
	Tetra sodium pyrophosphate	.1
	Zinc oxide	.2
	Canadian Carey TRF9 Asbestos	2.0
	Johns-Manville TRF02 Asbestos as req'd for st'd consistency	(3% in lab. batches)
	WMC P-85 Mica	0.8 formula V value (about 14%)
	~~Alba-car-45-3~~ or Marble White 325	To Make 100%
	Pigment	As Required

A * Summer formula to use SG-67.

RAW MATERIALS

Per Bulletin 61-2-23 with the addition of SG-61 ~~(Hercules Powder Co.)~~

MANUFACTURING PROCEDURE

Per Bulletin 61-2-23. Note - No liquid mix is used in JF448D.

Alba Car-45-3 is now obsolete at So. Gate.

End

NP007 7017

Operating Division
PRODUCT PROCEDURE

Approved:

CONFIDENTIAL
DO NOT REPRODUCE OR COPY

PERF-A-TAPE TOPPING COMPOUND

No. 61-2-23
Date 5-13-68
Page 3

Cancels Page 3
Dated 5-19-66

FORMULAS

	JF-418C New Brighton	JF 254 Montreal Hagersville	JF 364 Dallas	JF 200 South Gate	JF 185 Chamblee Gypsum New Brighton
Casein	2.5	3.75	4.0	3.0	2.5
Soy Protein	3.0	-	-	2.5	2.25
Ammonium Alginate (Note 6)	0.8	0.8	-	0.8	0.8
Hydrated Lime	As Req.	As Req.	As Req.	As Req.	As Req.
Ammonium Oxalate (Note 7)	1.0	1.0	0.9	1.0	1.0
Sodium Pentachlorophenate	-	-	-	0.2	-
Ammonium Pentaborate	1.2	1.2	1.2	-	1.2
Dicyandiamide	0.3	1.0	0.3	0.3	0.3
Mica J.C.	Formula V	0.6 Formula V	-	Formula V	-
Mica P-85	-	-	0.8 Formula V	-	0.6 Formula V
80-61			0.65		
Zinc Oxide (#42 green label)			0.20		
Tetra sodium pyrophosphate (Fine ground)			0.10		
Asbestos - (Note 1)	As Req.	As Req.	As Req.	As Req.	As Req.
Mica Sericite - (Note 2)	15.0	-	-	15.0	15.0
Whiting - (Note 5)	-	15.0	-	-	-
Talc	-	15.0	-	-	-
Polyglycol P1200 (Note 3)	0.150	0.150	-	0.150	0.150
Neutraliser 5050 - (Note 3)	0.003	0.003	-	0.003	0.003
Carbonate Filler - (Note 4)	To Make 100%	To make 100%	To make 100%	To Make 100%	To Make 100%
Pigments	Pigment with Ferrite Yellow and Other Lime Proof Colors as Required				

C Indicates Change

Also cancels Special Bulletin 61-2-23-R dated 12-21-67.

No. 61-2-23 Date 5-13-68 Page 4	**CONFIDENTIAL** **DO NOT REPRODUCE OR COPY**
Cancels Page 4 Dated 6-20-67	PERF-A-TAPE TOPPING COMPOUND

FORMULA NOTES

Note 1 - Asbestos used shall be as follows:

JF 418C - JM 7RF02
JF 254 - Johns Manville 7RF1
JF 200 - Phillip Carey 7RF9
JF 185 - 2/3 Johns Manville 7RF02; 1/3 Phillip Carey 7RF9 (Chamblee Only)
JF 364 - 4.0% Nicolet T7G25 plus Canadian Carey 7RF9 as req'd (approx. 2%)
JF 185 - JM7RF02 (Gypsum and New Brighton)

Note 2 - Sericite Mica used shall be as follows:

Gypsum and New Brighton - Ser-X or Narvon CE-F-1
Chamblee - DXW Mineralite in white Topping; Ser-X or CE-F-1 in pigmented Topping.
South Gate - M350 Sericite

Note 3 - Chamblee to replace .050 of Polyglycol P1200 with .050 of Tributyl-phosphate. The Polyglycol P1200 and neutralizer 5050 should be mixed together before adding to the other ingredients. In cold weather this mixture may be thinned with a little isopropyl alcohol if necessary to facilitate its uniform dispersion among the powder ingredients. This mixture is to be sprayed into the other ingredients while they are being mixed in a Broughton mixer. If spray equipment is not used to add the liquid mix to the dry powders in the mixer the tributyl phosphate must be increased to .1% (total liquid mix .203%) and the liquid mix dribbled slowly into the powder in the mixer.

Note 4 - Carbonate Fillers:

JF 254 - Bulletin 58-2-2, page 2 of 5, A or AA or Bulletin 6-24-2
JF 185 - Bulletin 6-24-9
JF 200 - Per Bulletin 6-24-1
JF 364 - #750-S Carbonate per Bulletin 6-24-9
JF 418C - 30.0% Rambo #4 per PMS 6-24-9; A Dolomite per Bul. 58-2-2 to make 100%.

Note 5 - Whiting

JF 254 per Bulletin C6-24-6

Note 6 - Gypsum, Montreal and New Brighton may substitute Collatex AS/KK Alginate in place of Marex Alginate.

South Gate to use Sodium Alginate instead of Ammonium Alginate.

A Hagersville may use Marex or Protan Alginate 512 in place of Marex Alginate.

A Note 7 - Chamblee only, to use 1.1% Ammonium Oxalate.

OP007 1360

A Indicates Addition

Operating Division PRODUCT PROCEDURE Approved:	CONFIDENTIAL DO NOT REPRODUCE OR COPY PERF-A-TAPE TOPPING COMPOUND	No. 61-2-23 Date 5-13-68 Page 5 Cancels Page 5 Dated 10-31-67

RAW MATERIAL SPECIFICATIONS

Casein	Per Bulletin 6-26-4
Soy Protein	" " 6-123-1
Hydrated Lime	" 6-69-1, 59-3-7, 59-8-7 or equiv.
Ammonium Oxalate	" Bulletin 6-11-5
Sodium Pentachlorophenate	" " 6-33-4
Dicyandiamide	" " 6-44-1
Mica JC	" " 6-143-1
Mica P-85	" " 6-143-3
Sericite Micas	" " 6-146-2
Asbestos	" " 6-14-5
Wetting Agent - Polyglycol P1200	Per PMS 6-40-16
Carbonate Fillers	Per Bulletin 6-24-1, 6-24-9, 58-2-2
C Ammonium Alginate *	" " 6-8-1
Whiting	" " 6-24-7, C6-24-6
Ferrite	- -
Talc	Per Bulletin C6-128-4
Sodium Alginate	Per Bulletin 6-8-4
Zinc Oxide (#42 green label)	Per Bulletin 6-94-91
Tetra sodium pyrophosphate	Per PMS 6-177-4
Tributyl Phosphate	Per Bulletin _____

SG-61 (Hercules Powder Co. - retarded solution, high viscosity hydroxy ethyl cellulose)

Ammonium pentaborate Technical grade powdered, per PMS 6-74-2.
Neutralizer 5050 - from Magnus, Mabee and Reynard, Inc.

A * Hagerstville only, may use Protan Alginate 512 or Marex.

MANUFACTURING PROCEDURE

Weigh all materials accurately. Maximum permissible weight departure is 3% of the amount specified. Mix in a Broughton mixer, spraying the mixed liquids after mixing of the powders has started. Continue mixing for a minimum of 10 minutes after the liquids have been sprayed into the batch.

After mixing is complete pass the batch through a Mikropulverizer using a coarse (3/32" slot width) screen. It is then ready for packing.

DP007 1397

No. 61-2-23 Date 5-22-68 Page 4 Cancels Page 4 Dated 5-13-68	**CONFIDENTIAL** DO NOT REPRODUCE OR COPY PERF-A-TAPE TOPPING COMPOUND

FORMULA NOTES

Note 1 - Asbestos used shall be as follows:

JF-418C - JM 7RF02
JF 254 - Johns Manville 7RF1
JF 200 - Phillip Carey 7RF9
JF 185 - 2/3 Johns Manville 7RF02; 1/3 Phillip Carey 7RF9 (Chamblee Only)
JF 364 - 4.0% Nicolet T7G25 plus Canadian Carey 7RF9 as req'd (approx. 2%)
JF 185 - JM7RF02 (Gypsum and New Brighton)

Note 2 - Sericite Mica used shall be as follows:

Gypsum and New Brighton - Ser-X or Marvon CE-F-1
Chamblee - DXW Mineralite in white Topping; Ser-X or CE-F-1 in pigmented Topping
South Gate - M350 Sericite

Note 3 - Chamblee to replace .050 of Polyglycol P1200 with .050 of Tributyl Phosphate. The Polyglycol P1200 and neutralizer 5050 should be mixed together before adding to the other ingredients. In cold weather, this mixture may be thinned with a little isopropyl alcohol if necessary to facilitate its uniform dispersion among the powder ingredients. This mixture is to be sprayed into the other ingredients while they are being mixed in a Broughton mixer. If spray equipment is not used to add the liquid mix to the dry powders in the mixer, the tributyl phosphate must be increased to .1% (total liquid mix .203%) and the liquid mix dribbled slowly into the powder in the mixer.

Note 4 - Carbonate Fillers:

C JF 254 - Bulletin 58-2-2, page 2 of 5, A or AA or PMS 6-24-2 or 6-24-17
JF 185 - PMS 6-24-9
JF 200 - PMS 6-24-1
JF 364 - #750-S Carbonate per PMS 6-24-9
C JF 418C - 30.0% Rambo #4 per PMS 6-24-9; A Dolomite per Bulletin 58-2-2 or #325 Mineral Filler per PMS 6-24-17 to make 100%.

Note 5 - Whiting:

JF 254 per PMS C6-24-6

Note 6 - Gypsum, Montreal and New Brighton may substitute Collatex AS/KK Alginate in place of Marex Alginate.
South Gate to use Sodium Alginate instead of Ammonium Alginate.
Hagersville may use Marex or Protan Alginate 512 in place of Marex Alginate.

Note 7 - Chamblee Only, to use 1.1% Ammonium Oxalate.

C Indicates Change

OP007 1336

Operating Division PRODUCT PROCEDURE Approved:	CONFIDENTIAL DO NOT REPRODUCE OR COPY PERF-A-TAPE JOINT COMPOUND - TOPPING	No. 61-2-23-7 Date 6-27-68 Page 3 Cancels NEW Dated

(JF448D) - SOUTH GATE

FORMULA	JF448D
Casein, fine grind unoiled	4.0%
SG-61*	.8
Dicyandiamide	.3
Ammonium pentaborate	1.2
Ammonium oxalate	0.50%
Tetra sodium pyrophosphate	.1
Zinc oxide	.2
Canadian Carey 7RF9 Asbestos	2.0
Johns-Manville 7RF02 Asbestos as req'd for st'd consistency	(3% in lab. batches)
WMC P-85 Mica	0.8 formula V value (about 14%)
Marble White 325	To Make 100%
Pigment	As Required

* Summer formula to use SG 67.

RAW MATERIALS

Per Bulletin 61-2-23 with the addition of SG-61 or SG-67 per PMS 6-151-6.

MANUFACTURING PROCEDURE

Per Bulletin 61-2-23. Note - No liquid mix is used in JF448D.

End

NP007 2651

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved:	**CONFIDENTIAL** **DO NOT REPRODUCE OR COPY** PERF-A-TAPE TOPPING COMPOUND (JF-582)	No. 61-2-23-6-D Date 9-10-68 Page 3 Cancels NEW Dated

FORMULA

	JF-582
FG Casein, Uncoiled	3.5
Natrosol 250KXR	0.8
Zinc Oxide	0.1
Ammonium Oxalate	0.8
Ammonium Pentaborate	1.2
Dicyandiamide	0.3
Hydrated Lime	As required
M-85 Mica	Formula V
DM-7RF02	As Required - About 3%
#SPP	0.1
#9NCS	To make 100%
Ferrite Yellow	0.1 approx.

RAW MATERIALS - Per Bulletin 61-2-23-6 except:

Natrosol 250KXR	Hercules Inc., Hopewell, Va.

End

GP007 2647

Cancels Special Bulletin 61-2-23-6-C Dated 3-5-68.
Cancels Special Bulletin 61-2-23-6-D Pgs. 1,2,&3 Dated 9-10-68.

No. 61-2-23-6 Date 11-7-68 Page 2	PERF-A-TAPE TOPPING COMPOUND
Cancels Page 2 Dated 3-11-68	P-A-T (JF-394D)

FINISHED PRODUCT SPECIFICATIONS

Color

Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match SHEETROCK manila color.

Viscosity

C 430-630 BB units on VC-3 at 77°F.

Consistency

C Consistency to be 64 cc per 100 gms.

pH

8.1 to 8.5 (8.3 normal).

- 0 -

npo07 201

M-5791 (Back)

C Indicates Change

Operating Division PRODUCT PROCEDURE Approved:	CONFIDENTIAL DO NOT REPRODUCE OR COPY PERF-A-TAPE TOPPING COMPOUND	No. 61-2-23-6 Date 11-7-68 Page 3 Cancels Page 3 Dated 3-11-68

P-A-T (JF-394D)

	FORMULA	JF-394D
	Casein, FG unoiled	3.5
C	Natrosol SG-68	0.8
	Zinc Oxide	0.1
	Ammonium Oxalate	0.8
	Ammonium Pentaborate	1.2
	Dicyandiamide	0.3
	Hydrated Lime	(As Required)
	P-85 Mica	Formula V
	JF-7RF02	(As Required - About 4%)
	TSPP	0.1
C	Carbonate Filler (#9NCS)	To make 100%
	Ferrite Yellow*	0.1 Approx.

* Omit Ferrite Yellow on all orders for Dual Purpose Compound.

RAW MATERIALS

Per 61-2-23 and:

D		
C	Natrosol SG-68	Per PMS 6-151-13
D		
D		

End

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

C Indicates Change
D Indicates Deletion

UP007 2014

Operating Division PRODUCT PROCEDURE Approved:	PERF-A-TAPE TOPPING COMPOUND (JF-582)	No. 61-2-23-6 Date 3-3-69 Page 1 Cancels Page 1 Dated 3-11-68

C

DESCRIPTION

A topping compound for PERF-A-TAPE with superior mixing properties (with much less tendency to over-dilute in cold water), lower shrinkage, and generally equal bond strength to Dual-Purpose Compounds, when used over metal bead or trim.

MANUFACTURING PLANTS

Gypsum

IDENTIFICATION AND PACKAGING

25 lb. P-A-T Topping Compound bag; layout 7-16-13-2 (2/MIL P.E. VP Barrier).

Under the code there should be a statement to the effect that "THIS PRODUCT MAY BE USED DIRECT OVER USG METAL BEAD".

Shipping Instructions

To be shipped on all orders for either ES or CS topping compound.

Shipments to Florida are to be made only with approval of Department 981.

Gypsum - On any order for "CS" or "ES" Topping Compound, the following formula must be shipped.

Bags of pigmented "CS" or "ES" topping for Fleming Materials are to be identified by printing the word "pigmented" over the code number.

A Gypsum to package "ES" PERF-A-TAPE Joint Compound in 32 lb. bags per Bulletin 7-16-13-7 for Hollenbeck & Sather or as directed by Dept. #971.

CODING

Regular code to be followed by letters "CS" or "ES" for all shipments, depending on what is ordered.

NPG07 2013

A Indicates Addition
C Indicates Change

No. 61-2-23-6 Date 3-3-69 Page 2		PERF-A-TAPE TOPPING COMPOUND
C Cancels Page 2 Dated 11-7-68		(JF-582)

FINISHED PRODUCT SPECIFICATIONS

Color

Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match SHEETROCK manila color.

Viscosity

430-630 BB units on VC-3 at 77°F.

Consistency

Consistency to be 64 cc per 100 gms.

pH

8.1 to 8.5 (8.3 normal).

- 0 -

USG 2011

C Indicates Change

C C

FORMULA JF-582

Casein, FG unoiled	3.5
Natrosol SG-68	0.8
Zinc Oxide	0.1
Ammonium Oxalate	0.8
Ammonium Pentaborate	1.2
Dicyandiamide	0.3
Hydrated Lime	(As Required)
P-85 Mica	Formula V
JF-7RF02	(As Required - About 4%)
TSPP	0.1
Carbonate Filler (#9NCS)	To make 100%
Ferrite Yellow*	0.1 Approx.

* Omit Ferrite Yellow on all orders for Dual Purpose Compound.

RAW MATERIALS

Per 61-2-23 and:

Natrosol SG-68 Per PMS 6-151-13

C

End

C

C

TP007 201

SPECIAL BULLETIN

Operating Division	CONFIDENTIAL	No. 61-2-23-6-E
PRODUCT PROCEDURE	DO NOT REPRODUCE OR COPY	Date 3-3-69
Approved:	PERF-A-TAPE TOPPING COMPOUND- (JF-394D) GYPSUM	Page 3
		Cancels NEW
		Dated

FORMULA	JF-394D
Casein, FG Unoiled	3.5
Natrosol SG-61	0.8
Zinc Oxide	0.1
Ammonium Oxalate	0.8
Ammonium Pentaborate	1.2
Dicyandiamide	0.3
Hydrated Lime	(As Req'd.)
P-85 Mica	Formula V
JM 7RF02	About 4.0% (As Req'd.)
TSPP	0.1
Carbonate Filler (#9NCS)	To make 100%
Ferrite Yellow	0.1 approx.

RAW MATERIALS

Per 61-2-23-6 except Natrosol SG-61 per PMS 6-151-6.

End

NP001 2055

No.	61-2-23
Date	5-8-69
Page	4
Cancels	Page 4
Dated	9-26-68

CONFIDENTIAL

DO NOT REPRODUCE OR COPY

PERF-A-TAPE TOPPING COMPOUND

FORMULA NOTES

Note 1 - Asbestos used shall be as follows:

JF-418C - JM 7RF02
JF 254 - Johns Manville 7RF1
JF 200 - Phillip Carey 7RF9
JF 185 - 2/3 Johns Manville 7RF02; 1/3 Phillip Carey 7RF9 (Chamblee Only)
JF 364 - 4.0% Nicolet T7G25 plus Canadian Carey 7RF9 as req'd (approx. 2%)
JF 185 - JM7RF02 (Gypsum and New Brighton)

Note 2 - Sericite Mica used shall be as follows:

Gypsum and New Brighton - Ser-X or Narvon CE-F-1
Chamblee - DXW Mineralite in white Topping; Ser-X or CE-F-1 in pigmented Topping
South Gate - M350 Sericite

Note 3 - Chamblee to replace .050 of Polyglycol P1200 with .050 of Tributyl Phosphate. The Polyglycol P1200 and neutralizer 5050 should be mixed together before adding to the other ingredients. In cold weather, this mixture may be thinned with a little isopropyl alcohol if necessary to facilitate its uniform dispersion among the powder ingredients. This mixture is to be sprayed into the other ingredients while they are being mixed in a Broughton mixer. If spray equipment is not used to add the liquid mix to the dry powders in the mixer, the tributyl phosphate must be increased to .1% (total liquid mix .203%) and the liquid mix dribbled slowly into the powder in the mixer.

Note 4 - Carbonate Fillers:

JF 254 - Bulletin 58-2-2, page 2 of 5, A or AA or PMS 6-24-2 or 6-24-17
JF 185 - PMS 6-24-9
JF 200 - PMS 6-24-1
C JF 364 - #750-S Carbonate per PMS 6-24-9 or Carthage-92 per PMS 6-24-20.
JF 418C - 30.0% Rambo #4 per PMS 6-24-9; A Dolomite per Bulletin 58-2-2 or #325 Mineral Filler per PMS 6-24-17 to make 100%.
Exception: Montreal may use Stonelite or Pulpro White #1 in place of A Dolomite. Stonelite per PMS 6-24-2, Pulpro White #1 per PMS C6-24-18.

Note 5 - Whiting:

JF 254 per PMS C6-24-6

Note 6 - Gypsum, Montreal and New Brighton may substitute Collatex AS/KK Alginate in place of Marex Alginate.
South Gate to use Sodium Alginate instead of Ammonium Alginate.
Hagersville may use Marex or Protan Alginate 512 in place of Marex Alginate.

Note 7 - Chamblee Only, to use 1.1% Ammonium Oxalate.

DP007 1379

C Indicates Change

Operating Division PRODUCT PROCEDURE Approved:	CONFIDENTIAL DO NOT REPRODUCE OR COPY PERF-A-TAPE TOPPING COMPOUND	No. 61-2-23 Date 5-8-69 Page 5 Cancels Page 5 Dated 5-22-68

RAW MATERIAL SPECIFICATIONS

Casein	Per PMS 6-26-4
Soy Protein	Per PMS 6-123-1
Hydrated Lime	Per PMS 6-69-1, Bul. 59-3-7, 59-8-7, or equivalent
Ammonium Oxalate	Per PMS 6-11-5
Sodium Pentachlorophenate	Per PMS 6-33-4
Dicyandiamide	Per PMS 6-44-1
Mica JC	Per PMS 6-143-1
Mica P-85	Per PMS 6-143-3
Sericite Micas	Per PMS 6-146-2
Asbestos	Per PMS 6-14-5
Wetting Agent - Polyglyco P1200	Per PMS 6-40-16
Carbonate Fillers	Per PMS 6-24-1, 6-24-9, 6-24-2, 6-24-17, 6-24-20, and Bulletin 58-2-2
Ammonium Alginate*	Per PMS 6-8-1
Whiting	Per PMS 6-24-7, C6-24-6
Ferrite	Per
Talc	Per PMS C6-128-4
Sodium Alginate	Per PMS 6-8-4
Zinc Oxide (#42 green label)	Per PMS 6-94-91
Tetra sodium pyrophosphate	Per PMS 6-177-4
Tributyl Phosphate	Per _____

SG-61 (Hercules Powder Co. - retarded solution, high viscosity hydroxy ethyl cellulose)
Ammonium pentaborate Technical grade powdered, per PMS 6-74-2.
Neutralizer 5050 - from Magnus, Mabee and Reynard, Inc.

* Hagersville Only may use Protan Alginate 512 or Marex.

MANUFACTURING PROCEDURE

Weigh all materials accurately. Maximum permissible weight departure is 3% of the amount specified. Mix in a Broughton mixer, spraying the mixed liquids after mixing of the powders has started. Continue mixing for a minimum of 10 minutes after the liquids have been sprayed into the batch.

After mixing is complete, pass the batch through a Mikropulverizer using a coarse (3/32" slot width) screen. It is then ready for packing.

Operating Division
PRODUCT PROCEDURE
Approved:

CONFIDENTIAL
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PERF-A-TAPE TOPPING COMPOUND

No. 61-2-23
Date 5-25-70
Page 3
Cancels Page 3
Dated 5-13-68

FORMULAS

	JP-418C New Brighton	JP 254 Montreal Hagersville	JP 364 Dallas	JP 200 South Gate	JP 185 Chamblee Gypsum New Brighton
Casein	2.5	3.75	4.0	3.0	2.5
Soy Protein	3.0	-	-	2.5	2.25
Ammonium Alginate (Note 6)	0.8	0.8	-	0.8	0.8
Hydrated Lime	As Req.	As Req.	As Req.	As Req.	As Req.
Ammonium Oxalate (Note 7)	1.0	1.0	0.9	1.0	1.0
Sodium Pentachlorophenate	-	-	-	0.2	-
Ammonium Pentaborate	1.2	1.2	1.2	-	1.2
Dicyandiamide	0.3	1.0	0.3	0.3	0.3
Mica J.C.	Formula V	C.6 Formula V	-	Formula V	-
Mica P-85	-	-	0.8 Formula V	-	0.6 Formula V
SG-61			0.65		
Zinc Oxide (#42 green label)			0.20		
Tetra sodium pyrophosphate (Fine ground)			0.10		
Asbestos - (Note 1)	As Req.	As Req.	As Req.	As Req.	As Req.
Mica Sericite - (Note 2)	15.0	-	-	15.0	15.0
Whiting - (Note 5)	-	15.0	-	-	-
Talc	-	15.0	-	-	-
C PPG-1200 (Note 3)	0.150	0.150	-	0.150	0.150
Neutralizer 5050 - (Note 3)	0.003	0.003	-	0.003	0.003
Carbonate Filler - (Note 4)	To Make 100%	To make 100%	To make 100%	To Make 100%	To Make 100%
Pigments	Pigment with Ferrite Yellow and Other Lime Proof Colors as Required				

M-5791-C 7/65 (Printed in U.S.A.)

C Indicates Change

No.	61-2-23
Date	5-25-70
Page	4
Cancels	Page 4
Dated	12-18-69

CONFIDENTIAL

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PERF-A-TAPE TOPPING COMPOUND

FORMULA NOTES

Note 1 - Asbestos used shall be as follows:

JF-418C - JM TRF02
JF 254 - Johns Manville TRF02
JF 200 - Phillip Carey TRF9
JF 185 - 2/3 Johns Manville TRF02; 1/3 Phillip Carey TRF9 (Chamblee Only)
JF 364 - 4.0% Nicolet T7G25 plus Canadian Carey TRF9 as req'd (approx. 2%)
JF 185 - JMTRF02 (Gypsum and New Brighton)

Note 2 - Sericite Mica used shall be as follows:

Gypsum and New Brighton - Ser-X or Marvon CE-F-1
Chamblee - DXW Mineralite in white Topping; Ser-X or CE-F-1 in pigmented Topping
South Gate - M350 Sericite

C Note 3 - Chamblee to replace .050 of PPG-1200 with .050 of Tributyl Phosphate.
C The PPG-1200 and neutralizer 5050 should be mixed together before adding to the other ingredients. In cold weather, this mixture may be thinned with a little isopropyl alcohol if necessary to facilitate its uniform dispersion among the powder ingredients. This mixture is to be sprayed into the other ingredients while they are being mixed in a Broughton mixer. If spray equipment is not used to add the liquid mix to the dry powders in the mixer, the tributyl phosphate must be increased to .1% (total liquid mix .203%) and the liquid mix dribbled slowly into the powder in the mixer.

Note 4 - Carbonate Fillers:

JF 254 - Bulletin 58-2-2, page 2 of 5, A or AA or PMS 6-24-2 or 6-24-17
JF 185 - PMS 6-24-9
JF 200 - PMS 6-24-1
JF 364 - #750-S Carbonate per PMS 6-24-9 or Carthage-92 per PMS 6-24-20.
JF-418C - 30.0% Rambo #4 per PMS 6-24-9; A Dolomite per Bulletin 58-2-2 or #325 Mineral Filler per PMS 6-24-17 to make 100%.
Exception: Montreal may use Stonelite or Pulpro White #1 in place of A Dolomite. Stonelite per PMS 6-24-2, Pulpro White #1 per PMS C6-24-16.

Note 5 - Whiting:

JF 254 per PMS C6-24-6

Note 6 - Gypsum, Montreal and New Brighton may substitute Collatex AS/NK Alginate in place of Marex Alginate.
South Gate to use Sodium Alginate instead of Ammonium Alginate.
Hagersville may use Marex or Protan Alginate 512 in place of Marex Alginate.

Note 7 - Chamblee Only, to use 1.1% Ammonium Oxalate.

C-5791-C (Back)

C Indicates Change

DP007 1369

Operating Division PRODUCT PROCEDURE Approved:	CONFIDENTIAL DO NOT REPRODUCE OR COPY PERF-A-TAPE TOPPING COMPOUND	No. 01-2-23 Date 5-25-70 Page 5 Cancels Page 5 Dated 12-18-69

RAW MATERIAL SPECIFICATIONS

Casein	Per PMS 6-26-4
Soy Protein	Per PMS 6-123-1
Hydrated Lime	Per PMS 6-69-1, Bul. 59-3-7, 59-8-7, or equivalent
Ammonium Oxalate	Per PMS 6-11-5
Sodium Pentachlorophenate	Per PMS 6-33-4
Dicyandiamide	Per PMS 6-44-1
Mica JC	Per PMS 6-143-1
Mica P-85	Per PMS 6-143-3
Sericite Micas	Per PMS 6-146-2
Asbestos	Per PMS 6-14-5 and PMS 6-14-10.
C Wetting Agent - PPG-1200	Per PMS 6-40-16
Carbonate Fillers	Per PMS 6-24-1, 6-24-9, 6-24-2, 6-24-17, 6-24-20, and Bulletin 58-2-2
Ammonium Alginate*	Per PMS 6-8-1
Whiting	Per PMS 6-24-7, C6-24-6
Ferrite	Per
Talc	Per PMS C6-128-4
Sodium Alginate	Per PMS 6-8-4
Zinc Oxide (#42 green label)	Per PMS 6-94-91
Tetra sodium pyrophosphate	Per PMS 6-177-4
Tributyl Phosphate	Per PMS 6-98-4
SG-61	Per PMS 6-151-6

Ammnium pentaborate Technical grade povdered, per PMS 6-74-2.
Neutralizer 5050 - from Magnus, Mabee and Reynard, Inc.

* Hagersville Only may use Protan Alginate 512 or Marex.

MANUFACTURING PROCEDURE

Weigh all materials accurately. Maximum permissible weight departure is 3% of the amount specified. Mix in a Broughton mixer, spraying the mixed liquids after mixing of the powders has started. Continue mixing for a minimum of 10 minutes after the liquids have been sprayed into the batch.

After mixing is complete, pass the batch through a Mikropulverizer using a coarse (3/32" slot width) screen. It is then ready for packing.

C Indicates Change

OP007 1365

Originally Issued 2-1-70 · SPECIAL BULLETIN 1st Extension

Operating Division	PERF-A-TAPE TOPPING COMPOUND (JF-394D)	No. 61-2-23-6-E Date 6-2-70 Page 1
PRODUCT PROCEDURE Approved:		Cancels Page 1 Dated 2-17-70

This bulletin expires 9-1-70.

DESCRIPTION

A topping compound with superior mixing properties, lower shrinkage, and good bond when used directly over metal bead.

MANUFACTURING PLANT

C Gypsum and Midway

IDENTIFICATION AND PACKAGING

Package "WC" PERF-A-TAPE Topping Compound in 32 lb. bags per Bulletin 7-16-13-7.

Shipment restricted to Drywall Interiors and Fox Valley Drywall. Plant to put customer's name on bag. Shipments to other customers only on approval of Dept. #971.

Coding

Regular code to be followed by letters "WC".

MP007 2053

D Indicates Deletion
C Indicates Change

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved:	**CONFIDENTIAL** **DO NOT REPRODUCE OR COPY** PERF-A-TAPE TOPPING COMPOUND - (JF394D)	No. 61-2-23-[illegible] Date 6-2-70 Page 3 Cancels Page 3 Dated 3-3-69

FORMULA	JF-394D
Casein, FG Unoiled	3.5
Natrosol SG-61	0.8
Zinc Oxide	0.1
Ammonium Oxalate	0.8
Ammonium Pentaborate	1.2
Dicyandiamide	0.3
Hydrated Lime	(As Req'd)
P-85 Mica	Formula V
JM 7RF02	About 4.0% (As Req'd)
TSPP	0.1
Carbonate Filler (#9NCS)	To make 100%
Ferrite Yellow	0.1 approx.

RAW MATERIALS

Per 61-2-23-6 except Natrosol SG-61 per PMS 6-151-6.

END

1502 20007

D Indicates Deletion

CONFIDENTIAL
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PERF-A-TAPE TOPPING COMPOUND

FORMULAS

	JF-418C New Brighton	JF 254 Montreal Hagersville	JF 364 Dallas	JF 200 South Gate	JF 185 Chamblee Gypsum New Brighton
Casein	2.5	3.75	4.0	3.0	2.5
Soy Protein	3.0	-	-	2.5	2.25
Ammonium Alginate (Note 6)	0.8	0.8	-	0.8	0.8
Hydrated Lime	As Req.	As Req.	As Req.	As Req.	As Req.
Ammonium Oxalate (Note 7)	1.0	1.0	0.9	1.0	1.0
Sodium Pentachlorophenate	-	-	-	0.2	-
Ammonium Pentaborate	1.2	1.2	1.2	-	1.2
Dicyandiamide	0.3	1.0	0.3	0.3	0.3
Mica J.C.	Formula V	0.6 Formula V	-	Formula V	-
Mica P-85 (Dallas use P-80F)	-	-	0.8 Formula V	-	0.6 Formula V
SG-61			0.65		
Zinc Oxide (#42 green label)			0.20		
Tetra sodium pyrophosphate (Fine ground)			0.10		
Asbestos - (Note 1)	As Req.	As Req.	As Req.	As Req.	As Req.
Mica Sericite - (Note 2)	15.0	-	-	15.0	15.0
Whiting - (Note 5)	-	15.0	-	-	-
Talc	-	15.0	-	-	-
PPG-1200 (Note 3)	0.150	0.150	-	0.150	0.150
Neutralizer 5050 - (Note 3)	0.003	0.003	-	0.003	0.003
Carbonate Filler - (Note 4)	To Make 100%	To make 100%	To make 100%	To Make 100%	To Make 100%
Pigments	Pigment with Ferrite Yellow and Other Lime Proof Colors as Required				

No.	61-[illegible]-23
Date	8-6-70
Page	4
Cancels	Page 4
Dated	7-10-70

CONFIDENTIAL

DO NOT REPRODUCE OR COPY

PERF-A-TAPE TOPPING COMPOUND

FORMULA NOTES

Note 1 - Asbestos used shall be as follows:

JF-410C - JM 7RF02
JF 294 - Johns Manville 7RF02
JF 200 - Phillip Carey 7RF9
JF 185 - 2/3 Johns Manville 7RF02; 1/3 Phillip Carey 7RF9 (Chamblee Only)
JF 304 - 7RF02
JF 185 - JM7RF02 (Gypsum and New Brighton)

Note 2 - Sericite Mica used shall be as follows:

Gypsum and New Brighton - Ser-X or Narvon CE-F-1
Chamblee - DXW Mineralite in white Topping; Ser-X or CE-F-1 in pigmented Topping
South Gate - M350 Sericite

Note 3 - Chamblee to replace .050 of PPG-1200 with .050 of Tributyl Phosphate. The PPG-1200 and neutralizer 5050 should be mixed together before adding to the other ingredients. In cold weather, this mixture may be thinned with a little isopropyl alcohol if necessary to facilitate its uniform dispersion among the powder ingredients. This mixture is to be sprayed into the other ingredients while they are being mixed in a Broughton mixer. If spray equipment is not used to add the liquid mix to the dry powders in the mixer, the tributyl phosphate must be increased to .1% (total liquid mix .203%) and the liquid mix dribbled slowly into the powder in the mixer.

Note 4 - Carbonate Fillers:

JF 294 - Bulletin 58-2-2, page 2 of 5, A or AA or PMS 6-24-2 or 6-24-17
JF 185 - PMS 6-24-9
JF 200 - PMS 6-24-1
JF 304 - #750-C Carbonate per PMS 6-24-9 or Carbonate-92 per PMS 6-24-20
JF 410C - 30.0% Range #4 per PMS 6-24-9; A Dolomite per Bulletin 58-2-2 or #325 Mineral Filler per PMS 6-24-17 to make 100%.
Exception: Harersville may use Pulpro White #1 and Montreal may use Stonelite or Pulpro White #1 in place of A Dolomite. Stonelite per PMS 6-24-[illegible], Pulpro White #1 per PMS 06-24-10.

Note 5 - Whiting:

JF 294 per PMS 06-[illegible]

Note 6 - Gypsum, Montreal and New Brighton may substitute Cellatex AF/43 Alginate in place of Marex Alginate. South Gate to use Sodium Alginate instead of Ammonium Alginate. Harersville may use Marex or Protan Alginate 512 in place of Marex Alginate.

Note 7 - Chamblee Only, to use 1.1% Ammonium Oxalate.

C Indicates Change

GP007 1362

Operating Division PRODUCT PROCEDURE Approved:	PERF-A-TAPE TOPPING COMPOUND (JF-582)	No. 61-2-23-6 Date 12-28-70 Page 1 Cancels Page 1 Dated 6-2-70

DESCRIPTION

A topping compound for PERF-A-TAPE with superior mixing properties (with much less tendency to over-dilute in cold water), lower shrinkage, and generally equal bond strength to Dual-Purpose Compounds, when used over metal bead or trim.

MANUFACTURING PLANTS

Chamblee, Gypsum and Midway

IDENTIFICATION AND PACKAGING

25 lb. P-A-T Topping Compound bag; layout 7-16-13-2 (2/MIL P.E. VP Barrier).

Under the code there should be a statement to the effect that "THIS PRODUCT MAY BE USED DIRECT OVER USG METAL BEAD".

Shipping Instructions

C To be shipped on all orders for ES topping compound.

Shipments to Florida are to be made only with approval of Department 981.

C Gypsum - On any order for "ES" Topping Compound, the following formula must be shipped.

C Bags of pigmented "ES" topping for Fleming Materials are to be identified by printing the word "pigmented" over the code number.

D Chamblee - Authority to ship for field trials and subsequent shipments per direction of #981 - Prod, Mgr. for Southern Construction Products Division.

CODING

C Regular code to be followed by letters "ES" for all shipments, depending on what is ordered.

NP007 2035

No. 61-2-23-6 Date 12-28-70 Page 2	PERF-A-TAPE TOPPING COMPOUND
Cancels Page 2 Dated 3-3-69	(JF-582)

FINISHED PRODUCT SPECIFICATIONS

Color

A Chamblee only:

Unpigmented (natural white) topping compound to be shipped when sales orders so specify - identify with word "white" printed over or under the code number. Otherwise all topping compound to be tinted to approximately match SHEETROCK manila color.

A Gypsum and Midway:

Unpigmented (natural) topping compound to be shipped on all sales orders unless it specifies pigmented. See Note 1.

Note 1: Unpigmented material may be pigmented on special order with minimum (5) five day lead time in 3000 lb. batch increments subject to approval of Division Product Manager.

Viscosity

430-630 BB units on VC-3 at 77°F.

Consistency

Consistency to be 64 cc per 100 gms.

pH

8.1 to 8.5 (8.3 normal).

- 0 -

DPC07 2011

Operating Division PRODUCT PROCEDURE Approved:	CONFIDENTIAL PERF-A-TAPE TOPPING COMPOUND (JF-582)	No. 61-2-23-6 Date 10-6-71 Page 3 Cancels Page 3 Dated 9-24-71

FORMULA — JF-582

Casein, FG unoiled	3.5
Natrosol SG-68 (Note 2)	0.8
Zinc Oxide	0.1
Ammonium Oxalate	0.8
Ammonium Pentaborate (Note 3)	1.2
Dicyandiamide (Note 3)	0.3
Hydrated Lime	(As Required)
P-85 Mica (Note 1)	Formula V
JF-7RF02	(As Required - About 4%)
TSPP	0.1
Carbonate Filler (#9NCS)	To make 100%
Ferrite Yellow*	0.1 Approx.

* Omit Ferrite Yellow on all orders for Dual Purpose Compound.

A Note 1: Dallas, New Brighton & Midway (per formula V) to use P80F Mica in place of P85 Mica.
Note 2: New Brighton to use Natrosol 250 HX.
Note 3: Chamblee to use 0.15% ZIRAM (95% Tech grade) in place of 1.2% Ammonium Pentaborate and 0.3% Dicyandiamide.

RAW MATERIALS

Per 61-2-23 and:

Natrosol SG-68	Per PMS 6-151-13
Ziram (95% Tech. Grade)	Per PMS 6-100-11
A P80F Mica	Per PMS 58-61-1

END

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A Indicates Addition

DP007 7003

Operating Division PRODUCT PROCEDURE Approved:	PERF-A-TAPE TOPPING COMPOUND (JF-582)	No. 61-2-23-6 Date 3-9-71 Page 1 Cancels Page 1 Dated 12-28-70

DESCRIPTION

A topping compound for PERF-A-TAPE with superior mixing properties (with much less tendency to over-dilute in cold water), lower shrinkage, and generally equal bond strength to Dual-Purpose Compounds, when used over metal bead or trim.

MANUFACTURING PLANTS

C Chamblee, Dallas, Gypsum and Midway

IDENTIFICATION AND PACKAGING

25 lb. P-A-T Topping Compound bag; layout 7-16-13-2 (2/MIL P.E. VP Barrier).

Under the code there should be a statement to the effect that "THIS PRODUCT MAY BE USED DIRECT OVER USG METAL BEAD".

Shipping Instructions

To be shipped on all orders for ES topping compound.

Shipments to Florida are to be made only with approval of Department 981.

Gypsum - On any order for "ES" Topping Compound, the following formula must be shipped.

Bags of pigmented "ES" topping for Fleming Materials are to be identified by printing the word "pigmented" over the code number.

D

CODING

Regular code to be followed by letters "ES" for all shipments, depending on what is ordered.

OP007 2004

Operating Division PRODUCT PROCEDURE Approved:	CONFIDENTIAL DO NOT REPRODUCE OR COPY PERF-A-TAPE TOPPING COMPOUND (JF-582)	No. 61-2-23-6 Date 3-9-71 Page 3 Cancels Page 3 Dated 3-3-69

FORMULA JF-582

	Casein, FG unoiled	3.5
	Natrosol SG-68	0.6
	Zinc Oxide	0.1
	Ammonium Oxalate	0.8
	Ammonium Pentaborate	1.2
	Dicyandiamide	0.3
	Hydrated Lime	(As Required)
C	P-85 Mica (Note 1)	Formula V
	JF-7RF02	(As Required - About 4%)
	TSPP	0.1
	Carbonate Filler (#9NCS)	To make 100%
	Ferrite Yellow*	0.1 Approx.

* Omit Ferrite Yellow on all orders for Dual Purpose Compound.

A Note 1: Dallas to use P80F Mica in place of P85 Mica.

RAW MATERIALS

Per 61-2-23 and:

Natrosol SG-68 Per PMS 6-151-13

End

NP007 7015

Operating Division
PRODUCT PROCEDURE

Approved:

CONFIDENTIAL
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PERF-A-TAPE TOPPING COMPOUND

No. 61-2-23
Date 3-9-71
Page 3

Cancels Page 3
Dated 8-6-70

FORMULAS

	JF-418C New Brighton	JF 254 Montreal Hagersville		JF 200 South Gate	JF 185 Chamblee Gypsum New Brighton
Casein	2.5	3.75		3.0	2.5
Soy Protein	3.0	-		2.5	2.25
Ammonium Alginate (Note 6)	0.8	0.8		0.8	0.8
Hydrated Lime	As Req.	As Req.		As Req.	As Req.
Ammonium Oxalate (Note 7)	1.0	1.0		1.0	1.0
Sodium Pentachlorophenate	-	-		0.2	-
Ammonium Pentaborate	1.2	1.2		-	1.2
Dicyandiamide	0.3	1.0		0.3	0.3
Mica J.C.	Formula V	0.6 Formula V		Formula V	-
Mica P-85 (Dallas use P-80F)	-	-		-	0.6 Formula V
SG-61					
Zinc Oxide (#42 green label)					
Tetra sodium pyrophosphate (Fine ground)					
Asbestos - (Note 1)	As Req.	As Req.		As Req.	As Req.
Mica Sericite - (Note 2)	15.0	-		15.0	15.0
Whiting - (Note 5)	-	15.0		-	-
Talc	-	15.0		-	-
PPG-1200 (Note 1)	0.150	0.150		0.150	0.150
Neutralizer 5050 - (Note 3)	0.003	0.003		0.003	0.003
Carbonate Filler - (Note 4)	To Make 100%	To make 100%		To Make 100%	To Make 100%
Pigments	Pigment with Ferrite Yellow and Other Line Proof Colors as Required				

D

D Indicates Deletion

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Date	3-9-71
Page	4
Cancels	Page 4
Dated	8-6-70

CONFIDENTIAL

DO NOT REPRODUCE OR COPY

PERF-A-TAPE TOPPING COMPOUND

FORMULA NOTES

Note 1 - Asbestos used shall be as follows:

JF-418C - JM 7RF02
JF 254 - Johns Manville 7RF02
JF 200 - Phillip Carey 7RF9
JF 185 - 2/3 Johns Manville 7RF02; 1/3 Phillip Carey 7RF9 (Chamblee Only)
D JF 185 - JM7RF02 (Gypsum and New Brighton)

Note 2 - Sericite Mica used shall be as follows:

Gypsum and New Brighton - Ser-X or Marvon CE-F-1
Chamblee - DXW Mineralite in white Topping; Ser-X or CE-F-1 in pigmented Topping
South Gate - M350 Sericite

Note 3 - Chamblee to replace .050 of PPG-1200 with .050 of Tributyl Phosphate. The PPG-1200 and neutralizer 5050 should be mixed together before adding to the other ingredients. In cold weather, this mixture may be thinned with a little isopropyl alcohol if necessary to facilitate its uniform dispersion among the powder ingredients. This mixture is to be sprayed into the other ingredients while they are being mixed in a Broughton mixer. If spray equipment is not used to add the liquid mix to the dry powders in the mixer, the tributyl phosphate must be increased to .1% (total liquid mix .203%) and the liquid mix dribbled slowly into the powder in the mixer.

Note 4 - Carbonate Fillers:

JF 254 - Bulletin 58-2-2, page 2 of 5, A or AA or PMS 6-24-2 or 6-24-17
JF 185 - PMS 6-24-9
JF 200 - PMS 6-24-1
D JF 418C - 30.0% Rambo #4 per PMS 6-24-9; A Dolomite per Bulletin 58-2-2 or #325 Mineral Filler per PMS 6-24-17 to make 100%.
Exception: Hagersville may use Pulpro White #1 and Montreal may use Stonelite or Pulpro White #1 in place of A Dolomite. Stonelite per PMS 6-24-2, Pulpro White #1 per PMS C6-24-18.

Note 5 - Whiting:

JF 254 per PMS C6-24-6

Note 6 - Gypsum, Montreal and New Brighton may substitute Collatex AS/KK Alginate in place of Marex Alginate. South Gate to use Sodium Alginate instead of Ammonium Alginate. Hagersville may use Marex or Protan Alginate 512 in place of Marex Alginate.

Note 7 - Chamblee Only, to use 1.1% Ammonium Oxalate.

C-5791-C (Back)

D Indicates Deletion

UP007 1359

J-157-F Banned

REQUEST FOR NEW OR REVISED OPERATING BULLETIN

MAIL TO 128-8 (3 COPIES)

EXCEPTION: Plants to mail to Manufacturing or Production Mgr.

BULLETIN NO. 61-2-23-4
61-2-23-6

DATE REQUESTED 1-12-72

SUBJECT: PERF-A-TAPE Joint Compound - Topping

PLANTS CONCERNED: Gypsum, Midway, Dallas

DETAILS AND OBJECT OF PROPOSED PRACTICE: (WHAT IS WANTED? LIST MAJOR CHANGES. WHY WANTED? WHAT IS EFFECT ON QUALITY?)

Please make the following changes:

Bulletin 61-2-23-4 page 1 of 2 Under Formula
delete ammonium pentaborate 1.2% and dicyandiamide 0.3%
add Zirex 0.15%
change Mica JC to read 0.8 x formula V
delete P-85 Mica
delete both JM7KF1 and PC7KF9 asbestos.
Add JM8KF02 asbestos - approx 9.0%

Bulletin 61-2-23-6 page 3 of 3 Under Formula
delete ammonium pentaborate 1.2% and dicyandiamide 0.3%
add Zirex 0.15%
change P-85 Mica to read Mica JC - per formula V
Omit Note 1 and Note 3 since these changes are now incorporated in the product. These changes will update bulletin to current plant practice and simplify plant raw material inventory. Cost savings of approximately $0.15 per cwt.

No adverse effect on quality.

WHAT IS EFFECT ON PLANT COSTS?

SOURCE OF INFORMATION

		PERSON	DEPT.	DATE
COST OF STANDARD AUTHORIZED PRODUCT	COST OF PROPOSED	W.S.A.	151	1-12-72
SELLING PRICE (STANDARD)	(PROPOSED)			
SALES VOLUME				

EQUIPMENT CHANGES AND CAPACITIES: None — DOLLAR VALUE

RAW MATERIALS, CONTAINERS, LABELS OR TAPES MADE OBSOLETE *: Use up stocks of existing raw materials before making changes. — DOLLAR VALUE

FINISHED PRODUCTS MADE OBSOLETE OR REQUIRING SPECIAL DISPOSITION ACTION: None — DOLLAR VALUE

INSTRUCTIONS: - - - - - - - - - - - - - - INCOMPLETE REQUESTS WILL BE RETURNED

All information requested is required to obtain approval. Mark "Not Applicable" where required. Use back of this sheet or additional sheets if necessary. Attach laboratory test reports, field trip reports, and copies of pertinent correspondence. Supplement request with exact bulletin wording and location for proposed revision. See Bulletin 1-1 for additional instructions.

*PLANTS WILL USE UP PRESENT STOCKS OF CONTAINERS, LABELS AND TAPES UNLESS REVISED BULLETIN INDICATES OTHERWISE.

PLEASE APPROVE BULLETIN HERE. SEE BULLETIN 1-2

DEPT.	NAME	INITIALS	DATE SIGNED
128-8			

HAVE THE CORRESPONDING CHANGES IN OTHER COMPANY BULLETINS AND MANUALS BEEN REQUESTED?

No.

REQUEST PREPARED BY W.S. Anderson

OF (DEPT. or PLANT) #151 Research

D-9562 REV. 7/71 (PRINTED IN U.S.A.)

Operating Division PRODUCT PROCEDURE Approved:	CONFIDENTIAL PERF-A-TAPE JOINT COMPOUND - TOPPING (JF448D) - SOUTH GATE	No. 61-2-23-T Date 2-28-72 Page 3 Cancels Page 3 Dated 4-30-71

FORMULA	JF448D
Casein, fine grind unciled	4.0%
SG-61*	.8
Ziram	0.15
Ammonium oxalate	0.50%
Tetra sodium pyrophosphate	.1
Zinc oxide	.2
UC-210 Asbestos	1.4%
Johns-Manville 7RF02 Asbestos as req'd for st'd consistency	(3% in lab. batches)
WMC P-85 Mica	0.8 formula V value (about 14%)
Marble White 325	To Make 100%
Pigment	As Required

C
D

* Summer formula to use SG 67.

RAW MATERIALS

Per Bulletin 61-2-23 with the addition of SG-61 or SG-67 per PMS 6-151-6.
UC-210 Asbestos — Per PMS 6-14-11

MANUFACTURING PROCEDURE

Per Bulletin 61-2-23. Note - No liquid mix is used in JF448D.

END

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TP007 2031

Operating Division PRODUCT PROCEDURE Approved:	CONFIDENTIAL PERF-A-TAPE TOPPING COMPOUND (JF-582)	No. 61-2-23-6 Date 3-9-72 Page 1 Cancels Page 1 Dated 3-30-71

DESCRIPTION

A topping compound for PERF-A-TAPE with superior mixing properties (with much less tendency to over-dilute in cold water), lower shrinkage, and generally equal bond strength to Dual-Purpose Compounds, when used over metal bead or trim.

MANUFACTURING PLANTS

C Chamblee, Dallas, Gypsum, and Midway.

IDENTIFICATION AND PACKAGING

25 lb. P-A-T Topping Compound bag; layout 7-16-13-2 (2/MIL P.E. VP Barrier).

Under the code there should be a statement to the effect that "THIS PRODUCT MAY BE USED DIRECT OVER USG METAL BEAD".

Shipping Instructions

To be shipped on all orders for ES topping compound.

Shipments to Florida are to be made only with approval of Department 981.

Gypsum - On any order for "ES" Topping Compound, the following formula must be shipped.

Bags of pigmented "ES" topping for Fleming Materials are to be identified by printing the word "pigmented" over the code number.

Chamblee - Authority to ship for field trials and subsequent shipments per direction of #981 - Product Mgr. for Southern Construction Products Division.

CODING

Regular code to be followed by letters "ES" for all shipments, depending on what is ordered.

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TP007 1997

Operating Division PRODUCT PROCEDURE Approved:	CONFIDENTIAL PERF-A-TAPE TOPPING COMPOUND (JF-582)	No. 61-2-23-6 Date 3-9-72 Page 3 Cancels Page 3 Dated 10-6-71

FORMULA JF-582

	Casein, FG unoiled	3.5
C	Natrosol SG-68	0.8
	Zinc Oxide	0.1
	Ammonium Oxalate	0.8
	Ammonium Pentaborate (Note 3)	1.2
	Dicyandiamide (Note 3)	0.3
	Hydrated Lime	(As Required)
	P-85 Mica (Note 1)	Formula V
	JF-TRF02	(As Required - About 4%)
	TSPP	0.1
	Carbonate Filler (#9ECS)	To make 100%
	Ferrite Yellow*	0.1 Approx.

* Omit Ferrite Yellow on all orders for Dual Purpose Compound.

C Note 1: Dallas, & Midway (per formula V) to use P80F Mica in place of P85 Mica.

D Note 3: Chamblee to use 0.15% ZIRAM (95% Tech grade) in place of 1.2% Ammonium Pentaborate and 0.3% Dicyandiamide.

RAW MATERIALS

Per 61-2-23 and:

Natrosol SG-68	Per PMS 6-151-13
Ziram (95% Tech. Grade)	Per PMS 6-100-11
P80F Mica	Per PMS 58-61-1

END

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Operating Division PRODUCT PROCEDURE Approved:	CONFIDENTIAL PERF-A-TAPE TOPPING COMPOUND (JF-582)	No. 61-2-23-6 Date 7-7-72 Page 3 Cancels Page 3 Dated 3-9-72

	FORMULA	JF-582
	Casein, FG unoiled	3.5
	Natrosol SG-68	0.8
	Zinc Oxide	0.1
	Ammonium Oxalate	0.8
	Ammonium Pentaborate (Note 3)	1.2
	Dicyandiamide (Note 3)	0.3
	Hydrated Lime	(As Required)
	P-85 Mica (Note 1)	Formula V
	JF-TRF02	(As Required - About 4%)
	TSPP	0.1
C	Carbonate Filler (#9NCS) (Note 4)	To make 100%
	Ferrite Yellow*	0.1 Approx.

* Omit Ferrite Yellow on all orders for Dual Purpose Compound.

Note 1: Dallas, & Midway (per formula V) to use P80F Mica in place of P85 Mica.

Note 3: Chamblee to use 0.15% ZIRAM (95% Tech grade) in place of 1.2% Ammonium Pentaborate and 0.3% Dicyandiamide.

A Note 4: Midway to use Quincy #3.

RAW MATERIALS

Per 61-2-23 and:

Natrosol SG-68	Per PMS 6-151-13
Ziram (95% Tech. Grade)	Per PMS 6-100-11
P80F Mica	Per PMS 58-61-1
A Quincy #3	Per PMS 6-24-22

END

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HP007 1976

Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** PERF-A-TAPE TOPPING COMPOUND (JP-582)	No. 61-2-23-6 Date 5-10-73 Page 1 Cancels Page 1 Dated 3-9-72

DESCRIPTION

A topping compound for PERF-A-TAPE with superior mixing properties (with much less tendency to over-dilute in cold water), lower shrinkage, and generally equal bond strength to Dual-Purpose Compounds, when used over metal bead or trim.

MANUFACTURING PLANT

C Midway

IDENTIFICATION AND PACKAGING

C 25 lb. P-A-T Topping Compound bag; layout 7-16-13-2.

Under the code there should be a statement to the effect that "THIS PRODUCT MAY BE USED DIRECT OVER USG METAL BEAD".

Shipping Instructions

D To be shipped on all orders for EB topping compound.

D Bags of pigmented "EB" topping for Flexmag Materials are to be identified by printing the word "pigmented" over the code number.

D

CODING

Regular code to be followed by letters "EB" for all shipments, depending on what is ordered.

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JP007 993

Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** PERF-A-TAPE TOPPING COMPOUND (JP-582)	No. 61-2-23-6 Date 5-10-73 Page 2 Cancels Page 2 Dated 12-28-70

FINISHED PRODUCT SPECIFICATIONS

D
D

Color

Unpigmented (natural) topping compound to be shipped on all sales orders unless it specifies pigmented. See Note 1.

Note 1: Unpigmented material may be pigmented on special order with minimum (5) five day lead time in 3000 lb. batch increments subject to approval of Division Product Manager.

Viscosity

430-630 BB units on VC-3 at 77°F.

Consistency

Consistency to be 64 cc per 100 gms.

pH

8.1 to 8.5 (8.3 normal).

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Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** PERF-A-TAPE TOPPING COMPOUND (JF-582)	No. 61-2-23-6 Date 5-10-73 Page 3 Cancels Page 3 Dated 7-7-72

	FORMULA	JF-582
	Casein, FG uncoiled	3.5
	Natrosol SG-68	0.8
	Zinc Oxide	0.1
	Ammonium Oxalate	0.8
C	Ammonium Pentaborate	1.2
C	Dicyandiamide	0.3
	Hydrated Lime	(As Required)
C	P-80F Mica	Formula V
	JF-7RF02	(As Required - About 4%)
	TSPP	0.1
C	Carbonate Filler (Quincy #3)	To make 100%
	Ferrite Yellow*	0.1 Approx.

D * Omit Ferrite Yellow on all orders for Dual Purpose Compound.

D

D RAW MATERIALS

D

D	Natrosol SG-68	Per PMS 6-151-13
	P80F Mica	Per PMS 58-61-1
	Quincy #3	Per PMS 6-24-22

END

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DP007 1915

Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** PERF-A-TAPE TOPPING COMPOUND (JF-582)	No. 61-2-23-6 Date 5-22-73 Page 3 Cancels Page 3 Dated 5-10-73

	FORMULA	JF-582
	Casein, FG uncoiled	3.5
	Natrosol SG-68	0.8
	Zinc Oxide	0.1
	Ammonium Oxalate	0.8
	Ammonium Pentaborate	1.2
	Dicyandiamide	0.3
	Hydrated Lime	(As Required)
	P-80F Mica	Formula V
C	TRF66	(As Required - About 4%)
	TSPP	0.1
	Carbonate Filler (Quincy #3)	To make 100%
	Ferrite Yellow*	0.1 Approx.

A Midway to use Azite 900.

* Omit Ferrite Yellow on all orders for Dual Purpose Compound.

RAW MATERIALS

	Natrosol SG-68	Per PMS 6-151-13
	P80F Mica	Per PMS 58-61-1
	Quincy #3	Per PMS 6-24-22
A	Azite 900	Per PMS 6-44-1

END

TP007 1977

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