

KAISER GYPSUM COMPANY INC.

INTER-OFFICE MEMORANDUM

TO C. E. Caprye - Seattle
R. L. Muhr - Antioch ✓

DATE April 8, 1975

COPIES TO G. B. Kirk
E. H. Schaper

FROM T. V. Smith
AT Antioch E & D

SUBJECT PREMIX DUAL PURPOSE NON-ASBESTOS

Work Order #696-314

We recommend producing one batch of Non-Asbestos Premix Dual Purpose on the attached test batch Bulletin.

We have found the use of Cellosize QP4400H to be critical to this material in obtaining proper water levels and workability.

Min-U-Gel FG replaces Attagel 40 at a lower cost. Since the Min-U-Gel FG is not stocked on the west coast, Attagel 40 can be used in these test batches.

Please send us a 5 lb. sample from the batch for our full product specification testing prior to release to Sales for the field evaluations.

TVS/sc
Attachment

*Copy to: Kelly
LoRy*

KG-0085

PRODUCT BULLETIN DRYWALL ACCESSORY PRODUCTS		PREMIA JOINT COMPOUND DUAL-PURPOSE (NON-ASBESTOS)		BULLETIN NO. J-2700 DATE: 4-8-75 PAGE: 1 of 2																
APPROVALS:		PRODUCING PLANT: ANTIOCH		XXXXXX TEST BATCH DATE:																
BULLETIN	DESCRIPTION		%	POUNDS	GALLONS															
165	Ground Raw Gypsum		47.07	2800																
489	Wollastonite P-1		3.36	200																
251	Mica AMC		2.52	150																
247	Mica S		2.52	150																
052	Min-U-Gel FG (Floridin Co.)		2.52	150																
442	Talc		1.68	100																
245	Cellosize CP-4400-H		0.34	20																
200	Keltose		0.13	8																
453	Preservative - Dowicil 75		0.13	8																
470	PVAc Emulsion (5.81% on solids)		6.19	368	40															
457	Nopco NXZ (defoamer)		0.30	18																
	Water - start		30.43	1810	217															
	Water - adjust to std. viscosity		2.81	167	20															
	TOTAL		100.00	5949																
<u>MANUFACTURING INSTRUCTIONS:</u> 1. See Process Bulletin J-2. 2. Dry blend all powder materials 8 minutes. 3. For PMG add 4 lbs. Yellow Oxide per batch (Bulletin RM-J-190). 4. For summer conditions add 8 gallons Ethylene Glycol per batch. <u>QUALITY CONTROL:</u> <table> <tr> <td>TM-1</td> <td>Viscosity, Vicat, 150 gm cyl @ 5 sec.</td> <td>20 - 23 mm</td> </tr> <tr> <td>TM-1A</td> <td>Viscosity, Brookfield, cps</td> <td>350,000-400,000</td> </tr> <tr> <td>TM-3</td> <td>Tape Bond</td> <td>9 - 10</td> </tr> <tr> <td>TM-6</td> <td>Application</td> <td>No lumps</td> </tr> <tr> <td>TM-7</td> <td>Workability</td> <td>Equal to Standard</td> </tr> </table>						TM-1	Viscosity, Vicat, 150 gm cyl @ 5 sec.	20 - 23 mm	TM-1A	Viscosity, Brookfield, cps	350,000-400,000	TM-3	Tape Bond	9 - 10	TM-6	Application	No lumps	TM-7	Workability	Equal to Standard
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TEST RESULTS

DUAL PURPOSE
(NON-ASBESTOS)

DA

NON-ASB. PREMIX 5.0 CONTAINING

Bulletin No.: _____ Date of Issue: _____ Producing Plant: DUAL-PURPOSE.

TEST METHOD	SPECIFICATION	RAW GYP 8150C. LHB 3-14-1 (75)
TM-1. Viscosity, Vicat, 150 gm cyl, 5 sec.		At mixer 23 mm In Lab 19 mm
TM-1A. Viscosity, Brookfield, cps. Letdown, cc/500 gm paste. Letdown Viscosity, cps.	190 - 210 M	At mixer 350 M In Lab 420 M 15 cc/500 gm.
TM-2. pH, Beckman Meter.	7.5 - 9.0	8.5
TM-3. Tape Bond, 65-80°F, 40-70% RH. Tape Bond, 42-48°F, 50-90% RH. After recovery at room temp. Tape Bond, refrigerator, low RH. After recovery at room temp.	9 - 10	10 2-3 7-8 0-1 2-3
TM-5. Open Time, 65-80°F, minutes. Open Time, 100-120°F, minutes.	15 minimum 4 minimum	17 minutes —
TM-6. Application.	No lumps	No lumps
TM-7. Workability, hand or Ames tools.	Equal to Standard	Equal to std.
TM-10. Edge Cracking, 100-120°F.	None 0.05%	None
TM-12. Grit, total.	All passing 20 Mesh	Passes
TM-11. Voids.	Equal to Standard	9-10
TM-18. Water Resistance, drop, minutes.	3 minimum	15 minutes
TM-9. Shrinkage (cup method), %.	26% maximum	23.3%
Density, gm/cc.		1.50 (12.3 sec)
Net wet wt., gm.		25.7 gm
Wet volume, cc.		17.3 cc
Net dry wt., gm.		16.3 gm
Dry volume, cc.		13.3 cc (4 sec. dry)
Percent Solids (on letdown mix).		63.0%
Percent Solids, as manufactured.		—
Viscosity) Mold resistance) after _____ days in Liquid separation) oven @ 100-120°F.		

Comments & Additional Data: _____

REVIEWED: _____

TESTED BY: M. H. M. G. G.

DATE: _____

DATE: April 3 1975