October 29, 1968
NEW FORMULA

PLAINTIFF'S EXHIBIT
GP-461

ACME, TEXAS PLANT FORMULA

READY MIX JOINT COMPOUND TEX-977 (HAND TOOLS) (READY MIX "X")

DESCRIPTION OF PRODUCT - White
Ready Mixed Joint Compound used for taping, covering tape, filling cornerhead and spotting nails.

FORMULA

Raw Material	Source	R.M. Spec.	% Act. Ingr.	Lbs./Batch
Water	Solvent	-	-	400.00 (48 gal.)* 114.28
Filler TEX-970	Body	-	91.5	700.0 200.0
Ucar WC-130	Adhesive	185	8.00	58.3 16.57
Benzoflex 50	Plasticizer	183	0.50	4 0 1.14
			100.00	1162.3**

*Approximately 52 lb./100 lbs. of active ingredients (this may vary ± 2 gallons per batch.)

**One batch yields 17(+)- 5 gallon pails of Ready Mix Joint Compound at 65.6 lbs./pail.

TESTING PROCEDURE

Working Consistency - Refer to Plant Testing Procedure No. 32.

Specifications for Paste: If paste is not proper working consistency, a maximum of 5 c. c. water per 150 grams of paste may be added to adjust.

Barbender - 580 ± ~~20~~ 10

Working Properties - Refer to Plant Testing Procedure No. 33.

Compound shall be plastic, buttery working, and free of any coarse, gritty, or undispersed particles. Material shall be free from lumps due to incomplete mixing.

Bonding Properties - Refer to Plant Testing Procedure No. 35.

Specifications: After compound has dried, tape shall show at least 90% fiber tear when delaminated.

Crack Resistance - Refer to Plant Testing Procedure No. 37.

Specifications: There shall be no large fissure cracks in the wedge, and no cracks in the thinner half of the wedge.

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

RRB:kgc

July 6, 1972
TEX-977
NEW FORMULA

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-977 (MACHINE TOOLS)

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

FORMULA

Raw Material	Function	R.M. Spec	Percent	Lbs/Batch
Nalco 71-D5	Anti-foaming agent	-	0.1	~~5.00~~ 4.6
Water	Solvent	-	-	~~1110.00~~ (~~132~~ 120 gal)
Preplasticized PVA Emulsion	Adhesive	185	7.4	~~148.00~~ * 137.00
Filler TEX-978	-	-	92.5	~~1841.00~~ 1700
			100.00	3104.00

** One batch yields 51 ± one 5 gallon pail

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.
Specifications - If paste is not of proper working consistency, a maximum of 5 cc of water per 150 grams of paste may be added to adjust.
Brabender Viscosity - ~~385~~ 365 ± 20

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications - Compound shall be plastic, buttery working, and free of any coarse, gritty or undispersed particles. Materials should be free of lumps caused by incomplete mixing.

BONDING PROPERTIES - Refer to Plant Testing Procedure No. 35.
Specifications - After compound has dried, tape shall show at least 75% fiber tear when delaminated.

CRACK RESISTANCE -
Specifications There shall be no large fissure cracks in the wedge, and no cracks in the thinner half of the wedge.

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

EDO:elz

* 14 3/4 gal

SGP 0018029

For yellow ready mix add 1 lb 11-07 oxide

August 25, 1972
Supersedes: TEX-977 Dated 7/6/72

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-977 (MACHINE TOOLS)

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

FORMULA

-/ Raw Material	Function	R.M. Spec	Percent	Lbs/Batch
Nalco 71-D5	Anti-foaming agent	-	0.1	4.60
Water	Solvent	-	-	996.00 (120 gals)
Preplasticized PVA Emulsion	Adhesive	185	7.4	137.00 *
Filler TEX-978	-	-	92.5	1700.00
			100.00	2837.60

-/ ** One batch yields 45 ± one 5 gallon pail

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.
Specifications - If paste is not of proper working consistency, a maximum of 5 cc of water per 150 grams of paste may be added to adjust.
Brabender Viscosity - ~~385~~ 365 ± 20

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications - Compound shall be plastic, buttery working, and free of any coarse, gritty or undispersed particles. Materials should be free of lumps caused by incomplete mixing.

BONDING PROPERTIES - Refer to Plant Testing Procedure No. 35.
Specifications - After compound has dried, tape shall show at least 75% fiber tear when delaminated.

CRACK RESISTANCE -
Specifications There shall be no large fissure cracks in the wedge, and no cracks in the thinner half of the wedge.

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

EDO:elz

-/ denotes change

* 14 3/4 gal

For weather ready mix add 1 lb 11 oz oxide

April 12, 1973
Formula TEX-977
NEW

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX-977

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound TEX-972 and TEX-973.

FORMULA

Raw Material	Function	RM Spec	Percent	Lbs/Batch
Gendriv 492S	Thickener	223	.50	40.0
Dowicil 100	Fungicide	126	.15	12.0
Gelvatol 6000	Adhesive	126	1.60	128.0
Attagel 40	Fiber Filler	9	4.00	320.0
Mica p80-H	Anti-cracking agent	11	9.00	720.0
Land Plaster TEX-25	Filler		84.75	6780.0
			100.00	8000.0

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32

Specifications:	Maximum	Minimum	Average
	62	58	60

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33
Specifications - Filler shall be very heavily bodied and possess fair plasticity. It shall be free of any coarse gritty or undispersed particles.

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

NOTE: A wet mix of the filler shall be prepared according to Formula TEX-974 at least twice a day or with every sixth or seventh batch of filler manufactured. This prepared mix shall be tested and shall meet all the specifications required of Ready Mix Joint Compound - Formula No. TEX-971.

WNG:elz

March 8, 1974
NEW FORMULA TEX-977

ACME, TEXAS, PLANT FORMULA
READY MIX TOPPING COMPOUND NO. TEX-977

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

FORMULA	Function	RM Spec	Percent	Lbs/Batch
Nalco 71-D5	Antifoaming agent	--	0.1	2.00
Water	Solvent	--	--	929.60 (112 gal)
Preplasticized PVA Emulsion	Adhesive	185	6.0	111.00 (12.3 gal)
Filler TEX-973	--	--	93.9	1733.00
			100.00	2775.60

One batch yields 60 ± one 4-gallon carton or 45 ± one 5-gallon pail.

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

Brabender Viscosity - 560 ± 20

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications - Compound shall be plastic, buttery working, and free of any coarse, gritty or undispersed particles. Materials should be free of lumps caused by incomplete mixing.

BONDING PROPERTIES - Refer to Plant Testing Procedure No. 35.
Specifications - After compound has dried, tape shall show at least 75% fiber tear when delaminated.

CRACK RESISTANCE - Refer to Plant Testing Procedure No. 37.
There shall be no large fissure cracks in the wedge, and no cracks in the thinner half of the wedge.

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

WNG:elz

May 29, 1975
Supersedes: Formula TEX-977
Dated: 3/8/74

ACME, TEXAS, PLANT FORMULA
READY MIX TOPPING COMPOUND NO. TEX-977

-/ DESCRIPTION OF PRODUCT - White Ready Mix Topping Compound used for finishing, filling corner beads and spotting nailheads. To be used in 4-gallon cartons and 5-gallon pails.

FORMULA	Function	RM Spec	Percent	Lbs/Batch
Nalco 71-D5	Antifoaming agent	125	0.1	2.00
Water	Solvent	--	--	929.60 (112 gal)
Preplasticized PVA Emulsion	Adhesive	185	6.0	111.00 (12.3 gal)
Filler TEX-973	--	--	93.9	1733.00
			100.00	2775.60

One batch yields 60 ± one 4-gallon carton or 45 ± one 5-gallon pail.

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

Brabender Viscosity - 560 ± 20

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications - Compound shall be plastic, buttery working, and free of any coarse, gritty or undispersed particles. Materials should be free of lumps caused by incomplete mixing.

BONDING PROPERTIES - Refer to Plant Testing Procedure No. 35.
Specifications - After compound has dried, tape shall show at least 75% fiber tear when delaminated.

CRACK RESISTANCE - Refer to Plant Testing Procedure No. 37.
There shall be no large fissure cracks in the wedge, and no cracks in the thinner half of the wedge.

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

WNG:elz

-/ denotes change

September 20, 1977
Formula TEX-977
NEW

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-977 (HAND TOOLS)

DESCRIPTIONS OF PRODUCT - White Ready Mix Joint Compound used for taping, topping and texturing. To be used in 4 gallon cartons and 5 gallon pails. For selected market trials and shipment to Memphis only.

FORMULA

Raw Material	Function	RM Spec	Percent	Lbs/Batch
Dowacil	Preservative	193	.35	7.0
Filler TEX-976	Filler	--	94.35	1958.0
Elvace EP-200	Adhesive	185	5.00	100.0(11.73gals
Nalco 71D-5	Defoamer	125	.10	2.0
Acrysol ASE-60	Thickener	147	.20	4.0
Water	Solvent	--	--	847.0(102 gals
			100.00	2918.0

One batch yields 64 ± 1 four gallon carton or 52 ± 1 five gallon pail.

SPECIAL MIXING INSTRUCTIONS - Blend ingredients in following order:
1) Water
2) Elvace EP-200
3) Nalco
4) Filler TEX-976
5) Mix until filler is dispersed
6) Add Acrysol ASE-60
7) Mix until Ready Mix is smooth - pumping viscosity should be 480 ± 20 to allow for 24 hour viscosity build of 100 pts.

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

Brabender: (580 ± 20) For machine tools add 7 gallons H_2O (400 ± 20)

pH Minimum - 9.0 Maximum - 9.5

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33. Compound shall be plastic, buttery working and free of any coarse, gritty or undispersed particles. Material shall be free from lumps due to incomplete mixing.

Continued on Page 2 ...

HCF:jg

BONDING PROPERTIES Specifications	- Refer to Plant Testing Procedure No. 35. After compound has dried, tape shall show at least 90% fiber tear when delaminated.
CRACK RESISTANCE Specifications	- Refer to Plant Testing Procedure No. 37. Rating shall be 4 or better.
COLOR Specifications	- White Dried compound shall match color of standard sample.

HCF:jg

October 26, 1977
Supersedes Formula TEX-977
Dated 9/20/77

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-977 (HAND TOOLS)

DESCRIPTIONS OF PRODUCT - White Ready Mix Joint Compound used for taping, topping and texturing. To be used in 4 gallon cartons and 5 gallon pails. For selected market trials and shipment to Memphis only.

FORMULA

Raw Material	Function	RM Spec	Percent	Lbs/Batch
-/Proxcel CRL	Preservative	193	.115	2.23
Filler TEX-976	Filler	--	94.585	1962.77
Elvace EP-200	Adhesive	185	5.00	100.0(11.73gals)
Nalco 71D-5	Defoamer	125	.10	2.0
Acrysol ASE-60	Thickener	147	.20	4.0
Water	Solvent	--	--	847.0(102 gals)
			100.00	2918.0

One batch yields 64 ± 1 four gallon carton or 52 ± 1 five gallon pail.

SPECIAL MIXING INSTRUCTIONS - Blend ingredients in following order:
1) Water
2) Elvace EP-200
3) Nalco
4) Filler TEX-976
5) Mix until filler is dispersed
6) Add Acrysol ASE-60
7) Mix until Ready Mix is smooth - pumping viscosity should be 480 ± 20 to allow for 24 hour viscosity build of 100 pts.

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

Brabender: (580 ± 20) For machine tools add 7 gallons H_2O (400 ± 20)

pH Minimum - 9.0 Maximum - 9.5

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33. Compound shall be plastic, buttery working and free of any coarse, gritty or undispersed particles. Material shall be free from lumps due to incomplete mixing.

-/ denotes change

Continued on Page 2 ...

HCF:jg

October 29, 1968
NEW FORMULA

ACME, TEXAS PLANT FORMULA

READY MIX JOINT COMPOUND TEX-977 (HAND TOOLS) (READY MIX "X")

DESCRIPTION OF PRODUCT - White
Ready Mixed Joint Compound used for taping, covering tape, filling cornerhead and spotting nails.

FORMULA

Raw Material	Source	R.M. Spec.	% Act. Ingr.	Lbs./Batch
Water	Solvent	-	-	400.00 (48 gal.)* 114.2
Filler TEX-970	Body	-	91.5	700.0 200.0
Ucar WC-130	Adhesive	185	8.00	58.3 16.57
Benzoflex 50	Plasticizer	183	0.50	4.0 1.14
			100.00	1162.3**

*Approximately 52 lb./100 lbs. of active ingredients (this may vary ± 2 gallons per batch.)

**One batch yields 17(+)- 5 gallon pails of Ready Mix Joint Compound at 65.6 lbs./pail.

TESTING PROCEDURE

Working Consistency - Refer to Plant Testing Procedure No. 32.

Specifications for Paste: If paste is not proper working consistency, a maximum of 5 c. c. water per 150 grams of paste may be added to adjust.

Barbender - 580 ± ~~20~~ 10

Working Properties - Refer to Plant Testing Procedure No. 33.

Compound shall be plastic, buttery working, and free of any coarse, gritty, or undispersed particles. Material shall be free from lumps due to incomplete mixing.

Bonding Properties - Refer to Plant Testing Procedure No. 35.

Specifications: After compound has dried, tape shall show at least 90% fiber tear when delaminated.

Crack Resistance - Refer to Plant Testing Procedure No. 37.

Specifications: There shall be no large fissure cracks in the wedge, and no cracks in the thinner half of the wedge.

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

RRB:kgc

July 6, 1972
TEX-977
NEW FORMULA

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-977 (MACHINE TOOLS)

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

FORMULA

Raw Material	Function	R.M. Spec	Percent	Lbs/Batch	
Nalco 71-D5	Anti-foaming agent	-	0.1	~~5.00~~	4.6
Water	Solvent	-	-	~~1110.00~~	(~~132~~ 120 gal)
Preplasticized PVA Emulsion	Adhesive	185	7.4	~~148.00~~ *	137.00
Filler TEX-978	-	-	92.5	~~1841.00~~	1700
			100.00	3104.00	

** One batch yields 51 ± one 5 gallon pail

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

Brabender Viscosity - ~~385~~ 365 ± 20

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications - Compound shall be plastic, buttery working, and free of any coarse, gritty or undispersed particles. Materials should be free of lumps caused by incomplete mixing.

BONDING PROPERTIES - Refer to Plant Testing Procedure No. 35.
Specifications - After compound has dried, tape shall show at least 75% fiber tear when delaminated.

CRACK RESISTANCE -
Specifications There shall be no large fissure cracks in the wedge, and no cracks in the thinner half of the wedge.

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

EDO:elz

* 14 3/4 gal

SGP 0018038

For yellow ready mix add 1 lb 11 oz oxide

August 25, 1972
Supersedes: TEX-977 Dated 7/6/72

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-977 (MACHINE TOOLS)

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

FORMULA

-/ Raw Material	Function	R.M. Spec	Percent	Lbs/Batch
Nalco 71-D5	Anti-foaming agent	-	0.1	4.60
Water	Solvent	-	-	996.00 (120 gals)
Preplasticized PVA Emulsion	Adhesive	185	7.4	137.00 *
Filler TEX-978	-	-	92.5	1700.00
			100.00	2837.60

-/ ** One batch yields 45 ± one 5 gallon pail

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.
Specifications - If paste is not of proper working consistency, a maximum of 5 cc of water per 150 grams of paste may be added to adjust.
Brabender Viscosity - ~~385~~ 365 ± 20

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications - Compound shall be plastic, buttery working, and free of any coarse, gritty or undispersed particles. Materials should be free of lumps caused by incomplete mixing.

BONDING PROPERTIES - Refer to Plant Testing Procedure No. 35.
Specifications - After compound has dried, tape shall show at least 75% fiber tear when delaminated.

CRACK RESISTANCE -
Specifications There shall be no large fissure cracks in the wedge, and no cracks in the thinner half of the wedge.

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

EDO:elz

-/ denotes change

* 14 3/4 gal

SGP 0018039

April 12, 1973
Formula TEX-977
NEW

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX-977

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound TEX-972 and TEX-973.

FORMULA

Raw Material	Function	RM Spec	Percent	Lbs/Batch
Gendriv 492S	Thickener	223	.50	40.0
Dowicil 100	Fungicide	126	.15	12.0
Gelvatol 6000	Adhesive	126	1.60	128.0
Attagel 40	Fiber Filler	9	4.00	320.0
Mica p80-H	Anti-cracking agent	11	9.00	720.0
Land Plaster TEX-25	Filler		84.75	6780.0
			100.00	8000.0

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32

Specifications:	Maximum	Minimum	Average
	62	58	60

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33
Specifications - Filler shall be very heavily bodied and possess fair plasticity. It shall be free of any coarse gritty or undispersed particles.

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

NOTE: A wet mix of the filler shall be prepared according to Formula TEX-974 at least twice a day or with every sixth or seventh batch of filler manufactured. This prepared mix shall be tested and shall meet all the specifications required of Ready Mix Joint Compound - Formula No. TEX-971.

WNG:elz

March 8, 1974
NEW FORMULA TEX-977

ACME, TEXAS, PLANT FORMULA
READY MIX TOPPING COMPOUND NO. TEX-977

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

FORMULA	Function	RM Spec	Percent	Lbs/Batch
Nalco 71-D5	Antifoaming agent	--	0.1	2.00
Water	Solvent	--	--	929.60 (112 gal)
Preplasticized PVA Emulsion	Adhesive	185	6.0	111.00 (12.3 gal)
Filler TEX-973	--	--	93.9	1733.00
			00.00	2775.60

One batch yields 60 ± one 4-gallon carton or 45 ± one 5-gallon pail.

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

Brabender Viscosity - 560 ± 20

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications - Compound shall be plastic, buttery working, and free of any coarse, gritty or undispersed particles. Materials should be free of lumps caused by incomplete mixing.

BONDING PROPERTIES - Refer to Plant Testing Procedure No. 35.
Specifications - After compound has dried, tape shall show at least 75% fiber tear when delaminated.

CRACK RESISTANCE - Refer to Plant Testing Procedure No. 37.
There shall be no large fissure cracks in the wedge, and no cracks in the thinner half of the wedge.

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

WNG:elz

SGP 0018041

May 29, 1975
Supersedes: Formula TEX-977
Dated: 3/8/74

ACME, TEXAS, PLANT FORMULA
READY MIX TOPPING COMPOUND NO. TEX-977

-/ DESCRIPTION OF PRODUCT - White Ready Mix Topping Compound used for finishing, filling corner beads and spotting nailheads. To be used in 4-gallon cartons and 5-gallon pails.

FORMULA	Function	RM Spec	Percent	Lbs/Batch
Nalco 71-D5	Antifoaming agent	125	0.1	2.00
Water	Solvent	--	--	929.60 (112 gal)
Preplasticized PVA Emulsion	Adhesive	185	6.0	111.00 (12.3 gal)
Filler TEX-973	--	--	93.9	1733.00
			100.00	2775.60

One batch yields 60 ± one 4-gallon carton or 45 ± one 5-gallon pail.

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

Brabender Viscosity - 560 ± 20

WORKING PROPERTIES Specifications
- Refer to Plant Testing Procedure No. 33.
- Compound shall be plastic, buttery working, and free of any coarse, gritty or undispersed particles. Materials should be free of lumps caused by incomplete mixing.

BONDING PROPERTIES Specifications
- Refer to Plant Testing Procedure No. 35.
- After compound has dried, tape shall show at least 75% fiber tear when delaminated.

CRACK RESISTANCE
- Refer to Plant Testing Procedure No. 37. There shall be no large fissure cracks in the wedge, and no cracks in the thinner half of the wedge.

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

WNG:elz

-/ denotes change

September 20, 1977
Formula TEX-977
NEW

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-977 (HAND TOOLS)

DESCRIPTIONS OF PRODUCT - White Ready Mix Joint Compound used for taping, topping and texturing. To be used in 4 gallon cartons and 5 gallon pails. For selected market trials and shipment to Memphis only.

FORMULA

Raw Material	Function	RM Spec	Percent	Lbs/Batch
Dowacil	Preservative	193	.35	7.0
Filler TEX-976	Filler	--	94.35	1958.0
Elvace EP-200	Adhesive	185	5.00	100.0(11.73ga
Nalco 71D-5	Defoamer	125	.10	2.0
Acrysol ASE-60	Thickener	147	.20	4.0
Water	Solvent	--	--	847.0(102 ga
			100.00	2918.0

One batch yields 64 ± 1 four gallon carton or 52 ± 1 five gallon pail.

SPECIAL MIXING INSTRUCTIONS - Blend ingredients in following order:
1) Water
2) Elvace EP-200
3) Nalco
4) Filler TEX-976
5) Mix until filler is dispersed
6) Add Acrysol ASE-60
7) Mix until Ready Mix is smooth - pumping viscosity should be 480 ± 20 to allow for 24 hour viscosity build of 100 pts.

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

Brabender: (580 ± 20) For machine tools add 7 gallons H_2O (400 ± 20)

pH Minimum - 9.0 Maximum - 9.5

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33. Compound shall be plastic, buttery working and free of any coarse, gritty or undispersed particles. Material shall be free from lumps due to incomplete mixing.

Continued on Page 2 ...

HCF:jg

BONDING PROPERTIES Specifications	- Refer to Plant Testing Procedure No. 35. After compound has dried, tape shall show at least 90% fiber tear when delaminated.
CRACK RESISTANCE Specifications	- Refer to Plant Testing Procedure No. 37. Rating shall be 4 or better.
COLOR Specifications	- White Dried compound shall match color of standard sample.

HCF:jg

October 26, 1977
Supersedes Formula TEX-977
Dated 9/20/77

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-977 (HAND TOOLS)

DESCRIPTIONS OF PRODUCT - White Ready Mix Joint Compound used for taping, topping and texturing. To be used in 4 gallon cartons and 5 gallon pails. For selected market trials and shipment to Memphis only.

FORMULA

Raw Material	Function	RM Spec	Percent	Lbs/Batch
-/Proxcel CRL	Preservative	193	.115	2.23
Filler TEX-976	Filler	--	94.585	1962.77
Elvace EP-200	Adhesive	185	5.00	100.0(11.73ga
Nalco 71D-5	Defoamer	125	.10	2.0
Acrysol ASE-60	Thickener	147	.20	4.0
Water	Solvent	--	--	847.0(102 gal
			100.00	2918.0

One batch yields 64 ± 1 four gallon carton or 52 ± 1 five gallon pail.

SPECIAL MIXING INSTRUCTIONS - Blend ingredients in following order:
1) Water
2) Elvace EP-200
3) Nalco
4) Filler TEX-976
5) Mix until filler is dispersed
6) Add Acrysol ASE-60
7) Mix until Ready Mix is smooth - pumping viscosity should be 480 ± 20 to allow for 24 hour viscosity build of 100 pts.

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

Brabender: (580 ± 20) For machine tools add 7 gallons H_2O (400 ± 20)

pH Minimum - 9.0 Maximum - 9.5

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33. Compound shall be plastic, buttery working and free of any coarse, gritty or undispersed particles. Material shall be free from lumps due to incomplete mixing.

-/ denotes change

Continued on Page 2 ...

HCF:jg

January 17, 1978
Supersedes Formula TEX- 977
Dated: 10-26-77

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-977 (HAND TOOLS)

DESCRIPTIONS OF PRODUCT - White Ready Mix Joint Compound used for taping, topping and texturing. To be used in 4 gallon cartons and 5 gallon pails.

FORMULA

Raw Material	Function	RM Spec	Percent	Lbs/Batch
-/Proxcel CRL	Preservative	193	.115	2.23
Filler TEX-976	Filler	--	94.585	1962.77
Elvace EP-200	Adhesive	185	5.00	100.0(11.73gals
Nalco 71D-5	Defoamer	125	.10	2.0
Acrysol ASE-60	Thickener	147	.20	4.0
Water	Solvent	--	--	847.0(102 gals)
			100.00	2918.0

One batch yields 64 ± 1 four gallon carton or 52 ± 1 five gallon pail.

SPECIAL MIXING INSTRUCTIONS - Blend ingredients in following order:
1) Water
2) Elvace EP-200
3) Nalco
4) Filler TEX-976
5) Mix until filler is dispersed
6) Add Acrysol ASE-60
7) Mix until Ready Mix is smooth - pumping viscosity should be 480 ± 20 to allow for 24 hour viscosity build of 100 pts.

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

Brabender: (460 ± 20) For machine tools add 7 gallons H_2O (400 ± 20)

pH Minimum - 9.0 Maximum - 9.5

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33. Compound shall be plastic, buttery working and free of any coarse, gritty or undispersed particles. Material shall be free from lumps due to incomplete mixing.

-/ denotes change

Continued on Page 2 ...

HCF:

May 2, 1978
Supersedes Formula TEX- 977
Dated: 1/17/78

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-977 (HAND TOOLS)

DESCRIPTIONS OF PRODUCT - White Ready Mix Joint Compound used for taping, topping and texturing. To be used in 4 gallon cartons and 5 gallon pails.

-/ FORMULA

Raw Material	Function	RM Spec	Percent	Lbs/Batch
Proxcel CRL	Preservative	193	.113	2.32
Filler TEX-976	Filler	--	94.83	1950.00
Elvace EP-200	Adhesive	185	4.863	100.0(11.73ga
Nalco 71D-5	Defoamer	125	.097	2.0
Acrysol ASE-60	Thickener	147	.097	2.0
Water	Solvent	--	--	861.68(104 gal
			100.00	2918.0

One batch yields 64 ± 1 four gallon carton or 52 ± 1 five gallon pail.

SPECIAL MIXING INSTRUCTIONS - Blend ingredients in following order:
1) Water
2) Elvace EP-200
3) Nalco
4) Filler TEX-976
5) Mix until filler is dispersed
6) Add Acrysol ASE-60
7) Mix until Ready Mix is smooth - pumping viscosity should be 480 ± 20 to allow for 24 hour viscosity build of 100 pts.

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

Brabender: (460 ± 20) For machine tools add 7 gallons H_2O (400 ± 20)

pH Minimum - 9.0 Maximum - 9.5

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33. Compound shall be plastic, buttery working and free of any coarse, gritty or undispersed particles. Material shall be free from lumps due to incomplete mixing.

-/ denotes change

Continued on Page 2 ...

HCF: jg

December 13, 1978
Supersedes Formula TEX-977
Dated: 5/2/78

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-977 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for taping, topping and texturing. To be used in 4 gallon cartons and 5 gallon pails.

FORMULA

	Raw Material	Function	RM Spec	Percent	Lbs/Batch	
-/	PMA-30	Preservative	193	.112	2.32	
	Filler TEX-976	Filler	-	94.864	1964.68	
-/	DuPont JCM	Adhesive	185	4.83	100.00	(12 gal.)
	Nalco 71D-5	Defoamer	125	.097	2.0	
	Acrysol ASE-60	Thickener	147	.097	2.0	
	Water	Solvent	-	-	1000.0	(120 gals.)
				100.00	3071.0	

One batch yields 61 ± 1 four gallon carton or 49 ± 1 five gallon pail.

SPECIAL MIXING INSTRUCTIONS - Blend ingredients in following order:
1) Water
2) DuPont JCM
3) Nalco
4) Filler TEX-976
5) Mix until filler is dispersed
6) Add Acrysol ASE-60
7) Mix until Ready Mix is smooth - pumping viscosity should be 480 ± 20 to allow for 24 hour viscosity build of 100 pts.

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

Brabender: (460±20) For machine tools add 7 gallons H_2O (400± 20)

pH Minimum - 9.0 Masimum - 9.5

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33. Compound shall be plastic, buttery working and free of any coarse, gritty or undispersed particles. Material shall be free from lumps due to incomplete mixing.

-/ denotes change

NEW
Formula TEX-977
July 13, 1979

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-977

DESCRIPTION: White Ready Mix Joint Compound used for taping, topping and texturing. To be used in 4-gallon cartons and 5-gallon pails for selected market trials only.

FORMULA:

Raw Material	Function	RM Spec	Percent	Lbs/Batch
Water	Solvent			1120.2 (135 gal.)
DuPont JCM	Adhesive	185	2.080	41.5 (4.6 gal.)
Nalco 71D-5	Defoamer	125	.100	2.0
PMA-30	Preservative	193	.115	2.3
Filler TEX-976	Filler		97.705	1950.0
			100.000	3116.0

Yield: One batch yields 62 ± 1 four-gallon cartons at 50 lbs/carton or 50 ± 1 five-gallon pails at 62 lbs/pail.

SPECIAL MIXING INSTRUCTIONS: Blend ingredients in the following order:

1) Water
2) Adhesive
3) Nalco
4) Preservative
5) Filler
6) Mix as required

WORKING CONSISTENCY: Plant Testing Procedure No. 32.

Brabender: As manufactured - 600 ± 20 at 75°F.
After 3 months - Maximum of 730 at 75°F.

pH: Minimum - 9.0 Maximum - 9.5

WORKING PROPERTIES: Refer to Plant Testing Procedure No. 33. Compound shall be plastic, buttery working and free of any coarse, gritty or undispersed particles. Material shall be free from lumps due to incomplete mixing.

-/ denotes change

HCF:ps

Continued on Page 2 . . . . .

BONDING PROPERTIES: Plant Testing Procedure No. 35.
When dried, tape shall show at least 90% fiber when delaminated.

CRACK RESISTANCE: Plant Testing Procedure No. 37.
Rating shall be 4 or better.

COLOR: White
Dried compounds shall match color of standard sample.

BACTERIA GROWTH: Plant Testing Procedure No. 119.
Current Production: Maximum of 6 colonies in 48 hrs.
Retain Three Months: Maximum of 20 colonies in 48 hrs.

HCF:ps

February 5, 1980
Supersedes Formula TEX-977
Dated: 7/13/79

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-977

-/ DESCRIPTION: White Ready Mix Joint Compound used for taping, topping and texturing. To be used in 4-gallon cartons and 5-gallon pails.

FORMULA:

Raw Material	Function	RM Spec	Percent	Lbs/Batch
-/ Water	Solvent			938.2 (113 gal.)
DuPont JCM	Adhesive	185	2.080	41.5 (4.6 gal.)
Nalco 71D-5	Defoamer	125	.100	2.0
PMA-30	Preservative	193	.115	2.3
Filler TEX-976	Filler		97.705	1950.0
			100.000	2934.0

-/ Yield: One batch yields 58 ± 1 four-gallon cartons at 50 lbs/carton or 47 ± 1 five-gallon pails at 62 lbs/pail.

SPECIAL MIXING INSTRUCTIONS: Blend ingredients in the following order:

1) Water
2) Adhesive
3) Nalco
4) Preservative
5) Filler
6) Mix as required

WORKING CONSISTENCY: Plant Testing Procedure No. 32.

Brabender: As manufactured - 600 ± 20 at 75°F.
After 3 months - Maximum of 730 at 75°F.

-/ pH: Minimum - 8.0 Maximum - 9.0

WORKING PROPERTIES: Refer to Plant Testing Procedure No. 33. Compound shall be plastic, buttery working and free of any coarse, gritty or undispersed particles. Material shall be free from lumps due to incomplete mixing.

-/ denotes change

HCF:ps

Continued on Page 2 . . . . .

February 5, 1980
Supersedes Formula TEX-977
Dated: 7/13/79

BONDING PROPERTIES:	Plant Testing Procedure No. 35. When dried, tape shall show at least 90% fiber when delaminated.
CRACK RESISTANCE:	Plant Testing Procedure No. 37. Rating shall be 4 or better.
COLOR:	White Dried compounds shall match color of standard sample.
BACTERIA GROWTH:	Plant Testing Procedure No. 119. Current Production: Maximum of 6 colonies in 48 hrs. Retain Three Months: Maximum of 20 colonies in 48 hrs.

HCF:ps

May 1, 1980
Supersedes Formula TEX-977
Dated: 3/24/80

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-977

DESCRIPTION: White Ready Mix Joint Compound used for taping, topping and texturing. To be used in 4-gallon cartons and 5-gallon pails.

FORMULA:

	Raw Material	Function	RM Spec	Percent	Lbs/Batch	
	Water	Solvent			998.0	(121 gal)
	DuPont JCM	Adhesive	185	1.986	43.61	(4.9 gal)
-/ *	Nalco 71D-5	Defoamer	125			
	PMA-30	Preservative	193	.105	2.3	
	Filler TEX-976	Filler		97.909	2150.0	
				100.000	3193.91	

Yield: One batch yields 64 ± 1 four-gallon cartons at 50 lbs/carton or 51 ± 1 five-gallon pails at 62 lbs/pail.

SPECIAL MIXING INSTRUCTIONS: Blend ingredients in the following order:

1) Water
2) Adhesive
-/ 3) * Nalco - 0 to 50 mls. as required to break foam.
4) Preservative
5) Filler
6) Mix as required

WORKING CONSISTENCY: Plant Testing Procedure No. 32.

Brabender: As manufactured - 600 ± 20 at 75°F.
After 3 months - Maximum of 730 at 75°F.

pH Minimum - 8.0 Maximum - 9.0

WORKING PROPERTIES: Refer to Plant Testing Procedure No. 33. Compound shall be plastic, buttery working and free of any coarse, gritty or undispersed particles. Material shall be free from lumps due to incomplete mixing.

-/ denotes change

HCF:ps

Continued on Page 2 . . . . .

September 24, 1980
Supersedes FORMULA TEX-977
(dated: 5/1/80)

ACME, TECAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-977

DESCRIPTION: White Ready Mix Joint Compound used for taping, topping and texturing. To be used in 4-gallon cartons and 5-gallon pails.

FORMULA:

	Raw Material	Function	RM Spec	Percent	Lbs/Batch
	Water	Solvent	---	---	998.0 (121 gal)
	DuPont JCM	Adhesive	185	1.986	43.61(4.9 gal)
*	Nalco 71D-5	Defoamer	125	---	---
-/	Proxel CRL	Preservative	---	.109	2.39
	Filler TEX-976	Filler	---	97.905	2150.0
				100.000	3194.00

Yield: One batch yields 64 ± 1 four-gallon cartons at 50 lbs/carton or 51 ± 1 five-gallon pails at 62 lbs/pail.

SPECIAL MIXING INSTRUCTIONS: Blend ingredients in the following order:

1) Water
2) Adhesive
3) Nalco - 0 to 50 mls. as required to break foam.
4) Preservative
5) Filler
6) Mix as required.

WORKING CONSISTENCY: Plant Testing Procedure No. 32.

Brabender: As manufactured - 600 ± 20 at 75°F.
After 3 months - Maximum of 730 at 75°F.

pH Minimum - 8.0 Maximum - 9.0

WORKING PROPERTIES: Refer to Plant Testing Procedure No. 33. Compound shall be plastic, buttery working and free of any coarse, gritting or undispersed particles. Material shall be free from lumps due to incomplete mixing.

Continued on Page 2 ....

-/ denote change
BGR: ps

ACME FORMULA #977
ASBESTOS CONTAINING PRODUCTS

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