

special bulletin

Operating Division PRODUCT PROCEDURE	CONFIDENTIAL	No. 61-2-12-1-T Date 10-22-71 Page 1 Cancels NEW Dated
Approved:	DURABOND R JOINT COMPOUND	

This bulletin expires 11-1-72.

Plants to manufacture hardening type joint compounds, DURABOND 45R (formula GB-217) and DURABOND 90R (formula GB-236B), for Industrialized Home Joint Compound and shipped per directions of Dept. 147-2 and 141-2.

DESCRIPTION

DURABOND 45R (Formula GB-217) and DURABOND 90R (Formula GB-236B) are dry powder setting type joint compounds for use with PERF-A-TAPE as a joint treatment in Industrialized Homes.

MANUFACTURING PLANTS

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

IDENTIFICATION AND PACKAGING

This material to be temporarily packaged and shipped in polyethylene lined plain bleached Kraft, 25 lb. Joint Compound Bags. The bags are to be stamped or stencilled "DURABOND 45R" or "DURABOND 90R". Direction-for-Use labels to be initially supplied by C. M. Howard, Dept. 147-2.

FINISHED PRODUCT SPECIFICATIONS

Consistency (cc water/100 grams)
Viscosity VC-3 Brabender pin
pH @ 77°F
Room Condition Bond to PERF-A-TAPE
Set Time (Vicat)

56-58cc
500-550EB
8.0 - 8.5
7
35-55 minutes as
DURABOND 45R
80-100 minutes as
DURABOND 90R

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CONFIDENTIAL

DURABOND R JOINT COMPOUND

FORMULA

	DURABOND 45R GB-217	DURABOND 90R GB-236B
Asbestos JM-7RFO2	4.5% + 1.0%	4.5% + 1.0%
Ziram 95% Tech	.1	.1
Mica P 80F	12.0	.5
Methocel GM-65	.5	.5
Vinac RP-251	5.0	5.0
E-Base HYDROCAL	To make 100%	To make 100%
Sodate Retarder	.2 + .1	1.0 + .1
Potassium Sulfate Type II	.2 + .1	.1 + .1
Sorbitol Powder	.5	.5
Tributyl Phosphate	.2	.2

RAW MATERIALS

Asbestos JM7RFO2	FMS 6-17-10
Ziram 95% Tech	FMS 6-100-11
Mica P-80F	FMS 6-143-1
Methocel GM-65	Dow Chemical Co., Midland, Mich.
Vinac RP-251	FMS 6-104-18
E-Base HYDROCAL	Per Bulletin 52-22-26
Sodate Retarder	Per Bulletin 52-22-20
Potassium Sulfate Type II	FMS 6-99-2
Sorbitol Powder	*
Tributyl Phosphate	FMS 6-98-4

* Charles Pfizer and Co., Inc., New York, New York

MANUFACTURING PROCEDURE

In normal manner used for manufacture of DURABOND Joint Compound except a clean out charge Must Be Run before the manufacture of this material. Even a small amount of Casein Joint Compound will severely contaminate it.

Important: Sodate is the ONLY retarder usable in this item.
Potassium Sulfate can be varied slightly to adjust set time if needed.

QUALITY CONTROL

Per Bulletin 61-2-12-1.

END

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M-8971-C (Back)

UNP007 0278

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CONFIDENTIAL

DURABOND R JOINT COMPOUND

FORMULA

	DURABOND 45R GB-217	DURABOND 90R GB-236B
Asbestos JM-TRFO2	4.5% $\pm$ 1.0%	4.5% $\pm$ 1.0%
Ziram 95% Tech	.1	.1
Mica P 80F	12.0	12.0
Methocel GM-65	.5	.5
Vinac RP-251	5.0	5.0
E-Base HYDROCAL	To make 100%	To make 100%
Sodate Retarder	.2 $\pm$.1	1.0 $\pm$.1
Potassium Sulfate Type II	.2 $\pm$.1	.1 $\pm$.1
Sorbitol Powder	.5	.5
Tributyl Phosphate	.2	.2

RAW MATERIALS

Asbestos JMTRFO2	PMS 6-17-10
Ziram 95% Tech	PMS 6-100-11
Mica P-80F	PMS 6-143-1
Methocel GM-65	Dow Chemical Co., Midland, Mich.
Vinac RP-251	PMS 6-104-18
E-Base HYDROCAL	Per Bulletin 52-22-26
Sodate Retarder	Per Bulletin 52-22-20
Potassium Sulfate Type II	PMS 6-99-2
Sorbitol Powder	*
Tributyl Phosphate	PMS 6-98-4

* Charles Pfizer and Co., Inc., New York, New York

MANUFACTURING PROCEDURE

In normal manner used for manufacture of DURABOND Joint Compound except a clean out charge Must Be Run before the manufacture of this material. Even a small amount of Casein Joint Compound will severely contaminate it.

Important: Sodate is the ONLY retarder usable in this item.
Potassium Sulfate can be varied slightly to adjust set time if needed.

QUALITY CONTROL

Per Bulletin 61-2-12-1.

END

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C Indicates Change

0P007 0276

Operating Division

PRODUCT PROCEDURE

Approved:

CONFIDENTIAL

DURABOND R JOINT COMPOUND

No. 61-2-12-1-T

Date 3-6-72

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Dated 2-10-72

This bulletin expires 11-1-72.

Plants to manufacture hardening type joint compounds, DURABOND 45R (formula GB-217), and DURABOND 90R (formula GB-236B), for Industrialized Home Joint Compound and shipped per directions of Dept. 147-2 and 141-2.

A Orders must be in 100 bag minimums and the shipping plant must have at least one week lead time. Exception: on smaller demonstration trials, amount subject to approval of Division Product Manager - Joint Treatment.

DESCRIPTION

DURABOND 45R (Formula GB-217) and DURABOND 90R (Formula GB-236B) are dry powder setting type joint compounds for use with PERF-A-TAPE as a joint treatment in Industrialized Homes.

MANUFACTURING PLANTS

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

IDENTIFICATION AND PACKAGING

This material to be temporarily packaged and shipped in DURABOND 90 Joint Compound bags. The bags are to be stamped/or stencilled prominently as 45R or 90R as necessary.

FINISHED PRODUCT SPECIFICATIONS

Consistency (cc water/100 grams)

Viscosity VC-3 Brabender pin

pH @ 77°F

Room Condition Bond to PERF-A-TAPE

Set Time (Vicat)

56-58cc

500-550HB

8.0 - 8.5

7

35-55 minutes as

DURABOND 45R

80-100 minutes as

DURABOND 90R