ASBESTOS:
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1971

PLAINTIFF'S EXHIBIT
GP-1514

SGP 0022931

Gypsum Wallboard For Wall And Ceiling Systems

Joint Systems and Specialty Products

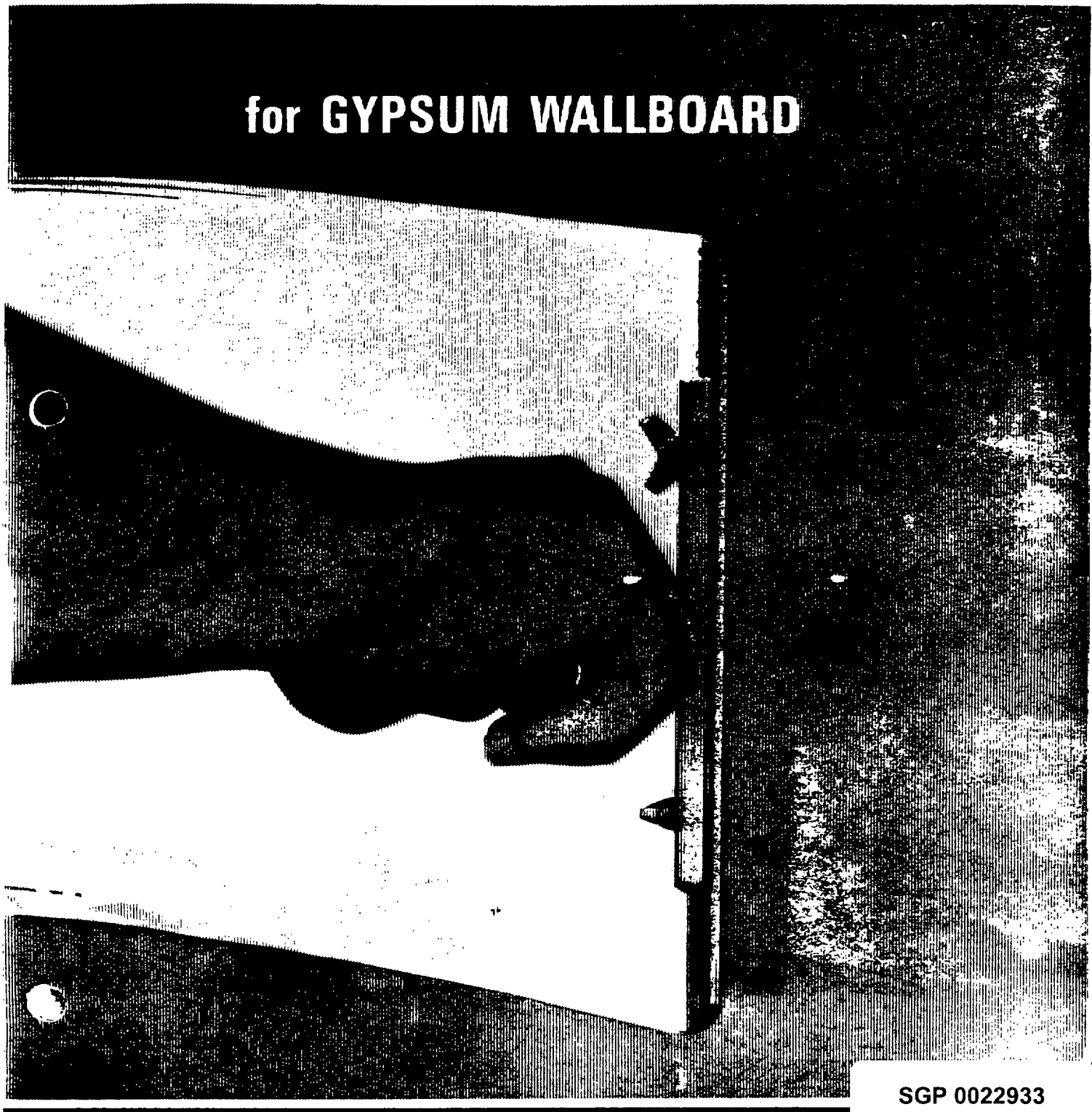
Lath & Plaster For Wall And Ceiling Systems

SGP 0022932

1971

JOINT SYSTEMS
and SPECIALTY PRODUCTS

for GYPSUM WALLBOARD



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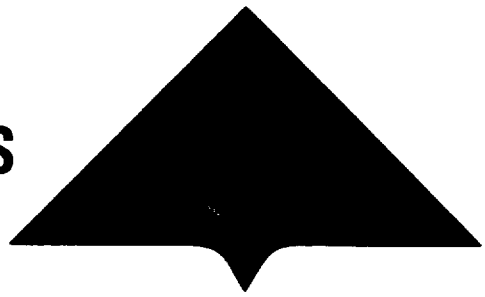
GENERAL SALES INFORMATION



GEORGIA-PACIFIC JOINT TREATMENT PRODUCTS CONFORM TO ASTM SPECIFICATION NO. C475-64 AND FEDERAL SPECIFICATION NO. SS-J-570.

ADVANTAGES OF G-P JOINT SYSTEM PRODUCTS

MIXING STABILITY Georgia-Pacific products are stable in wet mix consistency avoiding annoying adjustment before use.

PLASTICITY Georgia-Pacific products have smoother application properties. Plasticity enables better control in application and provides better shearing and feathering qualities.

DURABILITY BOND Georgia-Pacific products develop greater strength and water resistance. They produce an excellent bond and joints as strong as the board itself.

LESS SHRINKAGE Georgia-Pacific products exhibit the lowest shrinkage compatible with excellent job results.

QUALITY Quality standards and controls are the very best known to the industry.

NATURAL LIMITATIONS

1. Protect powder against moisture.
2. Each coat must be thoroughly dry before each succeeding coat or final decoration is applied.
3. During winter season or when temperature is less than 55°F, finishes should not be applied unless building has a controlled heat of at least 55°F for period of 24 hours before installation and until a permanent heating system is in operation. Use only clean mixing water at room temperature.
4. Do not mix one Georgia-Pacific product with another, or with any other material.



Joint System Products relate to gypsum wallboard in the same manner wood moldings relate to hardwood paneling. Whenever you sell or quote on gypsum wallboard your immediate second thought should relate to a sale or quote on joint compound to use with the board. This is not only good selling but profitable for all concerned. When this initial effort is made by you with a customer, you will find that future orders will automatically include the joint system products and result in a nice increase in the amount of the billing and the percentage of profit.

A good rule-of-thumb is "for every 1,000 square feet of gypsum wallboard you sell, you should also sell, as an accessory item, 50* pounds of a joint system product."

* When corner beads are to be covered with joint system — 60 pounds of joint system per 1000' wallboard is a more accurate figure.

PACKAGE COLOR CODING

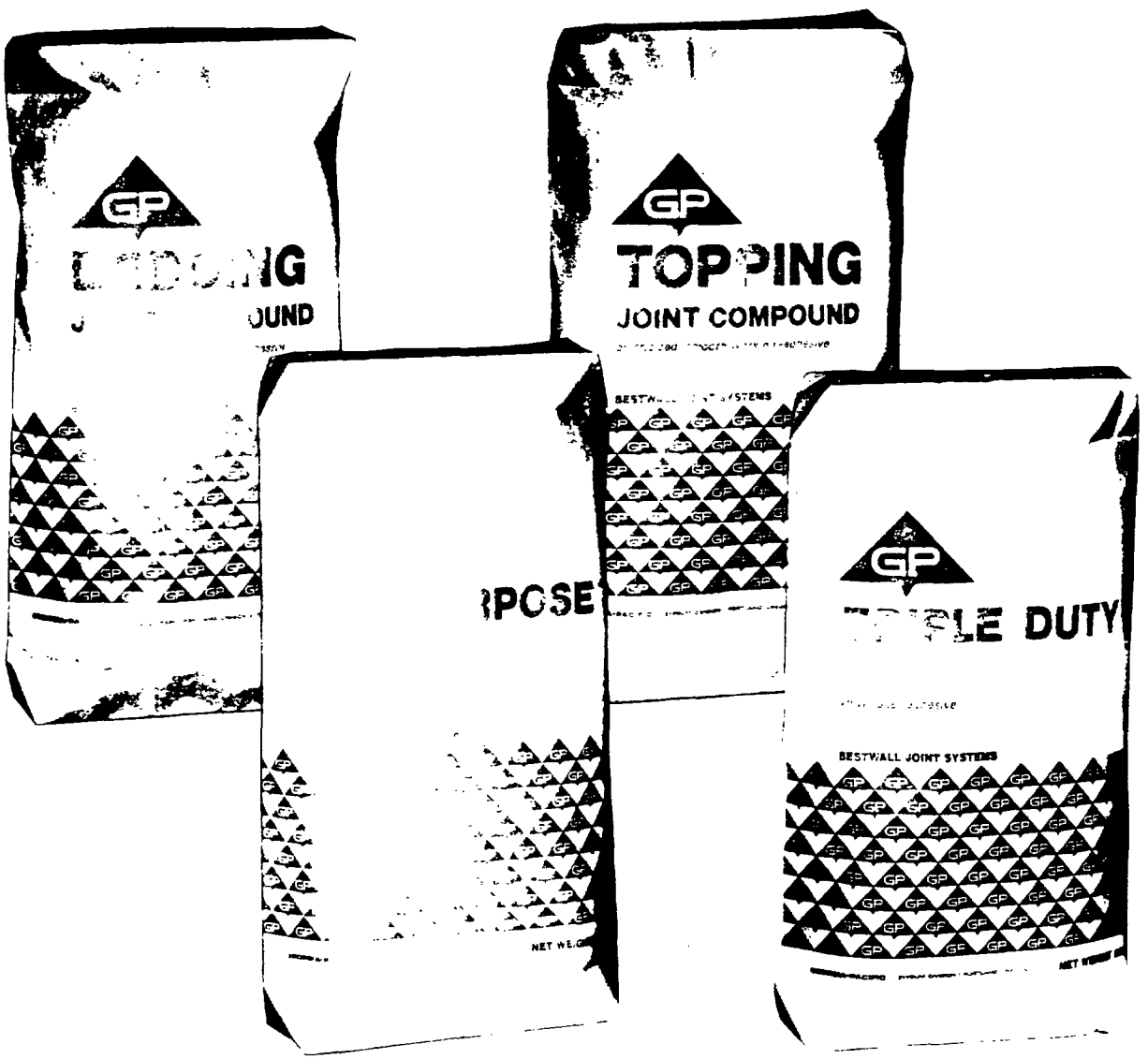
WEIGHT	BAG COLOR	LETTERING COLOR
25 lb.	Kraft & Yellow	Red
25 lb.	Kraft & Yellow	Blue
25 & 50 lb.	White	Blue/Green
1 & 5 gal. (pails)	White	Blue/Green
18 & 25 lb.	Kraft & Yellow	Brown
25 lb.	White	Orange
50 lb.	Kraft	Green
25 lb.	Kraft	Green
25 lb.	Yellow	Green
40 lb.	Yellow	Green

JOINT SYSTEM PRODUCTS

Joint System is the material for reinforcing and concealing gypsum wallboard joints to provide a smooth monolithic surface that will accept various types of decoration.

Today's complete G-P Joint System Products include ready-mixed as well as conventional powder compounds suitable for application by either hand tools or mechanical equipment.

The following pages give detailed information concerning the use of G-P Joint System Products.



BEDDING COMPOUND

G-P Bedding Compound is designed to provide maximum adhesion of wallboard tape to the joints, and for the initial application to nail heads and corner bead. It spreads smoothly and may be hand or machine applied. Since it is used for this express purpose, G-P builds in the maximum taping and adhesive qualities.

COVERAGE: Approximately 10 lbs. per 1,000 square feet. (Used in conjunction with 40 lbs. of Topping Compound.)

AVAILABLE IN 25 LB. BAGS.

TOPPING COMPOUND

G-P Topping Compound is specifically designed for the second and third coats over the Bedding Compound. Since it is used only for topping, we are able to reduce the amount of adhesive and incorporate other materials which reduce the shrinkage and make it easier to sand and work.

COVERAGE: Approximately 40 lbs. per 1,000 square feet. (Over 10 lbs. of Bedding Compound.)

AVAILABLE IN 25 LB. BAGS.

TRIPLE DUTY JOINT COMPOUND

G-P Triple Duty Joint Compound is a multi-purpose product for use where the finest results of the specialized Bedding and Topping Compounds are not necessary. A single bag offers taping, topping and texturing. It can be used for all coats in the reinforcing and concealing of joints in gypsum wallboard construction. The binder in Triple Duty gives this product a wet life of 30 to 60 days duration. This allows pre-mixing in large quantities prior to application. Triple Duty can be applied using standard hand or mechanical tools. The product has low shrinkage and it is easily sanded. When the application is completed, the surface is ready for priming and decoration as desired, with no further preparation necessary.

COVERAGE: Approximately 50 lbs. per 1,000 square feet (12-50 lbs. per 1,000 square feet when used as a texturing material).

AVAILABLE IN 25 AND 50 LB. BAGS.

ALL PURPOSE JOINT COMPOUND

G-P All Purpose Joint Compound is used for bedding tape, topping, corner beads, nail spotting and texturing. Be sure each coat or layer of compound is thoroughly dry before applying succeeding coats. When used for texturing, for best results apply a vinyl primer to the entire area before texturing. The texture may be applied with a roller, sponge, brush or other suitable implement depending on the type of configuration desired.

COVERAGE: Approximately 50 lbs. per 1,000 square feet.

AVAILABLE IN A 25 LB. BAG AND AN 18 LB. BAG WITH A 250' ROLL OF TAPE.

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JOINT SYSTEM PRODUCTS

READY MIX



G-P Ready Mix Joint Compound is a prepared wet mix material designed to bond tape to wallboard for joint reinforcement — to fill and finish joints — cover and finish nail heads and corner bead — and for texturing.

Controlled formulation and mixing results in:

- greater coverage
- easy sanding — smooth working
- saving in job mixing time
- uniform consistency

Ready Mix can be stored approximately one year and not lose any of its bonding or working properties.

Available in either machine or hand tool consistency. It is packaged in one gallon or five gallon pails. Coverage: approximately 5 gallons per 1,000 square feet of wallboard.

APPLICATION: It is best to use the Ready Mix compound at the consistency you receive it, to minimize shrinkage. If a thinner material is desired, Ready Mix can be easily thinned with water using a potato masher type mixing paddle. A drill type mixer is not recommended as this tends to whip air into the compound. Add the water gradually to speed the thinning process. Lukewarm water should be used. Do not use hot water. If overthinning occurs, simply add additional Ready Mix compound to thicken and then remix.

When storing the wet mix in a pail for prolonged periods, cover the mix with a damp cloth or a thin layer of water. When reusing, pour off water and remix.

G-P Ready Mix joint compounds are formulated so that they will not be destroyed if frozen unless it has been frozen and thawed several times, or is subjected to extremely low temperatures. If the material becomes frozen, allow it to thaw at room temperature. Do not force the thawing process. When Ready Mix freezes and thaws, the compound may settle to the bottom of the can. In the event this occurs, the compound should be thoroughly mixed insuring that the bottom layers have been mixed throughout. Following this, water may be added to obtain the desired consistency, and the compound should be thoroughly remixed as before.

DECORATION: For best results a prime coat should be used over the entire wallboard surface before final decoration.

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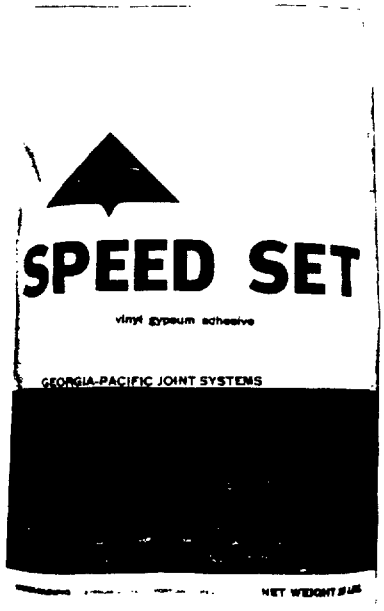
SPEED SET JOINT COMPOUND



DESCRIPTION: G-P Speed Set Joint Compound is a quick setting material to be used for taping, finishing joints, concealing nail heads, and covering corner beads, when time is important.

Speed Set comes 3 ways:

1. With 1/2 hour working time, setting hard in about 1 hour. It will be identified on the bag in inch high red letters "1/2 hour working."

2. With a 1 hour working time, setting hard in about 1½ hours. It will be identified on the bag in inch high red letters "1 hour working."

3. With a 2 hour working time, setting hard in about 2½ hours. It will be identified on the bag in inch high red letters "2 hour working."

MIXING: Add 25 lbs. of G-P Speed Set to 1½ gallons of clean (potable) water with continuous mixing. Allow to soak a minimum of 5 minutes. Remix, adding water if necessary to obtain proper working consistency. The mix may tend to stiffen slightly for as much as 10 minutes after it is mixed.

APPLICATION: Apply G-P Speed Set to joints and embed tape, leaving a uniform thickness under the tapes. Fill corner beads and spot nail heads. Apply finish coats over tapes, corner beads and nail heads after previous application has hardened (set). As an alternative, G-P Triple Duty or Ready Mix may be used for finishing.

PRECAUTIONS:

1. Do not mix more material than can be applied within the working time.

2. Do not mix with other joint compounds in either wet or dry form.

3. Clean tools and mixing equipment after each batch to prevent acceleration of setting time.

4. If stiffening occurs, except within the first 10 minutes, setting action is starting and material should be discarded.

5. Do not retemper mix — never add part of a previous batch to a fresh batch.

6. Minimum air and water temperature of 55° must be maintained in working areas until joints are completely dry.

DECORATION: For best results, a prime coat should be used over the entire wallboard surface before the final decoration. Be sure the entire surface is thoroughly dry before application of a primer.

SPECIALTY PRODUCTS



*Consistencies and coverage may vary with different types of equipment, workmanship and customer's requirements.



CEILING & WALL TEXTURES

G-P Wall texture is an unaggragated texture compound for hand tool or spray application. When applied with a spray, a splatter or orange peel texture is formed. When applied by hand, a stipple, swirl, or brocade texture can be produced.

G-P Wall texture can be applied immediately after G-P Ceiling overspray wipedown. It is made for fast, volume application. Because of its formulation, G-P Wall texture matches G-P Ceiling textures, without overlap discoloration.

G-P Ceiling textures are designed for spray application over ceilings constructed with gypsum wallboard or concrete. The resulting texture simulates accoustical texture finish. Especially designed for volume operations, these products give unsurpassed economy . . .

- The texture dries harder and tighter.
- The texture maintains a high quality white decorative finish.
- This texture gives exceptional coverage if used as instructed.

SURFACE PREPARATION: All surfaces, including joint system applications, must be dry and clean. Roughen glossy surfaces. Prime any exposed metal surfaces with a rust inhibitor. Fill and seal any wood surfaces. For best results, it is recommended that a vinyl primer or equivalent be applied to the entire surface prior to texturing.

APPLICATION: Apply with conventional spray texture apparatus as product warrants. Continuously agitate the mix when spraying to avoid separation or settling. For best coverage and uniformity of texture, spray a given area first in one direction, and then immediately double back at right angles to this application. Air pressure in spraying equipment will effect degree of texture. For coarser texture, use less air pressure, for finer texture, use more air pressure.

LAMINATING COMPOUND

Laminating Compound is a product developed for the sole purpose of laminating two gypsum boards together. It has the following advantages for laminating wallboard: (1) More permanent bond, (2) Easier to spread, (3) Longer open life, and (4) More economical.

CONSISTENCY: Dry powder mixes with water to form an adhesive which will not self-level and which retains consistency during application. Proper mixture is 25 lbs. of compound added to 4½ gallons of water (5½ lbs. per gallon). It hardens into a water-resistant solid form and will not increase thickness due to bridging.

APPLICATION / COVERAGE: Using a notched spreader (notches should be triangular 3/16" x 3/16" and 3/4" on center) — approximate coverage 30 pounds per 1,000 square feet.

Using a bead line (Ames tool or caulking gun) ⅜" bead, 16" on center — approximate coverage 35 pounds per 1,000 square feet.

GRABIT™

An adhesive which permits direct attachment of gypsum wallboard to masonry walls. It may be used on poured concrete, cinder block or concrete block walls which are reasonably straight and true and are free from surface treatment, decoration, or protrusions. Grabit may be used on exterior walls which are above grade level without waterproofing. Grabit may also be used to adhere gypsum wallboard to polystyrene insulation material.



Adhesion is secure and permanent, with no need for furring strips or fasteners. After being mixed with water as directed, Grabit can be applied with blade or caulking gun. Only four 1" ribbons are needed for each 4' wide wallboard panel. The adhesive fills in all normal irregularities in the masonry. In 3 to 4 hours, Grabit sets hard, and joint taping and finishing operations may then be started. This adhesive may be used wherever there is need to attach gypsum wallboard to masonry walls: in homes, apartments, hotels, offices and plants.

SURFACE PREPARATION: Surfaces should be reasonably straight and true, free of fragments of mortar, splinters from forms, protruding reinforcing rods, etc. Surface out of alignment should be leveled by some suitable means.

CONSISTENCY: Dry powder, mixes with clean water to form a paste, plastic enough to be applied with a caulking gun, yet stiff enough so that the bead will not sag or flow. It retains its consistency for 2½ hours or longer. Proper mixture is 50 lbs. of Grabit to 10 quarts of water. It fills in all normal irregularities in the masonry and hardens permanently in 3 to 4 hours.

APPLICATION: On the back side of the board, apply a 1" ribbon of Grabit to each edge, and two ribbons in the field of the board 16" from each edge. Use mechanical fasteners or a brace where necessary, to hold board in place until adhesive sets.

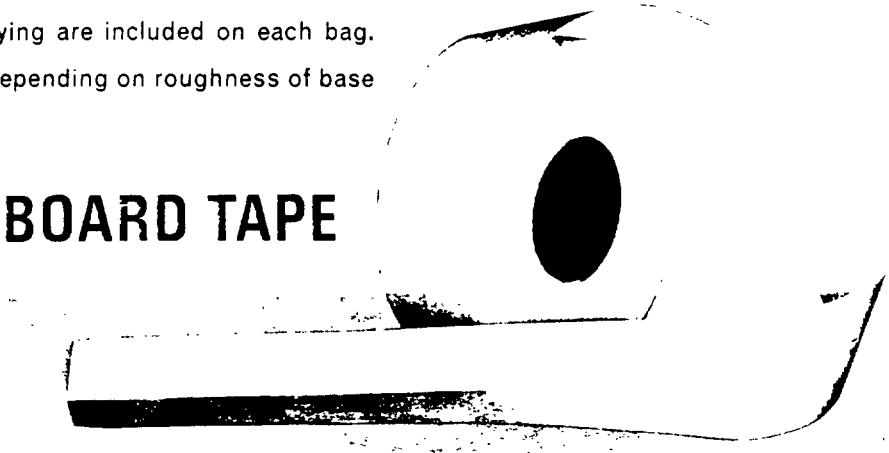
To align joints, place a 2" x 4" stud over the adjoining board edges and tap with a hammer. If boards are warped, use masonry nails to pull boards into alignment.

Remove all droppings before the adhesive sets.

Complete instructions for mixing and applying are included on each bag.

COVERAGE: Up to 1/4 lb. per square foot depending on roughness of base surface. Available in 50 lb. bags.

New, Improved WALLBOARD TAPE



G-P Wallboard Tape is a full 2" width, "Miracle Crease" spark perforated tape with chamfered edges and a special surface on both sides. Bonding qualities are excellent. Porosity permits rapid drying of Joint Compound. It is easy to use, economical, and has low expansion qualities. Stabilized against varying humidity conditions, it reduces uneven expansion and edge wrinkling.

PACKAGING: Available in 60', 250', and 500' rolls as follows: 60' rolls packed 60 per box, approximately 24 lbs.; 250' rolls packed 20 per box, approximately 29 lbs.; 500' rolls packed 10 per box, approximately 28 lbs.

APPLICATION METHODS

NAILS AND SCREWS



1. Draw finishing knife across nail and screw heads to be sure they are all driven to proper level. Apply first coat of embedding type compound (G-P Bedding, Triple Duty, Ready-Mix, All Purpose or Speed Set) over the nail or screw head. Apply ample pressure on knife to smooth compound to surface level of the board. Do not bow blade with excess pressure as this tends to scoop compound from the dimpled area.

2. When dry, apply second coat (G-P Topping, Triple Duty, Ready-Mix, Joint Compound or Speed Set) with even knife pressure to ensure complete coverage.

3. When second coat is dry, sand lightly and apply third coat. Depending on humidity, temperature, etc., additional coats may be required. Light sanding may be necessary before applying decoration.

TAPERED JOINTS



1. Apply G-P embedding type joint compound (G-P Bedding, Triple Duty, Ready-Mix, All Purpose or Speed Set) fully and evenly into the valley formed by adjoining tapered edges of G-P Wallboard. When using machines, tape and compound are applied in one operation.

2. Center G-P Wallboard Tape and press into compound with a drywall knife held at approximately a 45° angle. Draw knife along tape with sufficient pressure to squeeze some compound from edges of tape, yet leaving enough for a sufficient bond.

3. Apply a fill coat extending a few inches beyond edges of tape and feather edges of compound. The purpose of this coat is to conceal the tape and fill the portion of the valley not filled by the tape.

4. When dry (24 hours or longer — see chart page 13), apply a second coat and feather the edges, about 1½" beyond first coat, with a wide knife.
Speed Set may be covered as soon as compound sets.

5. When dry, sand lightly and touch up any imperfections. Wipe off dust from sanding in preparation for the decoration.

END JOINTS



1. The end or butt joints are not tapered, so care must be taken to leave sufficient joint compound underneath the tape to ensure a good bond between the tape and the board.

2. Apply a fill coat as described for tapered joints and feather compound 1 inch beyond edge of tape. When thoroughly dry, the second coat is feathered 1 to 2 inches beyond edges of skim coat. If necessary, third coat feathered 2 inches beyond edges of second coat may be applied. The total application of joint compound is approximately 14 to 18 inches wide. Alternately, end joint may be finished with a coat on each side of the tape but covering each edge. Another coat is subsequently applied to cover the center of the tape.

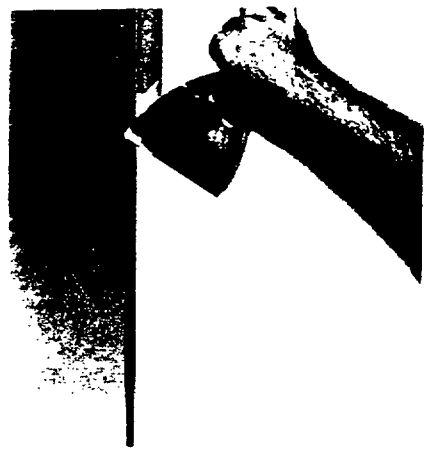
3. The object in finishing the end joint is to keep the center build-up of joint compound as low as possible, since a high crown encourages ridging and shadowed areas.

G-P Bedding and Topping Compound are 2-bag systems of specialized compounds for use where the very finest results are desired. Bedding is used for tape embedding and Topping is the recommended material for all succeeding coats.

G-P Triple Duty, Ready Mix, All Purpose and Speed Set are 1-bag systems and may be used independently for all steps in the treatment of drywall joints, nails and screws and corner bead applications. It is prefererable to use Ready Mix or Triple Duty for the final coat over Speed Set Joint Compound.

It is prefererable to use Ready Mix or Triple Duty for the final coat over Speed Set Joint Compound.

METAL BEAD



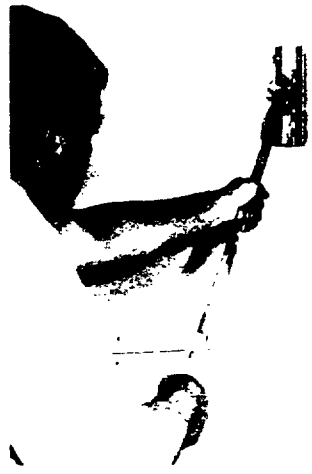
1. Be sure the metal bead is firmly attached, fasteners are not protruding and the bead is thoroughly cleaned. Use embedding type joint compound (G-P Bedding, Triple Duty, Ready-Mix, All Purpose or Speed Set) for application over the bead.

2. Cover both flanges completely using the bead as a screed. Smoothly spread the compound 3 to 4 inches wide from the nose of the bead.

3. When dry, sand lightly, if necessary, and apply second coat (G-P Topping, Triple Duty, Ready-Mix, All Purpose or Speed Set) feathering edges 2 to 3 inches beyond first coat. Depending on quality of work desired and job conditions, a third and fourth coat may be required. Feather the edges of each coat beyond the preceding coat.

4. When the final coat is dry, sand carefully before proceeding with the decoration.

TAPED ANGLES



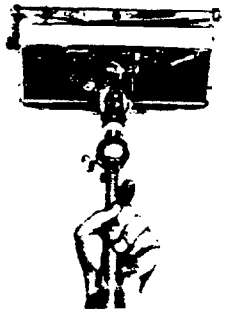
1. Using either a drywall knife or corner tool, spread embedding type joint compound (G-P Bedding, Triple Duty, Ready-Mix, All Purpose or Speed Set) on both sides of the interior angle. Be sure there is complete coverage and that the compound extends 1½" on each side of the angle.

2. Fold G-P Tape along the miracle crease and embed in the compound. Press each side of the tape alternately, with sufficient pressure to squeeze compound from edges of tape. Feather compound 2" from edge of tape.

3. When dry, apply a second coat (G-P Topping, Triple Duty, Ready-Mix, All Purpose or Speed Set) with a corner tool coating both sides of angle at the same time. Alternate method is to apply second coat, with a square edged knife, one side of angle at a time or both sides together feathering compound 1½" each side of tape. If third coat is necessary, apply when second coat is dry, feathering 1" beyond the edges of the second coat. Sand finish coat lightly, then it is ready for application.

4. To prevent hairline cracking, use a minimum amount of compound at apex of angles.

MECHANICAL TOOLS



1. The recommendations of the various tool manufacturers should be used for the best results in mechanically applying joint compound.

2. When mechanical tools are used, generally the width of feathering on joints is wider on each coat.

3. Each coat must be dry before subsequent coats are applied.

CAUTION — Topping Compound must never be used to embed tape mechanically or by hand.

TECHNICAL INFORMATION

PROBLEMS WHICH OCCUR IN JOINT TREATMENT

[illegible]	REMEDY OR PREVENTION
[illegible] soaking time, that is the binder may not be [illegible] so that optimum plasticity is not reached.	Allow sufficient soaking time (at least 20 minutes).
Dirty or contaminated buckets. Aggravated by hot humid weather conditions.	Use only clean mixing pails and tools. Avoid excessive standing of mixed materials.
Same as for Settling Condition.	Same as above.
Excessive amount of mixing water. Especially prevalent when cold water and cold compound are used.	Use 55°F minimum water and follow manufacturer's instructions.
Thick coats of compound under the tape. Fast drying conditions.	Avoid application over hot surfaces near pipes, radiators, salamanders. Control ventilation during the drying cycle in hot weather so as not to obtain radical changes in temperature, avoid drafts.
Airborne soot or dust particles collecting over nail-head. Shank of nail will conduct cold; airborne particles collect over this cooler area.	Dependent upon cleanliness of air. Deposits can be washed off. Insulate to provide uniform temperature.
Compound over tape is glazed due to tape being high. Deeper fills on either side of tape will not be glazed and will thus have a rougher texture. Low or high joints.	Press tapes in tightly. A sheer coat will equalize suction and texture. Refinish off level joint.
Delayed shrinkage (not allowing preceding coats to dry). Insufficient compound applied over tape to fill recess. Over sanding.	Allow sufficient drying time between coats of compound. Keep sanding to a minimum. Apply additional coat.
Insufficient compound under the tape. Tape not initially pressed into good contact with compound.	Open up blister by slitting tape. Fill cut with compound and press tape in place.
Cold compound, water, or walls. Freezing of wet compound in pail or on wall after application. Insufficient soaking time.	Maintain minimum 55°F temperature. Protect from freezing. Allow necessary soaking time.
Too much compound over the tape at apex of angle.	Wipe down corners correctly, leaving only small amount or no compound in the apex.
1. Painting before the joint system is completely dry. 2. Crowning the joints will cause a difference in light reflection. 3. Difference in texture and suction between compound and board. 4. Painting with paint having poor hiding properties — thinning pain too much. (Same is true for textures, as well as paints.)	1. Allow sufficient drying time. 2. Avoid high crowns. 3. Apply primer or skim coat. 4. Avoid excessive thinning of paints, or textures.
Movement of the board or uneven shrinkage. Due to strains caused by expansion and contraction of framing.	Let condition develop fully (6 months or 1 heating season). Sand ridge to tape (Do not cut tape) and fill concave areas each aide. When dry, apply finish coat and redecorate.
Shrinkage of lumber, loose board, poor framing, or poor nails cutting paper.	Renail about 1½" from popped nail holding board tight to framing. Reset popped nail and finish. If nail cutting is cause, the old nail should be removed.

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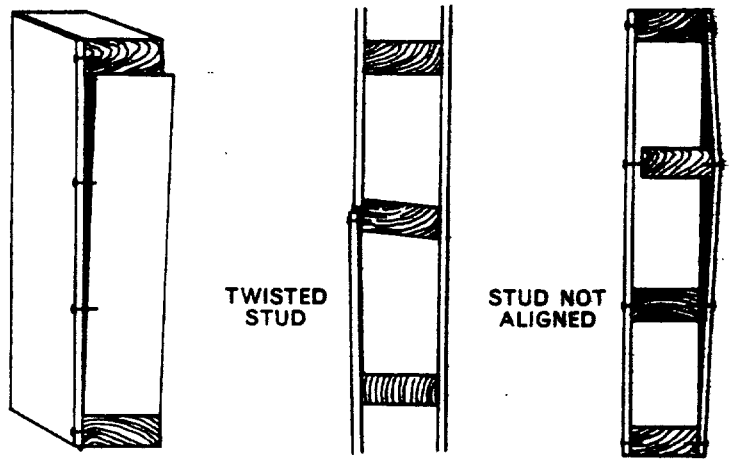


COMMON CAUSES OF "NAIL POPS"

JOINT SYSTEM DRYING TIMES:

Temperature and humidity have a direct effect on the drying time of joint treatment products. While there is very little that can be done to alter temperature and humidity under job conditions, care should be taken to note the average differences in drying times under different atmospheric conditions, so that problems may be minimized. Joint treatment products must be thoroughly dry before successive coats are applied, and/or final decoration is applied. In all cases, a well ventilated area assists in the proper drying of these materials. A minimum controlled heat of 55°F will avoid many job failures.

The chart shown below indicates the average drying periods for joint treatment products under different temperature and humidity conditions.

H = hours
D = days (24 hours)

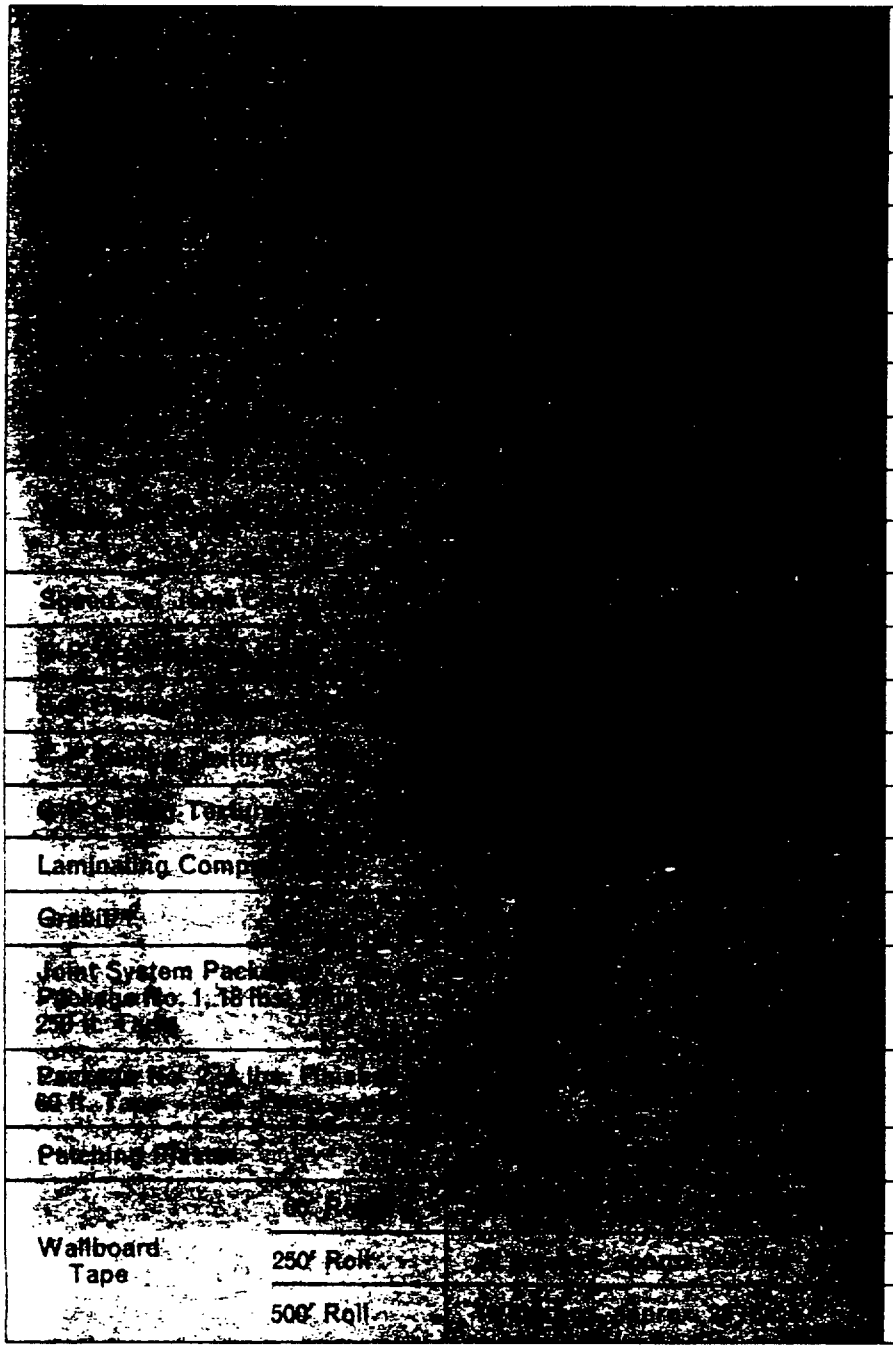
TEMPREATURE IN DEGREES FARENHEIT
40°
60°
80°
100°

PAINTING OF DRYWALL

It is extremely important that the difference in absorption between the wallboard surface and the compound over joints and nails be equalized to provide uniformity of color, suction and texture over the entire wall or ceiling. After the joint treatment has been completed and *thoroughly dried*, the surfaces should be sealed or primed with a reputable primer/sealer.

PRICING SHEET

JOINT SYSTEMS AND SPECIALTY PRODUCTS



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- St. Clair

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- Providence

SOUTH CAROLINA
- Columbia
- Greenville

TENNESSEE
- Bristol
- Chattanooga
- Knoxville
- Memphis
- Nashville

TEXAS
- Dallas
- El Paso
- Fort Worth
- Houston
- Lubbock
- San Antonio

UTAH
- Salt Lake City

VIRGINIA
- Lynchburg
- Norfolk
- Richmond

WASHINGTON
- Bellingham
- Seattle
- Spokane
- Tacoma

WASHINGTON, D.C.

WISCONSIN
- Milwaukee

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