Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** DURABOND JOINT COMPOUND ALL PURPOSE	No. 61-2-12-3-4 Date 6-4-74 Page 2 Cancels Page 2 Dated 2-26-74

FORMULA

	R/M No.		DURABOND 45 GB-217	DURABOND 90 GB-236B
	61741 or 61682	Asbestos JM-TRF02 or TRF-66	4.5% ± 1.0%	4.5% ± 1.0%
C	66688	Vancide MZ96 (Note 1)	.1	.1
	61747	Mica P 80 F	12.0	12.0
	66458	Methocel GM-65	.5	.5
C	65765	Vinac RP-251 (Note 2)	5.0	5.0
	61562	E-Base HYDROCAL	To make 100%	To make 100%
	66948	Sodate Retarder	.2 ± .1	1.0 ± .1
	67595	Potassium Sulfate Type II	.2 ± .1	.1 ± .1
	67061	Sorbitol Powder	.5	.5

A NOTE 1: or Ziram
A NOTE 2: or Monsanto RS 6402

RAW MATERIALS

R/M No.		Per
61741	Asbestos JMTRF02	PMS 6-17-10
66688	Vancide MZ96	PMS 6-100-11
61747	Mica P-80F	PMS 6-143-1
66458	Methocel GM-65	PMS 6-151-16
65765	Vinac RP-251	PMS 6-104-18
61562	E-Base HYDROCAL	Per Bulletin 52-22-26
66948	Sodate Retarder	Per Bulletin 52-22-20
67595	Potassium Sulfate Type II	PMS 6-99-2
67061	Sorbitol Powder	Chas. Pfizer Co.
61682	TRF-66 Asbestos	PMS 6-17-10
A 66683	Ziram	PMS 6-100-11
A 65777	RS6402	Monsanto

MANUFACTURING PROCEDURE

C In normal manner used for manufacture of DURABOND Joint Compound, (See 61-2-12-1) except a clean out charge Must Be Run before the manufacture of this material.
C Even a small amount of 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.

Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** DURABOND JOINT COMPOUND ALL PURPOSE	No. 61-2-12-3-- Date 2-26-74 Page 2 Cancels Page 2 Dated 9-13-73

FORMULA

	R/M No.	DURABOND 45 GB-217	DURABOND 90 GB-236B
Asbestos JM-7RF02 or TRF-66	61741 or 61682	4.5% ± 1.0%	4.5% ± 1.0%
Vancide MZ96	66688	.1	.1
Mica P 80F	61747	12.0	12.0
Methocel GM-65	66458	.5	.5
Vinac RP-251	65765	5.0	5.0
E-Base HYDROCAL	61562	To make 100%	To make 100%
Sodate Retarder	66948	.2 ± .1	1.0 ± .1
Potassium Sulfate Type II	67595	.2 ± .1	.1 ± .1
D Sorbitol Powder	67061	.5	.5

D

RAW MATERIALS

Asbestos JM7RF02	61741	PMS 6-17-10
Vancide MZ96	66688	PMS 6-100-11
Mica P-80F	61747	PMS 6-143-1
Methocel GM-65	66458	PMS 6-151-16
Vinac RP-251	65765	PMS 6-104-18
E-Base HYDROCAL	61562	Per Bulletin 52-22-26
Sodate Retarder	66948	Per Bulletin 52-22-20
Potassium Sulfate Type II	67595	PMS 6-99-2
C Sorbitol Powder	67061	Chas. Pfizer Co.
D TRF-66 Asbestos	61682	PMS 6-17-10

D

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.

C Indicates Change
D Indicates Deletion

Cancels Temporary Bulletin 61-2-12-1-T Dated 11-27-72

Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** DURABOND JOINT COMPOUND ALL PURPOSE	No. 61-2-12-3-4 Date 6-5-73 Page 1 Cancels NEW Dated

DESCRIPTION

DURABOND All Purpose 45 and DURABOND All Purpose 90 are powder setting type joint compounds which can be used for taping, filling and finishing coats. It can also be painted while damp with specified coatings.

MANUFACTURING PLANT

South Gate

IDENTIFICATION AND PACKAGING

This material to be packaged and shipped in DURABOND 90 bags over-stamped: "ALL PURPOSE" and including "45" when applicable.

SHIPMENT

All orders to be shipped with 90 minute setting range unless DURABOND All Purpose 45 is specifically ordered. Plant to have one week lead time except for demonstration material for Product Manager.

FINISHED PRODUCT SPECIFICATIONS

Consistency (cc water/100 grams)	56-58cc
Viscosity VC-3 Brabender pin	500-550BB
pH @ 77°F	8.0 - 8.5
Room Condition Bond to PERF-A-TAPE	7
Set Time (Vicat)	35-55 minutes as DURABOND 45 80-100 minutes as DURABOND 90

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Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** DURABOND JOINT COMPOUND ALL PURPOSE	No. 61-2-12-3-4 Date 6-5-73 Page 2 Cancels NEW Dated

FORMULA

	DURABOND 45 GB-217	DURABOND 90 GB-236B
Asbestos JM-7RF02	4.5% ± 1.0%	4.5% ± 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 ± .1	1.0 ± .1
Potassium Sulfate Type II	.2 ± .1	.1 ± .1
Sorbitol Powder	.5	.5
Tributyl Phosphate	.2	.2

RAW MATERIALS

Asbestos JM7RF02	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