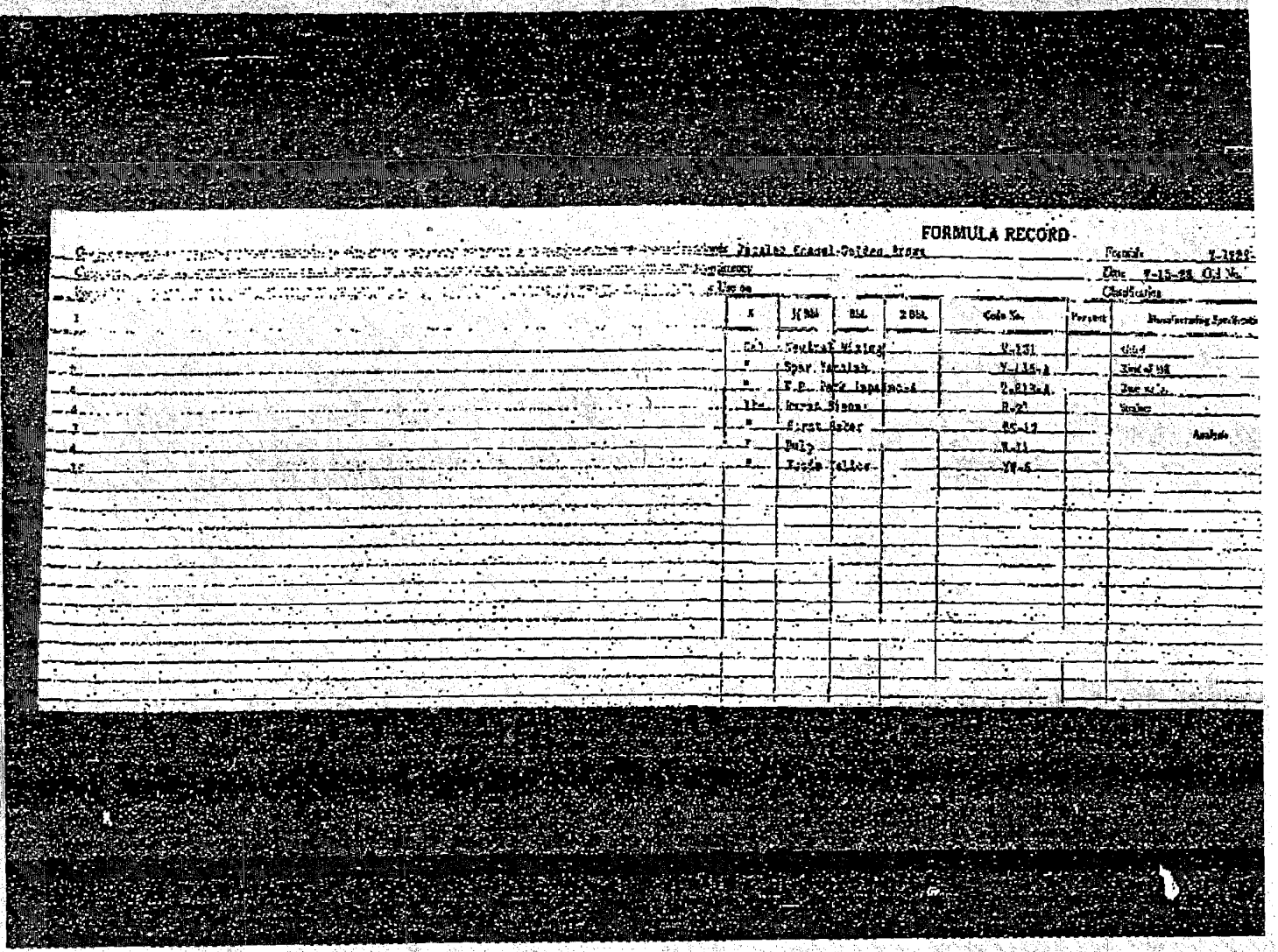

FORMULA RECORD

[illegible] Parallel Gravel-Golden Brown — Formula: [illegible]

[illegible] — Date: [illegible] Old No.

[illegible] — Classification

	K	½ Bbl.	Bbl.	2 Bbl.	Code No.	Percent	Manufacturing Specification
1							
2	Gal.	Neutral Mixing			V-131		Grind
3	"	Spar Varnish			V-135-A		Kind of Oil
4	"	F.P. Dark Japanese			V-213-A		Dose [illegible]
5	lbs.	Burnt Sienna			R-21		Strainer
6	"	Burnt Ember			RS-12		Analysis
7	"	Pulp			W-11		
8	"	Trade Yellow			YW-6		

N12385

GLD060166

FORMULA RECORD

A 450 5m 5-25

Goods Papalac Enamel-Golden Brown — Formula V-1229-A

Consistency — Date 7-16-25 Old No.

For Use on — Classification

1/2	6	1/2 Bbl	Bbl.	2 Bbl.	Code No.	Per cent	Manufacturing Specifications
2	Gal.	Neutral Mixing			V-131		Grind
2	"	Spar Varnish			V-135-A		Kind of Mill
4	"	W.P. Dark Japalac-A			V-218-A		Rate per hr.
4	lbs.	Burnt Sienna			S-21		Strainer
3	"	Burnt Umber			BU-17		Analysis
4	"	Pulp			W-11		
16	"	Woods Yellow			YW-6		

GLD060167

FORMULA RECORD

A 430 Im 1-28
Printed in U.S.A.

Goods: Japalac Enamel - Golden Brown Formula No. Y-1229-B

Consistency Date 8-3-28 Old No.

For Use on Cost Classification

1	5	½ Bbl	Bbl.	2 Bbl.	Code No.	Per cent	Manufacturing Specifications
25	gal.	Neutral Mixing			V-131		Grind
25	"	No. 2 Oil			V-202-A		Kind of Mill
43	"	W. P. Dk. Japalac			V-218-A		Rate per hr.
2	"	E-Japan			D-5		Strainer
5	"	Varnolene			S-43		Weight per Gallon
50	lbs.	Burnt Sienna			R-21		Light Baume Temp.
37 1/2	"	Burnt Umber			BR-17		Heavy Baume Temp.
200	"	Woods Yellow			YW-6		Viscosity Temp.
50	"	asbestine Pulp			W-11		Make of Viscosimeter
							Flash Point
							Is Agitator Package Required
							Remarks
Yield							

GLD060168

M-47-6M-11-40 PRINTED IN U.S.A. (B CO.)

COST DEPARTMENT RECORD

Classified Formula No. 4-1229C(N)

Goods JAPALAC ENAMEL-GOLDEN BROWN-(TEMP. RD6) Laboratory Formula No.

Consistency R.M. Date 2-13-41 Factory Letter No. R-071-178

For Use on Production No.

Customer Cost Classification

Ingredient Code Number	Lab'ty Formula	Large Batch Pounds	Large Batch Gallons	Do not write in these columns For Cost Department Use Only	Manufacturing Specifications
W-77	1 7/8	120			Grind "A"
BN-17	7/8	24			Kind of Mill Stone
R-21	3/4	48			Strainer Tinc
YW-2	7/16	28			Weight per Gallon
YW-37	3/32	6			Light Baume Temp.
W-11	1 1/4	80			Heavy Baume Temp.
G) V-109	3 1/2		28		Viscosity 127 1/2" Temp 80°
V-119	1 1/2		12		Viscosimeter #4 Ford
V-706	2		16		Flash Point
RVL-1191	1		8		Is Agitator Required
VM-430	3/32		3/4		
8742	Trace				Formulator J. FRYCE
Yield					

GLD060170

N-47 SM 11-40 PRINTED IN U.S.A. (B CO.)

COST DEPARTMENT RECORD

Classified Formula No. 4-1219 D (RM)

Goods JAPALAC ENAMEL - GOLDEN BROWN

Laboratory Formula No.

Consistency R.M. Date 6-12-41

Factory Letter No. R-061-021

For Use on

Production No.

Customer

Cost Classification

Ingredient Code Number	Lab'ry Formula	Large Batch: Pounds	Large Batch: Gallons	Do not write in these columns For Cost Department Use Only						Manufacturing Specifications
R-21	11½	96								Grind "A"
BN-17	3/4	48								Kind of Mill Stone
4W-2	13/32	70								Strainer Fine
167-9206	½	32								Weight per Gallon
W-91	3/4	48								Light Baume Temp
W-11	¼	16								Heavy Baume Temp
VM-308	1/16	4								Viscosity 1150" Temp 80°
G) V-850	3¾		30							Viscosimeter #4 Ford
V-318	3¾		30							Flash Point
S-43	½		4							Is Agitator Required
D-29	1/8		1							
D-44	1/16		½							Formulator J. FRYCE
Yield										

GLD060171

460-D 50M 6-40 PRINTED IN U.S.A. (WP)

FORMULA RECORD

Goods Japalac Enamel Golden Brown — Formula No. Y1229 D

Consistency Liquid — Date 2/24/41 — Laboratory No.

For Use on — Cost Classification

Code Number	One Gallon Batch Pints	Lbs.	Ozs.	Gallon Batch Gals.	Lbs.	Ozs.	Gallon Batch Gals.	Lbs.	Ozs.	Manufacturing Specifications
R 237			14	oz.						Grind Ok
B 223			4							Kind of Mill Stone
Y 116		2	4							Strainer
W 11			8							Weight per Gallon 9 lb
V 308			1	Lwt						Light Baume Temp.
										Heavy Baume Temp.
V 850	3 3/4									Viscosity 110 Temp.
V 318	3 3/4									Viscosimeter
S 43	1/2									Flash Point
										Is Agitator Required
D 29			2	Top to Gal						Remarks Hayward
D 27			1	" " "						Per
										JPW
		Changed to new Japalac quality								
										Match Porcelain
Grind in V 850										Panel
Yield										

DISCONTINUED SEE Y1229E

GLD060172

N-47 5M 11-49 PRINTED IN U.S.A. (B CO.)

COST DEPARTMENT RECORD

Classified Formula No. 40Y

Goods Jaffalac Cranmel Golden Brown (Rdg)

Laboratory Formula No. 4229E TEMP.

Consistency

Date 4/24/42

Factory Letter No. R-032-052

For Use on

Production No.

Customer

Cost Classification

Ingredient Code Number	Lab'ty Formula	Large Batch Pounds	Large Batch Gallons	Do not write in these columns For Cost Department Use Only						Manufacturing Specifications
YW-2		32								Grind "A"
R-21		48								Kind of Mill STONE
BN-17		16								Strainer
W-77		48								Weight per Gallon 10#
YW-37		8								Light Baume Temp.
W-11		32								Heavy Baume Temp.
W-10		64								Viscosity 1'40" ± 5" Temp.
2-KB-74			44							Viscosimeter
RVL-1273			16							Flash Point
S-43			4							Is Agitator Required
D-40			3/4							
CH-189 SUB.			12 L.D.							Formulator Schetter
Yield										

GLD060173

4800 25M 1-41 PRINTED IN U.S.A. WPI

FORMULA RECORD

Goods JAP-A-LAC ENAMEL GOLDEN BROWN Formula No. Y 1229 G

Consistency Date 9-26-41 Laboratory No.

For Use on Cost Classification

Code Number	One Gallon Batch			Gallon Batch			Gallon Batch			Manufacturing Specification
	Pints	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	
R 237			14							Grind A
BN 23			4							Kind of Mill STONE
YW 6		2	4							Strainer
W H			8							Weight per Gallon 9 1/4#
VM 308			1							Light Baume Temp.
										Heavy Baume Temp.
V 706 S	4									Viscosity 110-120" Temp.
V 318 A	4									Viscosimeter
										Flash Point
D 29			2 1/2 OZ TO GAL							Is Agitator Required
D 2A			1 " "							Remarks
GRIND IN V 706 S										MATCH PORCELAIN PANEL
CHANGED BECAUSE V 550 NOT AVAILABLE										
Yield										HAYWARD

DISCONTINUED
SEE NOTE
(11/14/41)

GLD060174

MOLD 28M 1-41 PRINTED IN U.S.A. (WP)

FORMULA RECORD

DISCONTINUED

Goods Japalac Eng. Golden Brown Formula No. Y1229E

Consistency Liquid Date 11-19-41 Laboratory No.

For Use on Cost Classification

Code Number	One Gallon Batch			Gallon Batch			Gallon Batch			Manufacturing Specifications
	Parts	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	
R237			14					2		Grind a
BR23			4			Acc. page only				Kind of Mill Stone
YW6		2	4						1	Strainer
W11			8							Weight per Gallon 9 7/8
VM308			1							Light Baume Temp.
										Heavy Baume Temp.
V706-8	4									Viscosity 40-120" Temp.
V705-CL	4									Viscosimeter
										Flash Point
D29			2	Lg. to gal						Is Agitator Required
D2A			1	" "						Remarks
										Hayward
										Match Porcelain
				DISCONTINUED						Panel
				SEE Y1229						
				7/12/43						
Yield										

GLD060175

400-O 5014 PRINTED IN U.S.A. (6)

FORMULA RECORD

Goods [illegible] Formula No. [illegible]

Consistency [illegible] Date [illegible] Laboratory No. [illegible]

For Use on [illegible] Cost Classification

Code Number	One Gallon Batch			Gallon Batch			Gallon Batch			Manufacturing Specifications
	Pints	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	
[illegible]			[illegible]					[illegible]		Grind [illegible]
[illegible]			[illegible]					[illegible]		Kind of Mill [illegible]
[illegible]		[illegible]	[illegible]					[illegible]		Strainer
[illegible]			[illegible]					[illegible]		Weight per Gallon [illegible]
										Light Baume Temp.
[illegible]	[illegible]						[illegible]			Heavy Baume Temp.
[illegible]	[illegible]						[illegible]			Viscosity [illegible] Temp.
[illegible]	[illegible]						[illegible]			Viscosimeter
[illegible]	[illegible]						[illegible]			Flash Point
										Is Agitator Required
[illegible]			[illegible]	[illegible]			[illegible]			Remarks
[illegible]			[illegible]	[illegible]			[illegible]			[illegible]
										[illegible]
	[illegible]									[illegible]
Yield										

DISCONTINUED
SEE # 1229-Y 3/23/45

GLD060176

480-D 50M 2-44 PRINTED IN U.S.A. (B)

FORMULA RECORD

Goods Japalac-Golden Brown Enamel — Formula No. Y 1229 G

Consistency — Date 3-23-45 — Laboratory No.

For Use on — Cost Classification

Code Number	One Gallon Batch Pints	Lbs.	Ozs.	Gallon Batch Gals.	Lbs.	Ozs.	Gallon Batch Gals.	Lbs.	Ozs.	Manufacturing Specifications
R 237			14					70		Grind A
BN 23			4					20		Kind of Mill Stone
YW 6		2	4					180		Strainer
JW 181			8					40		Weight per Gallon 9 1/8
W 104			2					10		Light Baume Temp.
										Heavy Baume Temp.
V 357	1 1/2						15			Viscosity 86-90 Temp.
VR 45016	5 3/4						57 1/2			Viscosimeter
O 63	1/2						5			Flash Point
S 43	1/4						2 1/2			Is Agitator Required
										Remarks Hayward
VM 524			3 oz				1 7/8			
D 15			2 oz				1 1/4			Match Porcelain panel 1.45 oil/gal.
Yield										J.P.W.

Standard Formula Not to be taken from File.

replaced with Y 1259 1/17/45

Changed to new Japalac Quality

GLD060177

Characteristics and Method of Using		Cost Data				Customers
Type of Goods						
Color						
Luster						
Match for						
Kind of Reducer						
Amount of Reduction for						
Brushing						
Spraying	Pressure					all plants 3-29-45
Dipping	Drip Time	Analysis				
Flooding	Drip Time	Pigment				34.5% Toronto 8/27/4
Tumbling		Aluminum Bronze		21.9%		
Air dry to recoat		Burnt Umber		6.2%		
To Sand or Rub		[illegible]		56.4%		
Bake Time	Temp.	Magnesium Silicate		12.4%		
Rub with		Basic Carb White Lead		3.1%		
Polish with				100.0%		
Schedule		Vehicle				65.5%
		Varnish		86.9%		
		Boiled Linseed Oil		6.6%		
		Mineral Spirits		2.7%		
		Liquid Drier		3.8%		
				100.0%		

GLD060178