

August 20, 1982

Supersedes FORMULA TEX-971

dated 9/25/81

ACME, TEXAS PLANT FORMULA
READY MIX TOPPING COMPOUND TEX-971

DESCRIPTION: White Ready Mix Topping Compound used for finishing joints and spotting nail heads. To be used in 4-gallon cartons and 5-gallon pails.

FORMULA:

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Water	Solvent		--	1006.16 (121 gal)
-/ Gen Flo 6500	Adhesive		.80	17.45 (2.0 gal)
*MD-76	Defoamer	125	.09	2.0
Proxel CRL	Preservative		.11	2.39
Filler TEX-976	Filler		99.00	2150.00
			100.00	3176.00

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) *MD-76 Defoamer
- 4) Preservative
- 5) Filler
- 6) Mix as required.

WORKING CONSISTENCY:

Plant Testing Procedure No. 32.

Brabender -

As manufactured - 540 + 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.

-/ *Nalco-71-D-5 may be substituted at equal loading.

Continued on Page 2 . . .

BGR:ps

-/ Denotes change

SGP 0017388

ACME, TEXAS PLANT FORMULA

READY MIX FILLER TEX-97 (FILLER "Y")

DESCRIPTION OF PRODUCT

- Filler for Ready Mix Joint Compound.

FORMULA

Raw Material

Troysan CMP-10-Sep
Gelvatol RS-6219
Cellosize QP 100,000
Mica P-80H
Asbestos 7RF-9
Land Plaster TEX-25

Function

R.M.Spec.

Percent

Lbs/Batch

Fungicide	189	.10	2
Adhesive	162	1.00	20
Water retention aid	170	.50	10
Anti-cracking agent	11	8.00	160
Bulking agent	9	6.00	120
Filler	--	<u>84.40</u>	<u>1688</u>
		100.00	2000

WORKING CONSISTENCY:

Specifications:

- Refer to Plant Testing Procedure #32.

Maximum

Minimum

Average

67

60

64

WORKING PROPERTIES:

Specifications:

- Refer to Plant Testing Procedure #33.
Filler shall be very heavily bodied and possess fair plasticity. It shall be free of any coarse, gritty or undispersed particles.

COLOR:

Specifications:

- White
Dried compound shall be prepared according to formula No. TEX-973 at least twice a day or with every 7th batch of filler manufactured. This prepared mix shall be tested and shall meet all specifications required of Ready Mix Joint Compound - Formula No. TEX-973.

ACME, TEXAS PLANT FORMULA

READY MIX FILLER TEX- 971 (FILLER "Y")

DESCRIPTION OF PRODUCT

- Filler for Ready Mix Joint Compound.

FORMULA

Raw Material

VANCIDE

~~Troysan GNP-10-Sep~~
Gelvato RS-6219
Cellosize QP 100,000
Mica P-80H
Asbestos 7RF-9
Land Plaster TEX-25

Function

R,M.Spec.

Percent

Lbs/Batch

Fungicide

189

30
10

6

Adhesive

162

1.00

20

Water retention aid

170

.50

10

Anti-cracking agent

11

8.00

160

Bulking agent

9

6.00

120

Filler

--

84.40

1688

100.00

2000

WORKING CONSISTENCY:

Specifications:

- Refer to Plant Testing Procedure #32.

Maximum

Minimum

Average

67

60

64

WORKING PROPERTIES:

Specifications:

- Refer to Plant Testing Procedure #33.
Filler shall be very heavily bodied and possess fair plasticity. It shall be free of any coarse, gritty or undispersed particles.

COLOR:

Specifications:

- White
Dried compound shall be prepared according to formula No. TEX-973 at least twice a day or with every 7th batch of filler manufactured.
This prepared mix shall be tested and shall meet all specifications required of Ready Mix Joint Compound - Formula No. TEX-973.

Gelvato 33.82 Mages on ft
Matorol 25.46
mica 12.54
Lysium 31.73 (loose)
" 49.78 (packed)
asbestos 20.14

ACME, TEXAS PLANT FORMULA

READY MIX FILLER TEX- 971 (FILLER "Y")

DESCRIPTION OF PRODUCT

- Filler for Ready Mix Joint Compound.

FORMULA

Raw Material

Troysan CMP-10-Sep
Gelvato1 RS-6219
Cellosize QP 100,000
Mica P-80H
Asbestos 7RF-9
Land Plaster TEX-25

Function

R,M,Spec.

Percent

Lbs/Batch

Fungicide	189	.10	2
Adhesive	162	1.00	20
Water retention aid	170	.50	10
Anti-cracking agent	11	8.00	160
Bulking agent	9	6.00	120
Filler	--	84.40	1688
		100.00	2000

WORKING CONSISTENCY:

Specifications:

- Refer to Plant Testing Procedure #32.

Maximum

Minimum

Average

67

60

64

WORKING PROPERTIES:

Specifications:

- Refer to Plant Testing Procedure #33.
Filler shall be very heavily bodied and possess fair plasticity. It shall be free of any coarse, gritty or undispersed particles.

COLOR:

Specifications:

- White
Dried compound shall be prepared according to formula No. TEX-973 at least twice a day or with every 7th batch of filler manufactured, This prepared mix shall be tested and shall meet all specifications required of Ready Mix Joint Compound - Formula No. TEX-973.

ACME, TEXAS PLANT FORMULA

READY MIX JOINT COMPOUND NO. TEX-971 (HAND TOOLS)

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

FORMULA:

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Nalco 71-D5	Anti-foaming agent	-	0.1	1.67 5.00
Water	Solvent	-	-	360.00 (43 gal)
Preplasticized PVA Emulsion	Adhesive	185	7.4	49.33 150.00
Filler TEX-970	-	-	92.5	613.67 1900.0
			100.0	1024.67

**One batch yields 18 ± one 5 gallon pails

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: 540 ± 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.

EDO:dek

April 14, 1972
Supersedes TEX-971
Dated 9/22/71

ACME, TEXAS PLANT FORMULA

READY MIX JOINT COMPOUND NO. TEX-971 (HAND TOOLS)

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

-/ FORMULA:

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Nalco 71-D5	Anti-foaming agent	-	0.1	5.00 4.6
Water	Solvent	-	-	1080.00 --998
Preplasticized PVA Emulsion	Adhesive	185	7.4	(129 gals) (120) * 148.00 137.00
Filler TEX-970	-	-	92.5	1841.00 1700
			100.0	3074.00

-/ **One batch yields 51 ± one 5 gallon pails

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:

~~540 ± 20~~
480 ± 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.

EDO:dek

-/ Denotes change in this reissue.

SGP 0017393

* 14 3/4 gal
For yellow ready mix add 1 lb 11 oz oxide

Lab batch of Ready Mix

200	grams	filler
16.2	grams	emulsion
117.3	grams	water

8

July 6, 1972
Supersedes TEX-971
Dated 4/14/72

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND #TEX-971 (MACHINE TOOLS)

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

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Nalco 71-D5	Anti-foaming agent	-	0.1	1.67 4.6
Water	Solvent	-	-	1245.00 (150 gal)
Preplasticized PVA Emulsion	Adhesive	185	5.0	100.00 * 92
Filler TEX-976	-	-	94.9	1898.00 1750
			100.0	3244.67

** One batch yields 65 ± one 4 gallon carton

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

- ~~385~~ ± 20
365

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

Specifications

- 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.

EDO:elz

* 10 gal

SGP 0017395

August 25, 1972
Supersedes TEX-971
Dated 7/6/72

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND #TEX-971 (MACHINE TOOLS)

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

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Nalco 71-D5	Anti-foaming agent	-	0.1	4.60
Water	Solvent	-	-	996.00 (120 gals)
Preplasticized PVA Emulsion	Adhesive	185	5.0	92.00 *
Filler TEX-976	-	-	94.9	1750.00
			100.0	2842.00

-/ ** One batch yields ⁵⁰~~60~~ ± one 4 gallon carton

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 - 365 ± 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
Specifications

- 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.

EDO:elz

-/ denotes change

* 10 gal

SGP 0017396

Septmeber 25, 1972
Supersedes TEX-971
Dated 8/25/72

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND #TEX-971 (MACHINE TOOLS)

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

<u>FORMULA</u>					
<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>	
Nalco 71-D5	Anti-foaming agent	-	0.1	5	4.60
Water	Solvent	-	-	1347.8	(150 gals)
Preplasticized PVA Emulsion	Adhesive	185	4.5	9.5	84.0 (9 gals.)
Filler TEX-976	-	-	95.4	200	1758.00
			100.0		2842.00

- / ** One batch yields ⁵⁰~~60~~ ± one 4 gallon carton or 45 ± one five 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 - ~~365~~ ± 20
315 12-1-72
- 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
Specifications
- 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.

EDO:elz

-/ denotes change

SGP 0017397

For yellow Ready mix add 1 lb 11 oz oxide

March 7, 1974
Supersedes TEX-971
Dated 9/25/72

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND #TEX-971 (MACHINE TOOLS)

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

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Nalco 71-D5	Anti-foaming agent	-	0.1	4.60
Water	Solvent	-	-	996.00 (150 gals)
Preplasticized PVA Emulsion	Adhesive	185	4.5	84.00 (9 gals.)
Filler TEX-976	-	-	95.4	1758.00
			100.0	2842.60

** One batch yields 60 ± one 4 gallon carton or 45 ± one five 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 365 ± 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 90% 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

Specifications

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

WNG:elz

- / denotes change

SGP 0017398

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND #TEX-971 (MACHINE TOOLS)

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

-/ FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Nalco 71-D5	Anti-foaming agent	125	0.25	4.60
Water	Solvent	-	-	996.00 (120 gals)
Preplasticized PVA Emulsion	Adhesive	185	2.00	37.00 (4 gals)
Filler TEX-976	-	-	97.75	1804.40
			100.0	2842.00

** One batch yields 60 $\pm$ one 4 gallon carton or 45 $\pm$ one five gallon pail.

WORKING CONSISTENCY

Specifications

Brabender Viscosity

- 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.
- 365 $\pm$ 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 90% 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

Specifications

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

WNG:elz

-/ denotes change

January 14, 1977
Supersedes TEX-971
Dated: 5/29/75

ACME, TEXAS PLANT FORMULA
READY MIX JOINT COMPOUND #TEX-971 (MACHINE TOOLS)

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

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Nalco 71-D5	Anti-foaming agent	125	0.25	4.60
-/ Water	Solvent	-	-	1129.00 (136 gals.)
Elvace EP-200	Adhesive	185	2.00	37.00 (4 gals.)
Filler TEX-976	--	-	<u>97.75</u>	<u>1804.40</u>
			100.00	2975.00

-/ **One batch yields 60 $\pm$ one 4 gallon carton or 48 $\pm$ one five 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 365 $\pm$ 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 90% 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
Specifications

- White
Dried compound shall match color of standard sample.

WNG/gvp

-/ denotes change

SGP 0017400

September 25, 1981
FORMULA TEX-971
New

ACME, TEXAS PLANT FORMULA
READY MIX TOPPING COMPOUND TEX-971

DESCRIPTION: White Ready Mix Topping Compound used for finishing joints and spotting nail heads. To be used in 4-gallon cartons and 5-gallon pails.

FORMULA:

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Water	Solvent		--	1006.16 (121 gal)
Gen Flo 6500	Adhesive		.80	17.45 (2.0 gal)
*Nalco 71-D-5	Defoamer	125	--	--
Proxel CRL	Preservative		.11	2.39
Filler TEX-976	Filler		99.09	2150.00
			100.00	3176.00

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 - 540 + 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.

Continued on Page 2

September 25, 1981
FORMULA TEX-971, Page 2
New

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 hours.

Retain Three Months: Maximum of 20 colonies
in 48 hours.

September 25, 1981
FORMULA TEX-971
New

ACME, TEXAS PLANT FORMULA
READY MIX TOPPING COMPOUND TEX-971

DESCRIPT ON: White Ready Mix Topping Compound used for finishing joints and spotting nail heads. To be used in 4-gallon cartons and 5-gallon pails.

FORMULA.

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Water	Solvent		--	1006.16 (121 gal
Gen Flo 6500	Adhesive		.80	17.45 (2.0 gal
*Nalco 71-D-5	Defoamer	125	--	--
Proxel CRL	Preservative		.11	2.39
Filler TEX-976	Filler		99.09	2150.00
			100.00	3176.00

Yield: One batch hields 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:

Brabender -

Plant Testing Procedure No. 32.

As manufactured - 540 + 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.

September 25, 1981
FORMULA TEX-971, Page 2
New

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 hours.

Retain Three Months: Maximum of 20 colonies
in 48 hours.

September 25, 1981
FORMULA TEX-971
New

ACME, TEXAS PLANT FORMULA
READY MIX TOPPING COMPOUND TEX-971

DESCRIPTION: White Ready Mix Topping Compound used for finishing joints and spotting nail heads. To be used in 4-gallon cartons and 5-gallon pails.

FORMULA:

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Water	Solvent		--	1006.16 (121 gal)
Gen Flo 6500	Adhesive		.80	17.45 (2.0 gal)
*Nalco 71-D-5	Defoamer	125	--	--
Proxel CRL	Preservative		.11	2.39
Filler TEX-976	Filler		99.09	2150.00
			<u>100.00</u>	<u>3176.00</u>

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 - 540 + 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.

Continued on Page 2

BGR:ps

SGP 0017405

**ACME FORMULA #971
ASBESTOS CONTAINING PRODUCTS**