

ACME, TEXAS PLANT FORMULA

READY MIX JOINT COMPOUND TEX-973 (HAND TOOLS) (READY MIX "X")

PLAINTIFF'S EXHIBIT

GP-1248

DESCRIPTION OF PRODUCT

- White Ready Mix Joint Compound used for taping, covering tape, filling cornerbead and spotting nails.

FORMULA:

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>#/Batch</u>
Water	Solvent	-		436.3 (52 gal.*)
Filler S-972	Bulking agent	-	91.66%	700.0
Polyvinyl Acetate Emulsion	Adhesive	185	7.86%	60.0
Benzoflex	Plasticizer	183	0.48%	3.7
			100.00%	1200.0 **

* Approximately 56.5 lbs./ 100 lbs. of active ingredients (this may vary $\pm$ 2 gallons per batch).

** One batch yields 18(+) - 5 gallon pails of Ready Mix Joint Compound at 65.6 lbs./pail.

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32

Specifications: - 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: 580 $\pm$ 20.

WORKING PROPERTIES: - Refer to Plant Testing Procedure No.33.

SPECIFICATIONS: - 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: Refer to Plant Testing Procedure No. 35.

SPECIFICATIONS: - After compound has dried, tape shall show at least, 75% fiber tear when delaminated.

CRACK RESISTANCE: - Refer to Plant Testing Procedure No. 37.

SPECIFICATIONS: - There shall be no large fissure cracks in the wedge, and no cracks in the thinner half of the wedge.

COLOR: - White

SPECIFICATIONS: - Dried compound shall match color of standard sample.

$$\begin{array}{r} 750 \\ .2 \\ \hline 1500 \end{array}$$

March 31, 1972
Acme No. TEX-973
NEW

ACME, TEXAS PLANT FORMULA

READY MIX FILLER TEX-973 (FILLER "X")

DESCRIPTION OF PRODUCT: - Filler for Ready Mix Joint Compound TEX-974 and TEX-975.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Asbestos 7RF09	Bulking agent	193	4.25	212.50 425.00
Dowicil 100	Fungicide	193	.15	7.50 15.00
Polyvinyl Alcohol	Adhesive <i>Helvatol 20-30</i>	I62	.60	30.00 60.00
Methocel 228	Water retention aid	11	.50	25.00 50.00
Mica	Anti-cracking agent	-	7.00	350.00 700.00
Asbestos (SG-210)	Bulking agent	13	1.75	87.50 175.00
Land Plaster	Filler	-	85.75	4287.50 8575.00
			100.00	5000.00 10,000.00

WORKING CONSISTENCY: - Refer to Plant Testing Procedure No. 32.
Specifications: Maximum Minimum Average
 65 60 62
 62 58 60

WORKING PROPERTIES: - Refer to Plant Testing Procedure No. 33.
Specifications Filler shall be very heavily bodied and possess fair plasticity. It shall be free of any coarse, gritty or undispersed particles.

COLOR: - White
Specifications Dried compound shall match color of standard sample.

NOTE: A wet mix of the filler shall be prepared according to Formula No. TEX-974 at least twice a day or with every 6th or 7th batch of filler manufactured. This prepared mix shall be tested and shall meet all the specifications required of Ready Mix Joint Compound - Formula No. TEX-974.

EDO:elz

Helvatol 33.82 lbs per cu ft
Mica 12.54
Gypsum 31.73 - loose
49.78 - packed
asbestos 20.14

SGP 0017595

1-24-72 *Gypsum taken out of hopper spout weighed 45# per cu ft*

ACME, TEXAS PLANT FORMULA

READY MIX FILLER TEX-973 (FILLER "X")

DESCRIPTION OF PRODUCT: - Filler for Ready Mix Joint Compound TEX-974 and TEX-975.

-/ FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Asbestos 7RF09	Bulking agent	193	4.25	340.00
Dowicil 100	Fungicide	193	.15	12.00
Polyvinyl Alcohol	Adhesive	162	.60	48.00
Methocel 228	Water retention aid	11	.50	40.00
Mica	Anti-cracking agent	-	7.00	560.00
Asbestos (SG-210)	Bulking agent	13	1.75	140.00
Land Plaster	Filler	-	81.75	6860.00
			100.00	8000.00

WORKING CONSISTENCY: - Refer to Plant Testing Procedure No. 32.
Specifications: Maximum Minimum Average

62	58	60
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WORKING PROPERTIES: - Refer to Plant Testing Procedure No. 33.
Specifications Filler shall be very heavily bodied and possess fair plasticity. It shall be free of any coarse, gritty or undispersed particles.

COLOR: - White
Specifications Dried compound shall match color of standard sample.

NOTE: A wet mix of the filler shall be prepared according to Formula No. TEX-971 at least twice a day or with every 6th or 7th batch of filler manufactured. This prepared mix shall be tested and shall meet all the specifications required of Ready Mix Joint Compound - Formula No. TEX-971.

EDO:elz

SGP 0017596

ACME, TEXAS PLANT FORMULA

READY MIX FILLER TEX-973 (FILLER "X")

DESCRIPTION OF PRODUCT: - Filler for Ready Mix Joint Compound TEX-974
and TEX-975.

-/ FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Asbestos 7RF09	Bulking agent	193	4.25	340.00
Dowicil 100	Fungicide	193	.15	12.00
Polyvinyl Alcohol <i>Relaxed 20-30</i>	Adhesive	162	.60	48.00
Gendriv 492S	Water retention aid	11	.50	40.00
Mica	Anti-cracking agent	-	7.00	560.00
Asbestos (SG-210)	Bulking agent	13	1.75	140.00
Land Plaster	Filler	-	85.75	6860.00
			100.00	8000.00

WORKING CONSISTENCY: - Refer to Plant Testing Procedure No. 32.
Specifications:

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
62	58	60

WORKING PROPERTIES: - Refer to Plant Testing Procedure No. 33.
Specifications Filler shall be very heavily bodied and possess fair plasticity. It shall be free of any coarse, gritty or undispersed particles.

COLOR: - White
Specifications Dried compound shall match color of standard sample.

NOTE: A wet mix of the filler shall be prepared according to Formula No. TEX-971 at least twice a day or with every 6th or 7th batch of filler manufactured. This prepared mix shall be tested and shall meet all the specifications required of Ready Mix Joint Compound - Formula No. TEX-971.

WNG:dek

April 12, 1973
Formula TEX-973
NEW

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND. NO. TEX-973 (HAND 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 5-gallon pails. To be supplied to Houston only.

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		0.1	2.0
Water	Solvent		-	972.0 (117 gal)
Filler TEX-977			<u>99.9</u>	<u>1800.0</u>
			100.00	2774.0

**One batch yields 60± one 4-gallon carton or 45 ± one 5-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 - 520 ± 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.

WNG:elz

SGP 0017598

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX - 973

DESCRIPTION OF PRODUCT - Filler for Ready Mix Topping Compound TEX-977.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Asbestos SG210	Fiber Filler	13	1.00	80.0
Gendriv 492S	Thickener	223	.50	40.0
Dowicil 75	Fungicide	193	.20	16.0
Asbestos 7RF9	Fiber Filler	9	5.00	400.0
Mica p80-H	Anti-cracking agent	11	4.00	320.0
Land Plaster TEX-25	Filler	-	74.30	5944.0
T. P. Blend Talc	Slip Agent	-	15.00	1200.0
			100.00	8000.0

<u>WORKING CONSISTENCY</u>	- Refer to Plant Testing Procedure No. 32		
<u>Specifications:</u>	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
	62	58	60

<u>WORKING PROPERTIES</u>	- Refer to Plant Testing Procedure No. 33
<u>Specifications</u>	- Filler shall be very heavily bodied and possess fair plasticity. It shall be free of any coarse gritty or undispersed particles.

<u>COLOR</u>	- White
<u>Specifications</u>	- Dried compound shall match color of standard sample.

NOTE: A wet mix of the filler shall be prepared according to Formula TEX-977 at least twice a day or with every sixth or seventh batch of filler manufactured. This prepared mix shall be tested and shall meet all the specifications required of Ready Mix Joint Compound - Formula No TEX-977.

WNG:vlm

February 27, 1975
Supersedes Formula TEX-973
Dated 3/7/74

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX - 973

DESCRIPTION OF PRODUCT - Filler for Ready Mix Topping Compound TEX-977.

-/FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Vancide	Preservative	126	.025	2.0
Gendriv 492S	Thickener	223	.50	40.0
Dowicil 75	Preservative	193	.175	14.0
Asbestos 7RF9	Fiber Filler	9	5.00	400.0
Mica p80-H	Anti-cracking agent	11	7.50	600.0
Land Plaster TEX-25	Filler	--	76.80	6144.0
T. P. Blend Talc	Slip agent	--	10.00	800.0
			100.00	8000.0

WORKING CONSISTENCY
Specifications:

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
62	58	60

WORKING PROPERTIES
Specifications:

- Refer to Plant Testing Procedure No. 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 match color of standard sample.

NOTE: A wet mix of the filler shall be prepared according to Formula TEX-977 at least twice a day or with every sixth or seventh batch of filler manufactured. This prepared mix shall be tested and shall meet all the specifications required of Ready Mix Joint Compound - Formula TEX-977.

WNG:jg

-/ denotes change

SGP 0017600

May 27, 1975
Supersedes Formula TEX-973
Dated 2/27/75

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX - 973

DESCRIPTION OF PRODUCT - Filler for Ready Mix Topping Compound TEX-977.

-/FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Vancide	Preservative	126	.025	2.0
Gendriv 492S	Thickener	223	.50	40.0
Dowicil 75	Preservative	193	.175	14.0
-/ Asbestos 7RF-02	Fiber Filler	9	3.25	260.0
Mica p80-H	Anti-cracking agent	11	7.50	600.0
Land Plaster TEX-25	Filler	--	78.55	6284.0
T. P. Blend Talc	Slip agent	2	10.00	800.0
			100.00	8000.0

WORKING CONSISTENCY
Specifications:

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
62	58	60

WORKING PROPERTIES
Specifications:

- Refer to Plant Testing Procedure No. 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 match color of standard sample.

NOTE: A wet mix of the filler shall be prepared according to Formula TEX-977 at least twice a day or with every sixth or seventh batch of filler manufactured. This prepared mix shall be tested and shall meet all the specifications required of Ready Mix Joint Compound - Formula TEX-977.

-/ *Asbestos 7RF9 may be substituted. Use at a loading of 5% (400 lbs/batch)

-/ denotes change

WNG:elz

SGP 0017601

September 11, 1975
Supersedes Formula TEX-973
Dated 5/27/75

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX - 973

DESCRIPTION OF PRODUCT - Filler for Ready Mix Topping Compound TEX-977.

-/FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Vancide	Preservative	126	.025	2.0
Gendriv 492S	Thickener	223	.50	40.0
Dowicil 75	Preservative	193	.175	14.0
-/ Asbestos SG-210	Fiber Filler	13	3.25	260.0
Mica p80-H	Anti-cracking agent	11	7.50	600.0
Land Plaster TEX-25	Filler	--	78.55	6284.0
T. P. Blend Talc	Slip agent	2	10.00	800.0
			100.00	8000.0

WORKING CONSISTENCY
Specifications:

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
62	58	60

WORKING PROPERTIES
Specifications:

- Refer to Plant Testing Procedure No. 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 match color of standard sample.

NOTE: A wet mix of the filler shall be prepared according to Formula TEX-977 at least twice a day or with every sixth or seventh batch of filler manufactured. This prepared mix shall be tested and shall meet all the specifications required of Ready Mix Joint Compound - Formula TEX-977.

-/

-/ denotes change

WNG: gvp

SGP 0017602

April 22, 1976
Supersedes Formula TEX-973
Dated 9/11/75

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX - 973

DESCRIPTION OF PRODUCT - Filler for Ready Mix Topping Compound TEX-977.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Vancide	Preservative	126	.025	2.0
-/ Galactosol 413-W	Thickener		.50	40.0
Dowicil 75	Preservative	193	.175	14.0
Asbestos SG-210	Fiber Filler	13	3.25	260.0
Mica p80-H	Anti-cracking agent	11	7.50	600.0
Land Plaster TEX-25	Filler	--	78.55	6284.0
T. P. Blend Talc	Slip agent	2	10.00	800.0
			100.00	8000.0

WORKING CONSISTENCY
Specifications:

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
62	58	60

WORKING PROPERTIES
Specifications:

- Refer to Plant Testing Procedure No. 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 match color of standard sample.

NOTE:

A wet mix of the filler shall be prepared according to Formula TEX-977 at least twice a day or with every sixth or seventh batch of filler manufactured. This prepared mix shall be tested and shall meet all the specifications required of Ready Mix Joint Compound - Formula TEX-977.

-/ denotes change

WNG: gvp

SGP 0017603

100.24
April 22, 1976
Supersedes Formula TEX-973
Dated 9/11/75

4/22/76

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX - 973

DESCRIPTION OF PRODUCT - Filler for Ready Mix Topping Compound TEX-977.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Vancide	Preservative	126	.025	2.0
-/ Galactosol 413-W	Thickener		.50	40.0
Dowicil 75 TROYESAN PNA 12 SEP	Preservative	127	.10 .175	14.0 6.0
Asbestos SG-210	Fiber Filler	13	3.25	260.0
Mica p80-H	Anti-cracking agent	11	7.50	600.0
Land Plaster TEX-25	Filler	--	76.65 78.55	6284.0 6292
T. P. Blend Talc	Slip agent	2	<u>10.00</u>	<u>800.0</u>
			100.00	8000.0

WORKING CONSISTENCY
Specifications:

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
62	58	60

WORKING PROPERTIES
Specifications:

- Refer to Plant Testing Procedure No. 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 match color of standard sample.

NOTE: A wet mix of the filler shall be prepared according to Formula TEX-977 at least twice a day or with every sixth or seventh batch of filler manufactured. This prepared mix shall be tested and shall meet all the specifications required of Ready Mix Joint Compound - Formula TEX-977.

-/ denotes change

WNG: gvp

SGP 0017604

November 24, 1976
Supersedes Formula TEX-973
Dated: 4/22/76

ACME, TEXAS PLANT FORMULA
READY MIX FILLER TEX-973

DESCRIPTION OF PRODUCT - Filler for Ready Mix Topping Compound TEX-977.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Galactosol 413-W	Thickener		.50	40.0
-/ Troysan PMA-10 SEP	Preservative		.10	8.0
Asbestos SG-210	Fiber Filler	13	3.25	260.0
Mica p80-H	Anti-cracking agent	11	7.50	600.0
-/ Land Plaster	Filler	-	78.65	6292.0
T.P. Blend Talc	Slip agent	2	<u>10.00</u>	<u>800.0</u>
			100.00	8000.0

<u>WORKING CONSISTENCY</u> <u>Specifications:</u>	- Refer to Plant Testing Procedure No. 32.		
	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
	62	58	60

<u>WORKING PROPERTIES</u> <u>Specifications:</u>	- Refer to Plant Testing Procedure No. 33.
	Filler shall be very heavily bodied and possess fair plasticity. It shall be free of any coarse, gritty or undispersed particles.

<u>COLOR</u> <u>Specifications:</u>	- White
	Dried compound shall match color of standard sample.

NOTE: A wet mix of the filler shall be prepared according to Formula TEX-977 at least twice a day or with every sixth or seventh batch of filler manufactured. This prepared mix shall be tested and shall meet all the specifications required of Ready Mix Joint Compound - Formula TEX-977.

WNG/gvp

-/ denotes change

SGP 0017605

May 19, 1977

Ready Mix Topping Formula TEX-973
NEW

ACME, TEXAS, PLANT FORMULA
READY MIX TOPPING COMPOUND NO. TEX - 973

DESCRIPTION OF PRODUCT - White Ready Mix Topping Compound used for finishing, filling corner beads and spotting nailheads. To be used in 4-gallon cartons and 5-gallon pails.

<u>FORMULA</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Nalco 71-D5	Anti-foaming agentb	125	0.1	2.00
Water	Solvent	-	-	1228.00 (148 gal.)
Elvace EP-200	Adhesive	185	2.0	40.00 (4.5 gal.)
Filler TEX-970	--	-	<u>97.9</u>	<u>1958.00</u>
			100.0	3228.00

One batch yields $64 \pm$ one 4 gallon carton or $52 \pm$ one 5 gallon pail.

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.
Specifications If paste is not of proper working consistency, a maximum of 5 cc water per 150 grams of paste may be added to adjust.

Brabender Viscosity - 520 ± 20

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications 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 - Refer to Plant Testing Procedure No. 35.
Specifications 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 - White
Specifications Dried compound shall match color of standard sample.

WNG: jr

SGP 0017606

September 15, 1977
Supersedes Topping Formula TEX-973
Dated May 19, 1977

ACME, TEXAS, PLANT FORMULA
READY MIX TOPPING COMPOUND NO. TEX - 973

DESCRIPTION OF PRODUCT - White Ready Mix Topping Compound used for finishing, filling corner beads and spotting nailheads. To be used in 4-gallon cartons and 5-gallon pails.

<u>FORMULA</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
-/ Dowicil	Preservative		.35	7.00
Nalco 71-D5	Anti-foaming agentb	125	0.1	2.00
-/ Water	Solvent	-	-	847.00 (102 gal.)
Elvace EP-200	Adhesive	185	2.0	40.00 (4.5 gal.)
-/ Filler TEX-970	--	-	97.55	1958.00
			100.0	2854.00

One batch yields $64 \pm$ one 4 gallon carton or $52 \pm$ one 5 gallon pail.

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.
Specifications If paste is not of proper working consistency, a maximum of 5 cc water per 150 grams of paste may be added to adjust.

Brabender Viscosity - 520 ± 20

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications 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 - Refer to Plant Testing Procedure No. 35.
Specifications 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 - White
Specifications Dried compound shall match color of standard sample.

-/ denotes change

WNG:jr

SGP 0017607

October 26 , 1977
Supersedes Topping Formula TEX-973
Dated September 15, 1977

ACME, TEXAS, PLANT FORMULA
READY MIX TOPPING COMPOUND NO. TEX - 973

DESCRIPTION OF PRODUCT - White Ready Mix Topping Compound used for finishing, filling corner beads and spotting nailheads. To be used in 4-gallon cartons and 5-gallon pails.

<u>FORMULA</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
-/ Proxcel CRL	Preservative		.115	2.23
Nalco 71-D5	Anti-foaming agentb	125	0.1	2.00
Water	Solvent	-	-	847.00 (102 gal.)
Elvace EP-200	Adhesive	185	2.0	40.00 (4.5 gal.)
-/ Filler TEX-970	--	-	97.785	1962.77
			100.0	2854.00

One batch yields 64 $\pm$ one 4 gallon carton or 52 $\pm$ one 5 gallon pail.

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.
Specifications If paste is not of proper working consistency, a maximum of 5 cc water per 150 grams of paste may be added to adjust.

Brabender Viscosity - 520 $\pm$ 20

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications 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 - Refer to Plant Testing Procedure No. 35.
Specifications 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 - White
Specifications Dried compound shall match color of standard sample.

-/ denotes change

HCF:jr

SGP 0017608

January 17, 1978
Supersedes Topping Formula TEX-973
Dated: 10-26-77

ACME, TEXAS, PLANT FORMULA
READY MIX TOPPING COMPOUND NO. TEX - 973

DESCRIPTION OF PRODUCT - White Ready Mix Topping Compound used for finishing, filling corner beads and spotting nailheads. To be used in 4-gallon cartons and 5-gallon pails.

<u>FORMULA</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Proxcel CRL	Preservative		.115	2.23
Nalco 71-D5	Anti-foaming agentb	125	0.1	2.00
Water	Solvent	-	-	847.00 (102 gal.)
Elvace EP-200	Adhesive	185	2.0	100.00 (11.73 gal.)
-/ Filler TEX-976	--	-	97.585	1962.77
-/ Acrysol-ASE-60	Thickener	147	.20	4.00
			<u>100.0</u>	<u>2918.00</u>

One batch yields $64 \pm$ one 4 gallon carton or $52 \pm$ one 5 gallon pail.

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.
Specifications If paste is not of proper working consistency, a maximum of 5 cc water per 150 grams of paste may be added to adjust.

Brabender Viscosity - 460 ± 20

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications 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 - Refer to Plant Testing Procedure No. 35.
Specifications 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 - White
Specifications Dried compound shall match color of standard sample.

-/ denotes change

HCF:jr

SGP 0017609

February 15, 1978
Supersedes Topping Formula TEX-973
Dated: 1-17-77

ACME, TEXAS, PLANT FORMULA
READY MIX TOPPING COMPOUND NO. TEX - 973

DESCRIPTION OF PRODUCT - White Ready Mix Topping Compound used for finishing, filling corner beads and spotting nailheads. To be used in 4-gallon cartons and 5-gallon pails.

<u>FORMULA</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Proxcel CRL	Preservative		.115	2.32
Nalco 71-D5	Anti-foaming agentb	125	0.1	2.00
Water	Solvent	-	-	847.00 (102 gal.)
Elvace EP-200	Adhesive	185	3.0	61.00 (7.0 gal.)
-/ Filler TEX-976	--	-	96.585	1950.00
-/ Acrysol-ASE-60	Thickener	147	.20	4.00
			<u>100.0</u>	<u>2866.32</u>

One batch yields 64 $\pm$ one 4 gallon carton or 52 $\pm$ one 5 gallon pail.

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.
Specifications If paste is not of proper working consistency, a maximum of 5 cc water per 150 grams of paste may be added to adjust.

Brabender Viscosity - 460 $\pm$ 20

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications 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 - Refer to Plant Testing Procedure No. 35.
Specifications 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 - White
Specifications Dried compound shall match color of standard sample.

-/ denotes change

HCF:jr

SGP 0017610

May 2, 1978
Supersedes Topping Formula TEX-973
Dated: 2/15/78

ACME, TEXAS, PLANT FORMULA
READY MIX TOPPING COMPOUND NO. TEX - 973

DESCRIPTION OF PRODUCT - White Ready Mix Topping Compound used for finishing, filling corner beads and spotting nailheads. To be used in 4-gallon cartons and 5-gallon pails.

<u>FORMULA</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Proxcel CRL	Preservative		.115	2.32
-/Nalco 71-D5	Anti-foaming agent	125	.099	2.00
-/Water	Solvent	-	-	886.68 (107 gal.)
-/Elvace EP-200	Adhesive	185	3.024	61.00 (7.0 gal.)
-/ Filler TEX-976	--	-	96.663	1950.00
-/ Acrysol-ASE-60	Thickener	147	.099	2.00
			100.0	2934.00

One batch yields 64 $\pm$ one 4 gallon carton or 52 $\pm$ one 5 gallon pail.

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.
Specifications If paste is not of proper working consistency, a maximum of 5 cc water per 150 grams of paste may be added to adjust.

Brabender Viscosity - 460 $\pm$ 20

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications 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 - Refer to Plant Testing Procedure No. 35.
Specifications 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 - White
Specifications Dried compound shall match color of standard sample.

-/ denotes change

HCF:jr

SGP 0017611

December 13, 1978

Supersedes Topping Formula TEX-973

Dated: 5/2/78

ACME, TEXAS, PLANT FORMULA
READY MIX TOPPING COMPOUND NO. TEX-973

DESCRIPTION OF PRODUCT - White Ready Mix Topping Compound used for finishing, filling corner beads and spotting nailheads. To be used in 4-gallon cartons and 5-gallon pails.

<u>FORMULA</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
PMA-30	Preservative		.115	2.32
Nalco 71-D5	Anti-foaming agent	125	.099	2.00
Water	Solvent	-	-	1042.50 (125 gal.)
Elvace EP-200	Adhesive	185	3.024	61.00 (7.0 gal.)
Filler TEX-976	-	-	96.663	1950.00
Acrysol-ASE-60	Thickener	147	.099	2.00
			<u>100.000</u>	<u>3059.82</u>

One batch yields $61 \pm$ one 4 gallon carton or $49 \pm$ 5 gallon pail.

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.
Specifications If paste is not of proper working consistency, a maximum of 5 cc water per 150 grams of paste may be added to adjust.

Brabender Viscosity - 460 ± 20

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications 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 - Refer to Plant Testing Procedure No. 35.
Specifications 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 - White
Specifications Dried compound shall match color of standard sample.

-/denotes change
GWG:jr

SGP 0017612

ACME, TEXAS PLANT FORMULA

READY MIX JOINT COMPOUND NO. TEX-973 (HAND TOOLS) (READY MIX "X")

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for taping, covering tape, filling cornerbead and spotting nails.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs./Batch</u>
Water 9.1	Solvent	-	-	400.0 (48 gal
Filler TEX-972	Bulking agent	-	91.66	700.0
Polyvinyl Acetate %s				
Emulsion	Adhesive	185	7.86	60.0
Benzoflex 4.5	Plasticizer	183	0.48	3.7
			100.00	1163.7**

* Approximately 52 lbs./100 lbs. of active ingredients (this may vary $\pm$ 2 gallons per batch).

** One batch yields ^(18.69) 17 (+ 5) gallons) pails of Ready Mix Joint Compound at ~~65.6~~ lbs./pail.
62.25

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:

- 580 $\pm$ ¹⁰ 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:

- 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

5 gal cartons = 6 1/4 lbs
4 gal cartons = 49 lbs

**ACME FORMULA #973
ASBESTOS CONTAINING PRODUCTS**