

September 20, 1963
 Supersedes Formula TEX-95.
 Dated Aug. 23, 1963

ACME, TEXAS PLANT FORMULA
HOUSTON AIRPURPOSE COMPOUND TEX-952

PLAINTIFF'S EXHIBIT

GP-1258

FORMULA

RAW MATERIAL	SOURCE	S.M. SPEC.	%	Lbs./Batch
Di-Ammonium Phosphate	Open Market	-	0.025	0.5
Vancide 51Z	R.T. Vandervilt Co.	126	0.10	2.0
Petro-AD	The Threnley Co.	143	0.10	2.0
Kelsize LV, #2166	Kelco Co.	-	0.25	5.0
Zinc Oxide	Mallinkrodt Chem. Works	119	0.35	7.0
Soda Ash	Open Market	32	0.50	10.0
Kaysoy, 200C	Archer-Daniels-Midland	122	2.50	50.0
Casein, 100M	International Casein Co.	10	5.00	100.0
-/ Asbestos, 7RF-9	Phillip Carey Co.	9	5.50	110.0
Mica P80-H	Western Mica Co.		16.00	320.0
-/ Mica 71-D5	Nalco Chemical Co.		0.05	1.0
Limastone	Purestone Co.	13	69.60	1392.0
Santobrite Fines (#1)	Monsanto Chem. Co.	15	0.025	0.5
			100.000	2000.0

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

Specification	-	<u>Max.</u> 72	<u>Min.</u> 64	<u>Ave.</u> 69
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ALKALINITY - Refer to Plant Testing Procedure No. 34.

Specification pH	-	<u>Max.</u> 9.3	<u>Min.</u> 8.7	<u>Ave.</u> 9.0
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However, minimum soda ash content - 0.55%

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

Specification - Wet mix shall be plastic and buttery working and free of coarse or gritty particles.

BONDING PROPERTIES - Refer to Plant Testing Procedure No. 35.

Specification - After compound has dried, tape shall delaminate when peeled back.

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

Specification - There shall be no large fissure cracks in the wedge and very few, if any, cracks in the thinner half of the wedge.

COLOR - White

Specification - Dried compound should match color of ivory wallboard paper closely and be free of color streaks.

-/ Denotes change.

SGP 0017144

August 25, 1966
TEX-952
NEW FORMULA

ACME, TEXAS PLANT FORMULA

ALL PURPOSE COMPOUND TEX-952
(For Memphis, Tenn. Area Only)

DESCRIPTION OF PRODUCT - All Purpose Compound for taping, topping joints, and spotting nailheads and texturing.

<u>FORMULA</u>	<u>Source</u>	<u>R.M. Spec.</u>	<u>%</u>	<u>Lbs./Batch</u>
<u>Raw Materials</u>				
Vancide 512	R. T. Vanderbilt	126	0.075	1.5
Petro - AD	The Thornley Co.	143	0.10	2.0
Natrosol 250 HXR (Fine Grind)	Hercules Powder	170	0.30	6.0
Zinc Oxide	Mallinkrodt Co.	119	0.10	2.0
Soda Ash	Open Market	32	0.40	8.0
Borax	Open Market		0.15	3.0
Casein 100M	International Casein Co.	10	4.5	90.0
Asbestos 7RF9	Phillip Carey	9	5.5	110.0
Mica P80H	Western Mica Co.	11	17.0	340.0
Naico 71-D5	Naico Chemical Co.		0.025	0.5
Limestone (Pure- stone)	Purestone Co.	13	71.85	1437.0
			100.000	2000.0

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

<u>Specifications:</u>	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
	72	64	68

ALKALINITY - Refer to Plant Testing Procedure No. 34.

<u>pH Specifications:</u>	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
	9.2	8.6	8.9

Minimum soda ash content - 0.40%

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

Specifications: Wet mix shall be plastic and buttery working and free of grit or coarse particles.

CRACK RESISTANCE -

Specifications: There shall be at most, only a couple of very small cracks in the wedge.

COLOR -

Specifications: Dried compound should be a neutral color and match the standard sample.

DAM:se

2-18-69

We do not make this
formula any more.

Per John Moss

SGP 0017145

ACME, TEXAS PLANT FORMULA

ALL PURPOSE COMPOUND TEX-952
(For Memphis, Tenn. Area Only)

DESCRIPTION OF PRODUCT - All Purpose Compound for taping, topping joints, and spotting nailheads and texturing.

-/ FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>%</u>	<u>Lbs./Batch</u>
Vancide 51Z	Fungicide	126	0.075	1.5
Petro AD	Wetting Agent	143	0.10	2.0
Natrosol 250 HXR (Fine Grind)	Water Retention Agent	170	0.30	6.0
Zinc Oxide	Viscosity Stabilizer	119	0.10	2.0
Soda Ash	Alkaline Source	32	0.40	8.0
Borax	Alkaline Source		0.15	3.0
Casein 100M	Adhesive	10	4.5	90.0
Asbestos 7RF9	Bulk	9	5.5	110.0
Mica p80H	Anti-Cracking Agent	11	17.0	340.0
Defoamer MIII	Anti-Foaming Agent	196	0.025	0.5
Limestone (Purestone)	Filler	13	<u>71.85</u> 100.000	<u>1427.0</u> 2000.0

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.
Specifications: - Maximum Minimum Average
 72 64 68

ALKALINITY - Refer to Plant Testing Procedure No. 34.
pH Specifications: Maximum Minimum Average
 9.2 8.6 8.9

Minimum soda ash content - 0.40%

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications: Wet mix shall be plastic and buttery working and free of grit or coarse particles.

CRACK RESISTANCE - There shall be at most, only a couple of very
Specifications: small cracks in the wedge.

COLOR -
Specifications: Dried compound should be a neutral color and match the standard sample.

EDON:kgc

-/ Denotes change in this reissue.

ACME, TEXAS PLANT FORMULA

ALL PURPOSE JOINT COMPOUND FORMULA NO. TEX-952

DESCRIPTION OF PRODUCT: - All Purpose compound for taping and finishing joints, spotting nailheads and texturing.

-/ FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M.Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Vanicide	Fungicide	126	.05	1.0
Cellosize QP 100,000	Water Retention aid	170	.20	4.0
Gelvato1 RS6219	Adhesive	162	2.5	50.0
Gelva GP 702	Adhesive	161	1.0	20.0
Asbestos 7RF-9	Bulking agent	9	4.0	80.0
Mica P80-H	Anti Cracking agent	11	5.0	100.0
Defoamer M111	Anti Foaming agent	196	.1	2.0
Land Plaster TEX-25	Filler	-	87.15	1743.0
			100.00	2000.0

WORKING CONSISTENCY:
Specifications:

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
58	52	55

WORKING PROPERTIES:
Specifications:

- Refer to Plant Testing Procedure No. 33.
Wet mix shall be plastic and buttery working and free of grit or coarse particles.

BONDING PROPERTIES:
Specifications:

- Refer to Plant Testing Procedure No. 35.
After compound has dried, tape shall delaminate when peeled back.

CRACK RESISTANCE:
Specifications

- There shall be at most only a couple of very small cracks in the wedge.

COLOR:
Specifications:

- White
Dried compound shall not vary in color from preceding batches.

EDO:dek

-/ Denotes change in this reissue.

SGP 0017147

ACME, TEXAS PLANT FORMULA

ALL PURPOSE JOINT COMPOUND FORMULA NO. TEX-952

DESCRIPTION OF PRODUCT: - All Purpose compound for taping and finishing joints, spotting nailheads and texturing.

<u>Formula</u> <u>Raw Material</u>	<u>Function</u>	<u>R.M.Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Vanicide	Fungicide	126	.05	1.0
Cellosize QP 100,000	Water Retention aid	170	.20	4.0
Gelvatol RS6219	Adhesive	162	2.5	50.0
Gelva GP 702	Adhesive	161	1.0	20.0
Asbestos 7RF-9	Bulking agent	9	4.0	80.0
Mica P80-H	Anti Cracking agent	11	5.0	100.0
Defoamer M111	Anti Foaming agent	196	.1	2.0
Land Plaster TEX-25	Filler	-	87.15	1743.0
			100.00	2000.0

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

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
58	52	55

WORKING PROPERTIES: - Refer to Plant Testing Procedure No. 33.
Specifications: Wet mix shall be plastic and buttery working and free of grit or coarse particles.

BONDING PROPERTIES: - Refer to Plant Testing Procedure No. 35.
Specifications: After compound has dried, tape shall delaminate when peeled back.

CRACK RESISTANCE: - There shall be at most only a couple of very
Specifications small cracks in the wedge.

COLOR: - White
Specifications: Dried compound shall not vary in color from preceding batches.

EDO:dek

- Denotes change in this reissue.

SGP 0017148

ACME, TEXAS PLANT FORMULA

ALL PURPOSE JOINT COMPOUND FORMULA NO. TEX-952

12-18-70
#49.32

DESCRIPTION OF PRODUCT: - All Purpose compound for taping and finishing joints, spotting nailheads and texturing.

-/ FORMULA:

<u>Raw Material</u>	<u>Function</u>	<u>R.M.Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>	
Vanicide	Fungicide	126	.05	1.0	.1
Cellosize QP 100,000	Water Retention aid	170	.30	6.0	.6
Gelvato1 RS-6219	Adhesive	162	2.00	40.0	4.0
Gelva GP 702	Adhesive	161	1.00	20.0	2.0
Asbestos 7RF-9	Bulking agent	9	5.00	100.0	10.0
Mica P8)-H	Anti Cracking agent	11	5.00	100.0	10.0
Defoamer M-11 NALCO	Anti Foaming agent	196	.10	2.0	.2
Land Plaster TEX-25	Filler	-	86.55	1731.0	173.1
			100.00	2000.0	

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

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
58	52	55

WORKING PROPERTIES: - Refer to Plant Testing Procedure No. 33.
Specifications: Wet mix shall be plastic and buttery working and free of grit or coarse particles.

BONDING PROPERTIES: - Refer to Plant Testing Procedure No. 35.
Specifications: After compound has dried, tape shall delaminate when peeled back.

CRACK RESISTANCE: - There shall be at most only a couple of very small cracks in the wedge.

COLOR: - White
Specifications: Dried compound shall not vary in color from preceding batches.

-/ Denotes change in this reissue.

June 30, 1971

Supersedes Formula No. TEX-952

Dated 9/1/70

ACME, TEXAS PLANT FORMULA

ALL PURPOSE JOINT COMPOUND FORMULA NO. TEX-952

9-27-71

150.99

DESCRIPTION OF PRODUCT: - All Purpose compound for taping and finishing joints, spotting nailheads and texturing.

-/ FORMULA:

<u>Raw Material</u>	<u>Function</u>	<u>R.M.Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>	
Gendriv 492S	Thickner	223	0.30	6.00	3
Vanicide 51Z	Fungicide	126	0.05	1.00	6
Gelvato1 6278C	Adhesive	126	2.00	40.00	240
Gelva GP702	Adhesive	161	1.00	20.00	120
Asbestos 7RF9	Fiber Filler	9	7.00	140.00	840
Mica p80-H	Anti-Cracking Agent	11	5.00	100.00	600
Defoamer M117	Anti-Foaming Agent	-	0.10	2.00	12
Land Plaster TEX-25	Filler	-	84.55	1691.00	
			100.00	2000.00	

-/ 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.
Wet mix shall be plastic and buttery working and free of grit or coarse particles.

BONDING PROPERTIES:
Specifications

- Refer to Plant Testing Procedure No. 35.
After compound has dried, tape shall delaminate when peeled back.

CRACK RESISTANCE:

- There shall be at most only a couple of very small cracks in the wedge.

COLOR:
Specifications

- White
Dried compound shall not vary in color from preceding batches.

-/ Denotes change in this reissue.

EDO:dek

SGP 0017150

ACME, TEXAS PLANT FORMULA

ALL PURPOSE JOINT COMPOUND FORMULA NO. TEX-952

11-22-71 48,24-

DESCRIPTION OF PRODUCT: - All Purpose compound for taping and finishing joints, spotting nailheads and texturing.

-/ FORMULA:

<u>Raw Material</u>	<u>Function</u>	<u>R.M.Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>	
Gendriv 492S	Thickner	223	0.30	6.00	24
Vanicide 51Z	Fungicide	126	0.05	1.00	4
Gelvato1 6278C	Adhesive	126	1.75	35.00	140
Gelva GP702	Adhesive	161	1.00	20.00	80
Asbestos 7RF9	Fiber Filler	9	7.00	140.00	560
Mica p80-H	Anti-Cracking Agent	11	5.00	100.00	400
Defoamer M117	Anti-Foaming Agent	-	0.10	2.00	8
Land Plaster TEX-25	Filler	-	84.80	1696.00	6784
			100.00	2000.00	8000

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.
Wet mix shall be plastic and buttery working and free of grit or coarse particles.

BONDING PROPERTIES:

Specifications

- Refer to Plant Testing Procedure No. 35.
After compound has dried, tape shall delaminate when peeled back.

CRACK RESISTANCE:

- There shall be at most only a couple of very small cracks in the wedge.

COLOR:

Specifications

- White
Dried compound shall not vary in color from preceding batches.

-/ Denotes change in this reissue.

EDO:dek

SGP 0017151

April 14, 1972

Supersedes Formula No. TEX-952

Dated 11/17/71

ACME, TEXAS PLANT FORMULA

ALL PURPOSE JOINT COMPOUND FORMULA NO. TEX-952

DESCRIPTION OF PRODUCT:

- All Purpose compound for taping and finishing joints, spotting nailheads and texturing.

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FORMULA:

<u>Raw Material</u>	<u>Function</u>	<u>R.M.Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Gendriv 492S	Thickner	223	0.30	24.00
Vanicide 51Z	Fungicide	126	0.05	4.00
Calvatol 6278C	Adhesive	126	1.75	140.00
Gelva GP702	Adhesive	161	1.00	80.00
Asbestos 7RF9	Fiber Filler	9	7.00	560.00
Mica p80-H	Anti-Cracking Agent	11	5.00	400.00
Defoamer M117	Anti-Foaming Agent	-	0.10	8.00
Land Plaster TEX-25	Filler	-	84.80	6784.00
			100.00	8000.00

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.
Wet mix shall be plastic and buttery working and free of grit or coarse particles.

BONDING PROPERTIES:

Specifications

- Refer to Plant Testing Procedure No. 35.
After compound has dried, tape shall delaminate when peeled back.

CRACK RESISTANCE:

- There shall be at most only a couple of very small cracks in the wedge.

COLOR:

Specifications

- White
Dried compound shall not vary in color from preceding batches.

-/ Denotes change in this reissue.

EDO:dek

SGP 0017152

**ACME FORMULA #952
ASBESTOS CONTAINING PRODUCTS**