

February 25, 1966
NEW FORMULA
Paoli Laboratory

ACME, TEXAS PLANT FORMULA

READY MIX JOINT COMPOUND TEX-975 (HAND TOOLS) (READY MIX "X")

DESCRIPTION OF PRODUCT - White

Ready Mixed Joint Compound used for taping, covering tape, filling cornerbead and spotting nails.

FORMULA

<u>Raw Material</u>	<u>Source</u>	<u>% Act. Ingr.</u>	<u>Lbs./Batch</u>
Water	Acme Plant	-	400.0 (48 gal.)*
Nalco 71-D5	Nalco Chemical Co.	0.10	0.8
Filler AK-970	Acme Plant	91.4	700.0
Elvacet 81-900	DuPont	8.00	61.5
Benzoflex 50	Tennessee Products Co.	0.50	* 4.0
		100.00	1166.3**

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

**One batch yields 17 (±) - 5 gallon pails of Ready Mix Joint Compound at 65.6 lbs./pail.

*For 200 gm.
Low batch*
→ .2 gm
→ 182.7
→ 16.0
→ 1.0

Percentages
are based on
filler and other
additives less
weight of water
1166.3 #/batch

TESTING PROCEDURE

Working Consistency - Refer to Plant Testing Procedure No. 32.

Specifications for Paste: If paste is not proper working consistency, a maximum of 55 c.c. water per 150 grams of paste may be added to adjust.

Brabender - ~~440-30~~ ⁵⁰⁰⁻⁵⁴⁰ machine ~~360-400~~ ³⁶⁰⁻⁴⁰⁰

Working Properties - Refer to Plant Testing Procedure No. 33.

Compound shall be plastic, buttery working, and free of any coarse, gritty, or undispersed particles. Plaster shall be free from lumps due to 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.

SGP 0017799

6-20-68 55 m d min. - 0.10 - 0.11

July 31, 1968
Supersedes Tex - 975
Dated 2/25/66

ACME, TEXAS PLANT FORMULA

READY MIX JOINT COMPOUND TEX-975 (HAND TOOLS) (READY MIX "X")

DESCRIPTION OF PRODUCT - White

Ready Mixed Joint Compound used for taping, covering tape, filling cornerhead and spotting nails.

-/ FORMULA

<u>Raw Material</u>	<u>Source</u>	<u>% Act. Ingr.</u>	<u>Lbs./Batch</u>
Water	Acme Plant	-	400.0 (48 gal.)*
Filler TEK-970	Acme Plant	91.5	700.0
Elvacet 81-900	Dupont	8.00	61.5
*Benzoflex 50	Tennessee Products Co.	0.50	4.0
		100.00	1165.5**

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

**One batch yields 17 (+) - 5 gallon pails of Ready Mix Joint Compound at 65.6 lbs./pail.

TESTING PROCEDURE

Working Consistency - Refer to Plant Testing Procedure No. 32.

Specifications for Paste: If paste is not proper working consistency, a maximum of 5 c.c. water per 150 grams of paste may be added to adjust.

-/ Brabender - 580 $\pm$ ~~10~~ 10

-/ 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.

-/ Bonding Properties - Refer to Plant Testing Procedure No. 35.

Specifications: After compound has dried, tape shall show at least 90% 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.

RRB:kgc

-/ Indicates changes in this reissue.

SGP 0017800

November 4, 1968
Supersedes Tex - 975
Dated 7/31/68

ACME, TEXAS PLANT FORMULA

READY MIX JOINT COMPOUND TEX-975 (HAND TOOLS) (READY MIX "X")

DESCRIPTION OF PRODUCT - White

Ready Mixed Joint Compound used for taping, covering tape, filling cornerhead and spotting nails.

-/ FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>% Act. Ingr.</u>	<u>Lbs./Batch</u>
Water	Solvent	-	-	400.0 (48 gal.)*
Filler	Body	-	91.5	700.0
Elvacet 81-90J	Adhesive	185	8.00	61.5
*Benzoflex 50	Plasticizer	183	0.50	4.0
			100.00	1165.5**

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

**One batch yields 17 (+) - 5 gallon pails of Ready Mix Joint Compound at 65.6 lbs./pail.

TESTING PROCEDURE

Working Consistency - Refer to Plant Testing Procedure No. 32.

Specifications for Paste: If paste is not proper working consistency, a maximum of 5 c.c. water per 150 grams of paste may be added to adjust.

Brabender - 580 $\pm$ 20/10

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.

Bonding Properties - Refer to Plant Testing Procedure No. 35.

Specifications: After compound has dried, tape shall show at least 90% 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.

RRB:kgc

-/ Indicates changes in this reissue.

10 64.04 on 9 lb

SEP

SGP 0017801

ACME, TEXAS PLANT FORMULA

READY MIX JOINT COMPOUND NO. TEX-975 (HAND TOOLS)

DESCRIPTION OF PRODUCT

- White Ready Mix Joint Compound used for taping, covering tape, filling cornerbeads 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	-	.07	0.5
Water	Solvent	-	-	400.0
UCAR WC 131	Adhesive	185	7.25	55.0
Ethylene Glycol	Wet edge extender	-	0.5	4.0
Filler TEX-975	-	-	<u>92.18</u>	<u>700.0</u>
			100.00	1159.5

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, TEXAS PLANT FORMULA

READY MIX JOINT COMPOUND NO. TEX-975 (HAND TOOLS)

DESCRIPTION OF PRODUCT: - WhiteReady Mix Joint Compound used for taping, covering tape, filling cornerbeads 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	-	.07	0.5
Water	Solvent	-	-	400.0
Preplasticized PVA Emulsion	Adhesive	185	5.38	40.0
Ethylene Glycol	Wet edge extender	-	.05	4.0
Filler TEX-975	--	-	94.05	700.0
			100.00	1144.5

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 $\pm$ 20
220 $\pm$ 10 *per 1.0 g. of 8-18-71*

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.

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

-/ Denotes change in this reissue.

EDO:dek

Handwritten notes:
1.08
1.81
1.46
1.31
1.31

ACME, TEXAS PLANT FORMULA

READY MIX JOINT COMPOUND NO. TEX-975 (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	5.00 5.00 4.6
Water	Solvent	-	-	1245.00 150 gal
Preplasticized PVA Emulsion	Adhesive	185	5.0	100.00 130
Filler TEX- 970 973	-	-	94.9	1898.00 92 (approx) 1750
			100.00	3244.67

**One batch yields 65 ± ² one 4 gallon cartons.

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~~
375 ± 15

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

SGP 0017804

ACME, TEXAS PLANT FORMULA

READY MIX JOINT COMPOUND NO. TEX-975 (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.

<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	5.00 4.6	
Water	Solvent	-	-	1245.00	(150 gal 130
Preplasticized PVA Emulsion	Adhesive	185	5.0	100.00	* 92
Filler TEX-973	-	-	94.9	1898.00	1750
			100.00	3244.67	2925.6

**One batch yields 65 ± one 4 gallon cartons.

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 - ~~385 ± 20~~
375 ± 15

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: -
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.

WNG:dek

* 10 gal

./ Denotes change

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX-975

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound TEX-978
and TEX-979.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Asbestos SG210	Fiber Filler	13	1.50	120.0
Gendriv 492S	Thickener	223	.50	40.0
Dowicil 100	Fungicide	126	.15	12.0
Gelvato1 6000	Adhesive	126	1.60	128.0
Attagel 40	Fiber Filler	9	2.50	200.0
Mica p80-H	Anti-cracking agent	11	9.00	720.0
Land Plaster TEX-25	Filler		84.75	6780.0
			100.00	8000.0

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

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
TEX-979 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-979.

WNG:elz

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX-975

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound TEX-978
and TEX-979.

FORMULA

Raw Material	Function	RM Spec	Percent	Lbs/Batch
Asbestos SG210	Fiber Filler	13	1.50	120.0 3.0
Gendriv 492S	Thickener	223	.50	40.0 1.0
-/ Dowicil 75	Fungicide	126	.20	16.0 .4
Gelvato1 6000	Adhesive	126	1.60	128.0 3.2
Attagel 40	Fiber Filler	9	2.50	200.0 5.0
Mica p80-H	Anti-cracking agent	11	9.00	720.0 18.0
Land Plaster TEX-25	Filler		84.70	6776.0 169.4
			100.00	8000.0 200

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
TEX-979 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-979.

WNG:elz

-/ indicates change

May 19, 1977
Ready Mix Formula TEX-977
NEW

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND NO. TEX 975 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for taping, finishing, filling corner beads and spotting nailheads. To be used for selective market trials only.

<u>FORMULA</u>	<u>FUNCTION</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Nalco 71-D5	Anti-foaming agent	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 For machine mix add 8 gallons H₂O (365 ± 20)

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Compound shall be plastic, buttery working and free of any course, gritty or undispersed particles. Materials should be free of lumps caused by incomplete mixing.

BONDING PROPERTIES - 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 - White
Specifications Dried compound shall match color of standard sample.

WNG:jr

SGP 0017808

May 23, 1977
Ready Mix Formula TEX-975
NEW

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND NO. TEX 975 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for taping, finishing, filling corner beads and spotting nailheads. To be used for selective market trials only.

<u>FORMULA</u>	<u>FUNCTION</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Nalco 71-D5	Anti-foaming agent	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 For machine mix add 8 gallons H_2O (365 ± 20)

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Compound shall be plastic, buttery working and free of any course, gritty or undispersed particles. Materials should be free of lumps caused by incomplete mixing.

BONDING PROPERTIES - 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 - White
Specifications Dried compound shall match color of standard sample.

WNG: jr

SGP 0017809

August 31, 1977
Supersedes Formula TEX-975
Dated May 23, 1977

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND NO. TEX 975 (HAND TOOLS)

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

<u>FORMULA</u>	<u>FUNCTION</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
-/ Dowicil 75	Preservative			5.00
Nalco 71-D5	Anti-foaming agent	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	--	-	97.9	1958.00
			100.0	2852.00

-/ One batch yields 60 $\pm$ one 4 gallon carton or 46 $\pm$ 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 For machine mix add 8 gallons H₂O (365 $\pm$ 20)

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Compound shall be plastic, buttery working and free of any course, gritty or undispersed particles. Materials should be free of lumps caused by incomplete mixing.

BONDING PROPERTIES - 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 - White
Specifications Dried compound shall match color of standard sample.

-/denotes change

WNG:jr

SGP 0017810

September 15, 1977
Supersedes Formula TEX-975
Dated August 31, 1977

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND NO. TEX 975 (HAND TOOLS)

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

<u>FORMULA</u>	<u>FUNCTION</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
-/ Dowicil 75	Preservative		.35	7.00
Nalco 71-D5	Anti-foaming agent	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	--	-	<u>97.55</u>	<u>1958.00</u>
			100.0	2854.00

-/ One batch yields 60 ± one 4 gallon carton or 46 ± 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 For machine mix add 8 gallons H₂O (365 ± 20)

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Compound shall be plastic, buttery working and free of any course, gritty or undispersed particles. Materials should be free of lumps caused by incomplete mixing.

BONDING PROPERTIES - 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 - White
Specifications Dried compound shall match color of standard sample.

-/denotes change

WNG:jr

SGP 0017811

October 26,, 1977
Supersedes Formula TEX-975
Dated September 15, 1977

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND NO. TEX 975 (HAND TOOLS)

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

<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 agent	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 $60 \pm$ one 4 gallon carton or $46 \pm$ 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 For machine mix add 8 gallons H₂O (365 ± 20)

WORKING PROPERTIES - 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 - 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 - White
Specifications Dried compound shall match color of standard sample.

-/denotes change

HCF:jr

SGP 0017812

December 21, 1978
Formula TEX-975
NEW

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX-975

DESCRIPTION OF PRODUCT - Filler for ready mix Compound TEX-978.
To be shipped to Phoenix or other approved markets only.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Pyrophyllite	Bulking Agent		4.368	350
Gypsum	Filler		84.862	6800
Mica p80H	Anti-Cracking	11	3.120	250
Methocel 8898.2	Water Retention		.374	30
Minugel FG	Bulking	8	1.872	150
Soda Ash	ph Stabilizer		.100	8
AquaFil K-8	Bulking		4.368	350
Staramic 105	Adhesive	23	.936	75
			<u>100.000</u>	<u>8013</u>

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

Minimum - 58 Maximum - 62 Average - 60

WORKING CONSISTENCY: 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: White
Dried compound shall match color of standard.

NOTE: A wet mix of the filler shall be prepared according to formula TEX-978 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-978.

GWG:jr

SGP 0017813

April 9, 1979
Supersedes Formula TEX-975
Dated 12/21/78

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX-975

DESCRIPTION OF PRODUCT - Filler for ready mix Compound TEX-978
and topping Compound TEX-970.

<u>FORMULA</u>				
<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Pyrophyllite	Bulking Agent		4.368	350
Gypsum	Filler		84.862	6800
Mica p80H	Anti-Cracking	11	3.120	250
Methocel 8898.2	Water Retention		.374	30
Minugel FG	Bulking	8	1.872	150
Soda Ash	ph Stabilizer		.100	8
AquaFil K-8	Bulking		4.368	350
* Staramic 105	Adhesive	23	.936	75
			<u>100.000</u>	<u>8013</u>

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

Minimum - 58 Maximum - 62 Average - 60

WORKING CONSISTENCY: 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: White
Dried compound shall match color of standard.

NOTE: A wet mix of the filler shall be prepared according to formula TEX-978 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-978.

* Hamaco 267 can be substituted at an equal loading.

HCF:ps

SGP 0017814

**ACME FORMULA #975
ASBESTOS CONTAINING PRODUCTS**

SGP 0017798