

NEW
Formula AK-972
July 30, 1979

AKRON, NEW YORK, PLANT FORMULA
READY MIX JOINT COMPOUND AK-972 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for taping, topping and texturing for 1-gallon shipments only.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
PMA 30	Preservative		.08	3.75
Filler AK-970	Filler		95.34	4400.00
DuPont JCM	Adhesive	185	4.48	206.75 (23.33 gal)
Nalco 71D-5	Defoamer	125	.10	4.60
* Water	Solvent			2106.25 (253 gal)
			100.00	6721.35

*Approximately 52 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch.

**One batch yields 108 $\pm$ 1 five-gallon pail Ready Mix Joint Compound at 62 lbs/pail.

SPECIAL MIXING INSTRUCTIONS

- Blend ingredients in following order
 - 1) Water/PMA-30
 - 2) JCM
 - 3) Nalco
 - 4) Filler AK-971
 - 5) Mix until Ready Mix is smooth - pumping viscosity should be 520 $\pm$ 20.

WORKING CONSISTENCY

Specifications for Paste

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

Brabender (520 $\pm$ 20)

For machine tools, add 4 gallons H₂O (470 $\pm$ 20)

pH

8.0 - 9.0

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. Material shall be free from lumps due to incomplete mixing.

HCF:ps

Continued on Page 2

SGP 0017518

NEW
Formula AK-972
July 30, 1979
Page Two

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

- Refer to Plant Testing Procedure No. 37.

Rating shall be 4 or better.

COLOR

Specifications

- White

Dried compound shall match color of standard sample.

HCF:ps

June 18, 1980

Supersedes Formula AK-972

dated 7/30/79

AKRON, NEW YORK, PLANT FORMULA
READY MIX JOINT COMPOUND AK-972 (HAND TOOLS)

-/ DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for
taping, topping and texturing.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
PMA 30	Preservative		.08	3.75
Filler AK-970	Filler		95.34	4400.00
DuPont JCM	Adhesive	185	4.48	206.75 (23.33 gal)
Nalco 71D-5	Defoamer	125	.10	4.60
* Water	Solvent			2106.25 (253 gal)
			100.00	6721.35

*Approximately 52 lbs/100 lbs. of active ingredients (this may vary
 $\pm$ 8 gallons per batch.

**One batch yields 108 $\pm$ 1 five-gallon pail Ready Mix Joint Compound
at 62 lbs/pail.

SPECIAL MIXING
INSTRUCTIONS

- Blend ingredients in following order
 - 1) Water/PMA-30
 - 2) JCM
 - 3) Nalco
 - 4) Filler AK-970
 - 5) Mix until Ready Mix is smooth - pumping
viscosity should be 520 $\pm$ 20.

WORKING CONSISTENCY

Specifications for
Paste

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

Brabender (520 $\pm$ 20)

For machine tools, add 4 gallons H₂O (470 $\pm$ 20)

pH

8.0 - 9.0

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. Material shall be free from lumps
due to incomplete mixing.

-/ denotes change.

CWL:ps

Continued on Page 2

SGP 0017520

October 30, 1980
Supersedes Formula AK-972
dated 10/13/80

AKRON, NEW YORK, PLANT FORMULA
READY MIX JOINT COMPOUND AK-972 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for
taping, topping and texturing.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
-/ Proxel CRL	Preservative		.109	5.04
Filler AK-970	Filler		95.311	4400.00
DuPont JCM	Adhesive	185	4.48	206.75 (23.33 gal)
Nalco 71D-5	Defoamer	125	.10	4.60
* Water	Solvent			2106.25 (253 gal)
			100.00	6722.64

*Approximately 52 lbs/100 lbs. of active ingredients (this may vary
 $\pm$ 8 gallons per batch.

**One batch yields 108 $\pm$ 1 five-gallon pail Ready Mix Joint Compound
at 62 lbs/pail.

SPECIAL MIXING
INSTRUCTIONS

- Blend ingredients in following order
 - 1) Water/Proxel CRL
 - 2) JCM
 - 3) Nalco
 - 4) Filler AK-970
 - 5) Mix until Ready Mix is smooth - pumping
viscosity should be 520 ± 20 .

WORKING CONSISTENCY

Specifications for
Paste

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

Brabender (520 ± 20)

For machine tools, add 4 gallons H₂O (470 ± 20)

pH

8.0 - 9.0

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. Material shall be free from lumps
due to incomplete mixing.

-/ denotes change.

BGR:ps

Continued on Page 2

SGP 0017521

April 15, 1981
Supersedes Formula AK-972
dated 10/30/80

AKRON, NEW YORK, PLANT FORMULA
READY MIX JOINT COMPOUND AK-972 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for
taping, topping and texturing.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
-/ Proxel CRL	Preservative		.11	5.2
Filler AK-970	Filler		95.35	4444.00
DuPont JCM	Adhesive	185	4.44	207.00 (23.26 gal)
Nalco 71D-5	Defoamer	125	.10	4.7
* Water	Solvent			1950.0 (234 gal)
			100.00	6611.8

*Approximately lbs/100 lbs. of active ingredients (this may vary
+ 8 gallons per batch.

**One batch yields 106 + 1 five-gallon pail Ready Mix Joint Compound
at 62 lbs/pail.

SPECIAL MIXING
INSTRUCTIONS

- Blend ingredients in following order
 - 1) Water/~~Proxel~~ CRL
 - 2) JCM
 - 3) Nalco
 - 4) Filler AK-970
 - 5) Mix until Ready Mix is smooth - pumping
viscosity should be 550 + 20.

WORKING CONSISTENCY

Specifications for
Paste

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

Brabender (550 + 20)

For machine tools, add 4 gallons H₂O (420 + 20)

pH

8.0 - 9.0

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. Material shall be free from lumps
due to incomplete mixing.

-/ denotes change.

BGR:ps

Continued on Page 2

SGP 0017522

April 20, 1981
Supersedes Formula AK-972
dated 4/15/81

AKRON, NEW YORK, PLANT FORMULA
READY MIX JOINT COMPOUND AK-972 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for
taping, topping and texturing.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>P rcent</u>	<u>Lbs/Batch</u>
Proxel CRL	Preservative		.11	5.2
Filler AK-970	Filler		5.35	4444.00
DuPont JCM	Adhesive	185	4.44	207.00 (23.26 gal)
Nalco 71D-5	Defoamer	125	.10	4.7
* Water	Solvent			1950.0 (234 gal)
			-/ 100.00	6610.9

*Approximately lbs/100 lbs. of active ingredients (this may vary
+ 8 gallons per batch.

**One batch yields 106 + 1 five-gallon pail Ready Mix Joint Compound
at 62 lbs/pail.

SPECIAL MIXING
INSTRUCTIONS

- Blend ingredients in following order
 - 1) Water/Proxel CRL
 - 2) JCM
 - 3) Nalco
 - 4) Filler AK-970
 - 5) Mix until Ready Mix is smooth - pumping
viscosity should be 550 + 20.

WORKING CONSISTENCY

Specifications for
Paste

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

Brabender (550 + 20)

For machine tools, add 4 gallons H₂O (420 + 20)

pH

8.0 - 9.0

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. Material shall be free from lumps
due to incomplete mixing.

-/ denotes change.

BGR:ps

Continued on Page 2

SGP 0017523

December 1, 1981
Supersedes Formula AK-972
dated 4/20/81

AKRON, NEW YORK, PLANT FORMULA
READY MIX JOINT COMPOUND AK-972 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for
taping, topping and texturing.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Proxel CRL	Preservative		.11	5.2
-/ Filler***	Filler		95.35	4444.00
DuPont JCM	Adhesive	185	4.44	207.00 (23.26 gal)
Nalco 71D-5	Defoamer	125	.10	4.7
* Water	Solvent			1950.0 (234 gal)
			100.00	6610.9

*Approximately 42 lbs/100 lbs. of active ingredients (this may vary
± 8 gallons per batch.

**One batch yields 106 ± 1 five-gallon pail Ready Mix Joint Compound
at 62 lbs/pail.

SPECIAL MIXING
INSTRUCTIONS

- Blend ingredients in following order
1) Water/Proxel CRL
2) JCM
3) Nalco
-/- *** 4) Filler AK-970 or AK-974
5) Mix until Ready Mix is smooth - pumping
viscosity should be 550 ± 20.

WORKING CONSISTENCY

Specifications for
Paste

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

Brabender (550 ± 20)

For machine tools, add 4 gallons H₂O (420 ± 20)

pH

8.0 - 9.0

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. Material shall be free from lumps
due to incomplete mixing.

-/ denotes change.

BGR:ps

Continued on Page 2

SGP 0017524

February 25, 1982.

Supersedes Formula AK-972

dated 12/1/81

AKRON, NEW YORK, PLANT FORMULA
READY MIX JOINT COMPOUND AK-972 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for
taping, topping and texturing.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs /Batch</u>
Proxel CRL	Preservative		.11	5.2
Filler ***	Filler		95.35	4441.00
DuPont JCM	Adhesive	185	4.44	207.00 (23.26 gal)
Nalco 71D-5	Defoamer	125	.10	4.7
* Water	Solvent			1950.0 (234 gal)
			100.00	6610.9

*Approximately 42 lbs/100 lbs. of active ingredients (this may vary
+ 8 gallons per batch.

**One batch yields 106 + 1 five-gallon pail Ready Mix Joint Compound
at 62 lbs/pail.

SPECIAL MIXING
INSTRUCTIONS

- Blend ingredients in following order
1) Water/Proxel CRL
2) JCM
3) Nalco
- / *** 4) Filler AK-974.
5) Mix until Ready Mix is smooth - pumping
viscosity should be 550 + 20.

WORKING CONSISTENCY

Specifications for
Paste

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

Brabender (550 + 20)

For machine tools, add 4 gallons H₂O (420 + 20)

pH

8.0 - 9.0

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. Material shall be free from lumps
due to incomplete mixing.

- / denotes change.

Continued on Page 2

HCF:ps

SGP 0017525

August 20, 1982
Supersedes Formula AK-972
dated 2/25/82

AKRON, NEW YORK, PLANT FORMULA
READY MIX JOINT COMPOUND AK-972 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for
taping, topping and texturing.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Proxel CRL	Preservative		.11	5.2
Filler ***	Filler		95.35	4444.00
-/ DuPont JCM	Adhesive	185	4.44	207.00 (23.26 gal)
-/ **MD-76	Defoamer	125	.10	4.7
* Water	Solvent			1950.0 (234 gal)
			100.00	6610.9

*Approximately 42 lbs/100 lbs. of active ingredients (this may vary
± 8 gallons per batch.

-/ One batch yields 106 ± 1 five-gallon pail Ready Mix Joint Compound
at 62 lbs/pail.

SPECIAL MIXING
INSTRUCTIONS

-/ - Blend ingredients in following order
1) Water/Proxel CRL
2) JCM
3) MD-76
-/-/ *** 4) Filler AK-974.
5) Mix until Ready Mix is smooth - pumping
viscosity should be 550 ± 20.

WORKING CONSISTENCY

Specifications for
Paste

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

Brabender (550 ± 20)

For machine tools, add 4 gallons H₂O (420 ± 20)

pH

8.0 - 9.0

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. Material shall be free from lumps
due to incomplete mixing.

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

Continued on Page 2

HCF:ps

SGP 0017526

July 8, 1964
Suporcedes AK-972
Dated June 15, 1964

AKRON. NEW YORK PLANT FORMULA

READY MIX FILLER - AK-972

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound - AK-976.

FORMULA

<u>RAW MATERIAL</u>	<u>SOURCE</u>	<u>R. M. SPEC. %</u>	<u>W/BATCH</u>
Natrusol 250 HR (fine grind)	Hercules Powder	0.30	12.0
Mica JP 80-F	Hassett Mica Co.	11 10.00	400.0
Asbestos 7RF-9	Phillip Carey Co.	9 4.50	180.0
Clay ASP - 100	Mineral & Chem. Co.	- 10.00	400.0
Limestone	Thompson-Weinman	13 75.20	3008.0
		100.00	4000.0

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

<u>Specifications:</u>	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
	62	56	59

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

Specification: Dried compound shall match color of standard sample.

Note: A wet mix of the filler shall be prepared according to Formula No. AK-976 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. AK-976.

October 2, 1964
Supercedes AK-972
Dated July 8, 1964

AKRON, NEW YORK PLANT FORMULA

READY MIX FILLER AK-972

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound AK-976.

FORMULA

<u>RAW MATERIAL</u>	<u>SOURCE</u>	<u>R. M. SPEC. %</u>	<u>#/BATCH</u>
Natrusol 250 HR (fine grind)	Hercules Powder	0.30	12.0
-/ Mica JP 80-F	Hassett Mica Co.	11 12.0	480.0
-/ Asbestos 7RF-9	Phillip Carey Co.	9 4.0	160.0
Clay ASP - 100	Mineral & Chem. Co.	- 10.00	400.0
-/ Limestone	Thompson-Weinman	13 73.7	2948.0
		100.00	4000.0

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

<u>Specifications:</u>	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
	54	44	49

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. AK-976 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. AK-976.

-/ Indicates change in this re-issue.

**AKRON FORMULA #972
ASBESTOS CONTAINING PRODUCTS**