

September 22, 1971
 NEW FORMULA TEX-970

ACME, TEXAS PLANT FORMULA
READY MIX FILLER TEX-970 (FILLER "X")

DESCRIPTION OF PRODUCT: - Filler for Ready Mix Joint Compound TEX-971 and TEX-972.

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	85.0	7.5
Vanicide 512	Fungicide	162	0.35	7.0	.7
Polyvinyl Alcohol	Adhesive <i>Yellowed in 30</i>	170	.60	12.0	1.2
Methocel 228	Water retention aid	11	.75	13.0	1.5
Mica	Anti-cracking agent	-	7.00	140.0	14.0
Asbestos (SG-210)	Bulking agent	13	1.75	35.0	3.5
Land Plaster	Filler	-	85.30	1706.0	170.6
			100.00	2000.0	200

WORKING CONSISTENCY:
Specifications:

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
65	60	62
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 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:dek

Helintol 33.82 lbs per cu ft
mica 12.54
Gypsum 31.73 - loose
49.78 - packed
asbestos 20.14

SGP 0017274

Lehnert.10.3.01-1

DEFENDANT'S
 EXHIBIT
Composite A

January 17, 1972
Supersedes TEX-970
Dated 9/22/71

ACME, TEXAS PLANT FORMULA

READY MIX FILLER TEX-970 (FILLER "X")

DESCRIPTION OF PRODUCT: - Filler for Ready Mix Joint Compound TEX-971 and TEX-972.

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	4.23	85.0 425
Dowicil 100	Fungicide	193	.13	3.0 15
Polyvinyl Alcohol	Adhesive <i>Relatol 30-30</i>	170	.60	12.0 60
Methocel 228	Water retention aid	11	.75	15.0 75
Mica	Anti-cracking agent	-	7.00	140.0 700
Asbestos (SG-210)	Bulking agent	13	1.75	35.0 175
Land Plaster	Filler	-	85.50	1710.0 8550
			100.00	2000.0 10000.0

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 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.

EDOrdek

Lehnert 10.3.01-2

Relatol 33.82 lbs per cu ft
Mica 12.54-
Asbestos 13.78 - loose
Asbestos 49.78 - packed
Asbestos 20.14-

SGP 0017275

10.3.01-2 specimens taken out of bin and used for test

April 14, 1972
Supersedes TEX-970
Dated 1/17/72

ACME, TEXAS PLANT FORMULA

READY MIX FILLER TEX-970 (FILLER "X")

DESCRIPTION OF PRODUCT: - Filler for Ready Mix Joint Compound TEX-971 and TEX-972.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Asbestos 7RF09	Bulking agent	9	4.25	340.00
Dowicil 100	Fungicide	193	.15	12.00
Polyvinyl Alcohol	Adhesive <i>Adhesive 10-30</i>	162	.60	48.00
Methocel 228	Water retention aid	170	.75	60.00
Mica	Anti-cracking agent	11	7.00	560.00
Asbestos (SQ-210)	Bulking agent	-	1.75	140.00
Land Plaster	Filler	13	85.50	6840.00
			100.00	8000.00

WORKING CONSISTENCY:
Specifications:

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
65	60	62
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 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.

Heavtop 33.82 lbs per cu ft

Mica 12.54

Lehnert 10.3.01-3

EDO:dek

Hypericum 31. 73 - loose

49.75 - packed

TRF 9 - asbestos 20.14 - packed

SC-210 sketches 5, 3 - loose

7RF9 - asbestos 10.6 - loose

SGP 0017276

September 22, 1971
NEW FORMULA TEX-971

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:

Raw Material

Function

R.M. Spec.

Percent

Lbs/Batch

Nalco 71-D5	Anti-foaming agent	-	0.1	1.67	5.00
Water	Solvent	-	-	360.00	(43 ga)
Preplasticized PVA Emulsion	Adhesive	185	7.4	49.33	150.01
Filler TEX-970	-	-	92.5	613.67	1900.3
			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

Lehnert 10.3.01-4

SGP 0017392

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-DS	Anti-foaming agent	-	0.1	5.00 4.6
Water	Solvent	-	-	1080.00 --99
Preplasticalized PVA Emulsion	Adhesive	183	7.4	(129 gals) (140) 148.00 137.
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 3 cc of water per 150 grams of paste may be added to adjust.

Brabender Viscosity:

~~840-130~~
480-120

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.

EDD:dek

-/ Denotes change in this reissue.

Lehnert 10.3.01-5

SGP 0017393

* 1 1/4 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

Lehnert 10.3.01-6



SGP 0017394

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-DS	Anti-foaming agent	-	0.1	1.67 4.6
Water	Solvent	-	-	1245.00 (150 gal)
Preplasticized PVA Emulsion	Adhesive	185	5.0	100.00 ¹²⁰ 92
Filler TEX-976	-	-	<u>94.9</u>	1898.67 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 3 cc of water per 150 grams of paste may be added to adjust.

Brabender Viscosity

- 385 ± 20
325

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.

EDD:ela

* 10 gal

Lehnert 10.3.01-7

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	2842.60

-/ ** One batch yields ⁵⁰ 48 ± 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.

EDC:elz

-/ denotes change

* 10 gal

Lehnert 10.3.01-8

SGP 0017396

September 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.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Nalco 71-D3	Anti-foaming agent	-	0.1	5.4.60
Water	Solvent	-	-	137.80
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 ⁵⁰~~50~~ ± 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

- ~~20~~ 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:ela

-/ denotes change

Lehnert 10.3.01-9

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, $\pm$ one 4 gallon carton or 43 $\pm$ 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:elz

-/ denotes change

Lehnert 10.3.01-10

SGP 0017398

May 29, 1975
Supersedes TEX-971
Dated: 3/7/74

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 ± 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

Lehnert 10.3.01-11

SGP 0017399

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

ACME, TEXAS PLANT FORMULA
READY MIX JOINT COMPOUND (TEK-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	123	0.25	4.60
-/ Water	Solvent	-	-	1129.00 (136 gals.)
Elvace EP-200	Adhesive	185	2.00	37.00 (4 gals.)
Fillar TEK-976	--	-	<u>97.75</u>	<u>1804.40</u>
			100.00	2975.00

-/ **One batch yields 60 ± one 4 gallon carton or 48 ± 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/gvp

-/ denotes change

Lehnert 10.3.01-12

SGP 0017400

July 6, 1972
TEX-976
NEW FORMULA

ACHE, TEXAS, PLANT FORMULA
READY MIX FILLER TEX -976 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound TEX-970 and TEX-971.

FORMULA

Raw Material	Function	R.M. Spec.	Percent	Lbs/Batch
Dowicil 100	Fungicide	193	.15	12.00
Polyvinyl Alcohol 20-30	Adhesive	162	.60	48.00
Gendriv 4928	Water retention aid	11	.50	40.00
Mica	Anti-cracking agent	-	7.00	560.00
Asbestos (80-210)	Bulking agent	13	3.75	300.00
Land Plaster	Filler	-	88.00	7040.00
			100.00	8000.00

WORKING CONSISTENCY
Specifications

- Refer to Plant Testing Procedure No. 32.

Maximum	Minimum	Average
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-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

7-10-72

Filler	40.8	lbs per cu ft.
Asbestos	33.8	
mica	12.54	
Gypsum	31.73	loose
	49.78	packed
TRF9	20.14	packed
	10.6	loose
SG-210	5.3	loose

Lehnert 10.3.01-13

1-24-72 gypsum taken out of hopper spout weighed 45"

SGP 0017802

July 11, 1973
Supersedes TEX-976
Dated 7/6/72

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX -976 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound TEX-970 and TEX-971.

-/ FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Dowicil 75	Fungicide	193	.20	16.00
Polyvinyl Alcohol	Adhesive	162	.60	48.00
Candriv 492S	Water retention aid	11	.50	40.00
Mica	Anti-cracking agent	-	7.00	560.00
Asbestos (SG-210)	Dulking agent	13	3.75	300.00
Land Plaster	Filler	-	87.95	7036.00
			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.
- 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-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.

ED0:elz

-/ denotes change

Lehnert 10.3.01-14

SGP 0017903

February 27, 1975
Supersedes TEX-976
Dated 7/11/73

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX-976 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound TEX-970 and TEX-971.

-/ FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Vancide	Preservative	126	.025	2.00
Dowicil 75	Preservative	193	.175	14.00
Gelvitol 3000	Adhesive	162	.60	48.00
Gendriv 4928	Water retention aid	11	.50	40.00
Mica	Anti-cracking agent	--	7.00	560.00
Asbestos SQ-210	Bulking agent	13	3.75	300.00
Land Plaster	Filler	--	87.95	7036.00
			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.
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-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.

-/ denotes change

WNG:jg

Lehnert 10.3.01-15

SGP 0017904

March 31, 1975
Supersedes TEX-976
Dated 2/27/75

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX-976 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound TEX-970 and TEX-971.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
	Preservative	126	.025	2.00
	Preservative	193	.175	14.00
-/ Dowicil 75	Adhesive	162	.60	48.00
Gelvitol 6000	Water retention aid	11	.50	40.00
Gendriv 492S	Anti-cracking agent	---	7.00	560.00
Mica	Bulking agent	13	3.75	300.00
Asbestos SG-210	Filler	---	87.95	7036.00
Land Plaster			100.00	8000.00

WORKING CONSISTENCY
Specifications:

- Refer to Plant Testing Procedure No. 32.
Maximum Minimum Average

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-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.

-/ denotes change.

WNG:als

Lehnert 10.3.01-16

SGP 0017905

May 29, 1975
Supersedes TEX-976
Dated: 3/21/75

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX-976 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound TEX-970 and TEX-971.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Vancoide	Preservative	126	.025	2.00
Dowicil 75	Preservative	193	.175	14.00
Gelvatol 6000	Adhesive	162	1.00	80.00
Gendriv 492S	Water retention aid	223	.50	40.00
Mica	Anti-cracking agent	11	6.25	500.00
Asbestos SG-210	Bulking agent	13	3.75	300.00
Land Plaster	Filler	---	88.30	7064.00
			100.00	8000.00

WORKING CONSISTENCY
Specifications:

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
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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-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.

-/ denotes change

WNG:elz

Lehnert 10.3.01-17

SGP 0017908

Hold
January 27, 1976
Supersedes TEX-976
Dated: 5/29/75

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX-976 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound TEX-970 and TEX-971.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Sorbitol (Powdered)	Borax Stabilizer	-	.400	32.00 9
Vancide	Preservative	126	.025	2.00 .5
Dowicil 75	Preservative	193	.175	14.00 3.4
Gelvatol 6000	Adhesive	162	1.00	80.00 20
Gendriv 4928	Water retention aid	223	.50	40.00 10
Mica	Anti-cracking agent	11	6.25	500.00 124
Asbestos SQ-210	Bulking agent	13	3.75	300.00 75
Land Plaster	Filler	-	87.9	7032.00 175
			100.00	8000.00 200

WORKING CONSISTENCY
Specifications:

- Refer to Plant Testing Procedure No. 32.
Maximum Minimum Average

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 coars 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-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.

-/ denotes change

WNG:els

Lehnert 10.3.01-18

SGP 0017907

April 22, 1976
Supersedes TEX-976
Dated: 1/27/76

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX-976 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound TEX-970
and TEX-971.

FORMULA

Raw Material	Function	RM Spec	Percent	Lbs/Batch
-/ Sorbitol (Powdered)	Borax Stabilizer	---	.300	24.00
Vancide	Preservative	126	.025	2.00
Dowicil 75	Preservative	193	.175	14.00
Gelvatol 6000	Adhesive	162	1.00	80.00
-/ Galactosol A11-W	Water retention aid	---	.50	40.00
Mica	Anti-cracking agent	11	6.25	500.00
Asbestos 90-210	Bulking agent	13	3.75	300.00
-/ Land Plaster	Filler	---	88.00	7040.00
			100.00	8000.00

WORKING CONSISTENCY
Specifications:

- Refer to Plant Testing Procedure No. 32.

Maximum	Minimum	Average
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-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.

-/ denotes change

WNG:avp

SGP 0017908

Lehnert 10.3.01-19

November 24, 1976
Supersedes Formula TEX-976
Dated: 4/22/76

ACME, TEXAS PLANT FORMULA
READY MIX FILLER TEX-976 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound TEX-970 & TEX-971.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Sorbitol (Powdered)	Borax Stabilizer	-	.300	24.00 / 2.00
-/ Troysan PMA-10 SEP	Preservative		.100	8.00
Gelvatol 6000	Adhesive	162	1.000	80.00
Galactosol 413-W	Water retention aid		.500	40.00
Mica	Anti-cracking agent	11	6.250	500.00
Asbestos SG-210	Bulking agent	13	3.750	300.00
-/ Land Plaster	Filler	-	<u>88.100</u>	<u>7048.00</u> 70.40
			100.000	8000.00

WORKING CONSISTENCY

- Refer to Plant Testing Procedure No. 32.

<u>Specifications:</u>	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
	62	38	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-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.

-/ denotes change

WNG/gvp

Lehnert 10.3.01-20

SGP 0017910

ACU 24, 1976
April 22, 1976
Supersedes TEX-976
Dated: 4/27/76

4/22/76

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX-976 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound TEX-970
and TEX-971.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
-/ Sorbitol (Powdered)	Borax Stabilizer	-126	.300	24.00
Vancide-	Preservative	-126	.025	2.00
Dowicil-75 TRAYED PMA 10123	Preservative	-129	.175	14.00 E.C.
Gelvitol 6000	Adhesive	162	1.00	80.00
-/ Galactosol 413-W	Water retention aid	-	.50	40.00
Mica	Anti-cracking agent	11	6.25	500.00
Asbestos SG-210	Bulking agent	13	3.75	300.00
-/ Land Plaster	Filler	-85.12	88.00	7040.00 A.C.
			100.00	8000.00

WORKING CONSISTENCY
Specifications:

- Refer to Plant Testing Procedure No. 32.
Maximum Minimum Average

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-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.

-/ denotes change

WNG:gvp

Lehnert 10.3.01-21

SGP 0017909

December 14, 1976
Supersedes Formula TEX-976
Dated: 11/24/76

ACME, TEXAS PLANT FORMULA
READY MIX FILLER TEX-976 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound TEX-970 & TEX-971.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
-/ Sorbitol (Powdered)	Borax Stabilizer	-	.100	8.00
Troysan PMA-10 SEP	Preservative		.100	8.00
Gelvatol 6000	Adhesive	162	1.000	80.00
Galactosol 413-W	Water retention aid		.500	40.00
Mica	Anti-cracking agent	11	6.250	500.00
Asbestos SG-210	Bulking agent	13	3.750	300.00
-/ Land Plaster	Filler	-	<u>88.300</u>	<u>7064.00</u>
			100.000	8000.00

WORKING CONSISTENCY

- Refer to Plant Testing Procedure No. 32.

<u>Specifications:</u>	<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-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.

-/ denotes change

WNO/gvp

Lehnert 10.3.01-22

SGP 0017911

August 25, 1972
Supersedes TEX-970
Dated 7/6/72

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND NO. TEX-970 (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 only.

<u>FORMULA</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
<u>Raw Material</u>				
Nalco 71-D5	Anti-foaming agent	-	0.1	4.60
Water	Solvent	-	-	929.60 (112 gal)
Perplasticized PVA Emulsion	Adhesive	185	5.0	92.00
Filler TEX-976	-	-	<u>94.9</u>	<u>1750.00</u>
			100.0	2776.20

-/ **One batch yields 60 $\pm$ 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 - 320 ± 20
470

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. 33.
- 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:els

-/ denotes change

Lehnert 10.3.01-23

SGP 0017278

September 25, 1972
Supersedes TEX-970
Dated 8/25/72

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND NO. TEX-970 (HAND TOOLS)

-/ <u>DESCRIPTION OF PRODUCT</u> - White Ready Mix Joint Compound used for taping, covering tape, filling corner beads and spotting nailheads. To be used in 4 gallon cartons and five gallon pails.	
-/ <u>FORMULA</u>	- <u>Function</u>
<u>Raw Material</u>	<u>R.M. Spec.</u> <u>Percent</u> <u>Lbs/Batch</u>
	GRAMS
Nalco 71-DS	Anti-foaming agent - 2 .5 4.60
Water	Solvent - 138 14.60 (14.6 gal)
Purplacized PVA Emulsion	Adhesive 185 4.5 9.5 84.00 (9 gals)
Filler TEX-976	- 95.4 100 1758.00
	100.0 348 2776.20

-/ **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

- 320 ± 20
470

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.

ED:als

-/ denotes change

Lehnert 10.3.01-24

SGP 0017279

March 7, 1974
Supersedes TEX-970
Dated 9/25/72

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND NO. TEX-970 (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 five gallon pails.

<u>FORMULA</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
<u>Raw Material</u>				
Nalco 71-D5	Anti-foaming agent	-	0.1	4.60
Water	Solvent	-	-	929.60 (17 1/2 gal)
Perplasticized PVA Emulsion	Adhesive	183	4.5	84.00 (9 gals.)
Filler TEX-976	-	-	91.4	1758.00
			100.0	2776.20

**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. 33.
- After compound has dried, tape shall show at least 90% 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:sls

-/ denotes change

Lehnert 10.3.01-25

SGP 0017280

January 14, 1977
Supersedes TEX-970
Dated: 5/29/75

..... ACME, TEXAS PLANT FORMULA
READY MIX JOINT COMPOUND NO. TEX-970 (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 five gallon pails.

<u>FORMULA</u>		<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
<u>Raw Material</u>					
Nalco 71-D5		Anti-foaming agent	125	0.25	4.60
-/ Water		Solvent	-	-	1068.00 (128 gals.)
Eivace EP-200		Adhesive	185	2.00	37.00 (4 gals.)
Filler TEX-976		--	-	<u>97.75</u>	<u>1804.40</u>
				100.00	2914.00

-/ **One batch yields 58 ± one 4 gallon carton or 47 ± 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 320 ± 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

- 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/gvp

-/ denotes change

Lehnert 10.3.01-26

SGP 0017281

September 22, 1971
NEW FORMULA TEK-972

ACME, TEXAS PLANT FORMULA

READY MIX JOINT COMPOUND NO. TEK-972 (MACHINE 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
Water	Solvent	-	-	370.00 (44 gal)
Preplasticized EVA Emulsion	Adhesive	185	7.4	49.33
Filler TEK-970	-	-	<u>92.3</u>	<u>613.67</u> 655.2
			100.00	1034.67 1066.20

**One batch yields $1\frac{1}{2}$ ± one 5 gallon pails

WORKING CONSISTENCY:
Specifications

Brabender Viscosity

WORKING PROPERTIES:
Specifications

BONDING PROPERTIES:
Specifications

CRACK RESISTANCE:
Specifications

COLOR:
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.
- 385 ± 20
- 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.
- Refer to Plant Testing Procedure No. 35. After compound has dried, tape shall show at least 75% fiber tear when delaminated.
- There shall be no large fissure cracks in the wedge, and no cracks in the thinner half of the wedge.
- White
- Dried compound shall match color of standard sample.

EDD:dek

Lehnert 10.3.01-27

SGP 0017509

April 14, 1972
Supersedes TEX-972
Dated 9/22/71

ACME, TEXAS PLANT FORMULA

READY MIX JOINT COMPOUND NO. TEX-972 (MACHINE TOOLS)

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

<u>FORMULA</u>	<u>Function</u>	<u>R.M. Spcs.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
<u>Raw Material</u>				
Nalco 71-D5	Anti-foaming agent	-	0.1	3.00 4.6
Water	Solvent	-	-	1110.00 (132 gal)
Preplasticized PVA Emulsion	Adhesive	185	7.4	148.00 137.00
Filler TEX-970	-	-	92.5	1841.00 1700
			100.00	3104.00

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

WORKING CONSISTENCY: - Refer to Plant Testing Procedure No. 32.
Specifications If paste is not of proper working consistency, a maximum of 3 cc of water per 150 grams of paste may be added to adjust.

Brabender Viscosity - ~~305 ± 20~~
385 ± 15

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 31
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.

EDO:dek

Lehnert 10.3.01-28

SGP 0017510

March 8, 1974
NEW FORMULA TEX 972

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND NO. TEX-972

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.

<u>FORMULA</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Nalco 71-D5	Antifoaming agent	--	.25	4.60
Water	Solvent	--	--	929.60 (112 gal)
Preplasticized PVA				
Emulsion	Adhesive	185	5.0	92.3 (10.25 gal)
Filler TEX-974	--	--	94.75	1749.00
			100.00	2775.50

One batch yields 60 $\pm$ one 4-gallon carton or 45 $\pm$ 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.

Brabander Viscosity - 560 $\pm$ 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

- 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

Lehnert 10.3.01-29

SGP 0017511

March 8, 1974
NEW FORMULA TEX-974

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX-974

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound TEX-972.

<u>FORMULA</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Asbestos 8G210	Fiber Filler	13	1.0	80.0
Candriv 4928	Thickener	223	.5	40.0
Dowicil 75	Fungicide	193	.2	16.0
Galvafol 6000	Adhesive	126	.5	40.0
Asbestos	Fiber Filler	9	5.0	400.0
Mica p80-R	Anticracking agent	11	4.0	320.0
Land Plaster TEX-25	Filler	--	73.8	5904.0
T.P. Blend Talc	Slip Agent	--	15.0	1200.0
			100.0	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-972 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-972.

WNG:elz

Lehnert 10.3.01-30

SGP 0017698

February 27, 1975
Supersedes Formula TEX-974
Dated 3/8/74

ACME, TEXAS, PLANT FORMULA
READY MIX FILLER TEX-974

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound TEX-972.

-/ 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
Asbestos 80210	Fiber Filler	13	1.0	80.0
Gendriv 492S	Thickener	223	.5	40.0
Dowicil 75	Preservative	193	.175	14.0
Gelvatol 6000	Adhesive	126	.5	40.0
Asbestos	Fiber Filler	9	5.0	400.0
Mica p80-H	Anti-cracking agent	11	4.0	320.0
Land Plaster TEX-25	Filler	--	73.8	5904.0
T.P. Blend Talc	Slip agent	--	15.0	1200.0
			100.0	8000.0

WORKING CONSISTENCY
Specifications:

- Refer to Paint 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-972 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-972.

-/ denotes change

WNG:jg

Lehnert 10.3.01-31

SGP 0017699

March 31, 1972
Acma 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 7RFO9	Bulking agent	193	4.25	212.50 425.00
Dowicil 100	Fungicide	193	.15	7.50 15.00
Polyvinyl Alcohol	Adhesive <i>Adhesive 10-50</i>	162	.60	30.00 60.00
Mothocel 228	Water retention aid	11	.50	25.00 50.00
Mica	Anti-cracking agent	-	7.00	350.00 700.00
Asbestos (8G-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.

<u>Specifications:</u>	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
	66	60	62
	66	58	66

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 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.

SDO:els

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

Lehnert 10.3.01-32

SGP 0017595

1-10-72 Gypsum takes out 45% lower amount weighted 45% per cu ft

April 14, 1972
Supersedes TEX-973
Dated 3/31/72

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
Lead 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.

EDO:slx

Lehnert 10.3.01-33

SGP 0017596

May 17, 1972
Supersedes Formula TEX-973
Dated 4/14/72

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>Hydrotol 20-30</i>	Adhesive	162	.60	48.00
Gandriv 4028	Water retention aid	11	.50	40.00
Mica	Anti-cracking agent	-	7.00	560.00
Asbestos (SQ-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

Lehnert 10.3.01-34

SGP 0017597

March 31, 1972
Acme No. TEX 974
NEW

ACME, TEXAS PLANT FORMULA

READY MIX JOINT COMPOUND NO. TEX-974 (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 only.

FORMULA:

Raw Material

	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Nalco 71-DS	Anti-foaming agent	-	0.1	1.00 4.6
Water	Solvent	-	-	1162.00 4.6 gal
Preplasticized PVA Emulsion	Adhesive	185	5.0	100.00 128 gal
Filler TEX-220 773	-	-	94.9	1898.00 92.0 gal
			100.0	3161.67

*One batch yields 65 ± one 4 gallon cartons

WORKING CONSISTENCY:
Specifications

Brabender Viscosity:

WORKING PROPERTIES:
Specifications

BONDING PROPERTIES:
Specifications

CRACK RESISTANCE:

COLOR:
Specifications

EDG:als

Lehnert 10.3.01-35

SGP 0017694

May 17, 1972
Supersedes Formula TEX-974
Dated 3/31/72

ACME, TEXAS PLANT FORMULA

READY MIX JOINT COMPOUND NO. TEX-974 (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 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	116.9 ^{5.28} 4.6
Water	Solvent	-	-	1162.00 (140 gal)
Preplasticized PVA Emulsion	Adhesive	185	5.0	100.00 128 gal
Filler TEX-973	-	-	<u>94.9</u>	<u>1898.00</u> 92 (140 gal)
			100.0	3161.67 2909.0

**One batch yields 65 ± 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 pasta may be added to adjust.

Brabender Viscosity:

~~540 ± 20~~
510 ± 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:

- 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:dek

-/ Denotes change

Lehnert 10.3.01-36

SGP 0017695

March 7, 1974
New Formula TEX 973

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 4928	Thickener	223	.50	40.0
Dowicil 75	Fungicide	193	.20	16.0
Asbestos 7R79	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

WORKING CONSISTENCY
Specifications:

- Refer to Plant Testing Procedure No. 32
Maximum Minimum Average
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 No TEX-977.

WNG:vlm

Lehnert 10.3.01-37

SGP 0017599

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

WNQ: gvp

Lehnert 10.3.01-38

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

Lehnert 10.3.01-39

SGP 0017603

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	-	78.63	6292.0
T.P. Blend Tale	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.

WNG/gvp

-/ denotes change

Lehnert 10.3.01-40

SGP 0017605

REV. 20
April 12, 1976
Supersedes Formula TEX-973
Dated 9/11/75

4/12/76

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>
Vancoide.	Preservative	126	.025	2.0
-/ Galactosol 413-W	Thickener		.50	40.0
Dewicil 75	Preservative	292	.10	14.0
Asbestos 86-210	Fiber Filler	13	3.25	260.0
Mica p80-H	Anti-cracking agent	11	7.50	600.0
Land Plaster TEX-25	Filler		76.475	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

Lehnert 10.3.01-41

SGP 0017804

A 11

April 12, 1973
Formula TEX-974
NEW

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-974 (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, 1-gallon pails, 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-D3	Antifoaming agent		0.1	2.0
Water	Solvent		-	1039.0 (125 gal)
Filler TEX-976			<u>99.9</u>	<u>1800.0</u>
			100.0	2841.0

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

Brabander 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 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.

WNG:alz

Lehnert 10.3.01-42

SGP 0017696

March 31, 1972
Acme No. TEX-973
NEW

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>Percant</u>	<u>Lbs/Batch</u>
Nalco 71-D5	Anti-foaming agent	-	0.1	5.00 4.6
Water	Solvent	-	-	1245.00 150 gal
Preplasticized PVA Emulsion	Adhesive	185	5.0	100.00 130 92.64
Filler TEX-970-973	-	-	.94.9	1898.00 1750
			100.00	3244.67

**One batch yields 63 $\frac{1}{2}$ one $\frac{2}{4}$ 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

- ~~285-300~~
376 $\pm$ 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:alz

Lehnert 10.3.01-43

SGP 0017804

May 17, 1972
Supersedes Formula TEX-975
Dated 3/31/72

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>Percents</u>	<u>Lbs/Batch</u>
Nalco 71-DS	Anti-foaming agent	-	0.1	5.00 4.6
Water	Solvent	-	-	1245.00 (130 130)
Preplasticized PVA Emulsion	Adhesive	185	5.0	100.00 * 9.2
Filler TEX- 973	-	-	94.9	1898.00 17.50
			100.00	3244.67 29.25

**One batch yields 65 $\pm$ 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

- ~~365 $\pm$ 20~~
375 $\pm$ 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.

WNG:dek * 10 gal
- / Denotes change

Lehnert 10.3.01-44

SGP 0017805

August 22, 1973
Formula TEX-975
NEW

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 80210	Fiber Filler	13	1.50	120.0
Gendriv 4928	Thickener	223	.50	40.0
Dowicil 100	Fungicide	126	.15	12.0
Calvatol 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		<u>84.75</u>	<u>6780.0</u>
			100.00	8000.0

WORKING CONSISTENCY
Specifications:

- Refer to Plant Testing Procedure No. 32

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

Lehnert 10.3.01-45

SGP 0017808

September 5, 1973
Supersedes: Formula TEX-975
Dated 8/22/73

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 SQ210	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
Gelvatol 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
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-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:els

-/ indicates change

Lehnert 10.3.01-46

SGP 0017807

October 22, 1973
Supersedes Formula TEX-978
Dated 8/22/73

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND, NO. TEX- 978 (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		-	97.9 ¹⁶⁰ gal
-/ Filler TEX- 975			99.9	1800.0
			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 - ⁴⁹⁰
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.

Lehnert 10.3.01-47

WNG:elz

-/ denotes change

SGP 0018159

October 22, 1973
Supersedes Formula TEX-979
Dated 8/22/73

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-979 (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, 1-gallon pails, 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	Antifoaming agent		0.1	2.0	150
Water	Solvent		-	1039.0	445 gal
-/ Filler TEX-975			99.9	1800.0	
			100.0	2841.0	

**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 - 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.

Lehnert 10.3.01-48

WNG:els

-/ denotes change

SGP 0018283

July 6, 1972
 TEX-978
 NEW FORMULA

ACME, TEXAS, PLANT FORMULA
 READY MIX FILLER TEX-978 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix Joint Compound TEX-977 and TEX-979.

FORMULA

Raw Material	Function	R.M. Spec	Percent	Lbs/Batch
Dowicil 100	Fungicide	193	.15	12.00
Polyvinyl Alcohol	Adhesive	162	.60	48.00
Methocel 228	Water retention aid	170	.75	60.00
Mica	Anti-cracking agent	11	7.00	560.00
Asbestos (SG-210)	Bulking agent	-	3.75	300.00
Land Plaster	Filler	13	87.75	7020.00
			100.00	8000.00

WORKING CONSISTENCY
 Specifications

- Refer to Plant Testing Procedure No. 32.
 - Maximum Minimum Average
 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 No. TEX-979 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-979.

EDO:elz

Helicatol 33.72 lbs per cu ft
 mica 12.54
 Hypsurim 31.73 - loose
 49.78 - packed
 78P9 asbestos 20.14 - packed
 " 10.6 - loose
 SG-210 asbestos 5.3 - loose
 Ready mix filler 40.5 - loose 7-10-72
 Lehnert 10.3.01-49 SGP 0018157

1-22-72 material taken out of bin. amount was 45"

July 6, 1972
TEX-979
NEW FORMULA

ACME, TEXAS PLANT FORMULA
READY MIX JOINT COMPOUND NO. TEX-979 (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	3.00 4.6
Water	Solvent	-	-	1080.00-- (120 gal)
Preplasticized PVA Emulsion	Adhesive	185	7.4	148.00 112
Filler TEX-978	-	-	<u>92.5</u>	<u>1841.00 137.00</u>
			100.00	<u>3074.00 1700</u>

**One batch yields 51 $\pm$ 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

- ~~540~~ $\pm$ 20
470

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:elz

Lehnert 10.3.01-50

SGP 0018260

August 25, 1972
Supersedes: TEX-979 dated 7/6/72

ACME, TEXAS PLANT FORMULA
READY MIX JOINT COMPOUND NO. TEX-979 (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	4.60
Water	Solvent	-	-	929.60 (112 gal)
Preplasticized PVA Emulsion	Adhesive	185	7.4	137.00
Filler TEX-978	-	-	<u>92.5</u>	<u>1700.00</u>
			100.00	2771.20

- **One batch yields 45 $\pm$ 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

430 $\pm$ 20
470

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:elz

Lehnert 10.3.01-51

-/ denotes change

SGP 0018281

A. 50

July 6, 1972
TEX-979
NEW FORMULA

ACME, TEXAS PLANT FORMULA
READY MIX JOINT COMPOUND NO. TEX-979 (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	-3.88 4.6
Water	Solvent	-	-	1080.00-- (120 gal)
Preplasticized PVA				112
Emulsion	Adhesive	185	7.4	-148.00 137.00
Filler TEX-978	-	-	92.5	-1841.00 1700
			100.00	-9874.00

**One batch yields 51 ± 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

--540 ± 20
470

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.

ED01a1z

Lehnert 10.3.01-52

SGP 0018264

August 23, 1972
Supersedes: TEX-979 dated 7/6/72

ACME, TEXAS PLANT FORMULA
READY MIX JOINT COMPOUND NO. TEX-979 (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	4.60
Water	Solvent	-	-	929.60 (112 gal)
Preplasticized PVA Emulsion	Adhesive	185	7.4	137.00
Filler TEX-978	-	-	<u>92.5</u>	<u>1700.00</u>
			100.00	2771.20

-/ **One batch yields 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
470

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:ela

-/ denotes change

Lehnert 10.3.01-53

SGP 0018265

October 22, 1973
Supersedes Formula TEX-979
Dated 8/22/73

ACME, TEXAS, PLANT FORMULA
READY MIX JOINT COMPOUND TEX-979 (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, 1-gallon pails, 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-D3	Antifoaming agent		0.1	2.0	150
Water	Solvent		-	1039.0	(445 gal)
-/ Filler TEX-975			99.9	1800.0	
			100.0	2841.0	

**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 - 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.

Lehnert 10.3.01-54

WNG:elz

-/ denotes change

SGP 0018267

July 13, 1976
Ready Mix Filler AK-970
NEW

AKRON, NEW YORK PLANT FORMULA
READY MIX FILLER AK-970 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix Topping Compound AK-971.

<u>FORMULA</u>				
<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Sorbitol (Powdered)	Borax Stabilizer	-	.09	4.0
**Asbestos 7RFO2	Bulking Agent	9	.90	40.0
*Cosan JTA 20	Fungicide	193	.09	4.0
Natrosol 250 HXR	Water Retention Aid	170	.74	32.0
Mica	Anti-cracking Agent	11	7.20	320.0
Asbestos (SG-210)	Bulking Agent	18	1.89	84.0
Limestone	Filler	13	<u>89.09</u>	<u>3960.0</u>
			100.00	4444.0

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 No. AK-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. AK-971.

*Troysan FMA-10-SEP may be substituted. Use at a loading of .18% (8 lbs/batch).

Lehnert 10.3.01-55

WNO:gvp

SGP 0017299

July 13, 1976
Ready Mix Filler AK-970
NEW

AKRON, NEW YORK PLANT FORMULA
READY MIX FILLER AK-970 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix Topping Compound AK-971.

<u>FORMULA</u>				
<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Sorbitol (Powdered)	Borax Stabilizer	-	.09	4.0
**Asbestos 7RFO2	Bulking Agent	9	.90	40.0
*Cosan JTA 20	Fungicide	193	.09	4.0
Natrosol 250 HXR	Water Retention Aid	170	.74	32.0
Mica	Anti-cracking Agent	11	7.20	320.0
Asbestos (SQ-210)	Bulking Agent	18	1.89	84.0
Limestone	Filler	13	89.09	3960.0
			100.00	4444.0

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 No. AK-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. AK-971.

*Troysan FMA-10-SEP may be substituted. Use at a loading of .18% (8 lbs/batch).

Lehnert 10.3.01-56

WNG:gvp

SGP 0017300

January 10, 1977
Supersedes Ready Mix Filler AK-970
Dated: 7/13/76

AKRON, NEW YORK PLANT FORMULA
READY MIX FILLER AK-970 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix Topping Compound AK-971.

<u>FORMULA</u>				
<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
-/ Sorbitol (Powdered)	Borax Stabilizer	-	.07	3.0
Asbestos 7RFO2	Bulking Agent	9	.90	40.0
*Cosan JTA 20	Fungicide	193	.09	4.0
Natrosol 250 HXR	Water Retention Aid	170	.74	32.0
Mica	Anti-cracking Agent	11	7.20	320.0
Asbestos (SG-210)	Bulking Agent	18	1.89	84.0
-/ Limestone	Filler	13	89.11	3961.0
			100.00	4444.0

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 No. AK-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. AK-971.

*Troysan PMA-10-SEP may be substituted. Use at a loading of .18% (8 lbs/batch).

WNG:gvp

Lehnert 10.3.01-57

SGP 0017301

July 13, 1976
Ready Mix Topping AK-971
NEW

AKRON, NEW YORK PLANT FORMULA
READY MIX TOPPING COMPOUND AK-971 (HAND TOOLS)

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

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Water	Solvent	--	2158.0 (260 gals.)*
Nalco	Anti-foaming agent	0.1	4.0
Elvace 1875	Adhesive	4.5	198.0 (22.25 gals.)
Filler AK-970	Filler	95.4	4200.0
		100.0	6560.0**

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch).

**One batch yields 106 ± 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

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: (580 ± 20) For machine tools add 14 gallons H_2O (400 ± 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. Material shall be free from lumps due to 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.

WNG:gvp

Lehnert 10.3.01-58

SGP 0017420

July 19, . . .
Ready Mix Topping
AK-971
NEW

AKRON, NEW YORK, PLANT FORMULA
READY MIX TOPPING COMPOUND AK-971 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Topping Compound used for finishing joint and spotting nail heads.

<u>FORMULA</u>				
<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Filler AK-970	Filler	--	93.3	4128.0
Elvace EP 200	Adhesive	183	6.0	266.0 (30 gals.)
Nalco 71D-5	Defoamer	125	.2	9.0
Acrysol ASE-60	Thickener	147	.5	22.0
*Water	Solvent	--	--	2075.0 (250 gals.)
				6500.0*

*Approximately 36.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch.

**One batch yields 104 ± 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

SPECIAL MIXING INSTRUCTIONS

- Blend ingredients in following order:
 - 1) Water
 - 2) Elvace EP 200
 - 3) Nalco
 - 4) Filler AK-970
 - 5) Mix until filler is thoroughly dispersed
 - 6) Add Acrysol ASE-60
 - 7) Mix until Ready Mix is smooth - check viscosity and pH

WORKING CONSISTENCY
Specifications for
Pasta

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

Brabander: (580 ± 20) For machine tools add 14 gallons H₂O (400 ± 20)

pH

Minimum - 9.0 Maximum - 10.0

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.

BONDING PROPERTIES
Specifications

- Refer to Plant Testing Procedure No. 35.
After compound has dried, tape shall show at least 75%
fiber tear when delaminated.

Continued on Page 2

Lehnert 10.3.01-59

SGP 0017421

Jul, 10, 1977
Ready Mix Topping
AK-971
NEW

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.

WNG:jr

Lehnert 10.3.01-60

SGP 0017422

MAY 27 1975
 January 16, 1975
 Subsequent Formula C-970
 NEW DATED 1/14/75

CHICAGO, ILLINOIS, PLANT FORMULA
READY MIX FILLER C-970

DESCRIPTION OF PRODUCT - Filler for Ready Mix joint compound C-971

<u>FORMULA</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
*Asbestos 7RF09	Bulking agent	9	4.25	170.00
Dowicil 75	Fungicide	193	.20	8.00
Celvatol 6000	Adhesive	162	1.00	40.00
Gendriv 4928	Water retention aid	223	.75	30.00
Mica	Anti-cracking agent	11	9.50	380.00
Asbestos (SG-210)"	Bulking agent	4-12	1.25	50.00
Limestone	Filler	13	83.05	3322.00
			100.00	4000.00

WORKING CONSISTENCY
Specifications

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
57	53	55

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.

* Asbestos 7RF09 may be substituted, use at a maximum of 2.75 (110 lbs/batch).

NOTE: A wet mix of the filler shall be prepared according to Formula No. C-972 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. C-972.

WNG:jg

Lehnert 10.3.01-61

SGP 0018548

A

ANN. 1.7, 1975
January 16, 1975
Formula 0-971
NEW DATED 1/16/75

CHICAGO, ILLINOIS, PLANT FORMULA
READY MIX JOINT COMPOUND 0-971 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for taping, topping, and texturing. ~~Special low-cost formula.~~
For trial shipments only.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Water	Solvent	--	1024.00 (128 gals.)*
Nalco	Anti-foaming agent	.2	4.00
Elvace 1875	Adhesive	2.0	39.00 (4.4 gals.)
Filler 0-970	Filler	97.8	1950.00
		100.0	3017.00**

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch).

**One batch yields 50 $\pm$ 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

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: (540 $\pm$ 20) For machine tools add 10 gallons H₂O. (400 $\pm$ 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. Material shall be free from lumps due to 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

- 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
Dried compound shall match color of standard sample.

WNG:jg

Lehnert 10.3.01-62

SGP 0018549

A. - (1.0)

Supersedes: Formula C-970

Dated: 7/21/76

11/23/76

CHICAGO, ILLINOIS, PLANT FORMULA
READY MIX FILLER C-970

DESCRIPTION OF PRODUCT - Filler for Ready Mix joint compound C-976.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Sorbitol	Borax Stabilizer	-	.090	4.00
Asbestos SQ210	Bulking Agent	18	1.575	70.00
*Asbestos 7RF02	Bulking Agent	9	1.575	70.00
**Dowicil 75	Preservative	193	.360	16.00
Hamico 267	Adhesive	23	.585	26.00
Natrosol 250 HXR	Water Retention Aid	170	.450	20.00
Mica P80-F	Anti-Cracking	11	6.751	300.00
-/ Sericite Mica GP-F-2	Mica-Extender	-	6.751	300.00
-/ Limestone	Filler	13	81.863	3638.00
			100.00	4444.00

WORKING CONSISTENCY
Specifications

- Refer to Plant Testing Procedure No. 32.

Maximum

Minimum

Average

57

53

55

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 No. C-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. C-971.

** TRAYSAN PNA-10-SEP MAY BE SUBSTITUTED.
USE AT A LOADING OF 8 LBS./BATCH

-/ denotes change

WNG:gvp

Lehnert 10.3.01-63

SGP 0018527

A. L. L.

January 10, 1977
Supersedes: Formula C-970
Dated: 12/1/76

CHICAGO, ILLINOIS, PLANT FORMULA
READY MIX FILLER C-970

DESCRIPTION OF PRODUCT - Filler for Ready Mix joint compound C-976...

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
-/ Sorbitol	Borax Stabilizer	-	.067	3.00
Asbestos SG210	Bulking Agent	18	1.575	70.00
*Asbestos 7RF02	Bulking Agent	9	1.575	70.00
-/ Troysan PMA-10-SEP	Preservative	-	.180	8.00
Hamico 267	Adhesive	23	.585	26.00
Natrosol 250 HXR	Water Retention Aid	170	.450	20.00
Mica P80-F	Anti-Cracking	11	6.751	300.00
Sericita Mica GP-F-2	Mica-Extender	-	6.751	300.00
-/ Limestone	Filler	13	82.066	3647.00
			100.00	4444.00

WORKING CONSISTENCY
Specifications

- Refer to Plant Testing Procedure No. 32.
Maximum Minimum

57

53

Average

53

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 No. C-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. C-971.

-/ denotes change

WNG: gvp

Lehnert 10.3.01-64

SGP 0018518

A-100

JAN. 10, 1977
 December 1, 1976
 Supersedes: Formula C-970
 Dated: 11/23/76
 12/1/76

CHICAGO, ILLINOIS, PLANT FORMULA
READY MIX FILLER C-970

DESCRIPTION OF PRODUCT - Filler for Ready Mix joint compound C-976.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>	
- Sorbitol	Borax Stabilizer	-	.067 .090-	4.00	3.0
Asbestos SG210	Bulking Agent	18	1.575	70.00	
*Asbestos 7RF02	Bulking Agent	9	1.575	70.00	
**Dewicil-75	Preservative	193	.18 .360	16.00	4.00
Hamico 267	Adhesive	23	.585	26.00	
Natrosol 250 HXR	Water Retention Aid	170	.450	20.00	
Mica P80-F	Anti-Cracking	11	6.751	300.00	
Sericite Mica GP-F-2	Mica-Extender	-	6.751	300.00	
- Limestone	Filler	138	2.066 .81-863.	2630.00	3647
			100.00	4444.00	

WORKING CONSISTENCY
Specifications

- Refer to Plant Testing Procedure No. 32.
Maximum Minimum

57

53

Average

55

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 No. C-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. C-971.

~~***Troyan PMA-10 SEP may be substituted. Use at a loading of 8 lbs./batch.~~

-/ denotes change

WNG:

JP

Lehnert 10.3.01-65

SGP 0018535

A-1-2

January 10, 1977
Supersedes Formula C-976
Dated: 7/21/76

CHICAGO, ILLINOIS, PLANT FORMULA
READY MIX JOINT COMPOUND C-976 (HAND TOOLS)

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

<u>FORMULA</u> <u>Raw Material</u>	<u>Function</u>	<u>Percent</u>	<u>Lbs/Batch</u>
-/ Water	Solvent	--	1038.00 (125 gals.)*
Nalco	Anti-foaming agent	.1	2.00
-/ Elvace EP-200	Adhesive	6.4	134.00 (15.0 gals.)
Filler C-970	Filler	<u>93.5</u>	<u>1950.00</u>
		100.0	3124.00**

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch).

-/ **One batch yields 50 $\pm$ 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

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: (580 $\pm$ 20) For machine tools add 10 gallons H₂O. (400 $\pm$ 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. Material shall be free from lumps due to 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

- 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
Dried compound shall match color of standard sample.

WNQ: gvp

-/ denotes change

Lehnert 10.3.01-66

SGP 0018521

A 1.1

JAN. 17, 1977
~~July 22, 1976~~
Supersedes Formula C-976
Dated 3/22/76
7/21/76

CHICAGO, ILLINOIS, PLANT FORMULA
READY MIX JOINT COMPOUND C-976 (HAND TOOLS)

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

<u>FORMULA</u> <u>Raw Material</u>	<u>Function</u>	<u>Percent</u>	<u>Lbs/Batch</u>
-/ Water	Solvent	--	1038 1038.00 (130 gals.)*
Nalco	Anti-foaming agent	.1	2.00
-/ Elvace 1873 @ 200	Adhesive	6.4	134.00 (15.0 gals.)
Filler C-970	Filler	93.3	1950.00
		100.0	-3166.00**

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary ± 8 gallons per batch.)

-/ **One batch yields 52 ± 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

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: (580 $\pm$ 20) For machine tools add 10 gallons H₂O. (400 $\pm$ 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. Material shall be free from lumps due to 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

- 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
Dried compound shall match color of standard sample.

WNO: gvp

-/ denotes change

SGP 0018538

A-6<

74.10.17, 1977
~~May 21, 1976~~
 Supersedes Formula C-979
 DATE DATED 5/21/76

CHICAGO, ILLINOIS PLANT FORMULA
 READY MIX JOINT COMPOUND C-979 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for taping, topping and texturing. (Special asbestos free formula for all one gallon ready mix and selective five gallon shipment only.)

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Filler C-978	Filler	--	92.8	1950.0
Elvaco 1875 CP 200	Adhesive	185	6.5	136.0 (15.25 gals.)
Nalco 71D-5	Defoamer	125	.2	4.0
Acrysol ASE-60	Thickener	147	.5	10.0 132
*Water	Solvent	--	--	1104 1120.0 (135 gals.)
			100.0	3240.0** 3204

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch.

** One batch yields 31 $\pm$ 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

SPECIAL MIXING INSTRUCTIONS

- Blend ingredients in following order:
 - 1) Water
 - 2) Elvaco 1875 CP 200
 - 3) Nalco
 - 4) Filler C-978
 - 5) Mix until filler is dispersed
 - 6) Add Acrysol ASE-60
 - 7) Mix until Ready Mix is smooth - pumping viscosity should be 480 $\pm$ 20 to allow for 24 hour viscosity build of 100 pts.

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: (580 $\pm$ 20) For Machine tools add 7 gallons H₂O (400 $\pm$ 20)

pH

Minimum - 9.0

Maximum - 10.0 (24 hrs.)

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.

WNG:gvp

Continued on Page 2...

Lehnert 10.3.01-67

SGP 0018540

A 1 C

Ready Mix Topping
RM-971
NEW

CHICAGO, ILLINOIS
~~ARMED, WEAPONED~~, PLANT FORMULA
READY MIX TOPPING COMPOUND RM-971 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Topping Compound used for finishing joint and spotting nail heads.

<u>FORMULA</u>				
<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Filler RM -970	Filler	--	93.7 95.7	1950.0 1950.0
Elvace EP 200	Adhesive	185	6.0	126.0 (26 gals.)
Nalco 71D-5	Defoamer	125	.1	2.0
Acrysol ASE-60	Thickener	147	2	22.0
*Water	Solvent	--	--	1124.0 (250 gals.)
				6500.0 3185.0

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch).

**One batch yields ⁵¹ ~~54~~ $\pm$ 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

SPECIAL MIXING INSTRUCTIONS

- Blend ingredients in following order:
 - 1) Water
 - 2) Elvace EP 200
 - 3) Nalco
 - 4) Filler ~~RM~~-970
 - 5) Mix until filler is thoroughly dispersed
 - 6) Add Acrysol ASE-60
 - 7) Mix until Ready Mix is smooth - check viscosity and pH

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: (580 $\pm$ 20) For machine tools add ² ~~4~~ gallons H₂O (400 $\pm$ 20)

pH

Minimum - 9.0

Maximum - ^{9.5} ~~10.0~~

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.

BONDING PROPERTIES
Specifications

- Refer to Plant Testing Procedure No. 35.
After compound has dried, tape shall show at least 75% fiber tear when delaminated.

Continued on Page 2

Lehnert 10.3.01-68

SGP 0018508

July 19, 1977
Ready Mix Topping
C-4E-971
NEW

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.

WNG:jr

Lehnert 10.3.01-69

SGP 0018509

MC: 7, 1976
 July 14, 1976
 Supersedes: Formula C-973
 Dated: 3/23/76
 7/14/70

CHICAGO, ILLINOIS, PLANT FORMULA
READY MIX FILLER C-973

DESCRIPTION OF PRODUCT - Filler for Ready Mix Topping compound C-974.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
* Sorbitol	Borax Stabilizer	-	.10	4.00
Asbestos SD 210	Bulking Agent	18	1.75	70.00
Asbestos 72F02	Bulking Agent	9	1.75	70.00
* Dowicil 75	Preservative	193	.20	8.00
Natrosol 250 HXR	Water Retention Aid	170	.75	30.00
Mica P80-F	Anti-Cracking	11	7.50	300.00
Sericite Mica GP-F-2	Mica-Extender	-	12.00	480.00
Limestone	Filler	13	75.95	3038.00
			100.00	4000.00

WORKING CONSISTENCY
Specifications

- Refer to Plant Testing Procedure No. 32.

Maximum

Minimum

Average

57

53

55

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 No. C-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. C-974.

** TROYAN PMA -10- SEP MAY BE SUBSTITUTED.
 USE AT A LOADING OF 8 LBS/BATCH.

WNG:gvp

Lehnert 10.3.01-70

SGP 0018528

January 10, 1977
Supersedes: Formula C-973
Dated: 12/1/76

CHICAGO, ILLINOIS, PLANT FORMULA
READY MIX FILLER C-973

DESCRIPTION OF PRODUCT - Filler for Ready Mix Topping compound C-974.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
-/ Sorbitol	Borax Stabilizer	-	.075	3.00
Asbestos SG 210	Bulking Agent	18	1.75	70.00
Asbestos 7RF02	Bulking Agent	9	1.75	70.00
-/ Troysan FMA-10-SEP	Preservative	-	.20	8.00
Natrosol 250 HXR	Water Retention Aid	170	.75	30.00
Mica P80-F	Anti-Cracking	11	7.50	300.00
Sericite Mica GP-F-2	Mica-Extender	-	12.00	480.00
-/ Limestone	Filler	13	75.975	3039.00
			100.00	4000.00

WORKING CONSISTENCY
Specifications

- Refer to Plant Testing Procedure No. 32.

Maximum

Minimum

Average

57

53

55

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 No. C-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. C-974.

-/ denotes change

WNG:gvp

Lehnert 10.3.01-71

SGP 0018519

JAN. 10, 1977
 December 1, 1976
 Supersedes Formula G-973
 Dated: 7/24/76
 12/1/76

CHICAGO, ILLINOIS, PLANT FORMULA
 READY MIX FILLER G-973

DESCRIPTION OF PRODUCT - Filler for Ready Mix Topping compound G-974.

FORMULA

Raw Material	Function	RM Spec	Percent	Lbs/Batch	
Sorbitol	Borax Stabilizer	-	.075	4.00	2.0
Asbestos SQ 210	Bulking Agent	18	1.75	70.00	
Asbestos 7RF02	Bulking Agent	9	1.75	70.00	
-/ Dowdell 75	Preservative	492	.20	8.00	
Natrosol 230 HCR	Water Retention Aid	170	.75	30.00	
Mica P80-F	Anti-Cracking	11	7.50	300.00	
Vericite Mica GP-F-2	Mica-Extender	-	12.00	480.00	
-/ Limestone	Filler	13	70.575	2835.00	2039
			100.00	4000.00	

WORKING CONSISTENCY
Specifications

- Refer to Plant Testing Procedure No. 32.

Maximum	Minimum	Average
97	53	55

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 No. G-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. G-974.

~~Asbestos 7RF02 may be substituted: Use at a loading of 8 lbs/batch.~~

-/ denotes change

WNO: 16
 9/3

GOP 0018538

Lehnert 10.3.01-72

0.10

February 6, 1975
Supersedes C-978
Dated 1/16/75

CHICAGO

CHICAGO, ILLINOIS, PLANT FORMULA
READY MIX FILLER C-978 (FILLER "X")

DESCRIPTION OF PRODUCT - Filler for Ready Mix joint compound C-976

<u>FORMULA</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Asbestos 7RFO9	Bulking Agent	9	4.25	170.00
Dowicil 75	Fungicide	193	.20	8.00
Gelvitol 3000	Adhesive	162	.40	16.00
-/Gandriv 4928	Water retention aid	223	.75	30.00
Mica	Anti-cracking agent	11	9.50	380.00
Asbestos (SG-210)	Bulking agent	---	1.25	50.00
Limestone	Filler	13	83.65	3346.00
			100.00	4000.00

WORKING CONSISTENCY
Specifications

- Refer to Plant Testing Procedure No. 32.
Maximum Minimum Average
57 53 55

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 No. C-979 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. C-979.

-/ denotes change

WNQ:slz

Lehnert 10.3.01-73

SGP 0018547

A-10

TAJ. 17, 1977
July 14, 1976
Supersedes Formula C-974
Dated: 3/28/76.
7/21/76

CHICAGO, ILLINOIS, PLANT FORMULA
READY MIX TOPPING COMPOUND C-974 (HAND TOOLS)

DESCRIPTION OF PRODUCT

- White Ready Mix Topping Compound used for topping and spotting nailheads.

FORMULA

Raw Materials	Function	RM Spec	Percent	Lbs/Batch 175
✓ Water	Solvent	--	--	105.0 (1080.00 (139 gals))*
Nalco	Anti-foaming Agent	125	0.1	2.00
-/ Elvaco 4875 C.D. - 200	Adhesive	185	4.5	92.00 (10.3 gals)
Filler C-973	Filler		95.4	1950.00
			100.0	3124.00**

*Approximately 54.4 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch).

**One batch yields 50 $\pm$ 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

WORKING CONSISTENCY

Specification 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: 580 $\pm$ 20

For machine tools add 6 gallons H₂O (400 $\pm$ 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. Material shall be free from lumps due to 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.

WNG:gvp

-/ denotes change

Lehnert 10.3.01-74

SGP 0018537

A-71

June 21, 1973
Supersedes Formula V-977
Dated 1/23/73

MILFORD, VIRGINIA PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE 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>
Water	Solvent	-		1140(136Gals
PVA Emulsion	Adhesive	185	7.40	148.0
NALCO	Antifoaming Agent	125	.10	2.00
Asbestos 7RFO9	Bulking Agent	9	3.92	78.00
Dowicil 100	Bactericide	193	.14	3.0
PV Alcohol	Adhesive	162	.74	15.0
*Thickner	Thickner	170or223	.69	14.0
Mica	Anticracking Agent	11	6.46	129.0
Asbestos SG-210	Bulking Agent	18	1.62	32.0
Limestone	Filler	13	78.70	1575.0
Calgon T	Slip Agent	229	.23	4.0
			100.00	3140.0

*Natrosol 250 HXR or Gendriv 4925

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary
± 4 gallons per batch.

**One batch yields 50 + 1 five gallon pail Ready Mix joint compound at
62 lbs/pail.

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

Brabender: 385 ± 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. 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 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.

BDO:jg

Lehnert 10.3.01-75

SGP 0018144

A-72

July 12, 1973
Supersedes Formula V-977
Dated 6/21/73

MILFORD, VIRGINIA PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE 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>
Water	Solvent	-		1140(136Gals
PVA Emulsion	Adhesive	185	7.40	148.0
NALCO	Antifoaming Agent	125	.10	2.00
Asbestos 7RF09	Bulking Agent	9	3.92	78.00
Dowicil 100	Bactericide	193	.19	4.0
PV Alcohol	Adhesive	162	.74	15.0
*Thickner	Thickner	170 or 223	.69	14.0
Mica	Anticracking Agent	11	6.46	129.0
Asbestos SG-210	Bulking Agent	18	1.62	32.0
Limestone	Filler	13	78.65	1574.0
Calgon T	Slip Agent	229	.23	4.0
			100.00	3140.0

*Natrosol 250 HXR or Gendriv 4925

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary
± 4 gallons per batch.

**One batch yields 50 + 1 five gallon pail Ready Mix joint compound at
62 lbs/pail.

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

Brabender: 365 ± 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. 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 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.

EDO:jg

Lehnert 10.3.01-76

SGP 0018145

A-73

Revised 17, 1977
Superior Formulas V-977
Dated 7/12/73

MILFORD, VIRGINIA, PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE 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>lb / gal</u>
Water	Solvent	-		11.36 gal
PVA Emulsion	Adhesive	185	7.40	11.36
NALCO	Antifoaming Agent	125	.10	.10
Asbestos 7RF09	Bulking Agent	9	3.92	3.92
-/ Troysan Cmp-10-Sop	Bactericide	193	.10	.10
PV Alcohol	Adhesive	162	.7	1.00
*Thickner	Thickner	170or223	.60	1.00
Mica	Anticracking Agent	11	6.46	6.46
-/ Asbestos SC-210	Bulking Agent	18	1.62	1.62
Limestone	Filler	13	78.97	78.97
			100.00	314.00

*Natrocol 250 HXR or Gendriv 4925

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 4 gallons per batch).

**One batch yields 50 + 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

WORKING CONSISTENCY
Specifications for
Paste:

- Refer to Plant Testing Procedure No. 37.
If paste is not proper working consistency,
a maximum of 5 cc. water per 150 grams of paste
may be added to adjust.

Brabender:

385 $\pm$ 20

WORKING PROPERTIES
Specifications

- Refer to Plant Testing Procedure No. 37.
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
Specifications

- Refer to Plant Testing Procedure No. 37.
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.

WHG:jg

Lehnert 10.3.01-77

SGP 0018148

A-74

January 15, 1974
Supersedes Formula V-977
Dated 10/18/73

MILFORD, VIRGINIA, PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE 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>
-/ Water	Solvent	-		1140(136gal.
PVA Emulsion	Adhesive	185	7.40	148.0
HALCO	Antifoaming Agent	125	.10	2.0
Asbestos 71FO9	Bulking Agent	9	3.92	78.0
Troyan Cmp-10-Sep	Bactericide	193	.10	2.0
PV Alcohol	Adhesive	162	.74	15.0
Natocel 250 HXR	Thickner	170	.69	14.0
Fica	Anticracking Agent	11	6.46	129.0
Asbestos 30-210	Bulking Agent	18	1.62	32.0
Limestone	Filler	13	78.74	1576.0
Calgon T	Dispersant	229	.23	4.0
			100.00	3140.0***

**Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 4 gallons per batch).

***One batch yields 50 $\pm$ 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

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.

-/ Erabander:

400 $\pm$ 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. Material shall be free from lumps
due to 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.

Lehnert 10.3.01-78

SGP 0018148

A-21

February 22, 1974
Supersedes Formula V-977
Dated 1/15/74

MILFORD, VIRGINIA, PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE 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>
**Water	Solvent	-		1140(136gal)
PVA Emulsion	Adhesive	185	7.00	140.0
NALCO	Antifoaming Agent	125	.10	2.0
Asbestos 7RF09	Bulking Agent	9	3.92	78.0
Troysan Cmp-10-Sep	Bactericide	193	.10	2.0
PV Alcohol	Adhesive	162	.75	15.0
Natrosol 250 HXR	Thickner	170	.70	14.0
Mica	Anticracking Agent	11	8.79	175.0
Asbestos SQ-210	Bulking Agent	18	1.25	25.0
Limestone	Filler	13	77.19	1537.0
Calgon T	Dispersant	229	.20	4.0
			<u>100.00</u>	<u>3132.0***</u>

** Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 4 gallons per batch).

*** One batch yields 50 $\pm$ 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

WORKING CONSISTENCY
Specifications for
Paste:

Brabender:

- 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.

400 $\pm$ 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. Material shall be free from lumps
due to 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.

Lehnert 10.3.01-79

SGP 0018149

A-22

March 6, 1974
Supersedes Formula V-977
Dated 2/22/74

MILFORD, VIRGINIA, PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE 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>
**Water	Solvent	-		1140(136gal
PVA Emulsion	Adhesive	185	7.00	140.0
NALCO	Antifoaming Agent	125	.10	2.0
Asbestos 7RFO9	Bulking Agent	9	3.92	78.0
Troysan Cmp-10-Sep	Bactericide	193	.10	2.0
FV Alcohol	Adhesive	162	.75	15.0
Natrosol 250 HXR	Thickner	170	.70	14.0
Mica	Anticracking Agent	11	8.79	175.0
Asbestos SG-210	Bulking Agent	18	1.25	25.0
Limestone	Filler	13	77.19	1537.0
Calgon T	Dispersant	229	.20	4.0
			100.00	3132.0***

** Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 4 gallons per batch).

*** One batch yields 50 $\pm$ 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

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:

400 $\pm$ 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. Material shall be free from lumps
due to 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

- 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.

Lehnert 10.3.01-80

SGP 0018150

May 20, 1974
Supersedes Formula V-977
Dated 3/6/74

MILFORD, VIRGINIA, PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE 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>
**Water	Solvent	-		1140(136gal
PVA Emulsion	Adhesive	185	7.00	140.0
NALCO	Antifoaming Agent	125	.10	2.0
Asbestos 7RF09	Bulking Agent	9	3.92	78.0
Troysan Cmp-10-Sep	Bactericide	193	.10	2.0
PV Alcohol	Adhesive	162	.375	7.5
Natrosol 250 HXR	Thickner	170	.70	14.0
Mica	Anticracking Agent	11	8.79	175.0
Asbestos SG-210	Bulking Agent	18	1.25	25.0
Limestone	Filler	13	77.565	1544.9
Calgon T	Dispersant	229	.20	4.0
			<u>100.00</u>	<u>3132.0***</u>

** Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 4 gallons per batch).

*** One batch yields 50 $\pm$ 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

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:

400 $\pm$ 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. Material shall be free from lumps
due to 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

- 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: jg

-/ denotes change

Lehnert 10.3.01-81

SGP 0018151

A-74

January 27, 1972
NEW FORMULA AK-501
Continued

Brabender Viscosity 480 $\pm$ 10. Viscosity can be adjusted by addition of water, reduction of mix water, or by addition of ASE-60 in small amounts. It is best to hold back a small amount of water to be added if the viscosity is too high. ASE-60 may be added to thicken the mix should too much water have been added. Should it be necessary to add ASE-60, the pH must again be checked since ASE-60 is acidic and its addition will lower pH. Remember, changes in the water content affect flow properties as well as the wet density.

WORKING CHARACTERISTICS: Shall extrude easily from tube and form a uniform bead that does not sag or run.

OPEN TIME - Refer to Plant Testing Procedure No. 114

WETTING CHARACTERISTICS: Refer to Plant Testing Procedure No. 115

TENSILE STRENGTH - Refer to Plant Testing Procedure No. 116

ALKALINITY - Refer to Plant Testing Procedure No. 34, Adjust with small quantities of AMP

Specifications:	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
	8.0	7.7	7.9

<u>DENSITY</u>			
Specifications: -	10.75 lbs/gal	10.65 lbs/gal	10.7 lbs/gal

Case weight should be 35 lbs. $\pm$ 1 lb.

EDO:elz

Lehnert 10.3.01-82

SGP 0016181

A-800

February 11, 1972
Supersedes AK-501
Dated 1/27/72

AKRON, NEW YORK, PLANT FORMULA
DRYWALL ADHESIVE AK-501

DESCRIPTION: - Drywall stud adhesive. Provisional formula for salvaging formula AK-955.

FORMULA:

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec.</u>	<u>Percent</u>	<u>Lbs./Batch</u>
Akron Stud Adhesive				(102 cases of small tubes
AK-955			54.9	2818.0 or 78 1/2 cases large tubes)
Water	Solvent		1.6	82.0 (9.8 gals.)
Advawet 33	Wetting agent		1.0	51.0 (6.1 gals.)
Water	Solvent		6.0	308.0 (37 gals.)
Clay	Filler		9.0	462.0
Asbestos SQ 210	Filler		0.8	41.0
Resin EB-12	Adhesive		8.2	421.0 (56 gals.)
Emulsion RA-315	Adhesive	217	5.2	267.0 (30 gals.)
Propasol	Filming Agent		1.1	56.0 (7.8 gals.)
Dibutyl Phthalate	Plasticizer		0.8	41.0 (4.7 gals.)
Water	Solvent		7.3	415.0 (50 gals.)
Acrysol ASE-60	Thickening agent		3.5	180.0 (21 gals.)
AMP 95	pH Buffer	225	0.6	31.0 (395 gals.)
				100.0 5133.0

YIELD - One batch yield 480 gals.

MIXING PROCEDURE - Extract AK-955 directly into mixer and proceed in the following order:

- 1) Add water followed by the Advawet 33.
- 2) Mix for five minutes.
- 3) Add the water (2nd addition) followed by the clay and asbestos.
- 4) Mix for a further 30 minutes.
- 5) Add the following ingredients allowing each ingredient to be thoroughly blended before addition of the next ingredient.

Resin EB-12
Emulsion RA-315
Propasol
Dibutyl phthalate

- 6) Add water and Acrysol ASE-60 (may be added simultaneously)
AMP 95

VISCOSITY - Refer to Plant Testing Procedure No. 109.

Specifications: 120 to 300 Brabender unit

Lehnert 10.3.01-83

SGP 0018182

A-81

February 11, 1972
Supersedes AK-501 (Cont.)
Dated 1/27/72

Braabender Viscosity Viscosity can be adjusted by addition of water, reduction of mix water, or by addition of ASE-60 in small amounts. It is best to hold back a small amount of water to be added if the viscosity is too high. ASE-60 may be added to thicken the mix should too much water have been added. Should it be necessary to add ASE-60, the pH must again be checked since ASE-60 is acidic and its addition will lower pH. Remember, changes in the water content affect flow properties as well as the wet density.

WORKING CHARACTERISTICS: Shall extrude easily from tube and form a uniform bead that does not sag or run.

OPEN TIME - Refer to Plant Testing Procedure No. 114

WETTING CHARACTERISTICS: Refer to Plant Testing Procedure No. 115

TENSILE STRENGTH - Refer to Plant Testing Procedure No. 116

ALKALINITY - Refer to Plant Testing Procedure No. 34. Adjust with small quantities of AMP

Specifications:	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
	9.0	7.7	8.3

DENSITY
Specifications: - 11.20 lbs/gal 10.60 lbs/gal 10.9 lbs/gal

Case weight should be 35 lbs. $\pm$ 1 lb.

EDO:elz

Lehnert 10.3.01-84

SGP 0016183

A-81a

February 18, 1972
Supersedes AK-501
Dated 2/11/72

AKRON, NEW YORK, PLANT FORMULA
DRYWALL ADHESIVE AK-501

DESCRIPTION:

- Drywall stud adhesive. Provisional formula for salvaging formula AK-955.

FORMULA:

<u>Raw Material</u>	<u>Function</u>	<u>RY Spec.</u>	<u>Percent</u>	<u>Lbs./Batch</u>
Akron Stud Adhesive AK-955			54.9	(102 cases of small tubes 2818.0 or 784 cases large tubes)
Water	Solvent		1.6	82.0 (9.8 gals.)
Advawet 33	Wetting agent		1.0	51.0 (6.1 gals.)
Water	Solvent		6.0	308.0 (37 gals.)
Clay	Filler		9.0	462.0
Asbestos SG 210	Filler		0.8	41.0
Resin E3-12	Adhesive		8.2	421.0 (56 gals.)
Emulsion RA-315	Adhesive	217	5.2	267.0 (30 gals.)
Propasol	Filming Agent		1.1	56.0 (7.8 gals.)
Dibutyl Phthalate	Plasticizer		0.8	41.0 (4.7 gals.)
Water	Solvent		7.3	413.0 (50 gals.)
Acrysol ASE-60	Thickening agent		3.5	180.0 (21 gals.)
AMP 95	pH Buffer	225	0.6	31.0 (395 gals.)
			100.0	5173.00

YIELD

- One batch yield 480 gals.

MIXING PROCEDURE

- Extract AK-955 directly into mixer and proceed in the following order:

- 1) Add water followed by the Advawet 33.
- 2) Mix for five minutes.
- 3) Add the water (2nd addition) followed by the clay and asbestos.
- 4) Mix for a further 30 minutes.
- 5) Add the following ingredients allowing each ingredient to be thoroughly blended before addition of the next ingredient.

Resin E3-12
Emulsion RA-315
Propasol
Dibutyl phthalate

- 6) Add water and Acrysol ASE-60 (may be added simultaneously)
AMP 95

VISCOSITY

- Refer to Plant Testing Procedure No. 109.

Specifications: 120 to 300 Brabander unit

Lehnert 10.3.01-85

SGP 0016184

A-82

February 18, 1972
Supersedes AK-501 (Cont.)
Dated 2/11/72

Brabender Viscosity Viscosity can be adjusted by addition of water, reduction of mix water, or by addition of ASE-60 in small amounts. It is best to hold back a small amount of water to be added if the viscosity is too high. ASE-60 may be added to thicken the mix should too much water have been added. Should it be necessary to add ASE-60, the pH must again be checked since ASE-60 is acidic and its addition will lower pH. Remember, changes in the water content affect flow properties as well as the wet density.

WORKING CHARACTERISTICS: Shall extrude easily from tube and form a uniform bead that does not sag or run.

OPEN TIME - Refer to Plant Testing Procedure No. 114

WETTING CHARACTERISTICS: Refer to Plant Testing Procedure No. 115

TENSILE STRENGTH - Refer to Plant Testing Procedure No. 116

ALKALINITY - Refer to Plant Testing Procedure No. 34. Adjust with small quantities of AMP

Specifications:	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
	9.0	7.7	8.3

DENSITY:
Specifications: - 11.20 lbs/gal 10.60 lbs/gal 10.9 lbs/gal

Case weight should be 35 lbs. $\pm$ 1 lb.

EDO:slz

Lehnert 10.3.01-86

SGP 0016185

A-82a

January 28, 1972
AKRON FORMULA AK-502
NEW

AKRON, NEW YORK, PLANT FORMULA
DRYWALL ADHESIVE AK-502

DESCRIPTION

- Drywall stud adhesive

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec.</u>	<u>Percent</u>	<u>Lbs./Batch</u>
Water	Solvent		12.0	617.0 (74 gals.)
Calgon-T	Wetting Agent	11	0.1	5.0
Ethylene Glycol	Solvent	182	3.0	154.0 (16.6 gals.)
Advawet-33	Wetting Agent		0.9	46.0 (5.5 gals.)
Atomite Limestone	Filler	220	27.0	1398.5
Clay BPO3	Filler		9.0	462.0
Asbestos SG210	Filler		0.8	41.0
Resin EB-12	Adhesive		8.0	410.0 (59 gals.)
Emulsion RA-315	Adhesive	217	30.0	1541.0 (173.0 gals.)
Propasol	Filming Agent		1.0	51.0 (7.0 gals.)
Dibutyl Phthalate	Plasticizer		0.8	41.0 (4.7 gals.)
Water	Solvent		2.8	144.0 (17.3 gals.)
Acrysol ASE-60	Thickening Agent		3.8	195.0 (22.4 gals.)
AMP-95	pH Buffer	225	0.3	26.0 (3.3 gals.)
Biocide 290	Fungicide		0.3	1.5
			100.0	5133.0

YIELD

- One batch yield 480 gals.

MIXING PROCEDURE

-

- 1) Add water (first addition) Calgon-T, Ethylene Glycol and Advawet 33.
- 2) Add Atomite, Clay, Asbestos and mix for 30 minutes
- 3) Add the following ingredients allowing each ingredient to be thoroughly blended before addition of the next ingredient:

Resin EB-12
Emulsion RA-315
Propasol
Dibutyl Phthalate

- 4) Add water (second addition) and Acrysol ASE-60 (may be added simultaneously)
- 5) Add AMP 95
Biocide-290

Lehnert 10.3.01-87

SGP 0016188

A-x2

VISCOSITY - Refer to Plant Testing Procedure No. 109

Specifications: 460 $\pm$ 10 Brabender unit

Brabender Viscosity 480 $\pm$ 10. Viscosity can be adjusted by addition of water, reduction of mix water, or by addition of ASE-60 in small amounts. It is best to hold back a small amount of water to be added if the viscosity is too high. ASE-60 may be added to thicken the mix should too much water have been added. Should it be necessary to add ASE-60, the pH must again be checked since ASE-60 is acidic and its addition will lower pH. Remember, changes in the water content affect flow properties as well as the wet density.

WORKING CHARACTERISTICS: Shall extrude easily from tube and form a uniform bead that does not sag or run.

OPEN TIME - Refer to Plant Testing Procedure No. 114

WETTING CHARACTERISTICS: Refer to Plant Testing Procedure No. 115

TENSILE STRENGTH - Refer to Plant Testing Procedure No. 116

ALKALINITY - Refer to Plant Testing Procedure No. 34. Adjust with small quantities of AMP

Specifications:	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
	8.0	7.7	7.9

DENSITY

Specifications: 10.75 lbs./gal 10.65 lbs./gal 10.7 lbs./gal

Case weight should be 35 lbs. $\pm$ 1 lb.

EDO:els

Lehnert 10.3.01-88

SGP 0016189

A 83c

August 15, 1972
Supersedes AK-502
Dated 1/28/72

AKRON, NEW YORK, PLANT FORMULA
DRYWALL ADHESIVE AK-502

DESCRIPTION

- Drywall stud adhesive

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec.</u>	<u>Percent</u>	<u>Lbs./Batch</u>
Water	Solvent		12.0	617.0 (74 gals.)
Calgon-T	Wetting Agent	11	0.1	5.0
Ethylene Glycol	Solvent	182	3.0	154.0 (16.6 gals.)
Advawet-33	Wetting Agent		0.9	46.0 (5.5 gals.)
Atomite Limestone	Filler	220	27.0	1398.5
Clay BPG3	Filler		9.0	462.0
Asbestos SG210	Filler		0.8	41.0
Resin EB-12	Adhesive		8.0	410.0 (53 gals.)
Emulsion RA-313	Adhesive	217	30.0	1541.0 (173.0 gals.)
Propasol	Filming Agent		1.0	51.0 (7.0 gals.)
Dibutyl Phthalate	Plasticizer		0.8	41.0 (4.7 gals.)
Water	Solvent		2.8	144.0 (17.3 gals.)
Acrysol ASE-60	Thickening Agent		3.8	195.0 (22.4 gals.)
AMP-95	pH Buffer	225	0.5	26.0 (3.3 gals.)
Biocide 290	Fungicide		0.3	1.5
			100.0	5133.0

YIELD

- One batch yield 480 gals.

MIXING PROCEDURE

- 1) Add water (first addition) Calgon-T, Ethylene Glycol and Advawet 33.
- 2) Add Atomite, Clay, Asbestos and mix for 30 minutes
- 3) Add the following ingredients allowing each ingredient to be thoroughly blended before addition of the next ingredient:
Resin EB-12
Emulsion RA-313
Propasol
Dibutyl Phthalate
- 4) Add water (second addition) and Acrysol ASE-60 (may be added simultaneously)
- 5) Add AMP 95
Biocide-290

Lehnert 10.3.01-89

SGP 0016190

13-54

-/ VISCOSITY - Refer to Plant Testing Procedure No. 109

Specifications: 430 to 460 Brabender unit

- / Brabender Viscosity 430 to 460 Viscosity can be adjusted by addition of water, reduction of mix water, or by addition of ASE-60 in small amounts. It is best to hold back a small amount of water to be added if the viscosity is too high. ASE-60 may be added to thicken the mix should too much water have been added. Should it be necessary to add ASE-60, the pH must again be checked since ASE-60 is acidic and its addition will lower pH. Remember, changes in the water content affect flow properties as well as the wet density.

WORKING CHARACTERISTICS: Shall extrude easily from tube and form a uniform bead that does not sag or run.

OPEN TIME - Refer to Plant Testing Procedure No. 114

WETTING CHARACTERISTICS: Refer to Plant Testing Procedure No. 115

TENSILE STRENGTH - Refer to Plant Testing Procedure No. 116

- / ALKALINITY - Refer to Plant Testing Procedure No. 34. Adjust with small quantities of AMP

Specifications:	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
	8.3	7.7	8.0

-/ DENSITY

Specifications: 11.00 lbs./gal 10.75 lbs./gal 10.85 lbs./gal

Case weight should be 35 lbs. $\pm$ 1 lb.

EDO:elz

- / Denotes change

Lehnert 10.3.01-90

SGP 0016191

A-84a

September 25, 1972
Supersedes AK-502
Dated 8/15/72

AKRON, NEW YORK, PLANT FORMULA
DRYWALL ADHESIVE AK-502

DESCRIPTION

- Drywall stud adhesive

-/ FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>FN Spec.</u>	<u>Percent</u>	<u>Vol. Batch</u>
Water	Solvent		12.0	617.5 (74 gals.)
Calgon-T	Wetting Agent	11	0.1	5.0
Ethylene Glycol	Solvent	182	3.0	154.0 (18.6 gals.)
Advocat-33	Wetting Agent		0.9	46.0 (5.5 gals.)
Atomite Limestone	Filler	220	27.0	1392.3
Clay BPG3	Filler		9.0	462.3
Asbestos SG210	Filler		0.8	41.0
Resin EB-12	Adhesive		8.0	410.0 (55 gals.)
Emulsion Elvace 1873	Adhesive	217	30.0	1541.5 (173.6 gals.)
Propasol	Filming Agent		1.0	51.0 (7.0 gals.)
Dibutyl Phthalate	Plasticizer		0.6	41.0 (4.7 gals.)
Water	Solvent		2.8	144.0 (17.3 gals.)
Acrysol ASE-60	Thickening Agent		3.8	195.0 (22.4 gals.)
AMP-95	pH Buffer	225	0.5	26.0 (3.3 gals.)
Biocide 290	Fungicide		0.3	15.5
			100.0	5133.0

YIELD

- One batch yield 480 gals.

MIXING PROCEDURE

-

- 1) Add water (first addition) Calgon-T, Ethylene Glycol and Advocat 33.
- 2) Add Atomite, Clay, Asbestos and mix for 30 minutes
- 3) Add the following ingredients allowing each ingredient to be thoroughly blended before addition of the next ingredient:
Resin EB-12
Emulsion RA-315
Propasol
Dibutyl Phthalate
- 4) Add water (second addition) and Acrysol ASE-60 (may be added simultaneously)
- 5) Add AMP 95
Biocide-290

Lehnert 10.3.01-91

-/ denotes change

DDC:elz

SGP 0016193

A-86

May 18, 1971
Supercedes Formula M-901
Dated 2/3/71

HARIETTA, GEORGIA, PLANT FORMULA

CENTRAL MIX JOINT COMPOUND M-901

DESCRIPTION OF PRODUCT:

- Vinyl multi-purpose compound for use with perforated tape. It is used for taping, finishing, spotting nailheads and texturing. It is supplied specifically to central mix or gramin type operations.

FORMULA:

Raw Material	Function	R.M. Hsg.	Percent	Lbs/Batch
2.5 Vanicide 512	Fungicide	124	0.03	2.0
125.0 Cover 9722				
(polyvinyl Alcohol)	Adhesive	142	2.50	100.0
25.0 Celva 702				
(Polyvinyl Acetate)	Adhesive	141	0.50	20.0
25.0 Metrosol 250 HXR	Thickner	170	0.50	20.0
12.5 Celgon T	Slip Agent	-	0.25	10.0
212.5 Asbestos 787-09	Filler	9	4.25	170.0
Asbestos 80310	Filler	-	1.75	70.0
77.5 Niles P20-M	Anti-cracking agent	11	6.00	240.0
300.0 Nalco 71-05	Anti-foaming agent	-	0.05	2.0
2.5 Limestone	Filler	13	84.13	3369.0
4207.5			100.00	4000.0
5000.0				

WORKING CONSISTENCY:
Specifications

- Refer to Plant Testing Procedure No. 32

Maximum	Minimum	Average
62	58	60

WORKING PROPERTIES:
Specifications

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

BONDING PROPERTIES:
Specifications

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

CRACK RESISTANCE:
Specifications

- Refer to Plant Testing Procedure No. 37.
There shall be no large fissure cracks in the wedges and very few, if any, cracks in the thinner half of the wedges.

COLOR:

- Dried compound should match color of standard sample.

REMARKS:

Lehnert 10.3.01-92

SGP 0016207

A-82

October 3, 1972
Formula No. AK-935
NEW

AKRON, NEW YORK, PLANT FORMULA
ALL PURPOSE JOINT COMPOUND AK-935

DESCRIPTION OF PRODUCT - Topping Compound for topping joints and spotting nailheads.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Defoamer M111	Antifoaming agent	196	.02	1.00
Vanicide	Fungicide	126	0.03	2.00
Asbestos 7RF09	Bulking Agent	9	4.25	170.00
Asbestos SG210	Bulking Agent	-	1.50	60.00
Natrosol 250 HXR	Water retention aid	170	0.20	8.00
Mica	Anticracking agent	11	7.00	280.00
Calgon T	Dispersant	-	0.20	8.00
Dow Resin 164 (XD76646)	Adhesive		3.75	150.00
Limestone	Filler		<u>83.03</u>	<u>3321.20</u>
			100.00	4000.00

WORKING CONSISTENCY
Specifications

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
71	65	68

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.

CRACK RESISTANCE
Specifications

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

COLOR
Specifications

- Neutral dried compound should match the color of standard sample.

Note: For yellow compound add 4 lbs. of yellow oxide 2087 per batch.

EDO:ez

Lehnert 10.3.01-93

SGP 0016758

A-89

December 5, 1972
Supersedes Formula No. AK-935
Dated 10/3/72

AKRON, NEW YORK, PLANT FORMULA
ALL PURPOSE JOINT COMPOUND AK-935

-/ DESCRIPTION OF PRODUCT - All Purpose Joint Compound for bedding, taping, and finishing joints and spotting nailheads.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Defoamer MIII	Antifoaming agent	196	.02	1.00
Vanicide	Fungicide	126	0.05	2.00
Asbestos 7RF09	Bulking Agent	9	4.25	170.00
Asbestos SG210	Bulking Agent	-	1.50	60.00
Natrosol 250 HXR	Water retention aid	170	0.20	8.00
Mica	Anticracking agent	11	7.00	280.00
Calgon T	Dispersant	-	0.20	8.00
Dow Resin 164 (XD76646)	Adhesive		3.75	150.00
Limestone	Filler		<u>83.03</u>	<u>3321.20</u>
			100.00	4000.00

WORKING CONSISTENCY
Specifications

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
71	65	68

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.

CRACK RESISTANCE
Specifications

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

COLOR
Specifications

- Neutral dried compound should match the color of standard sample.

Note: For yellow compound add 4 lbs. of yellow oxide 2087 per batch.

EDO:ez

-/ denotes change

Lehnert 10.3.01-94

SGP 0016756

A-90

December 5, 1972
Supersedes Chicago Formula C-935
Dated 10/3/72

CHICAGO, ILLINOIS, PLANT FORMULA
ALL PURPOSE JOINT COMPOUND C-935

-/ **DESCRIPTION OF PRODUCT** - Compound for taping joints and finishing joints and spotting nailheads.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Defoamer MIII	Antifoaming Agent	196	.02	1.00
Vanicide	Fungicide	126	0.05	2.00
Asbestos 7RF09	Bulking Agent	9	4.25	170.00
Asbestos SQ210	Bulking Agent	-	1.50	60.00
Natrosol 250 HXR	Water retention Aid	170	0.20	8.00
Mica	Anticracking Agent	11	7.00	280.00
Calgon T	Dispersant	-	0.20	8.00
Dow Resin 164 (XD76646)	Adhesive		3.75	150.00
Limestone	Filler		<u>83.03</u>	<u>3321.20</u>
			100.00	4000.00

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

<u>Specifications:</u>	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
	71	65	68

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 - Neutral dried compound should match the color of standard sample.

Note: For yellow compound add 4 lbs. of yellow oxide 2087 per batch.

EDO:elz

-/ denotes change

Lehnert 10.3.01-95

SGP 0016789

A-91

March 30, 1972
Chicago Formula 0C-936
NEW

CHICAGO, ILLINOIS PLANT FORMULA
TOPPING COMPOUND C-936

DESCRIPTION OF PRODUCT - White Topping Compound for topping joints and spotting nailheads.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs./Batch</u>
Defoamer: MIII	Antifoaming Agent	196	0.02	2.00
Vanicide	Fungicide	126	0.05	2.00
Asbestos 7RF09	Bulking Agent	9	4.25	170.00
Asbestos SG210	Bulking Agent	-	1.50	60.00
Katrosol 250 HXR	Water Retention Aid	170	0.20	8.00
Mica	Anticracking Agent	11	7.00	280.00
Calgon T	Dispersant	-	0.20	8.00
Dow Resin 164 (XD76646)	Adhesive	-	2.50	100.00
Limestone	Filler	-	84.28	3371.20
			100.00	4000.00

WORKING CONSISTENCY
Specifications:

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
71	65	68

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.

CRACK RESISTANCE
Specifications:

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

COLOR
Specifications:

- Neutral dried compound should match the color of standard sample.

EDO:elz

Lehnert 10.3.01-96

SGP 0016802

A-912

August 23, 1972
 Supersedes: Chicago Formula MC-936
 Dated March 30, 1972

CHICAGO, ILLINOIS PLANT FORMULA
TOPPING COMPOUND C-936

DESCRIPTION OF PRODUCT - White Topping Compound for topping joints and
 spotting nailheads.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs./Batch</u>
Defoamer M-11	Antifoaming Agent	196	.02	1.00
Fungicide	Fungicide	126	0.05	2.00
Asbestos 7R709	Bulking Agent	9	4.25	170.00
Asbestos SG210	Bulking Agent	-	1.50	60.00
Nacrosol 250 HVA	Water Retention Aid	170	0.20	8.00
Nica	Anticracking Agent	11	7.00	280.00
Calgon T	Dispersant	-	0.20	8.00
Dow Resin 164 (XD76646)	Adhesive	-	3.75	150.00
Limestone	Filler	-	83.03	3321.00
			100.00	4000.00

WORKING CONSISTENCY
Specifications:

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
71	65	68

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.

CRACK RESISTANCE
Specifications:

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

COLOR
Specifications:

- Neutral dried compound should match the color of
 standard sample.

ED0:slz

Lehnert 10.3.01-97

SGP 0016803

A-93

October 3, 1972
Supersedes Chicago C-936
Dated 8/25/72

CHICAGO, ILLINOIS, PLANT FORMULA
TOPPING COMPOUND C-936

DESCRIPTION OF PRODUCT - White Topping Compound for topping joints and spotting nailheads.

-/ FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Deafoamer MIII	Antifoaming Agent	196	.02	1.00
Vanicide	Fungicide	126	0.05	2.00
Asbestos 7RFO9	Bulking Agent	9	4.25	170.00
Asbestos SG210	Bulking Agent	-	1.50	60.00
Natrosol 250 HXR	Water Retention Aid	170	0.20	8.00
Mica	Anticracking agent	11	7.00	280.00
Calgon T	Dispersant	-	0.20	8.00
Dow Resin 164 (XD76646)	Adhesive		3.125	125.00
Limestone	Filler		83.655	3346.20
			100.00	4000.00

WORKING CONSISTENCY
Specifications

- Refer to plant testing procedure no. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
71	65	68

WORKING PROPERTIES
Specifications

- Refer to Plant Testing Procedure No. 23.

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

- Neutral dried compound should match the color of standard sample.

-/ denotes change

EDO:elz

Lehnert 10.3.01-98

SGP 0016804

11-94

October 3, 1972
Supersedes Akron Formula #AK-936
Dated 3/30/72

AKRON, NEW YORK PLANT FORMULA
TOPPING COMPOUND AK-936

DESCRIPTION OF PRODUCT - White Topping Compound for topping joints and spotting nailheads.

-/ FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs./Batch</u>
Defoamer Mill	Antifoaming Agent	196	1.020	1.00
Fungicide	Fungicide	126	0.050	2.00
Asbestos 7RF09	Bulking Agent	9	4.250	170.00
Asbestos SG210	Bulking Agent	-	1.500	60.00
Natrosol 250 HXR	Water Retention Aid	170	0.200	8.00
Mica	Anticracking Agent	11	7.000	280.00
Calgon T	Dispersant	-	0.200	8.00
Dow Resin 164 (XD76646)	Adhesive		3.125	125.00
Limestone	Filler		84.655	3346.20
			100.00	4000.00

WORKING CONSISTENCY
Specifications:

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
71	65	68

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.

CRACK RESISTANCE
Specifications:

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

COLOR
Specifications:

- Neutral dried compound should match the color of standard sample.

EDO:als

-/ denotes change

Lehnert 10.3.01-99

SGP 0016796

A-577

March 30, 1972
Akron Formula #AK-937
NEW

AKRON, NEW YORK PLANT FORMULA
BEDDING COMPOUND AK-937

DESCRIPTION OF PRODUCT - White Bedding Compound for bedding joints.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs./Batch</u>
Defoamer MIII	Antifoaming Agent	196	1.02	1.00
Vanicide	Fungicide	126	0.03	2.00
Asbestos 7RF09	Bulking Agent	9	4.25	170.00
Asbestos SG210	Bulking Agent	-	1.50	60.00
Natrosol 250 HXR	Water Retention Aid	170	0.20	8.00
Mica	Anticracking Agent	11	7.00	280.00
Calgon T	Dispersant	-	0.20	8.00
Dow Resin 164 (XD76646)	Adhesive	-	3.00	120.00
Limestone	Filler	-	83.78	3351.20
			100.00	4000.00

WORKING CONSISTENCY
Specifications:

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
71	65	68

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.

CRACK RESISTANCE
Specifications:

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

COLOR
Specifications:

- Neutral dried compound should match the color of standard sample.

ED0:el:

Lehnert 10.3.01-100

SGP 0016812

A-518

July 27, 1972
Akron Formula #AK-937
Supersedes formula
dated 3/30/72

AKRON, NEW YORK PLANT FORMULA
BEDDING COMPOUND AK-937

DESCRIPTION OF PRODUCT - White Bedding Compound for bedding joints.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>E.M. Spec.</u>	<u>Percent</u>	<u>Lbs./Batch</u>
Defoamer/Milk	Antifoaming Agent	196	1.02	1.00
Vanicide	Fungicide	126	0.05	2.00
Asbestos 7RF09	Bulking Agent	9	4.25	170.00
Asbestos SG210	Bulking Agent	-	1.50	60.00
Natrosol 250 HXR	Water Retention Aid	170	0.20	8.00
Mica	Anticracking Agent	11	7.00	280.00
Calgon T	Dispersant	-	0.20	8.00
Dow Resin 164 (XD76646)	Adhesive	-	3.75	150.00
Limestone	Filler	-	83.03	3321.20
			100.00	4000.00

WORKING CONSISTENCY
Specifications:

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
71	65	68

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.

CRACK RESISTANCE
Specifications:

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

COLOR
Specifications:

- Neutral dried compound should match the color of standard sample.

EDO:elz

Lehnert 10.3.01-101

SGP 0016813

11-99

October 3, 1972
Supersedes AK-937
Dated 7/27/72

AKRON, NEW YORK, PLANT FORMULA
BEDDING COMPOUND AK-937

DESCRIPTION OF PRODUCT - White Bedding Compound for bedding joints.

-/ FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Defoamer MIII	Antifoaming Agent	196	.02	1.00
Vanicide	Fungicide	126	0.05	2.00
Asbestos 7RP09	Bulking Agent	9	4.25	170.00
Asbestos SG210	Bulking Agent	-	1.50	60.00
Natrosol 250 HXR	Water retention aid	170	0.20	8.00
Mica	Anticracking agent	11	7.00	280.00
Calgon T	Dispersant	-	0.20	8.00
Dow Resin 164 (XD76646)	Adhesive		4.375	175.00
Limestone	Filler		82.405	3296.20
			100.00	4000.00

WORKING CONSISTENCY
Specifications

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
71	65	68

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.

CRACK RESISTANCE
Specifications

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

COLOR
Specifications

- Neutral dried compound should match the color of standard sample.

-/ denotes change

EDO:els

Lehnert 10.3.01-102

SGP 0016814

A 100

March 30, 1972
Chicago Formula #C-937.
NEW

CHICAGO ILLINOIS PLANT FORMULA
BEDDING COMPOUND C-937

DESCRIPTION OF PRODUCT - White Bedding Compound for bedding joints.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Seq.</u>	<u>Percents</u>	<u>Lbs./Batch</u>
Defoamer MIII	Antifoaming Agent	196	.02	1.00
Fungicide	Fungicide	126	0.05	2.00
Asbestos 7XFO9	Bulking Agent	9	4.25	170.00
Asbestos 8G210	Bulking Agent	-	1.50	60.00
Natrosol 350 HCR	Water Retention Aid	170	0.20	8.00
Mica	Anticracking Agent	11	7.00	280.00
Dalgon T	Dispersant	-	0.20	8.00
Dow Resin 164 (XD76646)	Adhesive		3.00	120.00
Limestone	Filler		83.78	3351.20
			100.00	4000.00

WORKING CONSISTENCY
Specifications:

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
71	65	68

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.

CRACK RESISTANCE
Specifications:

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

COLOR
Specifications:

- Neutral dried compound should match the color of standard sample.

ED0:elz

SGP 0016817

Lehnert 10.3.01-103

A-101

July-27, 1972
Supersedes Chicago #937
Dated 3/30/72

CHICAGO ILLINOIS PLANT FORMULA
BEDDING COMPOUND C-937

DESCRIPTION OF PRODUCT - White Bedding Compound for bedding joints.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs./Batch</u>
Defoamer NIII	Antifoaming Agent	196	.02	1.00
Vanicide	Fungicide	126	0.05	2.00
Asbestos 7RF09	Bulking Agent	9	4.25	170.00
Asbestos SG210	Bulking Agent	-	1.50	60.00
Natrosol 250 HXR	Water Retention Aid	170	0.20	8.00
Mica	Anticracking Agent	11	7.00	280.00
Calgon T	Dispersant	-	0.20	8.00
Dow Resin 164 (XD76646)	Adhesive		3.75	150.00
Limestone	Filler		<u>83.03</u>	<u>3321.20</u>
			100.00	4000.00

WORKING CONSISTENCY
Specifications:

- Refer to Plant Testing Procedure No. 32.

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
71	65	68

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.

CRACK RESISTANCE
Specifications:

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

COLOR
Specifications:

- Neutral dried compound should match the color of standard sample.

EDO:elz

Lehnert 10.3.01-104

SGP 0016818

A-102

April 20, 1972
TEX-943 NEW FORMULA

ACME, TEXAS PLANT FORMULA NO. TEX-943
POLYSTYRENE CEILING TEXTURE (PREMIUM)

<u>FORMULA:</u>					
<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>	
Gypsum	Filler		.628	7100	
Staramic Starch 747	Adhesive		1.220	100	
Hamico Starch 267	Adhesive		2.440	200	
Titanium Dioxide RA48	Pigment	221	2.440	200	
Paperad	Pigment	222	4.880	400	
	Extender				
Triton XL20	Wetting Agent		.098	8	
Vanicide	Fungicide	126	.098	8	
(1) Asbestos SG210	Thickener		2.196	180	
			100.000	8196	

(1) Note: This formula may be made by using TEX-942 and adding the proper amount of Asbestos SG210 to the texture mixer.

WORKING CONSISTENCY:

Refer to Plant Testing Procedure No. 109.
Mix @ 90 water/DM and allow to stand for
15 minutes, then check Brabender viscosity.

BRABENDER UNITS:

<u>Minimum</u>	<u>Maximum</u>	<u>Average</u>
80	120	100

BOND:
SPECIFICATION:

Test Procedure No. 35.
Tape shall show at least a 50% fiber
tear when dry.

CRACK RESISTANCE:
SPECIFICATION:

Test Procedure No. 37.
There shall be no large fissure crack.

COLOR:
SPECIFICATION:

White
Dried compound shall match color of
standard sample.

VANICIDE SPOT TEST:

Test Procedure No. 67.

STARCH SPOT TEST:

Test Procedure No. 112.

Lehnert 10.3.01-105

GWG:dek

SGP 0016924

A-104

April 18, 1973
TEX-943
Supersedes Formula TEX-943
Dated April 20, 1972

ACME, TEXAS PLANT FORMULA NO. TEX-943
POLYSTYRENE CEILING TEXTURE (PRE-MIX)

<u>FORMULA</u> <u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Gypsum	Filler		83.555	6900
Staramic 747	Adhesive	192	1.211	100
Hamico 267	Adhesive	23	2.422	200
TiO ₂ -RA4	Pigment	221	1.816	150
Paperad	Pigment	222	4.844	400
Attagel 40	Thickener		1.816	150
Vanicide	Fungicide	126	.098	8
			100.000	8258

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 109.
Mix @ 90 water/DM and allow to stand for
15 minutes, then check Brabender viscosity.

<u>BRABENDER UNITS</u>	- <u>Minimum</u>	<u>Maximum</u>	<u>Average</u>
	80	120	100

BOND
Specification: - Test Procedure No. 35
Tape shall show at least a 50% fiber
tear when dry.

CRACK RESISTANCE
Specification: - Test Procedure No. 37
There shall be no large fissure crack.

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

VANICIDE SPOT TEST - Test Procedure No. 67

STARCH SPOT TEST - Test Procedure No. 112

CNG:jg

Lehnert 10.3.01-106

SGP 0018925

A-111.

July 22, 1976
Supersedes Formula TEX-943
Dated 4/18/73

ACME, TEXAS PLANT FORMULA NO. TEX-943
POLYSTYRENE CEILING TEXTURE (PRE-MIX)

<u>FORMULA</u> <u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Gypsum	Filler		86.425	7150
Staramic 747	Adhesive	192	1.209	100
Hamico 267	Adhesive	23	2.418	200
TiO ₂	Pigment	221	1.813	150
Paperad	Pigment	222	4.835	400
Attagel 40	Thickener	8	1.813	150
Vancide	Fungicide	126	.097	8
Cellufloc DB 33	Bulking agent		1.209	100
Galactosol 413W	Thickener	223	.181	15
			100.000	8273

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 109.
Mix @ 90 water/DM and allow to stand for
15 minutes, then check Brabender viscosity.

<u>BRABENDER UNITS</u>	<u>Minimum</u>	<u>Maximum</u>	<u>Average</u>
	80	120	100

BOND
Specification: - Test Procedure No. 35
Tape shall show at least a 50% fiber tear
when dry.

CRACK RESISTANCE
Specification: - Test Procedure No. 37
There shall be no large fissure crack.

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

VANCIDE SPOT TEST - Test Procedure No. 67

STARCH SPOT TEST - Test Procedure No. 112

Lehnert 103.01-107

CWG:jg

SGP 0016928

A-1117

October 22, 1976
Supersedes Formula TEX-943
Dated 7/22/76

ACME, TEXAS PLANT FORMULA NO. TEX-943
POLYSTYRENE CEILING TEXTURE (PRE-MIX)

<u>FORMULA</u> <u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Gypsum	Filler		86.425	7150
Staramic 747	Adhesive	192	1.209	100
Hamico 267	Adhesive	23	2.418	200
TiO2	Pigment	221	1.813	150
Paperad	Pigment	222	4.835	400
Attagel 40	Thickener	8	1.813	150
Vancide	Fungicide	126	.097	8
Cellufloc DB 33	Bulking agent		1.209	100
-/ Gandriv 4928	Thickener	223	.181	15
			100.000	8273

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 109.
Mix @ 90 water/DK and allow to stand for
15 minutes, then check Brabender viscosity.

<u>BRABENDER UNITS</u>	<u>- Minimum</u>	<u>Maximum</u>	<u>Average</u>
	80	120	100

BOND
Specification: - Test Procedure No. 35
Tape shall show at least a 50% fiber tear
when dry.

CRACK RESISTANCE
Specification: - Test Procedure No. 37
There shall be no large fissure crack.

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

VANCIDE SPOT TEST - Test Procedure No. 67

STARCH SPOT TEST - Test Procedure No. 112

Lehnert 10.3.01-108

CWG:jg

SGP 0016927

11-1-0

November 7, 1972
Supersedes Formula TEX-91.2
Dated 7/1/71

ACME, TEXAS PLANT FORMULA
G-P TEXTURE NON-AGGREGATED NO. TEX-91.4

DESCRIPTION OF PRODUCT - A dry powdered product, containing no aggregate, for mixing with water to produce textured finishes on gypsum wallboard by means of spraying, rolling, or troweling.

-/ FORMULA:

<u>RAW MATERIAL</u>	<u>FUNCTION</u>	<u>R.M. SPEC #</u>	<u>PERCENT</u>	<u>LB/BATCH</u>
TEX-25	Filler		88.3125	7065
RS6278C	Adhesive	162	1.5625	125
Hamico 267	Adhesive		2.5	200
Paperad	Pigment Extender	222	3.75	300
TiO ₂ - RA44	Pigment	221	1.875	150
Asbestos SG210	Fiber Filler		1.875	150
Vanicide	Fungicide	126	.0625	5
Triton X120	Wetting Agent		.0625	5
			100.0	8000

SPECIFICATIONS:

WORKING CONSISTENCY - Mix at 90 W/P. Allow to soak for 10 minutes.

-/ Brabender Number:

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
120	80	100

WORKING PROPERTIES

- Refer to Plant Testing Procedure No. 33. Material shall be plastic, and free from any coarse, gritty or undispersed particle. Material shall be free from lumps due to incomplete mixing.

BONDING PROPERTIES

- Refer to Plant Testing Procedure No. 35. After compound has dried tape shall show at least 50% 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.

COLOR

- White: Color shall match standard sample.

VANICIDE SPOT TEST

- Plant Test Procedure No. 68.

STARCH SPOT TEST

- Plant Test Procedure No. 112.

EDO:ct

Lehnert 10.3.01-109

-/Denotes change in reissue.

SGP 0016940

5-3-72 38 1/2 per. cu ft. February 2, 1974
~~April 14, 1972~~
 Supersedes Formula No. TEX-952
 Dated 11/17/71

ACME, TEXAS PLANT FORMULA

ALL PURPOSE JOINT COMPOUND FORMULA NO. TEX-953

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 4928	Thickner	223	0.30	24.00
Vanicide 512	Fungicide	126	0.05	4.00
Gelvatol 62780	Adhesive	126	1.75	140.00
Gelvatol 62780 attager	Adhesive	161	1.00	80.00
Asbestos 5629 56210	Fiber Filler	9	7.00	100.00 200
Mica p80-H	Anti-Cracking Agent	11	5.00	400.00
Defoamer M117	Anti-Foaming Agent	-	0.10	8.00
Land Plaster TEK-25	Filler	-	84.80	100.00 7144
			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.

Lehnert 10.3.01-110

-/ Denotes change in this reissue.

KDO:dek

SGP 0017203

A-111

March 11, 1974
New Formula No. TEX-953

ACME, TEXAS, PLANT FORMULA
ALL PURPOSE JOINT COMPOUND FORMULA NO. TEX-953

DESCRIPTION OF PRODUCT - All Purpose compound for taping and finishing joints, spotting nailheads and texturing. To be shipped to Memphis only.

<u>FORMULA</u>	<u>Function</u>	<u>RW Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Cendriv 4928	Thickner	223	0.30	24.00
Vanicide 512	Fungicide	126	0.03	4.00
Gelvatol 6000	Adhesive	126	1.75	140.00
Attagel 40	Fiber Filler	161	1.00	80.00
Asbestos SG 210	Fiber Filler	9	2.50	200.00
Mica p80-H	Anticracking agent	11	5.00	400.00
Defoamer M117	Antifoaming agent	--	0.10	8.00
Land Plaster TEX-23	Filler	--	89.30	7144.00
			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.

NOTE: For yellow compound, add 4 lbs. of yellow oxide.

Lehnert 10.3.01-111

WNG:elz

SGP 0017204

A-112

December 16, 1975
 Supersedes Formula TEX-953
 Dated 3/11/74

ACME, TEXAS, PLANT FORMULA
ALL PURPOSE JOINT COMPOUND FORMULA NO. TEX-953

DESCRIPTION OF PRODUCT - All Purpose compound for taping and finishing joints, spotting nailheads and texturing. To be shipped to Memphis only.

<u>FORMULA</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>	
Sorbitol	Boron Stabilizer	--	.50	40.00	10
Oendriv 4928	Thickner	223	0.30	24.00	5
Venocide 512	Fungicide	126	0.03	4.00	1
Gelvato1 6000	Adhesive	126	1.75	140.00	35
Attagel 40	Fiber Filler	161	1.00	80.00	20
Asbestos SG 210	Fiber Filler	9	2.50	200.00	50
Mica p80-H	Anticracking agent	11	5.00	400.00	100
Defoamer M117	Antifoaming agent	--	0.10	8.00	2
Land Plaster TEX-25	Filler	--	<u>88.8</u>	<u>7104.0</u>	<u>1776</u>
			100.00	8000.00	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.

NOTE: For yellow compound, add 4 lbs. of yellow oxide.

-/ denotes change

WNG:jg

Lehnert 10.3.01-112

SGP 0017205

A-113

June 29, 1971
Supersedes Formula TEX-991
Dated 3/27/70

ACME, TEXAS PLANT FORMULA

SPRED SET JOINT COMPOUND WHITE TEX-991
(60 minutes and 2 hour working cement)

DESCRIPTION OF PRODUCT: - For use in reinforcing and concealing joints and nailheads.

-/ <u>FORMULA:</u>				
<u>Raw Material</u>	<u>Function</u>	<u>R. M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
*Sodium Citrate	Retarder	134	0.10	0.750
Nutrosol 250HXR	Thickner	170	0.20	1.500
Galvatol RS-627BC	Adhesive	162	2.25	16.875
Gelva GP702	Adhesive	167	0.50	3.750
Asbestos SG210	Fiber Filler	-	0.50	3.750
Asbestos 7RFO9	Fiber Filler	9	2.25	16.875
Mica p80H	Anti-Cracking Agent	11	4.00	30.000
Defoamer Mill	Anti-Foaming Agent	196	0.05	0.375
Vanicide	Fungicide	126	0.05	0.375
TEX-38	Plaster	-	90.10	675.750
			100.00	750.000

*Adjust quantity according to set time requirements.

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

SETTING TIME: - Refer to Plant Testing Procedure No. 6 (slow set)
Specifications Maximum Minimum Average
99.2 110 mins. 70 mins. 90 mins.
3 1/4 hours 2 1/4 hours 3 hours

WORKING PROPERTIES: - Refer to Plant Testing Procedure No. 33.
Specifications Must be plastic and buttery working; 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: - Refer to Plant Testing Procedure No. 37.
Specifications There shall be no large fissure cracks in the wedge and very few, if any, cracks in the thinner half of the wedge.

Lehnert 10.3.01-113

-/ Denotes change in this reissue.

EDO:dek

SGP 0018367

A-114

September 7, 1971
Supersedes Formula TEX-991
Dated 6/29/71

ACME, TEXAS PLANT FORMULA
SPEED SET JOINT COMPOUND WHITE TEX-991
(2 hour working cement)

DESCRIPTION OF PRODUCT - For use in reinforcing and concealing joints and nailheads.

-/ <u>FORMULA</u>				
<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percant</u>	<u>Lbs/Batch</u>
*Sodium Citrate	Retarder	134	0.10	0.750
Natrosol 250 HXR	Thickner	170	0.25	1.875
Gelvitol RS-6278C	Adhesive	162	2.00	15.000
Galva GP702	Adhesive	167	0.50	3.750
Asbestos SG210	Fiber Filler	-	1.50	11.250
Asbestos 7RF09	Fiber Filler	9	3.25	24.375
Mica p80H	Anti-Cracking Agent	11	5.00	37.500
Defoamer M117	Anti-Foaming Agent	196	.10	.750
Vanicide	Fungicide	126	.10	.750
Denscal	Plaster	-	86.00	645.375 654.00
			100.00	750.000

*Adjust quantity according to set time requirements.

<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>SETTING TIME:</u>	- Refer to Plant Testing Procedure No. 6 (slow set)
<u>Specifications</u>	3 1/4 hours 2 1/4 hours 3 hours

<u>WORKING PROPERTIES:</u>	- Refer to Plant Testing Procedure No. 33.
<u>Specifications</u>	Must be plastic and buttery working; free of grit or coarse particles.

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

<u>CRACK RESISTANCE:</u>	- Refer to Plant Testing Procedure No. 37.
<u>Specifications</u>	There shall be no large fissure cracks in the wedge and very few, if any, cracks in the thinner half of the wedge.

Lehnert 10.3.01-114

-/ Denotes change in this release.

EDC:dek

SGP 0018368

A-115

February 11, 1972
Superseded Formula TEX-991
Dated 9/7/71

ACME, TEXAS PLANT FORMULA
SPEED SET JOINT COMPOUND WHITE TEX-991
(2 Hour Working Cement)

9-21-73

~~from~~
can collect

DESCRIPTION OF PRODUCT - For use in reinforcing and concealing joints and nailheads.

-/ FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M.Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
*Sodium Citrate	Retarder	134	0.10	0.750
Nutrosol 250 HXR	Thickner	170	0.25	1.875
Gelvatol RS-6278C	Adhesive	162	1.30	11.250
Gelva GP702	Adhesive	167	0.30	3.750
Asbestos SG210	Fiber Filler	-	1.75	13.125
Asbestos 7RF09	Fiber Filler	9	5.00	37.500
Nico p80H	Anti-Cracking agent	11	5.00	37.500
Defoamer M111	Anti-Foaming agent	196	.10	.750
Vanicide	Fungicide	126	.10	.750
Denscal	Plaster	-	85.70	642.750
			100.00	750.000

*Adjust quantity according to set time requirements.

WORKING CONSISTENCY
Specifications

- Refer to Plant Testing Procedure no. 32.

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

SETTING TIME
Specifications

- Refer to Plant Testing Procedure No. 6 (slow set)

3 1/2 hours	2 1/2 hours	3 hours
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WORKING PROPERTIES
Specifications

- Refer to Plant Testing Procedure No. 33.
Must be plastic and buttery working; 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

- Refer to Plant Testing Procedure No. 37.
There shall be no large fissure cracks in the wedge and very few, if any, cracks in the thinner half of the wedge.

-/ Denotes change in this reissue.

Lehnert 10.3.01-115

EDO:dek

SGP 0018369

Here called 9-11-73 and
sent to Luman RS-6278
to 1.75% - 13 lbs 2oz

A. H.

September 8, 1971
NEW FORMULA TEX-992

ACME, TEXAS PLANT FORMULA
SPEED SET JOINT COMPOUND WHITE TEX-992
(1 hour working cement)

DESCRIPTION OF PRODUCT: - For use in reinforcing and concealing joints and nailheads.

FORMULA:

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
*Sodium Citrate	Retarder	134	0.10	0.750
Natrosol 250 HXR	Thickner	170	0.25	1.875
Gelvatol RS-6278C	Adhesive	162	2.00	15.000
Gelva GP702	Adhesive	167	0.50	3.750
Asbestos SG210	Fiber Filler	-	1.50	11.250
Asbestos 7RF09	Fiber Filler	9	3.25	24.375
Mica p80H	Anti-Cracking Agent	11	5.00	37.500
Defoamer M117	Anti-Foaming Agent	196	.10	.750
Vanicide	Fungicide	126	.10	.750
Denscal	Plaster	-	97.10	66.05
			100.00	750.000

*Adjust quantity according to set time requirements.

WORKING CONSISTENCY:
Specifications

- Refer to Plant Testing Procedure No. 32.

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

SETTING TIME:
Specifications

- Refer to Plant Testing Procedure No. 6 (slow set)

110 min.	70 min.	90 min.
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WORKING PROPERTIES:
Specifications

- Refer to Plant Testing Procedure No. 33.
Must be plastic and buttery working; 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

- Refer to Plant Testing Procedure No. 37.
There shall be no large fissure cracks in the wedge and very few, if any, cracks in the thinner half of the wedge.

Lehnert 10.3.01-116

EDO:dek

SGP 0018376

A-117

January 28, 1972
Supersedes TEX-992
Dated 9/8/71

ACME, TEXAS PLANT FORMULA
SPEED SET JOINT COMPOUND WHITE TEX-992
(1 hour working cement)

DESCRIPTION OF PRODUCT: - For use in reinforcing and concealing joints and nailheads.

<u>FORMULA:</u>				
<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
*Sodium Citrate	Retarder	134	0.10	0.750 3-07
Natrosol 250 HXR	Thickner	170	0.25	1.875 1 1/4
Geivatal RS-6278C	Adhesive	162	1.50	11.250 11 1/2
Calva GP702	Adhesive	167	0.50	3.750 3 3/4
Asbestos SG210	Fiber Filler	-	1.75	13.125 13 1/4
Asbestos 7RF09	Fiber Filler	9	5.00	37.500 37 1/2
Mica p80H	Anti-Cracking Agent	11	5.00	37.500 37 1/2
Defoamer M111	Anti-Foaming Agent	196	.10	.750 3/4
Vanicide	Fungicide	126	.10	.750 3/4
Denacal	Plaster	-	85.70	642.750 642 3/4
			100.00	750.000

*Adjust quantity according to set time requirements.

<u>WORKING CONSISTENCY:</u> Specifications	- Refer to Plant Testing Procedure No. 32.		
	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
	62	58	60
<u>SETTING TIME:</u> Specifications	- Refer to Plant Testing Procedure No. 6 (slow set)		
	110 min.	70 min.	90 min.
<u>WORKING PROPERTIES:</u> Specifications	- Refer to Plant Testing Procedure No. 33. Must be plastic and buttery working; free of grit or coarse particles.		
<u>BONDING PROPERTIES:</u> Specifications	- Refer to Plant Testing Procedure No. 35. After compound has dried, tape shall delaminate when peeled back.		
<u>CRACK RESISTANCE:</u> Specifications	- Refer to Plant Testing Procedure No. 37. There shall be no large fissure cracks in the wedge and very few, if any, cracks in the thinner half of the wedge.		

Lehnert 10.3.01-117

- / denotes change

ED0:slz

SGP 0018377

A-118

June 29, 1971
Supersedes Formula 993
Dated 2/27/70

ACME, TEXAS PLANT FORMULA

SPEED SET JOINT COMPOUND (YELLOW) TEX-993
(60 minute and 2 hour working cement)

DESCRIPTION OF PRODUCT: - For use in reinforcing and concealing joints and nailheads.

-/ FORMULA:

<u>Raw Material</u>	<u>Function</u>	<u>R. M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Yellow Oxide	Pigment	138	0.20	1.500
*Sodium Citrate	Retarder	134	0.10	0.750
Natrosol 250HXR	Thickner	170	0.20	1.500
Gelvatol RH-6278C	Adhesive	162	2.25	16.875
Gelva GP702	Adhesive	167	0.50	3.750
Asbestos SG210	Fiber Filler	-	0.50	3.750
Asbestos 7RF09	Fiber Filler	9	2.25	16.875
Mica p80H	Anti-Cracking Agent	11	4.00	30.000
Defoamer M11	Anti-Foaming Agent	196	0.05	0.375
Vanicide	Fungicide	126	0.05	0.375
TEX-38	Plaster	-	89.90	674.250
*Adjust quantity according to set time requirements.			100.00	750.000

-/ WORKING CONSISTENCY:

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

SETTING TIME:

<u>Specifications</u>	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
	110 mins.	70 mins.	90 mins.
	3 3/4 hours	2 1/2 hours	3 hours

WORKING PROPERTIES:

Specifications - Refer to Plant Testing Procedure No. 33. Must be plastic and buttery working; 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 - Refer to Plant Testing Procedure No. 37. There shall be no large fissure cracks in the wedge and very few, if any, cracks in the thinner half of the wedge.

-/ Denotes change in this reissue.

Lehnert 10.3.01-118

EDO:dek

SGP 0018388

A-119

January 28, 1972
Supersedes TEX-995
Dated 9/8/71

ACME, TEXAS PLANT FORMULA
SPEED SET JOINT COMPOUND WHITE TEX-995
(1/2 hour working cement)

DESCRIPTION OF PRODUCT: - For use in reinforcing and concealing joints and nailheads.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/ Batch</u>
*Sodium Citrate	Retarder	134	0.10	0.750
Natrosol 250 HXR	Thickner	170	0.25	1.875
Gelvatol RS-62780	Adhesive	162	1.50	11.250
Galva GP702	Adhesive	167	0.50	3.750
Asbestos SG210	Fiber Filler	-	1.75	13.125
Asbestos 7RF09	Fiber Filler	9	5.00	37.500
Mica p80H	Anti-Cracking Agent	11	5.00	37.500
Defoamor Mill	Anti-Foaming Agent	196	.10	.750
Vanicide	Fungicide	126	.10	.750
Denscal	Plaster	-	85.70	642.750
			100.00	750.000

*Adjust quantity according to set time requirements.

WORKING CONSISTENCY:
Specifications

- Refer to Plant Testing Procedure No. 32.

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

SETTING TIME:
Specifications

- Refer to Plant Testing Procedure No. 6 (slow set)
90 min. 40 min. 60 min.

WORKING PROPERTIES:
Specifications

- Refer to Plant Testing Procedure No. 33.
Must be plastic and buttery working; 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

- Refer to Plant Testing Procedure No. 37.
There shall be no large fissure cracks in the wedge and very few, if any, cracks in the thinner half of the wedge.

Lehnert 10.3.01-119

8-9-73

4 1/2 oz retarder

- / denotes change

EDO:slz

SGP 0018407

A-120

September 8, 1971
NEW FORMULA TEX-995

ACME, TEXAS PLANT FORMULA
SPEED SET JOINT COMPOUND WHITE TEX-995
(1/2 hour working cement)

DESCRIPTION OF PRODUCT: - For use in reinforcing and concealing joints and nailheads.

<u>FORMULA</u>				
<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/ Batch</u>
*Sodium Citrate	Retarder	134	0.10	0.750
Natrosol 250 HXR	Thickner	170	0.25	1.875
Gelvacol RS-62780	Adhesive	162	2.00	15.000
Gelva GP702	Adhesive	167	0.50	3.750
Asbestos SG210	Fiber Filler	-	1.50	11.250
Asbestos 7RF09	Fiber Filler	9	3.25	24.375
Mica p80H	Anti-Cracking Agent	11	5.00	37.500
Defoamer Mill	Anti-Foaming Agent	196	.10	.750
Vanicide	Fungicide	126	.10	.750
Denscal	Plaster	-	57.10-86.05	645.375 659.00
			100.00	750.000

*Adjust quantity according to set time requirements.

<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>SETTING TIME:</u>	- Refer to Plant Testing Procedure No. 6 (slow set)
<u>Specifications</u>	90 min. 40 min. 60 min.

<u>WORKING PROPERTIES:</u>	- Refer to Plant Testing Procedure No. 33.
<u>Specifications</u>	Must be plastic and buttery working; free of grit or coarse particles.

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

<u>CRACK RESISTANCE:</u>	- Refer to Plant Testing Procedure No. 37.
<u>Specifications</u>	There shall be no large fissure cracks in the wedge and very few, if any, cracks in the thinner half of the wedge.

Lehnert 10.3.01-120

EDO:dek

SGP 0018408

A-121

September 8, 1971
NEW FORMULA TEX-997

ACME, TEXAS PLANT FORMULA
SPEED SET JOINT COMPOUND WHITE TEX-997
(9 hour working cement)(Houston Formula)

DESCRIPTION OF PRODUCT: - For use in reinforcing and concealing joints and nailheads.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
*Full Strength Commercial				
Retarder	Retarder	134	0.10	0.750
Netrosol 250 HXR	Thickner	170	0.25	1.875
Galvatol RS-6278C	Adhesive	162	2.00	15.000
Gelva GP702	Adhesive	167	0.50	3.750
Asbestos SG210	Fiber Filler	-	1.50	11.250
Asbestos 7RF09	Fiber Filler	9	3.25	24.375
Mica p80H	Anti-Cracking Agent	11	5.00	37.500
Defoamer Mill	Anti-Foaming Agent	196	.10	.750
Vanicide	Fungicide	126	.10	.750
Denscal	Plaster	-	86.05	645.375
			100.00	750.00

*Adjust quantity according to set time requirements.

WORKING CONSISTENCY:
Specifications

- Refer to Plant Testing Procedure No. 32.

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

SETTING TIME:
Specifications

- Refer to Plant Testing Procedure No. 6 (slow set)

10 hours	8 hours	9 hours
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WORKING PROPERTIES:
Specifications

- Refer to Plant Testing Procedure No. 33.
Must be plastic and buttery working; 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

- Refer to Plant Testing Procedure No. 37.
There shall be no large fissure cracks in the wedge and very few, if any, cracks in the thinner half of the wedge.

NOTE: Set time measured by the first appearance of lumps in the mix.

EDO:dak

Lehnert 10.3.01-121

SGP 0018415

A-122

January 28, 1972
Supersedes TEX-997
Dated 9/8/71

ACME, TEXAS PLANT FORMULA
SPEED SET JOINT COMPOUND WHITE TEX-997
(9 hour working cement) (Houston Formula)

DESCRIPTION OF PRODUCT: - For use in reinforcing and concealing joints and nailheads.

<u>FORMULA</u>				
<u>Raw Material</u>	<u>Function</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
*Full Strength Commercial				
Retarder	Retarder	134	0.10	0.750
Natrosol 250 HXR	Thickner	170	0.25	1.875
Gelvatal KS-6278C	Adhesive	162	1.50	11.250
Galva GP702	Adhesive	167	0.50	3.750
Asbestos SG210	Fiber Filler	-	1.75	13.125
Asbestos 7RF09	Fiber Filler	9	3.00	37.500
Mica p80H	Anti-Cracking Agent	11	3.00	37.500
Defoamer M11	Anti-Foaming Agent	196	.10	.750
Vanlaido	Fungicide	126	.10	.750
Denseal	Plastor	-	85.70	642.750
			100.00	750.00

*Adjust quantity according to set time requirements.

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

SETTING TIME: - Refer to Plant Testing Procedure No. 6 (slow set)
Specifications 10 hours 8 hours 9 hours

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

BONDING PROPERTIES: - Refer to Plant Testing Procedure No. 33.
Specifications After compound has dried, tape shall delaminate when peeled back.

CRACK RESISTANCE: - Refer to Plant Testing Procedure No. 37.
Specifications There shall be no large fissure cracks in the wedge and very few, if any, cracks in the thinner half of the wedge.

NOTE: Set time measured by the first appearance of lumps in the mix.

EDO:alz

Lehnert 10.3.01-122

-/ denotes change

SGP 0018416

11-123

Union Carbide SG-210 Asbestos in
Georgia Pacific Joint System Product

Overall usage dates: 12-29-69 to 5-4-77

Acme, Texas Plant

Products	dates	% SG-210	Comments
Cell Purpose	3-11-74 to at least 12-16-75 (last avail)	2.5	Memphis only
Triple Duty	10-5-74 to at least 4-22-76 (last avail) but not later than 5-04-77	2.5	Denver only Gardiner
Speed Set	6-29-71 to 3-30-74 One formula possible June 1974	0.5 to 1.5	
Non aggregate Texture (Walls & Ceiling)	11-7-72 to 3-22-73	1.9	
Polystyrene Ceiling Texture	4-20-72 to 4-11-73	2.1 to 2.2	
Ready Mix	9-22-71 to 5-4-77	1.0 to 3.75	

(All formulas contained SG-210 except
RM Topping ^{3-2-74 to 9-10-75} 4 gal. Cartons and 5 gal
pails and asbestos free formulas.

Lehnert 10.3.01-123

Union Carbide SG-210 Cont'd

Marietta, GA Plant

Products	dates	% SG-210	Comment
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Central Mix	5-18-71 to nat	1.75	
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not later than 1-20-75

(Lab document)

Ready Mix	3-6-72 to 5-4-77	1.0 to 2.1	
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(all available formulas in this date range used some SG-210 except for asbestos free.)

Milford, VA Plant

Products	dates	% SG-210	Comment
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Ready Mix	6-21-73 to at	1.25 to 1.6	
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least 1-20-75

(Lab document)

(all general formulas from 6-21-73 to 1-75 had SG-210. No SG-210 in topping, crack resistant formula, buff topping, and asbestos free.)

Charles W. Lehnert

10/02/01

Lehnert 10.3.01-124

Union Carbide SG-210 cont'd

Akron, NY Plant

Products	dates	of SG-210	Comments
Drywall Adhesive	1-27-72 to not		
	later than end of 1972	0.8	
Bedding Compound *	3-30-72 to about 2/73	1.5	* Dow Resin
Topping Compound *	3-30-72 to about 2/73	1.5	* Dow Resin
Ready Mix	12-29-69 to 5-4-77	1.25 to 2.0	
(Virtually all formulas up to 9/70 used TRF-9 asbestos, from 9/70 forward all available formulas used some SG-210 except for asbestos free.)			

Chicago, Ill Plant

Products	dates	of SG-210	Comment
All Purpose	12-50 72 to about 2/73	1.5	* Dow Resin
Bedding Comp.	* 3-30-72 to about 2/73	1.5	* Dow Resin
Topping Comp	* 3-30-72 to about 2/73	1.5	* Dow Resin
Ready Mix	10-21-70 to 5-4-77		

Lehnert 10.3.01-125

(all general formulas during this period contained SG-210. Exceptions were 5-20-74 to 12/74, special request only; 3-1-75 to 3-23-76 special trial shipments; and two RM topping formulas 5-27-75 to 3-22-76 and 3-25-74 to 3-23-76 and asbestos free formula.)