

August 23, 1963
 September 26, 1963
 Supersedes Formula AK-952
 Dated Aug. 23, 1963

AKRON, NEW YORK PLANT FORMULA

ALL PURPOSE COMPOUND AK-952

PLAINTIFF'S EXHIBIT

GP-1259

DESCRIPTION OF PRODUCT - White Joint System Compound for use with perforated tape. This is a multi-purpose compound to be used in bedding and covering tape and spotting nailheads.

<u>FORMULA</u>				
<u>Raw Materials</u>	<u>Source</u>	<u>R.M.Spec.</u>	<u>%</u>	<u>Lbs/Batch</u>
Vancide 51Z	R. T. Vanderbilt	126	0.10	4.0
Petro-AD	The Thornley Co.	143	0.10	4.0
Kelsize LV 2166	Kelco Company		0.25	10.0
Zinc Oxide	Mallinkrodt Chem.Wks.	119	0.35	14.0
Soda Ash	Open Market	32	0.50	20.0
Kaysoy 200C	Archer-Daniels-Midland	122	2.50	100.0
Casein 100M	Paul A. Dunkel Co.	10	5.00	200.0
-/ Asbestos 7RF-9	Phillip Carey	9	5.50	220.0
Mica JP80-F	Hassett Mica Co.	11	16.00	640.0
Nalco 71-D5	Nalco Chem. Co.		0.05	2.0
-/ Limestone	Thompson-Weinman	13	60.60	2784.0
Santobrite (#1)	Monsanto Chem. Co.	15	0.025	1.0
-/ Di Ammonium Phosphate	Open Market		0.025	1.0
			100.000	4000.0

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

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

ALKALINITY - Refer to Plant Testing Procedure No. 34.

pH Specifications		<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
		9.3	8.7	9.0

However minimum soda ash content - 0.55%

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

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

BOND 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.

SGP 0017154

COLOR:
 Specification - White
 - Dried compound should match color of std. sample.

May 5, 1977
Formula AK-952
NEW

AKRON, NEW YORK, PLANT FORMULA
*YELLOW ALL PURPOSE COMPOUND AK-952

DESCRIPTION OF PRODUCT - Buff joint compound for taping and finishing joints and spotting nailheads.

FORMULA

<u>Raw Material</u>	<u>RM Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
*Yellow Oxide	139	.100	4.0
Mica	11	12.000	480.0
Pyrophyllite	--	5.000	200.0
**Minugel FG	--	2.500	100.0
Celatom MW 27	--	2.000	80.0
Limestone	13	72.6275	2905.1
Petro AD	126	.100	4.0
Vancide	143	.075	3.0
Natrosol	170	.400	16.0
Zinc Oxide	119	.060	2.4
Soda Ash	32	.200	8.0
Borax	37	.100	4.0
Staramic 747	192	2.750	110.0
Casein	10	2.000	80.0
Mlll	196	.025	1.0
Aluminum Sulfate	--	.0625	2.5
		100.000	4000.0

SPECIFICATIONS

	<u>Testing Procedure</u>	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
Working Consistency	No. 32	60	55	58
Alkalinity - pH	No. 34	9.2	8.8	9.0
Working Properties	No. 33 - Wet mix shall be plastic working and free of grit or coarse particles.			
Crack Resistance	No. 37 - There shall be at most only a couple of fine cracks in the wedge.			
*Color	- Dried compound shall match the color of a standard sample and be free of color streaks. For white compound leave out yellow oxide.			

**Attagel 40 may be substituted. Use at a loading of 1.875% (75 lbs/batch)

WNG:jg

SGP 0017155

September 2, 1977
Supersedes Formula AK-952
Dated: 5/5/77

AKRON, NEW YORK, PLANT FORMULA
*YELLOW ALL PURPOSE COMPOUND AK-952

DESCRIPTION OF PRODUCT - Buff joint compound for taping and finishing joints and spotting nailheads.

<u>FORMULA</u> <u>Raw Material</u>	<u>RM Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
*Yellow Oxide	139	.100	4.0
-/ Mica	11	12.500	500.0
-/ Pyrophyllite	--	2.500	100.0
-/ Englehart X-1927	--	4.000	160.0
--	--	--	--
-/ Limestone	13	75.190	3007.6
Petro AD	126	.100	4.0
Vancide	143	.075	3.0
Natrosol	170	.400	16.0
Zinc Oxide	119	.060	2.4
Soda Ash	32	.200	8.0
Borax	37	.100	4.0
Staramic 747	192	2.750	110.0
Casein	10	2.000	80.0
Mili	196	.025	1.0
--	--	--	--
		100.000	4000.0

<u>SPECIFICATIONS</u>	<u>Testing Procedure</u>	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
Working Consistency	No. 32	65	58	62
Alkalinity - pH	No. 34	9.2	8.8	9.0
Working Properties	No. 33 - Wet mix shall be plastic working and free of grit or coarse particles.			
Crack Resistance	No. 37 - There shall be at most only a couple of fine cracks in the wedge.			
*Color	- Dried compound shall match the color of a standard sample and be free of color streaks. For white compound leave out yellow oxide.			

WNG:jr

SGP 0017156

September 7, 1977
Supersedes Formula AK-952
Dated: 9/2/77

AKRON, NEW YORK, PLANT FORMULA
*YELLOW ALL PURPOSE COMPOUND AK-952

DESCRIPTION OF PRODUCT - Buff joint compound for taping and finishing joints and spotting nailheads.

<u>FORMULA</u> <u>Raw Material</u>	<u>RM Spec.</u>	<u>Percent</u>	<u>Lbs/Batch</u>
*Yellow Oxide	139	.100	4.0
Mica	11	12.500	500.0
Pyrophyllite	--	2.500	100.0
Englehart X-1927	--	4.000	160.0
--	--	--	--
-/ Limestone	13	.72.215	3008.6
Petro AD	126	.100	4.0
Vancide	143	.075	3.0
-/Methocel 228	170	.400	16.0
Zinc Oxide	119	.060	2.4
Soda Ash	32	.200	8.0
Borax	37	.100	4.0
Staramic 747	192	2.750	110.0
Casein	10	2.000	80.0
--	--	--	--
		100.000	4000.0

<u>SPECIFICATIONS</u>	<u>Testing Procedure</u>	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
Working Consistency	No. 32	65	58	62
Alkalinity - pH	No. 34	9.2	8.8	9.0
Working Properties	No. 33 - Wet mix shall be plastic working and free of grit or coarse particles.			
Crack Resistance	No. 37 - There shall be at most only a couple of fine cracks in the wedge.			
*Color	- Dried compound shall match the color of a standard sample and be free of color streaks. For white compound leave out yellow oxide.			

-/denotes change

WNG:jr

SGP 0017157

**AKRON FORMULA #952
ASBESTOS CONTAINING PRODUCTS**