

Product **Japalac Enamel - Rich Blue**

FIL #

FIL #

Formula Number **Y-1246-X**

Laboratory Number

R.M. Cost

Mill **Pebble** Grind **7-8**

NPVLA **11-62**

Label Warning **11-62** METHOD

Wh./Gal. **7.7%** **5-A-1**

Flash Pt. **100°** **Theo.**

N.V.Wt. **44.7%** **Calc.**

N.V.Vol. **34.8%** **Calc.**

Visc. F. **90-100"** **4-A-1**

Visc. Red.

Reducer **S-340** Ratio

P.V.C. **8.3%** pH

Color **Blue** March **New-**

Y-1246 dated July '66

Gloss **over 86** Method **Q-A-1**

Strainer

Container

Application **Brush F.B.**

Spray: (S-332)

Cure **Air Dry: 3-4 hrs.**

Recoat: Overnight

Remarks

Mill Charge - 129.3%

Formulator **Southwick/Bednarik**

Approved by **S. Bowell**

Customer

CODE NUMBER	100 GALLON BATCH		% BY WEIGHT	MANUFACTURING INSTRUCTIONS
	GALLONS	POUNDS		
W-830	0.70	24.0		not to be taken
A-200	1.92	28.0		from File.
R-661	0.30	3.8		
E-118)	0.20	3.0	) Premix	
S-213)	0.22	(1.5)		
V-2283	77.00	(585.2)	(13 Gallons in grind)	
S-340	18.20	(118.3)	(13 Gallons in grind)	
E-396	0.42	5.8	Add at first let-down.	
E-304	0.45	(3.6)		
E-392	0.50	(3.6)		
E-262	0.18	(1.4)		
Shade with 369 line bases.				
DISCONTINUED			For 4 x 5 Mill - Make 300 Gallons.	
			For 5 x 6 Mill - Make 600 Gallons.	
SEE Y 9 28				
Yield	x100.09	778.2		

N12085

GLD059504

Date 3/2/67

Formula No 2-1246-X

CLASS
CODES

Product Jenelec
Blue Blue

DESCRIPTORS (20 spaces-limit)

Label Warning 11-62 NPVLA

Trade Name Jenelec Customer

ANALYSIS

Substrate and Treatment

Pigment 7.1 %

End Use

Vehicle 92.9 %

Specifications

100.0%

Royalty Yes ☐ No ☒ Silicone Yes ☐ No ☒

Pigment

Resins Soya Isourthallac Alkyd
V-2283

Pigment 43.0%

IRON BLUE 50.1%

EON 2000 6.9%

100.0%

Color Blue Gloss 60 MINIMUM

For Use On

Resistance

Manufactured at Plant 1-2-1-12-14 2-16-67

Vehicle

Soya Alkyd Resin 40.5%

Metal Sprays &

Epoxy 59.5%

100.0%

Manufacturing Instructions or Remarks

T 30 12-6-66

NO CHANGE IN ANALYSIS

2-1246

667

GLD059505

GOODS Japalac - Rich Blue

LABORATORY NO.

CONSISTENCY

COST CLASS

DATE 4/30/65

FOR USE ON Hvy. plants #1-2-4-8-11-12-14-15-16-17-18-19-20

STRAINER

GRIND 7-8

CUSTOMER Less than 15 Lead

MILL Pebble

WT. OR BE 7.7#

CODE NUMBER	ONE GALLON BATCH			LARGE BATCH			IS AGITATOR REQUIRED
	PINTS	LBS.	OZS.	GALS.	LBS.	OZS.	
W-290				(0.58)	20.0		VISC. F. B. 90-100" TEMP. 77°F
BL-74				(1.57)	23.5		VISC. RED. TEMP.
R-227				(0.36)	5.6		VISCOSIMETER #4 Ford Cup
W-218) Premix				(0.13)	2.0		COLOR Blue SHEEN Gloss
S-91)				0.15	(1.0)		NO. VOL. 44.5% WT. FLASH PT. 100°F
							BATCH FOR Y-1246
V-891 (15 gals. in grind)				75.5	(573.5)		REDUCER S-43
S-43 (7 gals. in grind)				20.2	(131.1)		EXT. FOR BRUSHING F.B.
Grind to 7-8 Grind, then add:							SPRAYING S-342 TUMBLING
H-333				(0.42)	5.9		DIPPING DRIP TIME
Grind 15 min. and add:							BAKE TEMP.
VM-524				0.45	(3.60)		AIR DRIES IN 3-4 hours
VM-816				0.50	(3.60)		A. D. TO RECOAT IN Overnight
CH-359				0.18	(1.40)		REMARKS Changed to use Y-290
Use 369 line for shading if needed.							PVC - 8.8%
							NV by Vol. - 34.4%
							Mill Char're - 24.7%
							FORMULATOR J. E. Southwick
YIELD				100.04	771.2		

DISCONTINUED

SEE Y-1246

[illegible]

GLD059509

GLD059510 PRINTED IN U.S.A. FRONT

FORMULA RECORD

FORMULA NO. Y-1246-U

GOODS Japalac - Rich Blue

LABORATORY NO.

CONSISTENCY

COST CLASS

DATE 4/7/64

FOR USE ON Mfg. plants #1-2-4-5-8-11-12-14-15-16-17

STRAINER

GRIND 7-8

CUSTOMER Less than 1% Lead

MILL Pebble

WT. OR BE 7.72

CODE NUMBER	ONE GALLON BATCH			LARGE BATCH			IS AGITATOR REQUIRED
	PARTS	LBS.	OZS.	GALS.	LBS.	OZS.	
W-208				(0.62)	21.0		VISC. F. B. 90-100" TEMP. 77°F
HL-74				(1.57)	23.5		VISC. RED. TEMP.
R-227				(0.36)	5.6		VISCOSIMETER #1 - Nord Cup
W-218) Premix				(0.13)	2.0		COLOR SWEEN GLOSS
S-91)				0.15	(1.0)		NON VOL. FLASH PT. 100°F
							MATCH FOR Y-1246
V-891(15 gals. in grind)				75.5	(574.00)		REDUCER S-43
S-43 (7 gals. in grind)				20.15	(131.00)		EXT. FOR BRUSHING F.B.
Grind to 7-8 Grind - then add							SPRAYING TUMBLING
M-333				(0.42)	5.9		DIPPING DRY TIME
Grind 15 min. and add:							BAKE TEMP.
VM-324	Standard Formula			.45	(3.6)		
VM-316				.50	(3.6)		DRY DRIES IN 3-4 hours.
CH-359	Not to be taken			.18	(1.4)		D. TO RECOAT IN Overnight
	from File						REMARKS: Changed for closer color.
Use 369 line for shading if needed.							N.V. by wt. 43.8%
	Standard Formula						PVC 7.9%
	Not to be taken						NV by Vol. 34.0%
							FORMULATOR J. Southwick
YIELD	1.000	113.		100.00	772.2		

GLD059510

COST	DATE	ANALYSIS	CUSTOMERS	Y-1246-U
		PIGMENT 6.74 %	Japalac Enamel - Rich Blue	
		VEHICLE 95.26 %		4/7/64
		100.00%		
		PIGMENT		
		Titanium Dioxide 41.8%	WATLING NO. 11-52 MPVLA	
		Iron Blue 47.0		
		Bordeaux Red 11.2	Y Enamel Ltd 4-10-64	
		100.0%	#1-2-4-5-8-11-12-14-15-16-17	
			Colombia 4-24-64 (2)	
			Ecuador 4-27-64 (3)	
			Peru 5-5-64 "	
		VEHICLE		
		Soya Alkyd Resin 44.5%	Mexico 8-6-64 (3)	
		Mineral Spirits & Driers 50.5%		
		100%	Italy 8-19-64 "	
		Guatemala 9-18-64 (3)	Sevilla Japan 1-20-64 "	
		Mexico 12-1-64 (4)	Costa Rica 8-24-64 "	
			Guatemala 8-26-64 "	
		Y-1246 46%	West India 9-4-64 "	

GLD059511

FORMULA RECORD

FORMULA NO. **Y-1246-T BASE**

GOODS **Japalac - Rich Blue**

LABORATORY NO. **Tallate Driers**

CONSISTENCY

COST CLASS.

DATE **7/24/62**

FOR USE ON **Mfg. at plants #2-8-16-17-1-4-5-11-12-14-15**

STRAINER

GRIND

7-8

CUSTOMER **Less than 1% Lead**

MILL **Pebble**

WT. OF BE

7.6

CODE NUMBER	ONE GALLON BATCH			LARGE BATCH			IS AGITATOR REQUIRED	
	PINTS	LBS.	OZS.	GALS.	LBS.	OZS.	VISC. F. 90-100"	TEMP.
W-208				(.50)	17.1		VISC. RED.	TEMP.
HL-74				(1.56)	23.4		VISCOSIMETER	#1 Ford Cup
R-227				(.12)	1.8		COLOR	SHEN Gloss
W-218 Premix				(.13)	2.0		NON VOL.	FLASH PT. 100° F
S-91				.13	(1.0)		MATCH FOR	Y-1246
V-891 (15 gals. in grind)				76.0	(578.0)		REDUCER	S-43
S-43 (7 gals. in grind)				20.1	(131.1)		AMT. FOR BRUSHING	F.B.
Grind to 7-8 and add:								
M-333				(.42)	5.9		SPRAYING	TUMBLING
Grind 15 min.								
VM-524				.45	(3.1)		DIPPING	DRIP TIME
VM-816				.5	(3.6)		BAKE	TEMP.
CH-359				.38	(1.4)		AIR DRIES IN	3-4
Standard Formula Not to be taken from File							A. O. TO RECOAT IN	O.N.
							REMARKS:	
							IV by Wt.	43.3%
							IV by Vol.	33.8%
DISCONTINUED							PVC	6.8
							Mill Base	24.4%
SEE Y-1246-U							FORMULATOR	J. E. Southwick
							YIELD	
				100.15	768.1			

GLD059512

COST	DATE	ANALYSIS	CUSTOMERS	Y-1246-T
		PIGMENT 5.0 %	Japan and enamel - Rich Blue	
		VEHICLE 94.3 %		
		100.0%		7/24/62
		PIGMENT	Warning 11-62 11/14	
		Ti Dioxide 40.5%		
		Iron Blue 55.2	No change in analysis	
		Aluminum Blue 4.3		
		100.0%		
		<i>John Dwyer</i> 2-11-64		
		<i>Mothers</i> 2-21-64		
		<i>Walt Jones</i> 3-3-64		
		VEHICLE		
		3-12-64 42%	Panama 9-25-63	
		4-12-64 58%	Costa Rica 11-19-62	
		100%	Italy 9-3-63	
		<i>Guatemala</i> 3-9-64	#1 (Dwyer - U.C.B. Cat) 8-2-62	
		<i>Manila</i> 3-31-64	#30 (Southwick - Hugg) "	
			Plant #2-8-16-17 8-3-62	
			#1 (Enamel Cat) 8-8-62	
		<i>1-1-64</i> 54	#4-5-11-12-14-15 5-29-62	

GLD059513

FORMULA RECORD

FORMULA NO. Y-1246-T PAGE

GOODS Japalac - Rich Blue

LABORATORY NO.

CONSISTENCY.

COST CLASS.

DATE 7/24/62

FOR USE ON Mfg. at plants #1-2-4-12-14

STRAINER

GRIND 7-8

CUSTOMER Less than 1% Lead

MILL Pebble

WT. OR BE 7.6

CODE NUMBER	ONE GALLON BATCH			LARGE BATCH			OZS.	IS AGITATOR REQUIRED	VISC. F.B. 90-100 ^u	TEMP.
	PINTS	LBS.	OZS.	GALS.	LBS.	OZS.				
W-208				(.50)	17.1					
BL-74				(1.58)	23.4					
R-227				(.12)	1.8					
W-218) Premix				(.13)	2.0					
S-91)				.13	(1.0)					
V-891 (15 gals. in grind)				76.0	(578.0)					
S-43 (7 gals. in grind)				19.7	(128.0)					
Grind to 7-8 and add:										
M-333				(.42)	5.9					
Grind 15 min.										
D-83				.9	(6.2)					
VA-816				.5	(3.6)					
CH-359				.18	(1.4)					
Standard Formula, Not to be taken from file.										
YIELD								100.15	768.1	
								DISCONTINUED		
								REMARKS: Better gloss - less seeding.		
								NV by Wt. 43.3%		
								NV by Vol. 33.8%		
								PVC 6.8%		
								Mill Base 24.4%		
								FORMULATOR J. E. Southwick		

GLD059514

[illegible]

GLD059515

GLD059516 PRINTED IN U.S.A. FRONT

FORMULA RECORD

FORMULA NO.

Y-1246-S

GOODS

Japalac Enamel - High Blue

LABORATORY NO.

CONSISTENCY

DISCONTINUED

COST CLASS.

DATE 7/10/61

FOR USE ON

Less than 1% Lead

STRAINER

GRIND

7-8

CUSTOMER

MILL Pebble

WT. OR BE 7.6

CODE NUMBER	ONE GALLON BATCH			LARGE BATCH			IS AGITATOR REQUIRED
	PINTS	LBS.	OZS.	GALS.	LBS.	OZS.	
W-208				.50	17.1		VISC. F.B. 90-100" TEMP.
BL-74				1.56	23.4		VISC. RED. TEMP.
H-227				.12	1.8		VISCOSIMETER #4 Ford Cup
M-333				.42	5.9		COLOR SEEN GLOSS
CH-354				.19	1.4		NOY VEL. FLASH PT.
							WATCH FOR Y-1246
V-891 (9 Gal. in grind)				81.0	615.0		REDUCER S-43
S-43 (9 Gal. in grind)				14.6	95.2		AMT. FOR BRUSHING F.B.
D-83				.7	5.0		SPRAYING TUMBLING
VM-432				.4	3.4		DIPPING DRIP TIME
VM-523				.4	2.9		BAKE TEMP.
CH-359				.1	1.0		AIR DRIES IN 3-4 hrs.
							A. D. TO RECDY IN Overnight
							REMARKS: *Reissued to eliminate VM-431.
							21.5% Mill Base
							FORMULATOR J. E. Southwick
YIELD				99.99	772.1		

GLD059516

GLD059517

FORMULA RECORD

FORMULA NO. Y-1246-S BASE

GOODS Japalac Enamel - Rich Blue

LABORATORY NO. (Atlanta Only)

CONSISTENCY

COST CLASS.

DATE 5/16/61

FOR USE ON

STRAINER

GRIND 7-8

CUSTOMER

Less than 1% Lead)

MILL Pebble

WT. OR BE 7.6

CODE NUMBER	ONE GALLON BATCH			LARGE BATCH			IS AGITATOR REQUIRED
	PINTS	LBS.	OZS.	GALS.	LBS.	OZS.	
W-208				.50	17.1		VISC. F.B. 90-100" TEMP.
BL-74				1.56	23.4		VISC. RED. TEMP.
R-227				.12	1.8		VISCOSIMETER #4 Ford Cup
M-333				.42	5.9		COLOR SHEEN Gloss
CH-354				.19	1.4		NON VOL. FLASH PT.
V-891 (9 gal. in grind)				81.0	615		MATCH FOR Y-1246
S-43 (9 gal. in grind)				14.6	95.2		REDUCER S-43
VM-524				.35	2.8		AMT. FOR BRUSHING F.B.
VM-526				.4	3.4		SRRAYING TUMBLING
VM-858				.4	2.9		CURPING DRIP TIME
CH-359				.1	1.0		BATE TEMP.
							DR DRIES IN 3-4 hrs.
							D. TO RECOAT IN Overnight
							REMARKS:
							21.5% Mill Base
							FORMULATOR J.E. Southwick
YIELD				99.99	772.1		

Standard Formula,
Not to be taken
from File.

DISCONTINUED
SEE X-12

GLD059518

GOODS Japalac Enamel - Rich Blue

CONSISTENCY

FOR USE ON THIS PRODUCTION MUST NOT CONTAIN LEAD

CUSTOMER (Less than 1% Lead)

LABORATORY NO.

COST CLASS.

DATE 5/8/61

STRAINER

GRIND 7-5

WASH Pebble

WT. OR BE 7.6

CODE

Q1. ANEXMIX

LARGE BATCH

NUMBER

XKMS

LBS.

OZS.

W.S.

LBS.

OZS.

IS AGITATOR REQUIRED

WISC. F.B. 90-100

TEMP.

WISC. RED.

TEMP.

DISCOSIMETER #4 Ford Cup

FEED OR

SHEEN Gloss

NEW VOL.

FLASH PT.

MATCH FOR Y-1246 Panel

REDUCER S-43

WMT. FOR BRUSHING

F.B.

SPRAYING

TUMBLING

DIPPING

DRIP TIME

BAKE

TEMP.

AIR DRIES IN 3-4 hrs.

A. D. TO RECOAT IN O.N.

REMARKS: **Relieved to eliminate VM-431.

*100 Gals. - Add in grind. *** 9 Gals.

*105 Gals. - Add in grind. *** 9 Gals.

Y-4133

Y-4133

Y-4133

Y-4133

FORMULATOR J.E. Southwick

YIELD

1316

10,015

100.0

761

30-12-13

GOODS Japalac Enamel - Rich Blue
 CONSISTENCY
 FOR USE ON THIS PRODUCTION MUST NOT CONTAIN LEAD
 CUSTOMER (Less than 1% Lead)

LABORATORY NO.
 COST CLASS. DATE 11/2/59
 STRAINER GRIND 7-8
 MILL Pebble WT. OR BE 7.6

CODE	Gal. SMALL BATCH	LBS.	OZS.	GALS.	LBS.
NUMBER					
V-208		225			17.1
BL-74		307			23.4
N-227		24			1.8
N-333		77			5.9
CH-354		19			1.4
VM-431	9.6	77		0.7	5.9

5' AGITATOR REQUIRED
 VISC. F.B. 90-100" TEMP.
 VISC. RED. TEMP.
 VISCOSIMETER #4 Ford Cup
 COLOR SHEEN Gloss
 NON VOL. FLASH PT.
 MATCH FOR Y-1246 Panel

V-891	*1036	7872		78.7	598.0 ***
S-43	*192	1251		14.6	95.2 ***
P-83	9.6	66		0.7	5.0
VM-432	4.8	45		0.4	3.4
VM-523	4.8	38		0.4	2.9
CH-359	1.7	13		0.1	1.0

REDUCER S-43
 AMT. FOR BRUSHING F.B.
 SPRAYING TUMBLING
 DIPPING DRIP TIME
 BAKE TEMP.
 AIR DRIES IN 3-4 hrs.
 A. D. TO RECOAT IN O.N.

REMARKS:
 Changed to V-891
 *100 Gals. - Add in grind. *** 9 Gals.
 *105 Gals. - Add in grind. *** 9 Gals.

DESTROY COPY DATED
 9/28/59. Y-413? Discont
 Y-4108

YIELD	1316	10,015		100.0	761
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FORMULATOR J.E. Southwick
 20-12-12

COST	DATE	ANALYSIS	CUSTOMERS
		PIGMENT 5.6 %	V-1246-S
		VEHICLE 4.4 %	Japalac Enamel - Rich Blue
		100.0%	11/2/59
		PIGMENT	
		Titanium Dioxide 40.5%	/ Enamel Lot 11-5-59
		Iron Blue 55.2	
		Alizarine Blue 4.3	No. 1 Label Warning
		100.0%	No change in analysis
			Marche (Portland) 11-5-59
			Heating (Tulsa) 11-5-59
		VEHICLE	
		Soya Alkyd Resin 42%	Panama (SLH) 11-14-60
		Mineral Spirits & Driers 58	Chile 2-12-60
		100.0%	Colombia "
			Costa "
			Ecuador "
			Guatemala "
			Peru "
			West Indies 2-12-60
			Mexico 9-14-60
		Y-1246 959	Beck (Hub) #7 1-25-61

GLD059523

FORMULA NO. Y-1246-R

GOVERNMENT Japalac Enamel - Rich Blue

LABORATORY NO.

CONSISTENCY

COST CLASS.

DATE 1/26/55

FOR USE ON

4-22-55

STRAINER

GRIND 7-B

CUSTOMER

MILL Pebble WT. OR BE 8.6#

CODE NUMBER	ONE GALLON BATCH			LARGE BATCH			IS AGITATOR REQUIRED
	PINTS	LBS.	OZS.	GALS.	LBS.	OZS.	
W-170			2-3/4				VISC. F.N. 90-105" TEMP.
BL-74			4				VISC. RED. TEMP.
R-227			5/16				VISCOSIMETER #4 Ford Cup
W-154		1	2				COLOR SHEEN Gloss
X-333			1				NOV VOL. FLASH PT.
CH-185			3/4				WATCH FOR Y-1246 Panel
V-872	6-3/4						REDUCER S-43
D-320	1/4						WAT. FOR BRUSHING FB
S-43	1						SPRAYING TUBING
D-29			2	Loz.			DIPPING DRIP TIME
VM-530			1/2	"			BAKE TEMP.
CH-269			1/8	"			AIR DRIES IN 4-6 hrs.
							A. D. TO RECOAT IN 0.7
							REMARKS:
							Changed to remove W-104
							Also Y-4133
							FORMULATOR J.E.S.
YIELD	1.10						OK PCH 28-8-7

Standard Formula.
Not to be taken
from File.

GLD059527

6023 Japalac - Rich Blue Enamel

LABORATORY NO.

CONSISTENCY Liquid

COST CLASS.

DATE 8/20/53

FOR USE ON

STRAINER

GRIND 7-8

CUSTOMER

MILL Pebble

WT. OR BE 8.6#

CODE NUMBER	ONE GALLON BATCH			LARGE BATCH			IS AGITATOR REQUIRED	
	PINTS	LBS.	OZS.	GALS.	LBS.	OZS.	VISC. F.D.	TEMP.
W-170			2-3/4				90-105"	80°F
BL-74			4				VISC. RED.	TEMP.
R-227			5/16				VISCOSIMETER #4 Ford Cup	
W-154		1					COLOR Blue	SHEEN
W-104			2				NON VOL.	FLASH PT.
M-333			1				MATCH FOR Y-1246 Porcelain	
CH-185			3/4				REDUCER S-43	
V-872	6-3/4						AMT. FOR BRUSHING F.B.	
O-320	1/4						SPRAYING	TUBBLING
S-43	1						DIPPING	DRIP TILE
							BAKE	TEMP.
D-29			2	Loz.			AIR DRIES IN	4-6 hrs.
D-75			2	"			A. O. TO RECOAT IN	Overnite
CH-259			1/8	"			REMARKS:	
							To replace W-69 with W-170.	
							Standard Formula. Not to be taken from File.	
YIELD	1.109	Gals.					FORMULATOR J.C. Walter	
								28-8-6

GLD059528

MADE IN U.S.A. PRINTED IN U.S.A.

FORMULA RECORD

FORMULA NO. **Y-1246-R (Rdg.)**

GATS: **JAFALAC ENAMEL - RICH BLUE**

LABORATORY NO.

CONSISTENCY: **Liquid**

COST CLASS: **X**

DATE: **11-12-57**

FOR USE ON

STRAINER: **X**

CRIND: **7-8**

CUSTOMER

MILL: **Pebble**

WT. OR DE: **8.6%**

CODE NUMBER	ONE GALLON BATCH			LARGE BATCH			IS AGITATOR REQUIRED	VISC. F.O.	TEMP.
	PINTS	LBS.	OZS.	GALS.	LBS.	OZS.			
V-170					15.8		X	90-105°	80°F
BL-74					21.1		X	X	TEMP. X
B-227					1.6		X	#6 Ford OWD	
W-154					10.4		X	COLOR X	SHEEN GLOSS
W-333					5.8		X	NON VOL. X	FLASH POINT 80
CH-185					4.3		X	MATCH FOR	New color chip
V-872				63.5			X	REDUCER 8-13	
O-320				2.8			X	AMT. FOR BRUSHING P.B.	
S-43				11.5			X	SPRAYING X	TUBING X
2-KB-564				14.4			X	DIPPING X	CRIP TIME X
D-29				1.4			X	BAKE X	TEMP. X
VM-530				.36			X	AIR DRIES IN	4-6 hrs.
CH-243				.09			X	A. D. TO RECOAT IN	c/n
							X	CATALYST	
							X	AMT. OF CATALYST	
							X	POT LIFE	TEMP.
							X	STABILITY AT 200°F.	
							X	STABILITY AT 135°F.	
							X	STABILITY AT 100°F.	
							X	REMARKS	
							X	FORMULATOR	JPharner
YIELD					102.8 gals.				

GLD059530

CLIPPER 480-H. PRINTED IN U.S.A. **Apple Rich Blue Enamel** FORMULA RECORD

FORMULA RECORD

FORMULA NO. Y-1246-N

CONSISTENCY

Liquid

LABORATORY NO.

FOR USE ON

COST CLASS.

DATE 4/4/52

CUSTOMER

STRAINER

GRIND 7-8

MILL Pebble

WT. OR DE 9-1/2

CODE NUMBER	ONE GALLON BATCH			LARGE BATCH			IS AGITATOR REQUIRED	
	PINTS	LBS.	OZS.	GALS.	LBS.	OZS.	VISC. F.B. 90-105 ^H	TEMP.
W-170			3-1/8				VISC. RED.	TEMP.
BL-74			4-3/4				VISCOSIMETER #4 Ford Cup	
BL-78			7-3/4				COLOR	SHEEN Gloss
W-154	1		8				NON VOL.	FLASH PT. 100°F
W-104			2				MATCH FOR Y-1246	Porcelain
M-333			3/4				REDUCER	
CH-185			1				AMT. FOR BRUSHING F.B.	
V-372	6-3/4						SPRAYING	TUBBLING
O-320	1/4						DIPPING	DRIP TIME
S-43	1						BAKE	TEMP.
D-29			2	Loz/gal.			AIR DRIES IN 4-6 hrs.	
D-75			2	" "			A. D. TO RECOAT IN Overnight	
CH-269			1/8	" "			REMARKS	
RL-B721			1/8	" "				
Changed to replace V-357.								
YIELD							FORMULATOR Southwick	25-8-4

CONSISTENCY

LABORATORY NO.

FOR USE OF

COST CLASS.

DATE 2/25/52

CUSTOMER

STRAINER

GRIND 7-8

MILL Pebble

WT. OR PE 9#

CODE NUMBER	ONE GALLON BATCH			LARGE BATCH			IS AGITATOR REQUIRED
	PINTS	LBS.	OZS.	GALS.	LBS.	OZS.	
W-170			3-1/8				VISC. F.B. 90-105" TEMP.
BL-74			4-3/4				VISC. RED. TEMP.
BL-78			7-3/4				VISCOSIMETER #4 Ford Cup
W-154		1	8				COLOR SHEEN
W-104			2				NON VOL. FLASH PT.
W-333			3/4				MATCH FOR Y-1246 Porcelain
CH-185			1				REDUCER
V-872	3-1/2						AMT. FOR BRUSHING F.B.
V-357	4-1/8						SPRAYING TUMBLING
S-43	3/8						DIPPING DRIP TIME
D-29			2				BAKE TEMP.
D-75			2				AIR DRIES IN 4-6 hrs.
CH-269			1/8				A. D. TO RECOAT IN Overnight
RL-8721			1/8				REMARKS:
Changed to use BL-78 & W-170.							
YIELD							FORMULATOR Southwick HGH

Standard Formula.
Not to be taken
from File.

25-8-4

GLD059534

COST	DATE	ANALYSIS		CUSTOMERS	
		PIGMENT	24.8 %	<i>all Plant</i>	<i>2-27-52</i>
		VEHICLE	75.2 %		
			100.0 %		
		PIGMENT			
		Titanium Oxide	7.5%		
		C.P. Iron Blue	11.4		
		Ultramarine Blue	18.6		
		Calcium Carbonate	57.7		
		Basic Lead Carbonate	4.8		
			100.0 %		
		VEHICLE			
		* Varnish	94.6%		
		Mineral Spirits	2.5		
		Liquid Drier	2.9		
			100.0 %		
		*Non-Vol. (Alkyd Resin, P.E.			
		Ester Gum, Tung & Linseed Oils)	54.6%		
		Volatile (Mineral Spirits)	45.4		
			100.0 %		
		Y-1246	252		

GLD059535

CONSISTENCY Liquid

LABORATORY NO.

FOR USE ON

COST CLASS.

DATE 11/12/51

CUSTOMER

STRAINER

GRIND 7-8

MILL

WT. OR BE 9-1/4#

CODE NUMBER	ONE GALLON BATCH			LARGE BATCH			IS AGITATOR REQUIRED	
	PINTS	LBS.	OZS.	GALS.	LBS.	OZS.	VISC. F.B. 100-110"	TEMP.
W-69		1	4		100		VISC. RED.	TEMP.
BL-74			4		20		VISCOSIMETER #4 Ford Cup	
R-227			5/16		1	9	COLOR	SHEEN Gloss
W-154		1			80		NON VOL.	FLASH PT.
W-104			2		10		MATCH FOR Y-1246 Porcelain	
M-333			1		5			
CH-185			3/4		3	12	REDUCER	
V-872	3-1/2			35			INT. FOR BRUSHING F. B.	
V-357	4-1/4			42-1/2			SPRAYING	TUMBLING
S-43	1/4			2-1/2			DIPPING	DRIP TIME
							BAKE	TEMP.
D-29		2 Loz/gal.		1-1/4			AIR DRIES IN 4-6 hrs.	
D-75		2 " "		1-1/4			A. D. TO RECOAT IN Overnite	
CH-269		1/8 " "				10 Loz	REMARKS:	
RL-8721		1/8 " "				10 Loz		
	Analysis Change			Standard Formula Not to be taken from File.				
YIELD							FORMULATOR Southwick H.C.H.	25-6-4

COST	DATE	ANALYSIS		CUSTOMERS Y-1246-L	
		PIGMENT	25.7 %	Japalac	
		VEHICLE	74.3 %	1246 Rich Blue	
			100.0 %	11/12/51	
				<i>all Plante</i>	<i>12-4-57</i>
		PIGMENT			
		Lithopone	47.5 %		
		C.P. Iron Blue	9.4		
		Alizarine Lake	.3		
		Calcium Carbonate	38.2		
		Basic Lead Carbonate	4.6		
			100.0 %		
		VEHICLE			
		* Varnish	94.6 %		
		Mineral Spirits	2.5		
		Liquid Drier	2.9		
			100.0 %		
		* Non-Vol. (Alkyd Resin, P.E.			
		Ester Gum, Tung, Linseed Oil)	54.6 %		
		Volatile (Mineral Spirits)	45.4		
			100.0 %		
		Y-1246	1511		

GLD059537

GLIDDEN ENAMELS
Japanned Rich Blue Enamel

FORMULA RECORD

FORMULA NO. Y-1246-K/

CONSISTENCY Liquid

Standard Formula

LABORATORY NO.

FOR USE ON

COST CLASS.

DATE 2/20/51

CUSTOMER

STRAINER

GRIND 7-8

MILL

WT. OR BE 9-1/4#

CODE NUMBER	ONE GALLON BATCH			LARGE BATCH			IS AGITATOR REQUIRED	
	PINTS	LBS.	OZS.	GALS.	LBS.	OZS.	VISC. F.B.	TEMP.
W-69		1	4		100		100-110"	
BL-74			4		20		VISC. RED.	TEMP.
R-227			5/16		1	9	VISCOSIMETER #4 Cup	
W-154		1			80		COLOR	SHED GLOSS
W-104			2		10		NON VOL.	FLASH PT.
M-333			1		5		MATCH FOR Y-1246 Porcelain	
CH-185			3/4		3	12	REDUCER	
V-872	3-1/2			35			AMT. FOR BRUSHING P B	
V-357	4-1/4			42-1/2			SPRAYING	TUMBLING
S-43	1/4			2-1/2			DIPPING	DRIP TIME
D-29		2 Loz/gal		1-1/4			BAKE	TEMP.
D-75		2 Loz/gal		1-1/4			AIR DRIES IN 4-6 hrs.	
CH-243		1/8 Loz/gal				10 Loz	A. D. TO RECOAT IN Overnite	
RL-8711		1/2 " "				10. "	REMARKS: 1/8 Oz/gal RL-8721	
							for silking when	
							necessary.	
(Back to "I" Formula with better match to color standard.							FORMULATOR Southwick	
YIELD							25-6-4	

GLD059538

COST	DATE	ANALYSIS		CUSTOMERS
		PIGMENT 25.7	%	Y-1246K
		VEHICLE 74.3	%	
		100.0%		
				Y-1246K
		PIGMENT		1246 Rich Blue
		Lithopone	47.5%	
		C.P. Iron Blue	9.4	
		Alizarine Lake	0.3	
		Calcium Carbonate	38.2	
		Basic Lead Carbonate	4.6	
			100.0%	
		VEHICLE		
		Varnish	94.6%	
		Mineral Spirits	2.5	
		Liquid Drier	2.9	
			100.0%	
				Gum
		Non Vol. 54.6%	(Soya Oil Alkyd, Oiticica Oil, Linseed Oil, Ester-	
		Vol. 45.4	(Mineral Spirits	
		100.0%		
		Y-1246	152	

GLD059539

Japan's Rich Blue Enamel

FORMULA RECORD

FORMULA NO. Y-1246-J

CONSISTENCY

Liquid

LABORATORY NO.

FOR USE ON

COST CLASS.

DATE 1/17/51

CUSTOMER

STRAINER

GRAND 7-8

6031 E

WT. OR BE 9-1/2

[illegible]

COST	DATE	ANALYSIS		CUSTOMERS
		PIGMENT	25.5 %	<i>W. G. Harts 1-25-31</i>
		VEHICLE	74.5 %	
			100.0 %	
		PIGMENT		
		Lithopone	36.8 %	
		C. P. Iron Blue	8.3 %	
		Ultramarine Blue	13.5 %	
		Calcium Carbonate	36.8 %	
		Basic Lead Carbonate	4.0 %	
			100.0 %	
		VEHICLE		
	*	Varnish	94.5 %	
		Mineral Spirits	2.5 %	
		Liquid Drier	2.9 %	
			100.0 %	
	*	Non Vol. 54.6 % (Soya oil Alkyd, Oiticica Oil, Linseed Oil)		
		Vol. 45.4 % (Mineral Spirits)		

GLD059541

FORMULA RECORD

Formula No. Y-1246-I

Laboratory No.

Cost Class.

Date 6/1/49

Strainer

Grind 7-8

Mill Pebble

Wt. or Be 9-1/2#

Goodlaplac Rich Blue Enamel

Consistency Liquid

For use on

Customer

Code Number	One Gallon Batch			Large Batch		Is agitator required 9-1/2# Temp.
	Pints	Lbs.	Ozs.	Gals.	Lbs.	
V-69		1	4		100	Viscosity 80"-90" Temp.
BL-74			4		20	Viscosimeter #4 Cup
W-154		1			80	Color Blue Sheen
R-227			3/16		15 oz	Non Vol. Flash Pt 100-F
W-104			2		10	Match for Y-1246 Chip
M-333			1		5	
CH-185			1/2		2-1/2	Reducer
V-872	3-1/2			35		Amt. for brushing F.B
V-357	4-1/4			42-1/2		Spraying Tumbling
S-43	1/8			1-1/4		Dipping Drip time
S-90	1/8			1-1/4		Bake Temp.
D-29		2 Loz/gal		1-1/4		
D-75		2 " " "		1-1/4		Air dries in 4-6 hrs
CH-243		1/8 " " "		10 oz		A. D. to recont in Overnite
Changed to new quality using V-872						Remarks:
						Standard Formula
						Active
						Discontinued
						See
						Formulation
Yield	SEE	11.12	11.12			

GLD059542

Cost	Date	Analysis	Customers
		Pigment 25.5 %	
		Vehicle 74.5 %	
		100.0 %	
		Pigment	
		Lithopone 47.6 %	
		C.P. Iron Blue 9.4	
		Alizarine Blue .2	
		Calcium Carbonate 38.2	
		Basic Lead Sulphate 4.6	
		100.0 %	
		Vehicle	
		Varnish 94.6 %	
		Mineral Spirits 2.5	
		Liquid Drier 2.9	
		100.0 %	
		Non Vol 54.6 %	

GLD059543

Characteristics and Method of Using		Cost Data		Customers
Type of Goods				
Color				
Luster				
Match for				
Kind of Reducer				
Amount of Reduction for		Pigment	25.5	All plants 6-30-47
Brushing		Vehicle	74.5	
Spraying	Pressure		100.0	
Dipping	Drip Time	Analysis		
Flooding	Drip Time	Pigment		
Tumbling		Pythopone	117.60	
Air dry to recoat		CP Iron Blue	9.50	
To Sand or Rub		Alizarine Lake	0.15	
Bake Time	Temp.	Calcium Carbonate	38.05	
Rub with		Basic Lead Sulphate	4.70	
Polish with			100.0	
Schedule		Vehicle		
		X Varnish	91.7	X % Vol 51.35%
		Mineral Spirits	5.3	
		Liquid Drier	3.0	
			100.0	

GLD059545

FORMULA RECORD

Goods
Consistency
For Use on

Japalac Rich Blue Enamel
Liquid

Formula No. *Temp 1124611*
Date *2-4-48*
Laboratory No.
Cost Classification

Code Number	One Gallon Batch			Gallon Batch			Gallon Batch			Manufacturing Specifications
	Pints	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	
<i>W-69</i>		<i>1</i>	<i>4</i>							Grind <i>7-8</i>
<i>BL-74</i>			<i>4</i>							Kind of Mill <i>Pebble</i>
<i>W-154</i>		<i>1</i>								Strainer
<i>R-227</i>			<i>1/16</i>							Weight per Gallon <i>9.3 #</i>
<i>W-104</i>			<i>2</i>							Light Baume Temp.
DISCONTINUED SEE <i>11246-1</i> <i>6/1/49</i> Standard Formula Not to be used from File										Heavy Baume Temp.
										Viscosity <i>80-90</i> Temp.
										Viscosimeter <i>4 Cps</i>
										Flash Point
<i>D65A Japalac</i>										Is Agitator Required
<i>or</i>										Remarks <i>air driven</i>
<i>1240 dropless</i>										<i>4-6 Hrs</i>
<i>V-357</i>	<i>4 1/4</i>									<i>Ant. for brushing</i>
<i>S-43</i>	<i>1/2</i>									<i>Full Body</i>
<i>J-44</i>				<i>2 Loz / gal</i>						<i>Match for 11246 Porcelain</i>
<i>J-29</i>				<i>2 " " "</i>						<i>O.D. to recast in 24 Hrs</i>
Yield	<i>Formula to be used 11858 is available</i>									<i>H.G.H</i>

GLD059546

FORMULA RECORD

Goods

Japan Lac Enamel Rich Blue

Formula No.

Y 1246-C

Consistency

Liquid

Date

12-11-45

Laboratory No.

For Use on

Y

Cost Classification

Code Number	One Gallon Batch			Gallon Batch			Gallon Batch			Manufacturing Specifications
	Pints	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	
W 69		1						80		Grind H
BL-16		1	12					140		Kind of Mill Colloid
W 154		1						80		Strainer Screen
W-1			2					10		Weight per Gallon 9.6 lb
V 357 S. D.	1 1/2						15			Light Baume Temp.
VR 45016	53						57 1/2			Heavy Baume Temp.
0.63	1/2						5			Viscosity 80-90 Temp.
5.43	1/4						2 1/2			Viscosimeter
										Flash Point
D 2 A			3				1 1/2			Is Agitator Required
D 15			2				1 1/4			Remarks Handwork
73-B-7		Trace								Match porcelain paint
73-A-74			2							Y 1246 6/18/47
										Change to more closely match standard on the ground
Yield										

GLD059548

Characteristics and Method of Using		Cost Data		Customers
Type of Goods	<i>Enamel</i>			
Color	<i>Blue</i>			
Luster	<i>Gloss</i>			
Match for	<i>V-1276</i>			
Kind of Reducer				
Amount of Reduction for				<i>All plants 12-14-45</i>
Brushing	<i>OK</i>	<i>Pigment</i>	<i>83.8%</i>	
Spraying	Pressure	<i>Vehicle</i>	<i>66.2%</i>	
Dipping	Drip Time	Analysis <i>100.0%</i>		
Floccing	Drip Time	<i>Pigment</i>		
Tumbling		<i>Lithopone</i>	<i>25.8%</i>	
Air dry to recoat	<i>over night</i>	<i>Ultramarine Blue</i>	<i>45.1%</i>	
To Sand or Rub		<i>Calcium Carbonate</i>	<i>25.8%</i>	
Bake Time	Temp.	<i>Basic Sulphate white lead</i>	<i>33%</i>	
Rub with			<i>100.0%</i>	
Polish with		<i>With necessary tinting color added</i>		
Schedule		<i>Vehicle</i>		
		<i>Varnish</i>	<i>86.9%</i>	
		<i>Boiled Linseed Oil</i>	<i>6.6%</i>	
		<i>Mineral Spirits</i>	<i>2.7%</i>	
		<i>Spirit Veneer</i>	<i>3.8%</i>	
			<i>100.0%</i>	

GLD059549

FORMULA RECORD

Goods *Formula Record Book*Formula No. *41246-F*Consistency *Liquid*Date *3-23-45*Laboratory *10*

For Use on

Cost Classification

Code Number	One Gallon Batch			Gallon Batch			Gallon Batch			Manufacturing Specifications
	Pints	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	
<i>W 69</i>		<i>1</i>	<i>9</i>				<i>125</i>			Grind <i>A</i>
<i>BL-16</i>		<i>1</i>	<i>8</i>				<i>120</i>			Kind of Mill <i>Steel</i>
<i>W 181</i>		<i>1</i>					<i>80</i>			Strainer
<i>W 104</i>			<i>2</i>				<i>10</i>			Weight per Gallon <i>10.54</i>
<i>V 357</i>	<i>1 1/2</i>			Standard Formula Not to be taken from File.			<i>15</i>			Light Baume Temp.
<i>VR 45016</i>	<i>5 3/4</i>						<i>2 3/4</i>			Heavy Baume Temp.
<i>0 63</i>	<i>1 1/4</i>						<i>5</i>			Viscosity <i>80-90</i> Temp.
<i>S 43</i>	<i>1 1/4</i>						<i>2 1/2</i>			Viscosimeter
<i>KM 547</i>			<i>20 lbs.</i>				<i>1 1/4</i>			Flash Point
<i>D 15</i>			<i>20 lbs.</i>				<i>1 1/4</i>			Is Agitator Required
DISCONTINUED SEE <i>4-12-45</i> <i>12-11-45</i>										Remarks <i>new work</i>
										<i>new work</i>
										<i>new work</i>
<i>Changed to new formula</i>										
Yield										<i>J.P.W.</i>

GLD059550

FORMULA RECORD

Goods

Consistency

For Use on

Formula No.

Laboratory No.

Cost Classification

Code Number	One Gallon Batch			Gallon Batch			Gallon Batch			Manufacturing Specifications
	Pints	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	
1111		1	4					1.5		Grind
1112								1.2		Kind of Mill
1113		1						8.0		Strainer
1114			1					5		Weight per Gallon
1115										Light Baume Temp.
1116	4							5.0		Heavy Baume Temp.
1117								1.0		Viscosity Temp.
1118										Viscosimeter
1119								Trace		Flash Point
1120										Is Agitator Required
1121			2	1/2				1 1/4		Remarks
1122			2	1/2				1 1/4		White Porcelain
1123										
1124										
1125										
1126										
1127										
1128										
1129										
1130										
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1193										
1194										
1195										
1196										
1197										
1198										
1199										
1200										

DISCONTINUED

SEE 7/1246 7

3/23/45

GLD059552

FORMULA RECORD

Goods

Enamel Rich Blue

Formula No.

1546

Consistency

Thick

Date

7-3-43

Laboratory No.

For Use on

Cost Classification

Code Number	One Gallon Batch			Gallon Batch			Gallon Batch			Manufacturing Specifications
	Pints	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	
<i>W 113</i>			<i>3</i>					<i>15</i>		Grind <i>U</i>
<i>W 69</i>			<i>13</i>					<i>65</i>		Kind of Mill <i>W.L.</i>
<i>BL 16</i>		<i>1</i>	<i>8</i>					<i>120</i>		Strainer
<i>W 11</i>		<i>1</i>						<i>80</i>		Weight per Gallon <i>11.5</i>
<i>V 357</i>	<i>6 3/4</i>						<i>6 3/4</i>			Light Baume Temp.
<i>063</i>	<i>7/8</i>						<i>3 3/4</i>			Heavy Baume Temp.
<i>052</i>	<i>3/4</i>						<i>3 3/4</i>			Viscosity <i>10-120</i> Temp.
<i>S 104</i>	<i>1/2</i>						<i>5</i>			Viscosimeter
<i>1230</i>			<i>2</i>	<i>1/2</i>			<i>1 1/4</i>			Flash Point
<i>122A</i>			<i>2</i>	<i>1/2</i>			<i>1 1/4</i>			Is Agitator Required
										Remarks <i>Wagon 2-1</i>
										<i>U</i>
										<i>Match Potassium</i>
										<i>Panel</i>
<i>DISCONTINUED</i>										
<i>SEE 7/12462 10/27/43</i>										
<i>Yield:</i>										

GLD059554

Characteristics and Method of Using		Cost Data				Customers
Type of Goods						
Color						
Luster						
Match for						
Kind of Reducer						
Amount of Reduction for						
Brushing						
Spraying	Pressure					
Dipping	Drip Time	Pigment Analysis				
Floccing	Drip Time	Vehicle				
Tumbling		100.0%				
Air dry to recoat		Pigment				
To Sand or Rub		Titanium Oxide				5.35
Bake Time	Temp.	Zinc Oxide				23.20
Rub with		Ultramarine Blue				42.90
Polish with		Magnesium Silicate				28.55
Schedule		100.00%				
		Vehicle				
		Varnish				82.5-Non Vol. 50%
		Refined Linseed Oil				9.7
		Mineral Spirits				5.6
		Drier				2.2
		100.0%				

GLD059555

Characteristics and Method of Using	Cost Data				Customers
Type of Goods					
Color					
Luster					
Match for					
Kind of Reducer					
Amount of Reduction for					
Brushing					
Spraying Pressure					
Dipping Drip Time	Original Analysis 3.5.0				
Flooding Drip Time	1.5.0				
Tumbling	1.5.0				
Air dry to recoat	1.5.0				
To Sand or Rub	1.5.0				
Bake Time Temp.	1.5.0				
Rub with	Magnesium Silicate				
Polish with	Crucible Sand				
Schedule	1.5.0				
	Vehicle				
	Elastic Varnish				100%
	Non-Volatile				100%

GLD059557

FORMULA RECORD

Goods JAP-A-LAC ENAMEL RICH BLUEFormula No. V-1246-B

Consistency

LIQUIDDate 9-26-41

Laboratory No.

For Use on

Cost Classification

Code Number	One Gallon Batch			Gallon Batch			Gallon Batch			Manufacturing Specifications
	Pints	Lbs.	Ozs.	Cals.	Lbs.	Ozs.	Cals.	Lbs.	Ozs.	
<u>W 133</u>			<u>3</u>							Grind <u>A</u>
<u>W 69</u>			<u>13</u>							Kind of Mill <u>STONE</u>
<u>BL 16</u>		<u>1</u>	<u>8</u>							Strainer
<u>W 11</u>		<u>1</u>								Weight per Gallon <u>10.4</u>
<u>VM 308</u>			<u>1</u>							Light Baume Temp.
										Heavy Baume Temp.
<u>V 706 S</u>	<u>4</u>									Viscosity <u>110-120</u> Temp.
										Viscosimeter
<u>V 318 A</u>	<u>4</u>									Flash Point
										Is Agitator Required
<u>D 29</u>			<u>2.519.02.50 GAL</u>							Remarks
<u>D 2A</u>			<u>1 " " "</u>							
										<u>MATCH PORCELAIN</u>
										<u>PANEL</u>
<u>GRIND IN V 706 S</u>										
<u>CHANGED BECAUSE V 850 NOT AVAILABLE</u>										
Yield										<u>HAYWARD</u>

GLD059558

COST DEPARTMENT RECORD

Grade Rich Blue Japalac En. (Temp.)

Consistency Liquid

For Use on

Customer

Date 12-1-41

Classified Formula No. Y-1246-B

Laboratory Formula No. TEMP.

Factory Letter No.

Production No.

Cost Classification

Ingredient Code Number	Lab'y Formula	Large Batch		Do not write in these columns For Cost Department Use Only						Manufacturing Specifications
		Pounds	Gallons							
87-A-3		96								Grind <u>M.x</u>
87-W-77		256								Kind of Mill
87-A-51		4								Strainer
2-KB-74			44							Weight per Gallon <u>9.3</u>
RVL-1273			16							Light Baume Temp.
S-43 (hold)			4							Heavy Baume Temp.
D-40			1							Viscosity <u>120-130</u> Temp. <u>80°F</u>
CH-189 (Sub.)			12 lb. oz.							Viscosimeter <u>4</u> Ford Cup
										Flash Point
This Formula For										Is Agitator Required <u>Yes</u>
small batches only.										
										Formulator <u>W. B. Davis</u>
Yield										

GLD059560

Characteristics and Method of Using		Cost Data				Remarks
Type of Goods		Date	Bulk Cost	Date	Bulk Cost	
Type of Goods	A.D. Enamel					Reformulated to
Color	Rich Blue					match standard panel
Finish	Gloss					more closely.
Match for	Pure Panel					
Kind of Reducer						
Amount of Reducer	Brushing	F.B.				
	Spraying					
	Dipping					
	Floccing					
	Tumbling					
Air dry to recoat						
To Sand or Rub						
Bake Time	Temp.					
Rub with						
Polish with						
Schedule						
COOL DEVELOPMENT RECORD						

GLD059561

PRINTED IN U.S.A. (A CO.)

COST DEPARTMENT RECORD

Rich Blue Japalac Enamel (Temp.)

Classified Formula No. Y-1241

Laboratory Formula No. (Temp.)

Consistency Unmixed

Date 12-3-41

Factory Letter No.

For Use on

Production No.

Quantity

Cost Classification

Ingredient Code Number	Lab'y Formula	Large Batch		Do not write in these columns For Cost Department Use Only						Manufacturing Specifications
		Pounds	Gallons							
W-77		176								Grind <u>A</u>
BL-53		34								Kind of Mill <u>Stone</u>
BL-S1		1								Strainer
2-KB-74		44								Weight per Gallon
RVL-1273		16								Light Boume <u>Temp.</u>
S-43		4								Heavy Boume <u>Temp.</u>
D-46		$\frac{3}{4}$								Viscosity <u>1'20"-1'30" Temp 80°F</u>
SH-189 (S.b.)		103								Viscosimeter <u>#4 Ford Cup</u>
										Flash Point
										Is Agitator Required
Use this formula for large batches only. Use the mix for small batches.										Formulator <u>W. Burns</u>
Field										

GLD059562

Characteristics and Method of Using		Cost Data				Remarks
Type of Goods		Date	Bulk Cost	Date	Bulk Cost	
Type of Goods	A. D. Enamel					
Color	Rich Blue					
Luster	Gloss					
Match for	Pure Enamel					
Kind of Reducer						
Amount of Reducer	Brushing F.B.					
	Spraying					
	Dipping					
	Flacoing	Analysis				
	Tumbling					
For dry to recoat						
To Sand or Rub						
Bake Time	Temp.					
Rub with						
Polish with						
Schedule						
COPI OF ENAMEL RECORD						

GLD059563

FORM 100-100 PRINTED IN U.S.A. 1941

FORMULA RECORD

Goods *Supracor Enamel Rich Blue*

Formula No. *712463*

Consistency *Thick*

Date *2/24/41*

Laboratory No.

For Use on

Cost Classification

Code Number	One Gallon Batch			Gallon Batch			Gallon Batch			Manufacturing Specifications
	Pints	Lbs.	Oz.	Gals.	Lbs.	Oz.	Gals.	Lbs.	Oz.	
<i>W133</i>			<i>3</i>	<i>2.7</i>						Grind <i>R</i>
<i>W169</i>			<i>13</i>							Kind of Mill <i>Stone</i>
<i>W176</i>		<i>1</i>	<i>8</i>							Strainer
<i>W176</i>		<i>1</i>								Weight per Gallon <i>12</i>
<i>W1308</i>			<i>1</i>	<i>1.6</i>						Light Baume Temp.
<i>V850</i>	<i>3 3/4</i>									Heavy Baume Temp.
<i>V318</i>	<i>3 3/4</i>									Viscosity <i>20-100</i> Temp.
<i>S143</i>	<i>1/2</i>									Viscosimeter
										Flash Point
										Is Agitator Required
<i>839</i>			<i>1</i>	<i>1/2</i>	<i>1/2</i>	<i>1/2</i>				Remarks <i>Thick</i>
<i>8217</i>			<i>1</i>	<i>1/2</i>	<i>1/2</i>	<i>1/2</i>				<i>W</i>
<i>8357</i>		<i>Ind.</i>								<i>1/2</i>
<i>8373</i>			<i>3</i>	<i>1/2</i>	<i>1/2</i>	<i>1/2</i>				<i>Match Porcelain</i>
<i>87644</i>			<i>1</i>	<i>1/2</i>	<i>1/2</i>	<i>1/2</i>				<i>Pure</i>
<i>Grind in V.P. 50</i>										
Yield				<i>Changed to New Supracor quality</i>						

DISCONTINUED

SEE 712463

GLD059564

Characteristics and Method of Using		Cost Data				Customers
Type of Goods						
Color						
Luster						
Match for						
Kind of Reducer						
Amount of Reduction for						
Brushing						
Spraying	Pressure					
Dipping	Drip Time	Pigment Analysis 34				
Floccing	Drip Time	Vehicle 66				
Tumbling		100				
Air dry to recoat		Pigment				
To Sand or Rub		Titanated Lithopone				28.0
Bake Time	Temp.	Ultramarine Blue				40.0
Rub with		Magnesium Silicate				27.0
Polish with		Prussian Blue				5.0
Schedule						100%
		Vehicle				
		Elastic Varnish				100%

GLD059565

Goods Rich Blue. Japalan Eva.

Formula No. _____

V1246

Consistency

John

Date 6/12-33

Laboratory No.

For Use on

Cost Classification

GLD059566

Characteristics and Method of Using		Con Data			Customers
Type of Gnech					
Color					
Luster					
Match for					
Kind of Reducer					
Amount of Reduction for					
Brushing					
Spraying	Pressure				
Dipping	Drip Time	Pigment Analysis	34%		
Floccing	Drip Time	Vehicle	66%		
Tumbling			100%		
Air dry to recoat		Pigment:			
To Sand or Rub		Titanolite	28%		
Bake Time	Temp.	Ultramarine Blue	40		
Rub with		Magnesium Silicate	27		
Polish with		Prussian Blue	5%		
Schedule			100%		
		Vehicle:			
		Elastic Varnish	100%		
		Round Caps 1"-1/2" - 1/4" - 1/8" - 1/16" - 1/32"			
		Japanlac Label			

GLD059567