February 26, 1965
NEW FORMULA
Paoli Laboratory

PLAINTIFF'S EXHIBIT
GP-1272

ACME, TEXAS PLANT FORMULA

ALL PURPOSE COMPOUND TEX-953

DESCRIPTION OF PRODUCT - Topping Compound for Topping joints and spotting nailheads; shipped into Chicago market.

FORMULA

Raw Materials	Source	R. M. Spec.	%	LBS/BATCH
Vancide 51Z	R. T. Vanderbilt	126	0.075	1.5
Petro - AD	The Thornley Co.	143	0.10	2.0
Natrosol 250 HYR (Fine Grind)	Hercules Powder		0.30	6.0
Zinc Oxide	Mallinkrodt Co.	119	0.35	7.0
Soda Ash	Open Market	32	0.40	8.0
Borax	Open Market		0.15	3.0
Casein 100M	International Casein Co.	10	4.3	86.0
Asbestos 7RF9	Phillip Carey	9	5.5	110.0
Mica P80H	Western Mica Co.	11	16.0	320.0
Nalco 71-D5	Nalco Chemical Co.		0.025	0.5
Limestone (Purestone)	Purestone Co.	13	72.8	1456.0
			100.000	2000.0

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32

Specifications:	Maximum	Minimum	Average
	72	64	68

ALKALINITY - Refer to Plant Testing Procedure No. 34

pH Specifications:	Maximum	Minimum	Average
	9.2	8.6	8.9

Minimum soda ash content - 0.40%

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: Dried compound should be a neutral color and match the standard sample.

April 20, 1965
Supersedes Formula No. TEX-953
Dated Feb. 26, 1965

ACME, TEXAS PLANT FORMULA

ALL PURPOSE COMPOUND TEX-953

-/ DESCRIPTION OF PRODUCT - All Purpose Compound for taping, topping joints, and spotting nailheads and texturing.

-/ FORMULA

Raw Materials	Source	R.M. Spec.	%	Lbs./Batch	
Vancide 51Z	R. T. Vanderbilt	126	0.075	1.5	.15
Petro - AD	The Thornley Co.	143	0.10	2.0	.20
Natrosol 250 HXR (Fine Grind)	Hercules Powder	170	0.30	6.0	.60
Zinc Oxide	Mallinkrodt Co.	119	0.10	2.0	.20
Soda Ash	Open Market	32	0.40	8.0	.80
Borax	Open Market		0.15	3.0	.30
Casein 100M	International Casein Co.	10	4.5	90.0	9.0
Asbestos 7RF9	Phillip Carey	9	5.5	110.0	11.0
Mica P80H	Western Mica Co.	11	16.0	320.0	32.0
Nalco 71-D5	Nalco Chemical Co.		0.025	0.5	.05
~~Limestone~~ (Purestone)	Purestone Co.	13	72.85	1457.0	145.7
			100.000	2000.0	200 jars

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

Specifications:	Maximum	Minimum	Average
	72	64	68

ALKALINITY - Refer to Plant Testing Procedure No. 34.

pH Specifications:	Maximum	Minimum	Average
	9.2	8.6	8.9

Minimum soda ash content - 0.40%

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: Dried compound should be a neutral color and match the standard sample.

-/ Denotes change in this reissue.

Cost ~~61.64~~ / ton for R.M.
61.80

8-3-66
(52.36)

SGP 0017201

April 9, 1969
Supersedes Formula No. TEX- 95
Dated 4/20/65

43# per cu ft

ACME, TEXAS PLANT FORMULA

ALL PURPOSE COMPOUND TEX - 953

DESCRIPTION OF PRODUCT - All Purpose Compound for taping, topping joints, and spotting nailheads and texturing.

-/ FORMULA

Raw Material	Function	R.M. Spec.	%	Lbs./Batch
Vancide 51Z	Fungicide	126	0.075	1.5
Petro AD	Wetting Agent	143	0.10	2.0
Natrosol 250 HXR (Fine Grind)	Water Retention Agent	170	0.30	6.0
Zinc Oxide	Viscosity Stabilizer	119	0.10	2.0
Soda Ash	Alkaline Source	32	0.40	8.0
Borax	Alkaline Source		0.15	3.0
Casein 100M	Adhesive	10	4.5	90.0
Asbestos 7RF9	Bulk	9	5.5	110.0
Mica p80H	Anti-Cracking Agent	11	16.0	320.0
Defoamer MIII	Anti-Foaming Agent	196	0.025	0.5
Limestone (Purestone)	Filler	13	72.85	1457.0
			100.000	2000.0

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.
Specifications: - Maximum 72, Minimum 64, Average 68

ALKALINITY - Refer to Plant Testing Procedure No. 34.
pH Specifications: Maximum 9.2, Minimum 8.6, Average 8.9

Minimum soda ash content - 0.40%

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

COLOR -
Specifications: Dried compound should be a neutral color and match the standard sample.

EDON:kgc
-/ Denotes change in this reissue.

SGP 0017202

February 2, 1974
~~April 14, 1972~~
Supersedes Formula No. TEX-952
Dated 11/17/71

5-3-72 38½ # per. cu. ft.

ACME, TEXAS PLANT FORMULA

ALL PURPOSE JOINT COMPOUND FORMULA NO. TEX-953 ~~[illegible]~~

DESCRIPTION OF PRODUCT: - All Purpose compound for taping and finishing joints, spotting nailheads and texturing.

-/ FORMULA:

Raw Material	Function	R.M.Spec.	Percent	Lbs/Batch
Gendriv 492S	Thickner	223	0.30	24.00
Vanicide 51Z	Fungicide	126	0.05	4.00
Gelvatol 6278C	Adhesive	126	1.75	140.00
~~Gelva OP702~~ attagel	Adhesive	161	1.00	80.00
Asbestos ~~7R9~~ S6210	Fiber Filler	9	7.00	~~560~~ 00 200
Mica p80-H	Anti-Cracking Agent	11	5.00	400.00
Defoamer M117	Anti-Foaming Agent	-	0.10	8.00
Land Plaster TEX-25	Filler	-	84.80	~~6784~~ 00 7144
			100.00	8000.00

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

Specifications:

Maximum	Minimum	Average
62	58	60

WORKING PROPERTIES: - Refer to Plant Testing Procedure No. 33.
Specifications
Wet mix shall be plastic and buttery working and 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: - There shall be at most only a couple of very small cracks in the wedge.

COLOR: - White
Specifications
Dried compound shall not vary in color from preceding batches.

-/ Denotes change in this reissue.

EDO:dek

SGP 0017203

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.

FORMULA	Function	RM Spec	Percent	Lbs/Batch
Gendriv 492S	Thickner	223	0.30	24.00
Vanicide 51Z	Fungicide	126	0.05	4.00
Gelvatol 5000	Adhesive	126	1.75	140.00
Attagel 40	Fiber Filler	161	1.00	80.00
Asbestos 7G 210	Fiber Filler	9	2.50	200.00
Mica p80-d	Anticracking agent	11	5.00	400.00
Defoamer M117	Antifoaming agent	--	0.10	8.00
Land Plaster TEX-25	Filler	--	89.30	7144.00
			100.00	8000.00

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

Specifications:	Maximum	Minimum	Average
	62	58	60

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications: Wet mix shall be plastic and buttery working and 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 - There shall be at most only a couple of very small cracks in the wedge.

COLOR - White
Specifications: Dried compound shall not vary in color from preceeding batches.

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

WNG:elz

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.

-/FORMULA	Function	RM Spec	Percent	Lbs/Batch	
Sorbitol	Boron Stabilizer	--	.50	40.00	10
Gendriv 492S	Thickner	223	0.30	24.00	6
Vanicide 51Z	Fungicide	126	0.05	4.00	
Gelvatol 6000	Adhesive	126	1.75	140.00	35
Attagel 40	Fiber Filler	161	1.00	80.00	20
Asbestos SG 21C	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	--	88.8	7104.0	1776
			100.00	8000.00	2000.0

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

Specifications:	Maximum	Minimum	Average
	62	58	60

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications: Wet mix shall be plastic and buttery working and 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 - There shall be at most only a couple of very small cracks in the wedge.

COLOR - White
Specifications: Dried compound shall not vary in color from preceeding batches.

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

-/ denotes change

WNG:jg

SGP 0017199

ACME FORMULA #953
ASBESTOS CONTAINING PRODUCTS