4-180-0 50m 1-35

FORMULA RECORD

Goods Rich Blue Japalac Ena. Formula No. V1246

Consistency Enfield Date 6/12-35 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.	
V 109	3½						42			Grind
V 114	1½						18			Kind of Mill
V 706	½						24			Strainer
V 202 R	1						12			Weight per Gallon
										Light Bayme Temp.
32 H	15g						3¼			Heavy Baume Temp.
										Viscosity Temp.
W 93		1					96 #			Viscosimeter
BL 16		1	8				144 #			Flash Point
W 11		1					96 #			Is Agitator Required
										Remarks
26 B 3	Trace									Shows as a pure
93 R 3			3				21 #	18		shade of Rich
6 T 46			1				7 #	6		Blue Japalac &
										must be matched
			DISCONTINUED							to new Standard
			SEE							JPW
Yield										

N12388

GLD060222

FORMULA RECORD

Goods Cobalt Enamel Rich Blue Formula No. V1465

Consistency Liquid Date 3/24/41 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.	
V133			3	20						Grind Ball
V169			13	1						Kind of Mill Stone
3L16		1	8							Strainer
V11		1								Weight per Gallon 10.4
CM308			1	Vc						Light Baume Temp.
										Heavy Baume Temp.
V850	3¾									Viscosity 20-130 Temp.
V318	3¾									Viscosimeter
543	½									Flash Point
										Is Agitator Required
V29			2	Tolerance						Remarks Hayward
V27			1							Thin
										Run
V337		Scant								
V283			3	Good						Metal Lacker
V606			1							Panel
Grind in V850										
Yield				Charged to Mfg. Labor (guide)						

DISCONTINUED
SEE V2463

GLD060223

COST DEPARTMENT RECORD

Good R&K Blue Japan Enamel (Temp.) Classified Formula No. Y-246-B

Crossley Laboratory Laboratory Formula No. (Temp.)

For Use of Date 12-3-41 Factory Lattice No.

Customer Product No.

Cost Classification

Invoiced Code Number	Laboratory Formula	Large Batch Pounds	Gallons	Do not write in these columns For Cost Department Use Only	Manufacturing Specifications	Grade	A
W-27		136				Kind of Mill	Stone
BL-53		34				Source	
BL-51		1					
2-KB-74		44				Weight per Gallon	
BV-121-3		6				Light Base	Tint
2-43		4				Heavy Base	Tint
0-40		34				Viscosity	20-150 cps. Brkf.
GH-89(S16)		63½				Viscosity	2.4 Ford Cup
						Flash Point	

COST DEPARTMENT RECORD

Grade Rich Blue Jasmine Eau (Temp) Checked Formula No. Y-1246-R

Conditioning Period Date 12-1-41 Factory Letter No. 12mp

Fat Used In Production No.

Container Cost Classification

Ingredient Code Number	Lab'y Formula	Large Batch Pounds	Large Batch Gallons	Do not write in these columns For Cost Department Use Only	Manufacturing Specifications
87-A-3	96				Grind Mix
87-W-77	256				End of Mill
87-A-51	4				Strainer
2-K-R-14	44				Weight per Gallon 9.7#
RV-1-33	16				Color Brown
S-4-6 (1:10)	4				Heavy Body Thin
D-4-0					Viscosity #4 Ford 60 Sec.
Chrome (5:1)	12				Odor Rose
					Filter Pad
Tube Texture Fat					Filling Method Y-8
Small Tube Cap					Formulator W. Brown
Mica					

GLD060225

Characteristics and Method of Using	Cert. Data					Remarks
Type of Finish: A.D. Enamel	Date	Bulk Coat	Date	Add Coat		Reformulated to water thinned panel
Color: Rich Olive						
Luster: Gloss						
Match for: Pre-Panel						Were closely
Kind of Surface: Roofing F.B.						
Amount of Reduction: Spraying						
Brushing						
Rolling						
Thinning: Ready to use						
As by manufacturer						
To suit purpose						
Base used						
Ratio mix						
Ready mix						
Mixed with						
Solvent						

GLD060226

GLD060227

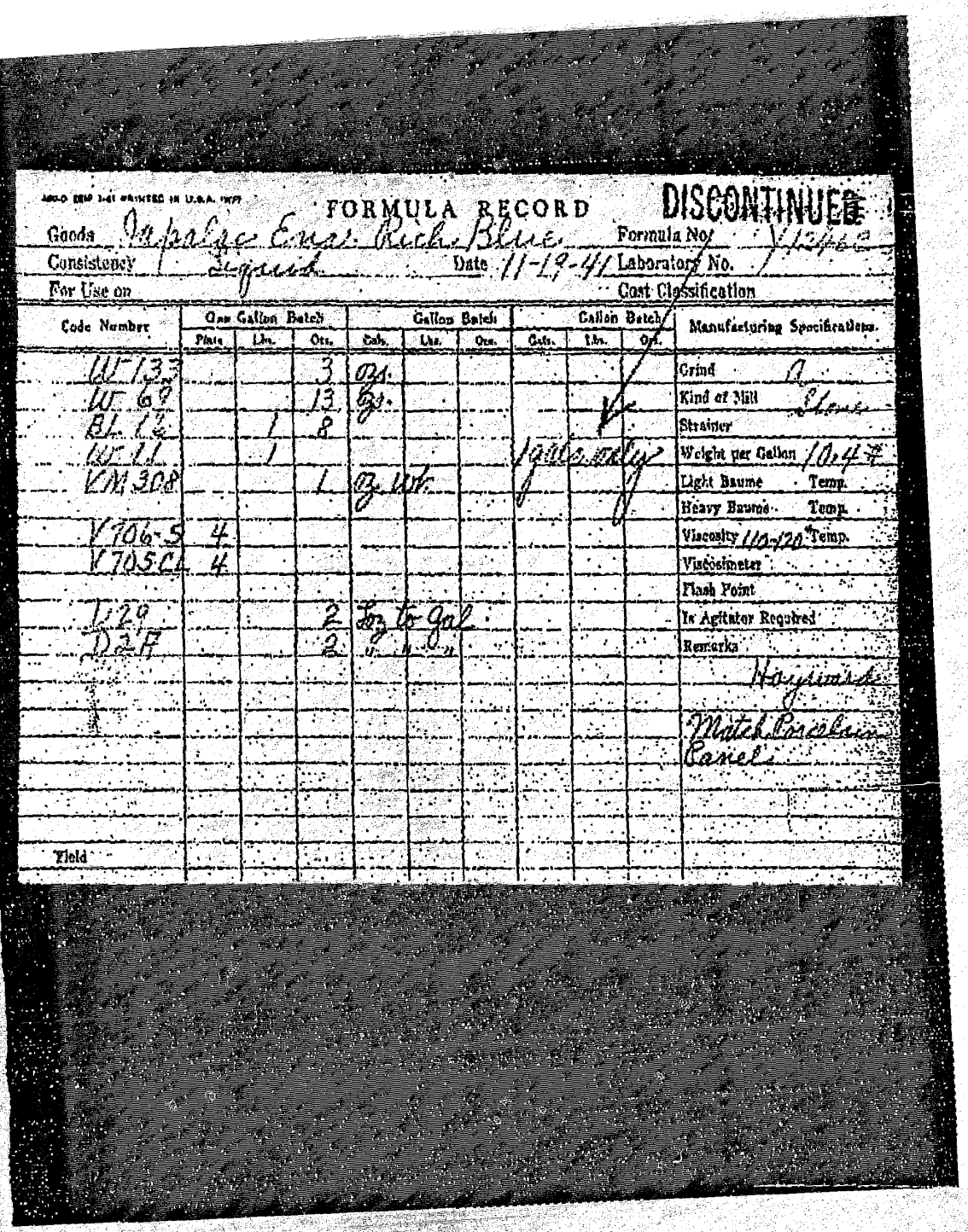
FORMULA RECORD

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

Consistency LIQUID Date 4-26-41 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.	
W 133			3							Grind A
W 69			13							Kind of Mill STONE
BL 16		1	8							Strainer
W 11		1								Weight per Gallon 10 1/4 #
VM 308			1							Light Baume Temp.
										Heavy Baume Temp.
V 706 S	4									Viscosity 70-120" Temp.
										Viscosimeter
V 318 A	4									Flash Point
										Is Agitator Required
D 29			2 1/2 OZ TO GAL							Remarks
D 2A			1 " " "							
										MATCH PORCELAIN
										PANEL
GRIND IN V 706 S										
CHANGED BECAUSE V 706 NOT AVAILABLE										
Yield										HAYWARD



FORMULA RECORD

DISCONTINUED

Goods Japlac Enam. Rich Blue Formula No. 1125

Consistency Liquid Date 11-19-41 Laboratory No.

For Use on Cost Classification

Code Number	One Gallon Batch			Gallon Batch			Gallon Batch			Manufacturing Specifications
	Plate	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	
W 133			3	Qts.						Grind A
W 69			13	Qts.						Kind of Mill Stone
BL 12		1	8							Strainer
W 11		1					Gallon only			Weight per Gallon 10.4#
VM 308			1	Qt. Wk.						Light Baume Temp.
										Heavy Baume Temp.
V 706-5	4									Viscosity 110-120 Temp.
V 705 C	4									Viscosimeter
										Flash Point
L 29			2	Qts to Gal.						Is Agitator Required
D 2 F			2	" " "						Remarks
										Hardware
										Match Porcelain Panel
Yield										

GLD060228

419-D 5CM PRINTED IN U.S.A. (B)

FORMULA RECORD

Goods Lulex Enamel Rich Blue. Formula No. 11349.

Consistency Liquid Date 7-3-43 Laboratory No.

For Use on Cost Classification

Code Number	One Gallon Batch			Gallon Batch			Gallon Batch			Manufacturing Specifications
	Plate	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	Gals.	Lbs.	Ozs.	
W143			3					15		Grind Ball
W69			13					65		Kind of Mill Kaltex
BL16		1	8					120		Strainer
W11		1						80		Weight per Gallon 10.4#
										Light Baume Temp.
V357	6¾						67½			Heavy Baume Temp.
063	⅜						3¾			Viscosity 10-120" Temp.
052	⅜						3¾			Viscosimeter
5104	½						5			Flash Point
										Is Agitator Required
D30			2 Lbs.				17¼			Remarks
D28			2 "				17¼			Hanging
										Match Production
DISCONTINUED Changed to new Satinlac number										Panel
SEE 11262 10/27/43										
Yield										

GLD060229

48-0 30M PRINTED IN U.S.A. (B)

FORMULA RECORD

Goods Interior Enamel Rich Cream Formula No. V1246E

Consistency Liquid Date 10/27/43 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.	
V069	2	1	9					125		Grind R
BL 16		1	8					120		Kind of Mill Stone
W 11		1						80		Strainer
V W 308			1					5		Weight per Gallon 15.5 #
										Light Baume Temp.
V 106 J	4						40			Heavy Baume Temp.
V 10 F 12	4						40			Viscosity 110 120 Temp.
										Viscosimeter #4 Tank
2 H T		1 oz					Trace			Flash Point
										Is Agitator Required
929			2	1/2			1/4			Remarks
924			2	1/2			1/4			Metal Porcelain Panel
DISCONTINUED	Weight Per Gallon Emulsion Only									1911
SEE V1246F										R
3/29/44 S										

GLD060230

GLD060231

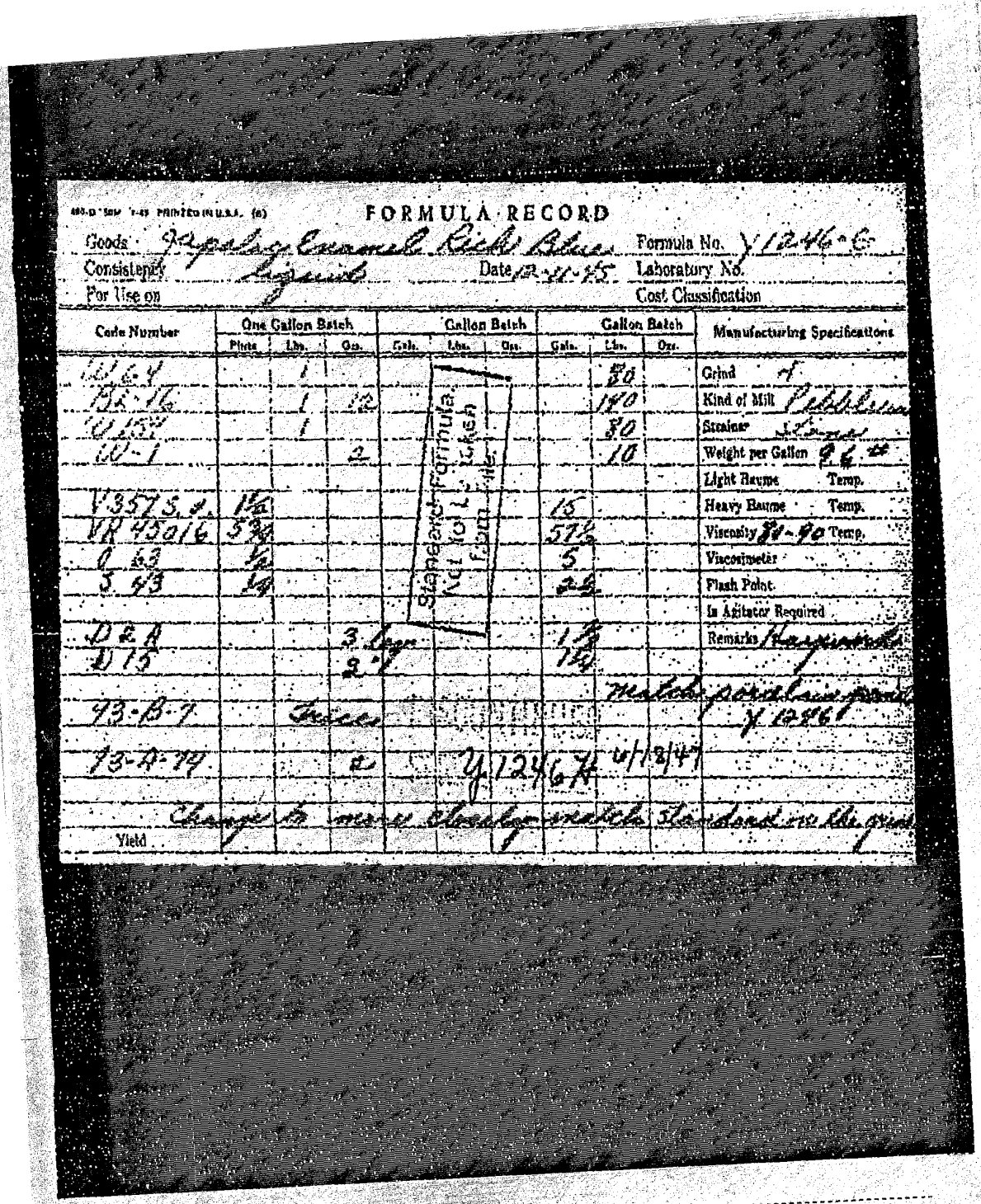
FORMULA RECORD

Good Indian Empire Red Base — Formula No. 4 1246-F

Consigned to Lucas — Date 7-23-45 — Laboratory No.

For Use on — Cost Classification

Code Number	One Gallon Batch Pints	One Gallon Batch Lbs.	One Gallon Batch Ozs.	Gallon Batch Gals.	Gallon Batch Lbs.	Gallon Batch Ozs.	100 Gallon Batch Gals.	100 Gallon Batch Lbs.	100 Gallon Batch Ozs.	Manufacturing Specifications
W69		1	9					125		Grind A
BL-16		1	8					120		Kind of Mill Sarco
W181		1						20		Strainer
W104			2					10		Weight per Gallon 10.6#
										Light Baume Temp.
V357	1½			Use Revised Formula			15			Heavy Baume Temp.
VR46016	5¾			Not to be taken			57½			Viscosity 21-28" Temp.
063	½			from File.			5			Viscosimeter
S43	¼						2½			Flash Point
										Is Agitator Required
VM524		Refer					17½			Remarks Hammond
D6		2 Office					1½			Mill Practice
DISCONTINUED										Same
SEE 4-1246-B										
11-45 Changed Formula per Lucas Ltr.										
Yield										G.P.M.



FORMULA RECORD

Goods: Rayon Covered Cable Blue — Formula No. Y1246-C

Consistency: Liquid — Date 2-11-45 — Laboratory No.

For Use on — Cost Classification

Code Number	One Gallon Batch: Pints	Lbs.	Ozs.	Gallon Batch: Gals.	Lbs.	Ozs.	Gallon Batch: Gals.	Lbs.	Ozs.	Manufacturing Specifications
1164		1						80		Grind 4
1X-16		1	12					140		Kind of Mill Colloid
1159		1						80		Strainer 120 mesh
60-1			2					10		Weight per Gallon 9.6 #
										Light Baume Temp.
Y357 S.A.	1/2						15			Heavy Baume Temp.
VR 4501C	3/4						57½			Viscosity 85-90 Temp.
1163	1/2						5			Viscosimeter
3-43	1/2						2½			Flash Point
										Is Agitator Required
DEA			3.4 gm				1¾			Remarks Experimental
D13			2.7				14			
								Mixed powder pigment		
93-B-1		Trace								Y 1246
73-A-79			2			Y1246K	4/13/45			
Change 5 mesh Stainless steel							Standard Mfg.			
Yield										

Standard formula No. 1 from Wire Color

GLD060232

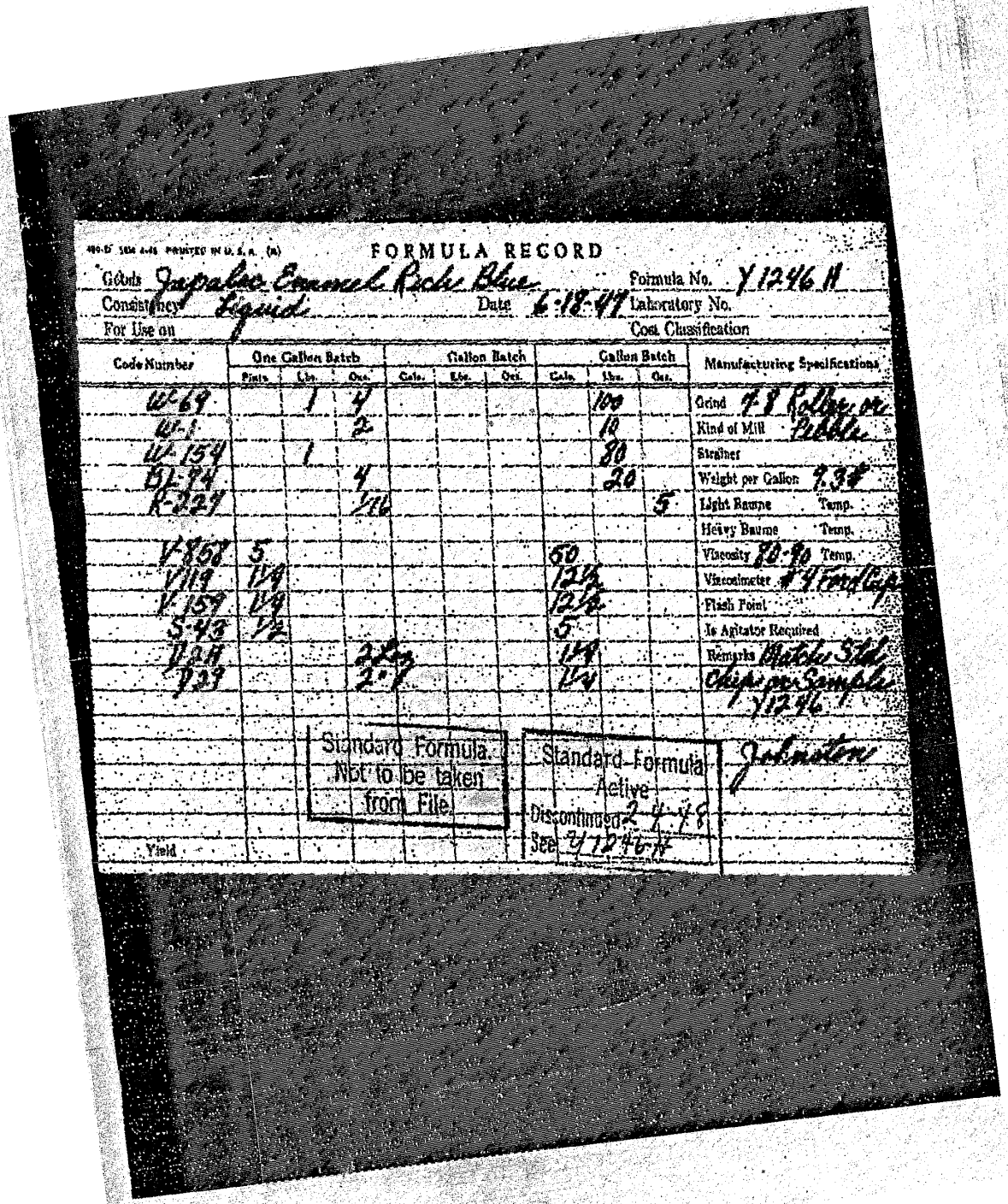
FORMULA RECORD

Gloss
Consistency Japalac Rich Blue Enamel Formula No. Temp. V1246H
For Use on Liquid Date 2-4-48 Laboratory No.
Cost Classification

Code Number	One Gallon Batch Pints	Lbs.	Ozs.	Gallon Batch Gals.	Lbs.	Ozs.	Gallon Batch Gals.	Lbs.	Ozs.	Manufacturing Specifications
W-69		1	4							Grind 7-8
BL-74			4							Kind of Mill Pebble
W-154		1								Strainer
R-227			1/16							Weight per Gallon 9.3#
W-104			2							Light Baume Temp.
										Heavy Baume Temp.
D65A Purple Lac		3 3/16								Viscosity 80-90 Temp.
1240 Aroplaz										Viscosimeter 4 Cup
V-357		4/4								Flash Point
S-43		1/2								Is Agitator Required
D-44			2 oz/gal							Remarks Air Dry 4-6 Hrs. Amts. for brushing Full Body
D-29			2 " "							Match for V1246 Porcelain to recoat in 24 hrs. H.G.H
Yield	Formula to Lbs.			1 Lbs. 12			V1858 is available			

DISCONTINUED
SEE V-1246-A 10/1/49
Standard Formula
Put to Batch
Iron File

GLD060233



FORMULA RECORD

Gloss: Japalac Enamel Roche Blue — Formula No. Y 1246 H

Consistency: Liquid — Date: 6-18-47 — Laboratory No.

For Use on: Liquid — Cost Classification

Code Number	One Gallon Batch Pints	Lbs.	Ozs.	Gallon Batch Gals.	Lbs.	Ozs.	Gallon Batch Gals.	Lbs.	Ozs.	Manufacturing Specifications
W-69		1	4					100		Grind 7-8 Roller or Pebble
W-1			2					10		Kind of Mill
W-154		1						80		Strainer
OL-74			4					20		Weight per Gallon 9.3#
K-229			1/16						5	Light Baume Temp.
										Heavy Baume Temp.
V-857	5						50			Viscosity 80-90 Temp.
V-119	1/4						12½			Viscosimeter #4 Ford Cup
V-159	1/4						12½			Flash Point
S-43	1/2						5			Is Agitator Required
D-24			2 2/3				17½			Remarks Match Std.
D-29			2 1/3				17½			Chip per Sample Y 1246
										Johnston
Yield										

Standard Formula Not to be taken from File

Standard Formula Active

Discontinued 2-4-48

See Y 1246-H

GLD060234

Duplicate Rich Blue Enamel FORMULA RECORD Formula No. Y-1246-I

Consistency Liquid Laboratory No.

Fineness Coal Chart Date 6/1/48

Customer Shatter Grind 7-B

Mill Pebble Wt. or Sp. 9-1/2#

Code Number	One Gallon Batch		Large Batch		
	Pints	Lbs.	Ozs.	Gals.	Lbs.
V-69	1		4		100
BL-74			4		20
V-154	1				80
R-827			3/16		15 oz
V-104			2		10
N-333			1		5
CL-183			1/2		2-1/2
Y-872	3-1/2			35	
V-357	4-1/4			42-1/2	
B-43	1/8			1-1/4	
S-90	1/8			1-1/4	
V-129	2 Lbs/Gal.			1-1/4	
V-175	2 " "			1-1/4	
CL-243	1/8 " "			1-1/4	

1 1/2 oz. Ammonia

Add 1 oz. Ammonia

Change to new quality V-877 Shatter Formula

DISCONTINUED Discontinued

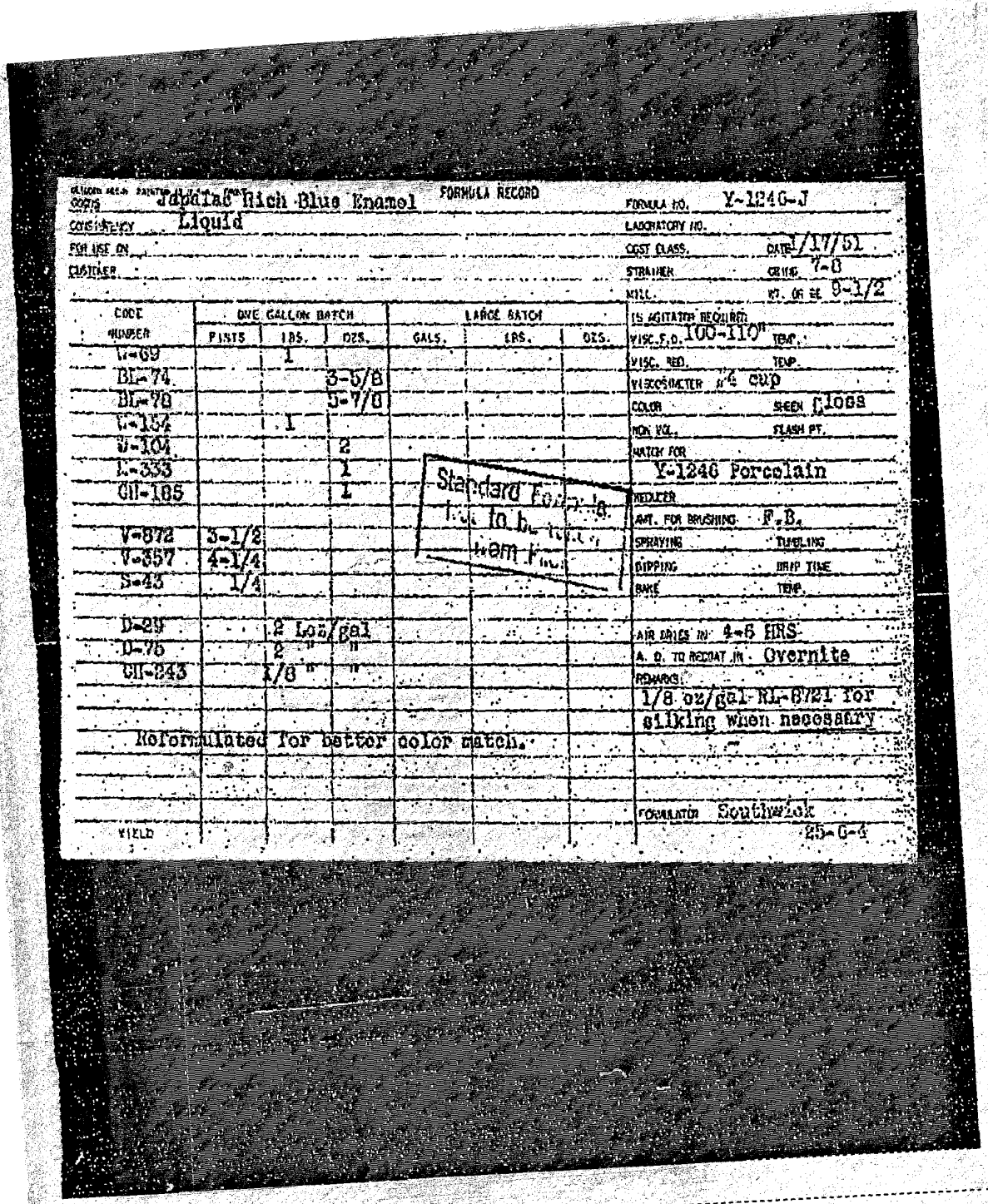
SEE Discontinued

Yield SEE

Remarks:

Printed in U.S.A.

GLD060235



FORMULA RECORD

DUCO AND DULUX PAINTS

DUPONT Jdpdtac Rich Blue Enamel

COATS

CONSISTENCY Liquid

FOR USE ON

CUSTOMER

FORMULA NO. Y-1246-J

LABORATORY NO.

COST CLASS. DATE 1/17/51

STRAINER CHING Y-8

MILL WT. OR GAL 9-1/2

CODE NUMBER	ONE GALLON BATCH PINTS	LBS.	OZS.	LARGE BATCH GALS.	LBS.	OZS.
W-69		1				
BL-74			3-5/8			
BL-78			5-7/8			
W-154		1				
U-104			2			
L-333			1			
GH-185			1			
V-872	3-1/2					
V-357	4-1/4					
S-43	1/4					
D-29		2 Loz/gal				
D-75		2 " "				
GH-243		1/8 " "				

Reformulated for better color match.

YIELD

Standard Formula to be used from item #

IS AGITATOR REQUIRED

VISC. F.O. 100-110" TEMP.

VISC. REQ. TEMP.

VISCOSIMETER #4 cup

COLOR SHEEN Gloss

NON VOL. FLASH PT.

MATCH FOR Y-1246 Porcelain

REDUCER

APP. FOR BRUSHING F.B.

SPRAYING TUMBLING

DIPPING DRIP TIME

BAKE TEMP.

AIR DRIES IN 4-6 HRS.

R. O. TO RECOAT IN Overnite

REMARKS: 1/8 oz/gal RL-8721 for silking when necessary

FORMULATOR Southwick 25-6-4

GLD060236

MIXING INSTRUCTIONS

Jaguar Rich Blue Enamel — FORMULA RECORD

FORMULA NO. Y-7248-K

DATE 2/20/51

DATE 7-8

DATE 9-1/2

CONSISTENCY	Liquid
COLLOID	
CLOTHER	
LABORATORY NO.	
COST CLASS	
STRAINED	
MILL	
U.S. STANDARD REQUIRED	100-110
WISC. F. RED	TSP.
VISCOSIMETER #4 Cup	SECONDS 108
COLOR	CRUSH PT.
MATCH FOR	Y-1245 Porcelain
REDUCER	
BRUSHING	TUBBING
DIPPING	DIP TIME
BASE	TSP.
AIR DRIES IN	4-6 HRS.
O. D. TO RECOAT IN	6 HOURS
REMARKS	1/8 Oz/Gal RL-8721
	1 Oz = Slight Wash
	Recommend.
	Gallons Southlok
	25-6-4

CODE NUMBER	ONE GALLON BATCH PINTS	LBS.	OZS.	LARGE BATCH GALS.	LBS.	OZS.
M-69	1	4		100		
BL-74		4		80		
R-227			5/16		8	
W-154		1		80		
W-104		2		10		
M-833		1			5	
CH-185			3/4		3	12
Y-872	5-1/2			83		
Y-357	4-1/4			82-1/2		
S-43	1/4			2-1/8		
D-29	2 Loz/Gal			1-1/4		
D-75	2 Loz/Gal			1-1/4		
CH-243 1/	1/8 Loz/Gal				10 Loz	
RL-8721	1/4				10	
	Grind					
	"T" Formula with Rubber match to					
	color standard.					
	YIELD					

GLD060237

COST	DATE	ANALYSIS		CUSTOMERS Y-1246K
		PIGMENT 25.7 %		
		VEHICLE 74.3 %		
		100.0%		No. 1 Cans
				12½ Red Yellow
		PIGMENT		
		Lithopone	47.5%	
		C.P. Iron Blue	9.4	
		Alizarine Lake	.3	
		Calcium Carbonate	38.3	
		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%		
		Y1246 158		

GLD060238

GLD060239

FORMULA RECORD

GOODS: Janalac Rich Blue Enamel
CONSISTENCY: Liquid
FOR USE ON:
CUSTOMER:

FORMULA NO.: Y-1246-L
LABORATORY NO.:
COST CLASS: DATE 11/12/51
STRAINER: CKNO 7-8
MILL: WT. OR DE 9-1/4#

CODE NUMBER	ONE GALLON BATCH PINTS	LBS.	OZS.	LARGE BATCH GALS.	LBS.	OZS.
W-69		1	4		100	
BL-74			4		20	
R-227			5/16		1	9
W-154		1			80	
W-104			2		10	
M-333			1		5	
GR-185			3/4		3	12
V-872	8-1/2			35		
V-367	4-1/4			42-1/2		
S-43	1/4			2-1/2		
D-89		2 Loz/gal.		1-1/4		
D-75		2 "	"	1-1/4		
GR-869		1/8 "	"			10 Loz
BL-8722		1/8 "	"			10 Loz.
	Analysis Change					
YIELD						

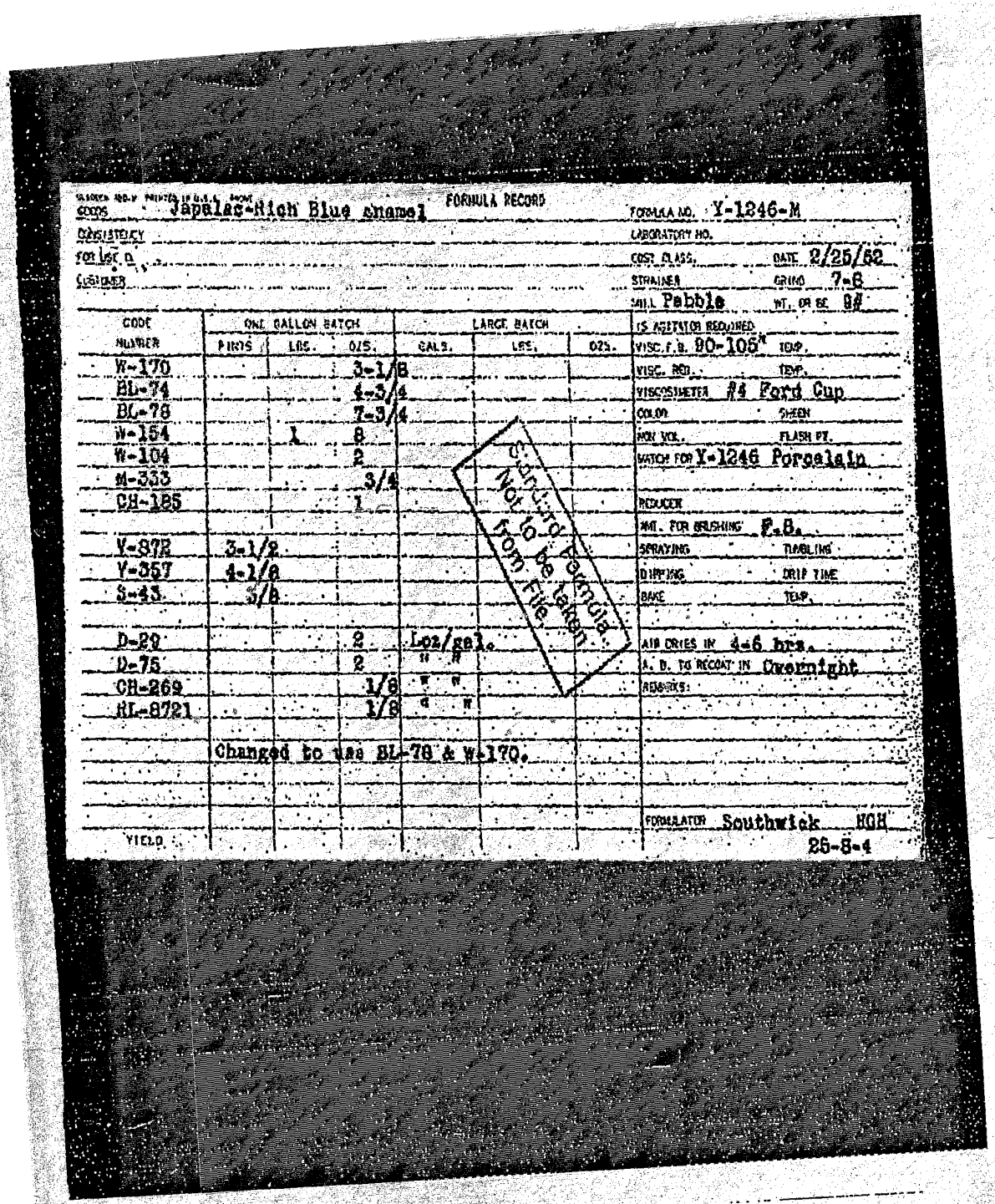
Standard Formula. Not to be taken from File.

IS AGITATOR REQUIRED
VISC. F. H. 100-110" TEMP.
VISC. RED. TEMP.
VISCOSIMETER #4 Ford Cup
COLOR SHEEN Gloss
NON VOL. FLASH PT.
MATCH FOR Y-1246 Porcelain
REDUCER
ADT. FOR BRUSHING F. B.
SPRAYING TUMBLING
DIPPING DRIP TIME
BAKE TEMP.
AIR DRIES IN 4-6 hrs.
A. D. TO RECOAT IN Overnite
REMARKS:

FORMULATOR Southwick H.G.H.
25-6-4

COST	DATE	ANALYSIS	CUSTOMERS Y-1246-L
		PIGMENT 25.7	Japalac
		VEHICLE 74.3	1235 Rich Blue
		100.0 %	11/18/51
			Ellis Bowles 12-4-51
		PIGMENT	
		Lithopone 17.5 %	
		C.P. Iron Blue 9.4	
		Alizarine Lake .3	
		Calcium Carbonate 38.2	
		Basic Lead Carbonate 4.6	
		100.0 %	
		VEHICLE	
		a Varnish 94.6 %	
		Mineral Spirits 2.5	
		Liquid Drier 2.9	
		100.0 %	
		a Non-Vol. (Alkyd Resin, P.E.	
		Beta, dum, Tung, Linseed Oil) 54.6 %	
		Volatile (Mineral Spirits) 45.4	
		100.0 %	
	Y-1846	1511	

GLD060240



GOODS Japalac-High Blue Enamel — FORMULA RECORD — FORMULA NO. Y-1246-M

CONSISTENCY — LABORATORY NO.

FOR USE ON — COST CLASS — DATE 2/25/62

CUSTOMER — STRAINER — GRIND 7-8

SKILL Pebble — WT. OR SP. GR.

IS AGITATOR REQUIRED

VISC. F.S. 90-105" 100°

VISC. RED. — TEMP.

VISCOSIMETER #4 Ford Cup

COLOR — SHEEN

NON VOL. — FLASH PT.

BATCH FOR Y-1246 Porcelain

REDUCER

WT. FOR BRUSHING F.S.

SPRAYING — TUMBLING

DIPPING — DRIP TIME

BAKE — TEMP.

AIR DRIES IN 4-6 hrs.

A. D. TO RECOAT IN Overnight

REMARKS:

CODE NUMBER	ONE GALLON BATCH PINTS	LBS.	OZS.	LARGE BATCH GALS.	LBS.	OZS.
W-170			3-1/8			
BL-74			4-3/4			
BL-78			7-3/4			
W-154		1	8			
W-104			2			
M-333			3/4			
CH-185			1			
V-372	3-1/2					
V-357	4-1/8					
S-43	3/8					
D-29			2	Loz/gal.		
D-75			2	" "		
CH-269			1/8	" "		
BL-8721			1/8	" "		

Changed to use BL-78 & W-170.

Original Formula NOT to be taken from File

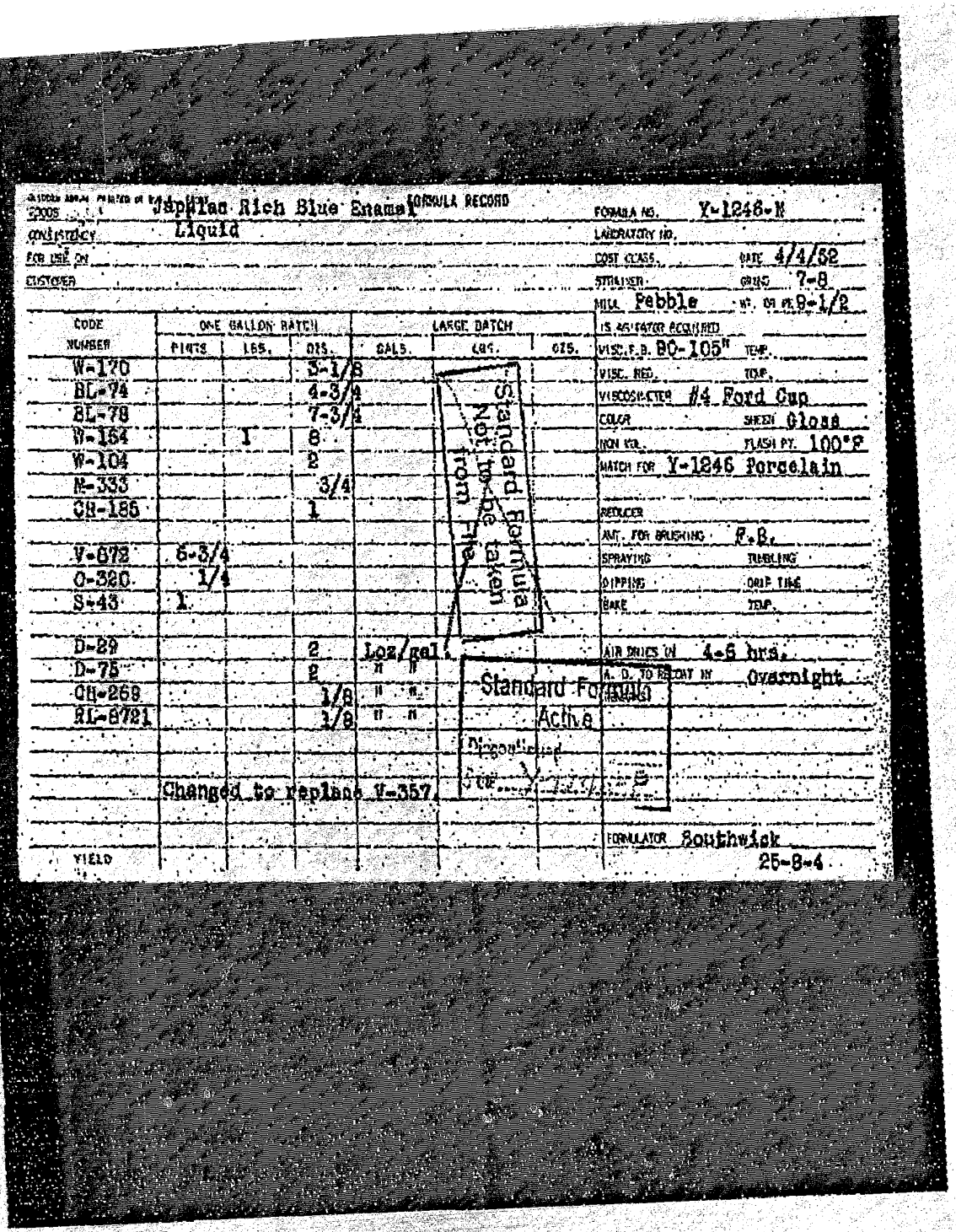
FORMULATOR Southwick HOH

YIELD 26-8-4

GLD060241

COST	RATE	ANALYSES		CUSTOMERS
		PIGMENT 24.8 %		All Plants 2-22-52
		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	94.5%	
		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-1646	252	

GLD060242



FORMULA RECORD

GOODS: Japanese Rich Blue Enamel — 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 PT.: 8-1/2

IS AGITATOR REQUIRED:

VISC. F.B.: 80-105" — TEMP.:

VISC. REQ.: — TEMP.:

VISCOSIMETER: #4 Ford Cup

COLOR: — SHEEN: Gloss

NON VOL.: — FLASH PT.: 100°F

MATCH FOR: Y-1246 Porcelain

REDUCER:

ADT. FOR BRUSHING: K.B.

SPRAYING: — TUMBLING:

DIPPING: — DRIP TIME:

BAKE: — TEMP.:

AIR DRIES IN: 4-6 hrs.

A. D. TO RECOAT IN: Overnight

CODE NUMBER	ONE GALLON BATCH: PINTS	LBS.	OZS.	LARGE BATCH: GALS.	LBS.	OZS.
W-170			3-1/8			
BL-74			4-3/4			
BL-78			7-3/4			
W-164		1	8			
W-104			2			
M-333			3/4			
CH-186			1			
V-672	6-3/4					
O-320	1/4					
S-43	1					
D-29			2	1oz/gal.		
D-75			2	" "		
CH-269			1/8	" "		
BL-8721			1/8	" "		

Standard Formula Not to be taken from File

Standard Formula Active

Discontinued 19__

Changed to replace Y-357

FORMULATOR: Southwick

YIELD: 25-8-4

GLD060243

FORMULA RECORD

CODE: JAPALAC ENAMEL - RICH BLUE
CONSISTENCY: Liquid
FOR USE ON
CUSTOMER

FORMULA NO.: T-1246-R (Rdg.)
LABORATORY NO.
COST CLASS: X DATE: 11-12-57
STRAINER: X GRIND: 7-8
MILL: Pebble WT. OR SP. GR.: 8.6#

CODE NUMBER	50# GALLON BATCH PINTS	LBS.	OZS.	LARGE BATCH GALS.	LBS.	OZS.
N-170					15.8	
BL-74					21.1	
R-227					1.6	
W-154					104	
K-333					5.8	
CH-185					4.3	
V-872				63.5		
O-320				2.8		
S-40				11.5		
2-KB-564				14.4		
D-29				1.4		
VM-530				.36		
CH-243				.09		
YIELD				102.8 gals.		

IS AGITATOR REQUIRED: X
VISC. F.S. 90-105" TEMP. 80°F
VISC. RED. X TEMP. X
VISCOSIMETER #4 Ford cup
COLOR X SHEEN Gloss
NON VOL. X FLASH Over 80
MATCH FOR New color chip

REDUCER S-43
ANT. FOR BRUSHING T.B.
SPRAYING X TUMBLING X
DIPPING X DRIP TIME X
BAKE X TEMP. X
AIR DRIES IN 4-6 hrs.
A.O. TO RECOAT IN O/N
CATALYST
ANT. OF CATALYST
POT LIFE TEMP.
STABILITY AT 200°F.
STABILITY AT 115°F.
STABILITY AT °F.
REMARKS
FORMULATOR: JFHarner

GLD060244

FORMULA RECORD

FORMULA NO. V-1246-P

DESIGN Japan - Rich Blue Enamel

LABORATORY NO.

CONSISTENCY Liquid

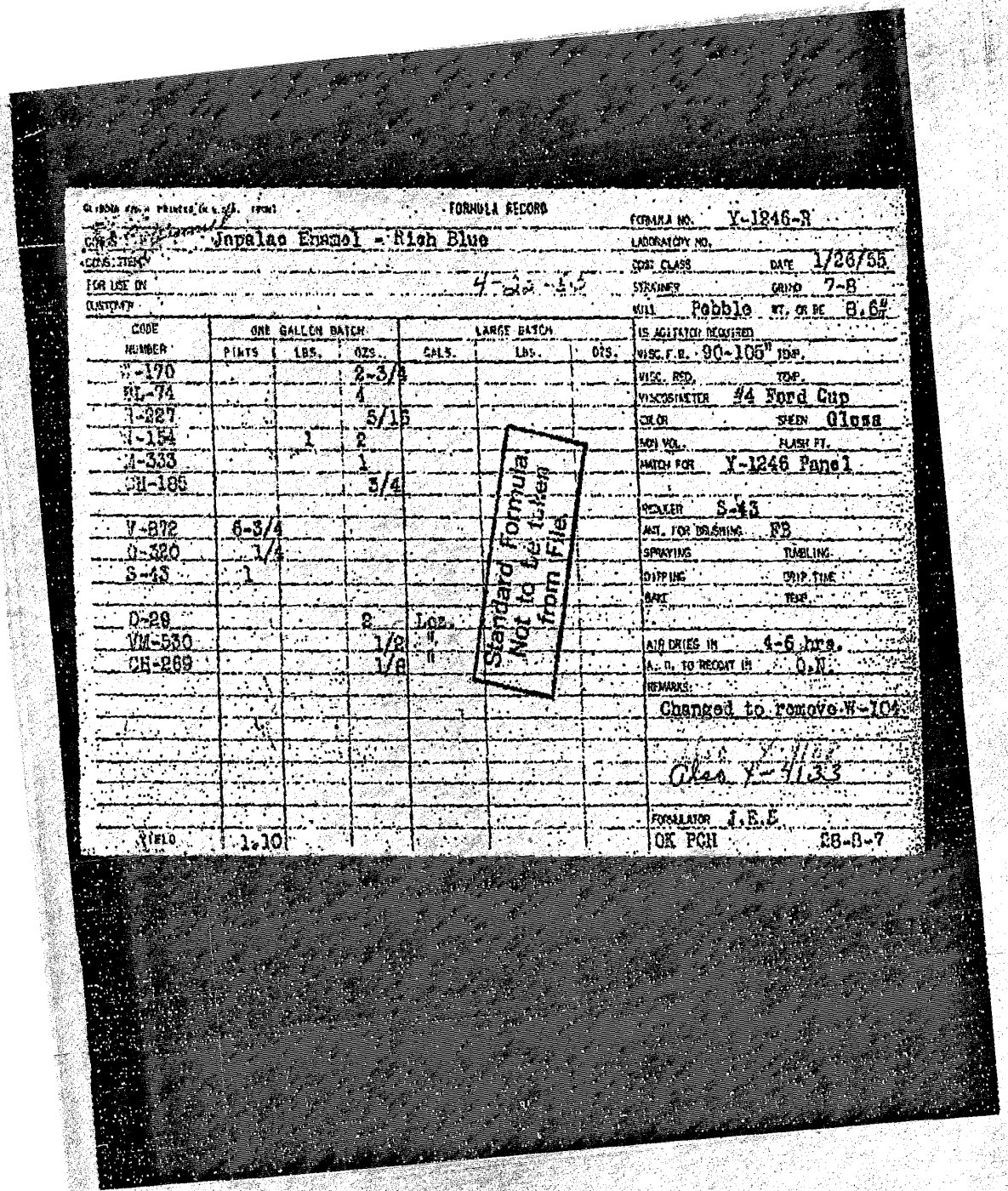
COST CLASS DATE 8/20/53

FOR USE ON

DISTRIBUTED STRAINED Pebble MFT. OR ST. 8, 6#

MILL

CODE NUMBER	ONE GALLON BATCH			LARGE BATCH		US JUSTEEN REQUIRED	
	PRINTS	LBS.	OZS.	GALS.	LBS.	OZS.	VISC. 60-100 SEC. TEMP. 80°F
W-170		2	2/4				VISC. RED. TEMP.
BL-74							VISCOSIMETER #4 Ford Cup
B-227			5/16				COLOR Blue SPEED
W-184	1						MILL VOL. FLASH PT.
W-104		2					WATER PER 1 C.1216 Porcelain
K-333		1	3/4				
GH-186							REDUCER - S-43
							MAT. FOR GRINDING W.B.
Y-872	6-3/4						SCREENING TAILINGS
O-320	1/4						DUSTING DRIP TIME
S-43	1						BAKE TEMP.
D-28		2	Lbs.				AIR DRIED IN 4-6 hrs.
D-75		2					A. D. TO RECOAT IN Overnite
GH-269			1/8				HOURS
							To replace W-69 with
							W-170.



FORMULA RECORD

CUST. Japalac Enamel - Rich Blue

CODE ITEM

FOR USE ON 4-22-55

CUSTOMER

FORMULA NO. Y-1246-R

LABORATORY NO.

CODE CLASS DATE 1/26/55

STRAINER GRIND 7-8

MILL Pebble WT. OR BC 8.6#

IS AGITATOR REQUIRED

VISC. F.B. 90-105" TEMP.

VISC. REQ. TEMP.

VISCOSIMETER #4 Ford Cup

COLOR SHEEN Gloss

NON VOL. FLASH PT.

MATCH FOR Y-1246 Panel

CODE NUMBER	ONE GALLON BATCH PINTS	LBS.	OZS.	LARGE BATCH GALS.	LBS.	OZS.
W-170			2-3/4			
RL-74			4			
T-227			5/15			
T-154		1	2			
T-333			1			
CH-186			3/4			
V-872	6-3/4					
O-320	1/4					
S-43	1					
D-28			8	Lgs.		
VM-530			1/2	"		
CH-269			1/8	"		
YIELD	1.10					

Standard Formula Not to be taken from File

PEELER S-43

AGT. FOR BRUSHING FB

SPRAYING TUMBLING

DIPPING DIP TIME

BAKE TEMP.

AIR DRIES IN 4-6 hrs.

A. D. TO RECOAT IN O.N.

REMARKS:

Changed to remove W-104

Also Y-4133

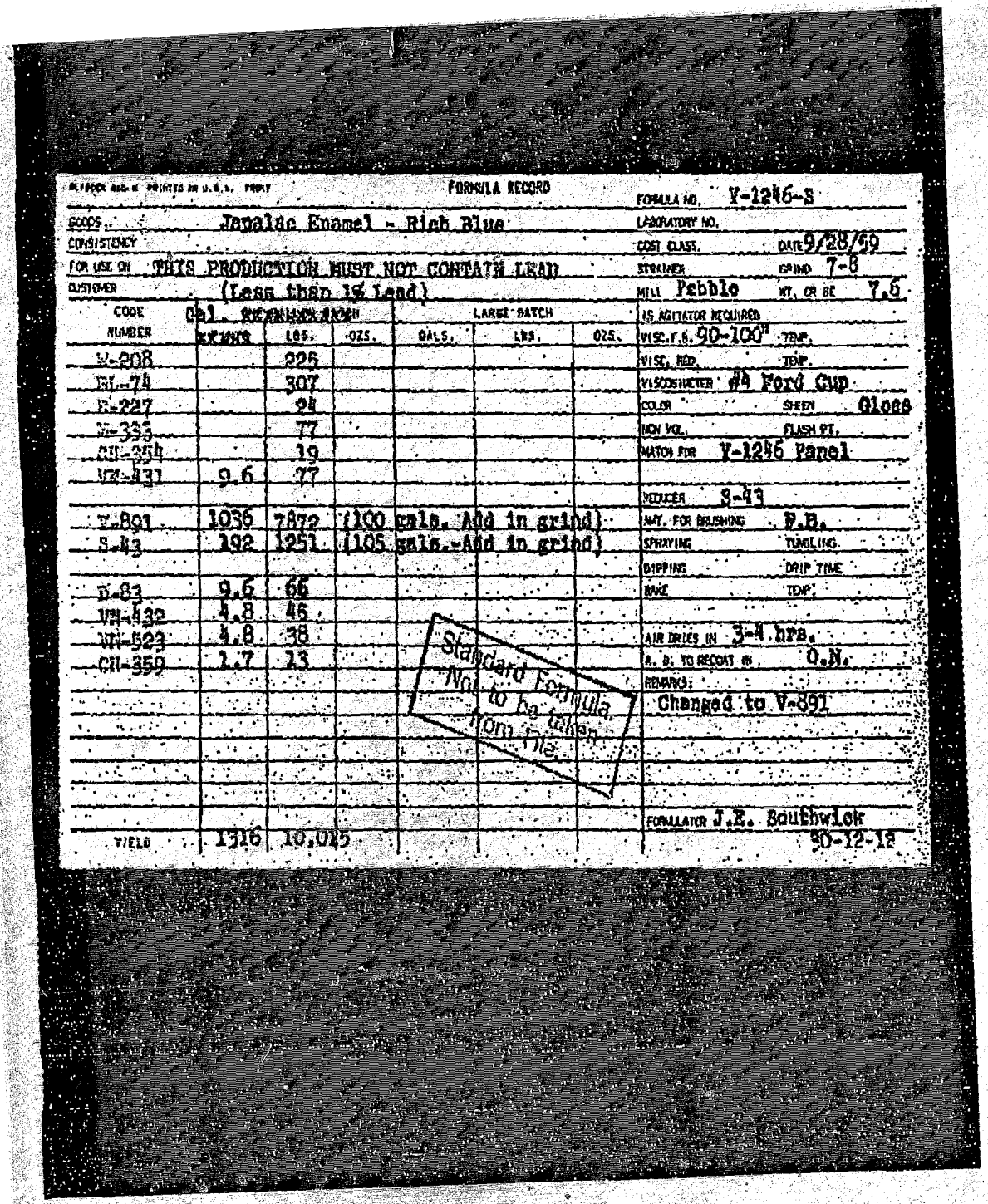
FORMULATOR J.E.E

OK PCH 28-8-7

GLD060246

COST	DATE	ANALYSIS		CUSTOMERS Y-1246-R
		PIGMENT 16.5 %		Japalac Enamel
		VEHICLE 83.5 %		Rich Blue
		100.0 %		1/26/55
		PIGMENT		"Y" Trade Sales Lot 4-28-53
		Titanium Dioxide	11.0%	Navy Blue
		Iron Blue	13.0	Shipped 7-26-55
		Alizarine Blue	1.0	Canada 2-16-57
		Calcium Carbonate	72.0	Penna 2-15-57
			100.0 %	Chgd 5-6-57
				Schultz 4-29-57
				Texas 7-24-58
		VEHICLE		Non Paint-Vill-A Frame
		Soya Alkyd Resin	58.1%	6-23-58
		Mineral Spirits & Driers	41.9	West Indies 11-11-58
			100.0 %	Guatemala 11-18-58
		Y-1246 551		

GLD060247



FORMULA RECORD

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

FORMULA NO. Y-1246-S
LABORATORY NO.
COST CLASS. DATE 9/28/59
STRAINER GRIND 7-8
MILL Pebble WT. OR SP. 7.6
IS AGITATOR REQUIRED
VISC. F.S. 90-100" TEMP.
VISC. RED. TEMP.
VISCOSIMETER #4 Ford Cup
COLOR SHEEN Gloss
NON VOL. FLASH PT.
MATCH FOR Y-1246 Panel
REDUCER S-43
MAT. FOR BRUSHING F.H.
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

CODE NUMBER	Cal. BATCH KETTLE LBS.	OZS.	LARGE BATCH GALS.	LBS.	OZS.
V-208		226			
EM-74		307			
E-227		24			
V-333		77			
MU-354		19			
VM-431	9.6	77			
V-891	1036	7872	(100 gals. Add in grind)		
S-43	192	1251	(105 gals.-Add in grind)		
D-83	9.6	66			
VM-432	4.8	46			
VM-523	4.8	38			
CM-359	1.7	13			
YIELD	1316	10,045			

Standard Formula
Not to be taken
from file

FORMULATOR J.E. Southwick
90-12-12

GLD060248

COST	DATE	ANALYSIS	CUSTOMER F-1246-S
		PIGMENT 5.6 1.	Jonaleo Enamel - Rich Blue
		VEHICLE 94.4 2.	
		100.0%	9/28/59
		Titanium Dioxide 40.5%	
		Rich Blue 55.2	
		Mineral Spirits 4.3	
		100.0%	No. 1 Lead Wetzdure
		Soya Alkyd Resin 42%	
		Mineral Spirits & Driers 58	
		100.0%	
		F-1246 959	

GLD060249

FORMULA RECORD

FORMULA NO. Y-1246-S

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

STRAINED GRIND 7-8

MILL Pebble WT. OR BE 7.6

AGITATOR REQUIRED

VISC. F.S. 90-100" TEMP.

VISC. RED. TEMP.

VISCOSIMETER #4 Ford Cup

COLOR SHEEN Gloss

NON VOL. FLASH PT.

MATCH FOR Y-1246 Panel

REDUCER S-43

ANT. FOR BRUSHING R.H.

SPRAYING FAGLING

DIPPING DRIP TIME

BAKE TEMP.

AIR DRIES IN 3-4 hrs.

A. D. TO RECOAT IN O.N.

REMARKS:

Changed to V-891

** DESTROY COPY DATED 9/28/59. Y-933 Discard Y-4108

FORMULATOR J.E. Sodenwick 30-12-12

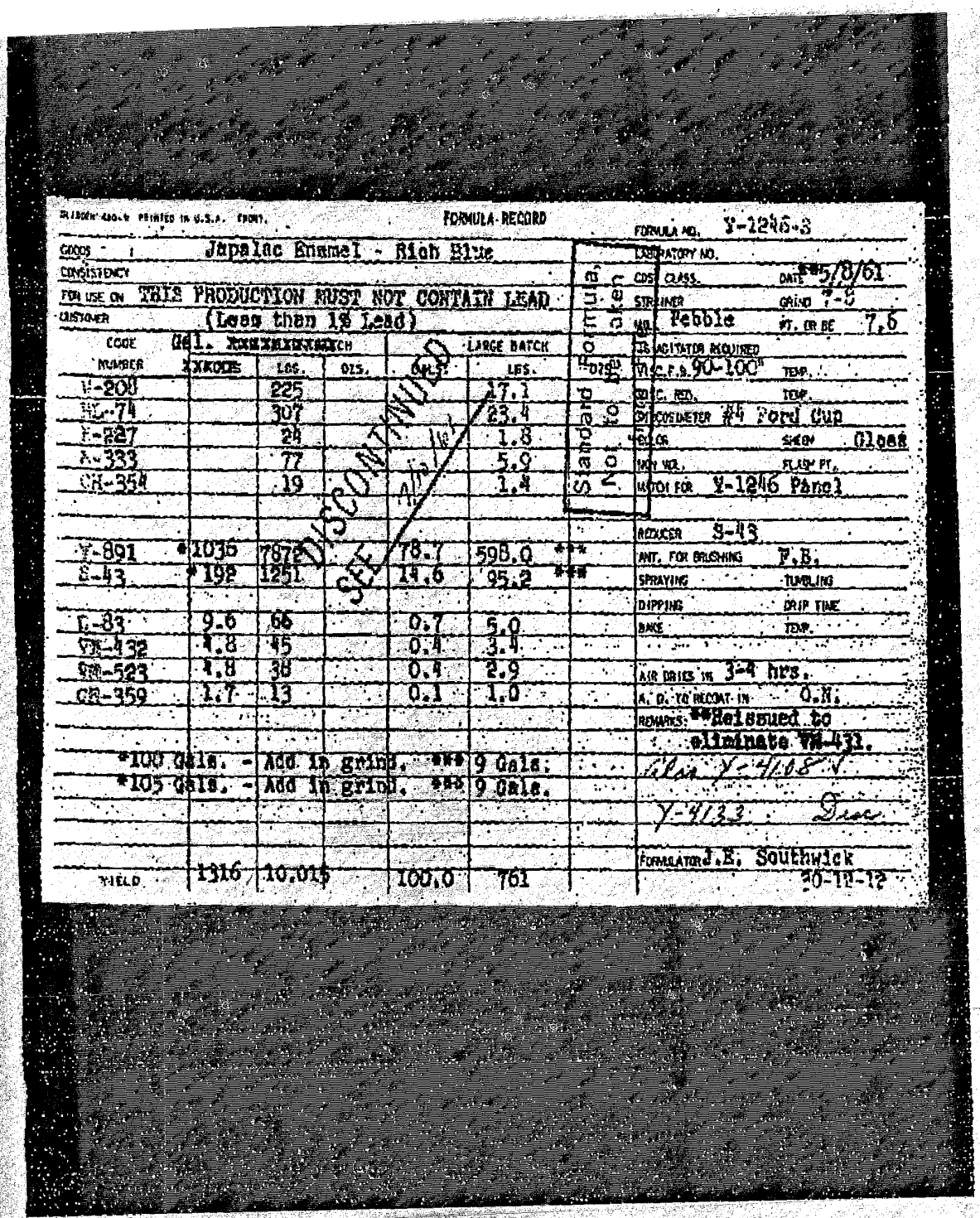
CODE NUMBER	XXXXXX	LBS.	OZS.	GALS.	LARGE BATCH LBS.	
Y-202		225			17.1	
BL-74		307			23.4	
R-227		24			1.8	
M-333		77			5.9	
CH-354		19			1.4	
VM-431	9.6	77		0.7	5.9	
V-891	*1035	7872		78.7	598.0	***
S-43	*192	1251		14.6	95.2	***
D-83	9.6	66		0.7	5.0	
VM-432	4.8	45		0.4	3.4	
VM-523	4.8	38		0.4	2.9	
CR-359	1.7	13		0.1	1.0	
*100 Gals. - Add in grind. *** 9 Gals.						
*105 Gals. - Add in grind. *** 9 Gals.						
YIELD	1316	10.015		100.0	761	

Estimated Formula Cost $1.84 Gal.

GLD060250

COST	DATE	ANALYSIS		CUSTOMERS Y-1246-S
		PIGMENT 5.6	%	Japalac Enamel - Rich Blue
		VEHICLE 94.4	%	
		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
				Keating (Tulsa) 11-5-59
		VEHICLE		
		Soya Alkyd Resin	42%	Pompano (Ft. Pierce) 2-1460
		Mineral Spirits & Driers	58	Chalk 2-12-60
			100.0%	Colombia
				Cuba
				Ecuador
				Guatemala
				Peru
				Venezuela 2-12-60
				Wilmington 9-14-60
		Y-1246	959	Buck (Ft.L.) #9 1-05-61

GLD060251



FORMULA-RECORD

GOODS: Japalac Enamel - Rich Blue

CONSISTENCY

FOR USE ON: THIS PRODUCTION MUST NOT CONTAIN LEAD

CUSTOMER: (Less than 1% Lead)

CODE NUMBER	Gal. XXXXXXXXXXXX	LBS.	GALS.	LARGE BATCH LBS.	
V-200		225		17.1	
W-74		307		23.4	
F-227		24		1.8	
A-333		77		5.9	
CH-358		19		1.4	
Y-891	*1035	7878	78.7	598.0	***
S-43	*192	1251	14.6	95.2	***
L-83	9.6	66	0.7	5.0	
VR-432	1.8	45	0.4	3.4	
GR-523	1.8	38	0.4	2.9	
CR-359	1.7	13	0.1	1.0	
*100 Gals. - Add in grind, *** 9 Gals.					
*105 Gals. - Add in grind, *** 9 Gals.					
YIELD	1316	10,015	100.0	761	

SEE DISCONTINUED

Standard Paint Co. Detroit

FORMULA NO. Y-1246-S

LABORATORY NO.

COST CLASS. DATE 5/8/61

STRAINER GRIND 7-8

MILL Pebble WT. OR BE 7.6

AGITATOR REQUIRED

VISC. F.S. 90-100" TEMP.

VISC. REQ. TEMP.

VISCOSIMETER #4 Ford Cup

COLOR SHEEN Gloss

NON VOL. FLASH PT.

MATCH FOR Y-1246 Panel

REDUCER S-43

ANT. 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: **Reissued to eliminate VR-431.

Use Y-418 V

Y-433 Dec

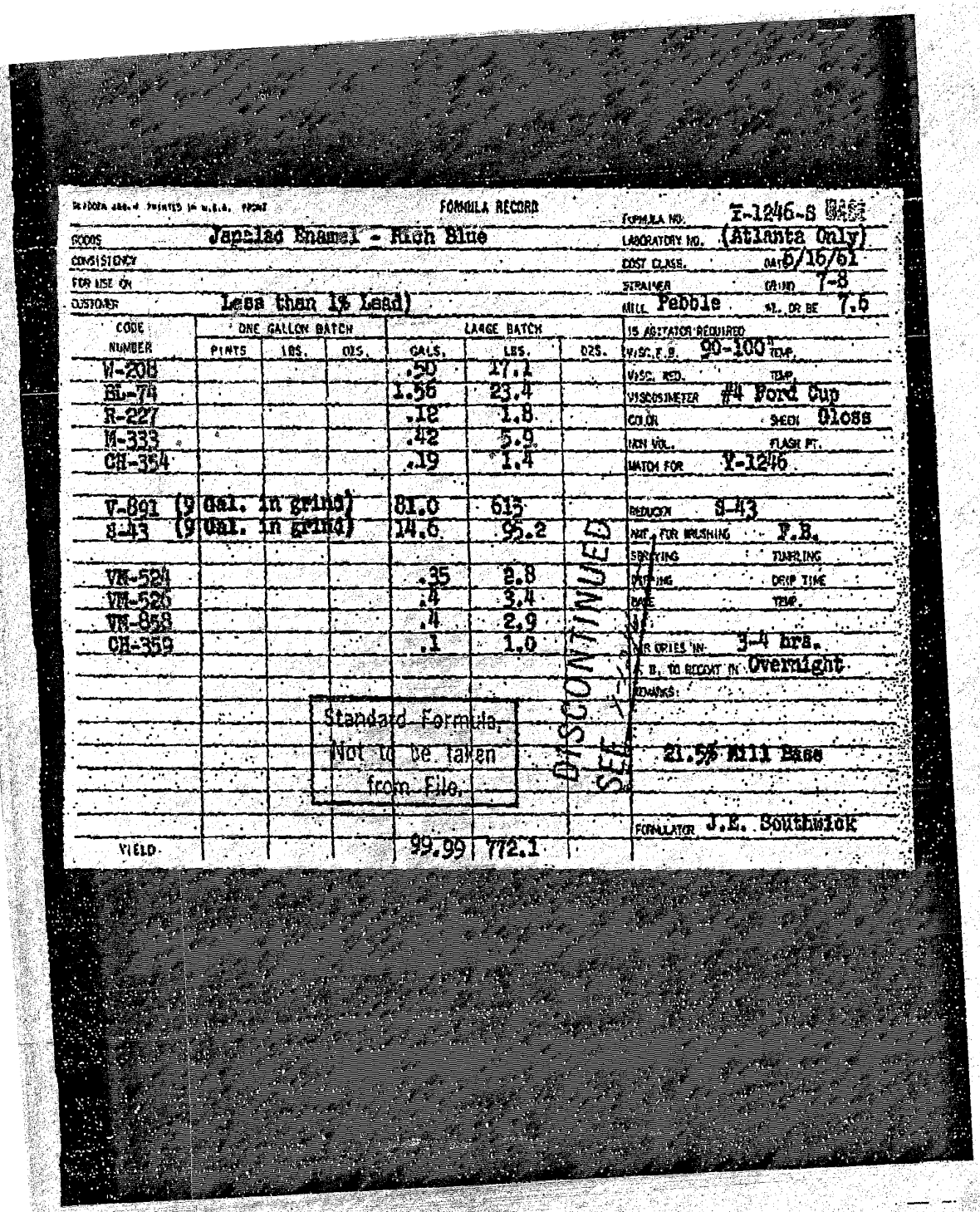
FORMULATOR J.E. Southwick

10-19-12

GLD060252

COST	DATE	ANALYSIS		CUSTOMERS Y-1246-S
		PIGMENT 5.6	%	Jonslac Enamel - High Blue
		VEHICLE 94.4	%	
		100.0%		11/2/59
		PIGMENT		
		Titanium Dioxide	40.5%	
		Iron Blue	55.2	
		Alizarine Blue	4.3	No. 1 Label Warning
			100.0%	
				No change in analysis
				Y Enamel Lot 5-11-61
				Plants #1-2-4-5-12-14-5- 11-17
				#15 (Moscha) 5-11-61
		VEHICLE		
		Soya Alkyd Resin	42%	#7 (Resting) 5-11-61
		Mineral Spirits & Driers	58	Chile-Colombia-Ecuador-Guatemala
			100.0%	Mexico-Peru-W.I. Sales 6-22-61
		Y-1246	959	

GLD060253



FORMULA RECORD

GOODS: Japalac Enamel - Rich Blue
CONSISTENCY:
FOR USE ON:
CUSTOMER: Less than 1% Lead)

FORMULA NO. Y-1246-S
LABORATORY NO. (Atlanta Only)
COST CLASS. DATE 6/16/61
STRAINER GRIND 7-8
MILL Pebble WT. OR BE 7.5
IS AGITATOR REQUIRED
W/SC. F.P. 90-100° TEMP.
VISC. RED. TEMP.
VISCOSIMETER #4 Ford Cup
COLOR SHEEN 01088
IRON VOL. FLASH PT.
MATCH FOR Y-1246
REDUCER S-43
WT. FOR BRUSHING F.B.
SPRAYING THINNING
DIPPING DRIP TIME
BAKE TEMP.
AIR DRIES IN 3-4 hrs.
F. B. TO RECOAT IN Overnight
REMARKS:

21.5% Mill Base

FORMULATOR J.E. Southwick

CODE NUMBER	ONE GALLON BATCH PINTS	LBS.	OZS.	LARGE BATCH GALS.	LBS.	OZS.
V-208				.50	17.1	
BL-74				1.56	23.4	
R-227				.12	1.8	
M-333				.42	5.9	
CH-354				.19	1.4	
V-891 (9 Gal. in grind)				81.0	615	
S-43 (9 Gal. in grind)				14.6	95.2	
VM-524				.35	2.8	
VM-526				.4	3.4	
VM-858				.4	2.9	
CH-359				.1	1.0	
YIELD				99.99	772.1	

Standard Formula, Not to be taken from File.

DISCONTINUED SEE Y-1246-S

GLD060254

FORMULA RECORD

GOODS: Japalac Enamel - Rich Blue DISCONTINUED

CONSISTENCY

FOR USE ON

CUSTOMER: Less than 1% Lead SEE Y-1246-T

CODE NUMBER	ONE GALLON BATCH PINTS	LBS.	OZS.	LARGE BATCH GALS.	LBS.	OZS.
W-208				.50	17.1	
BL-74				1.56	23.4	
R-227				.12	1.8	
M-333				.42	5.9	
CR-354				.19	1.4	
V-891 (9 Gal. in grind)				81.0	615.0	
S-43 (9 Gal. in grind)				14.6	95.2	
D-83				.7	5.0	
VM-432				.4	3.4	
VM-523				.4	2.9	
CR-359				.1	1.0	
YIELD				99.99	772.1	

FORMULA NO. Y-1246-S

LABORATORY NO.

COST CLASS. DATE 7/10/61

STRAINER GRIND 7-8

MILL Pebble WT. OR PE 7.6

IS AGITATOR REQUIRED

VISC. F.S. 90-100" TEMP.

VISC. REQ. TEMP.

VISCOSIMETER #4 Ford Cup

COLOR SHEEN Gloss

NON VOL. FLASH PT.

MATCH FOR Y-1246

REDUCER S-43

AIR. FOR BRUSHING F.S.

SPRAYING TUMBLING

DIPPING DRIP TIME

BAKE TEMP.

AIR DRIES IN 3-4 hrs.

R. D. TO RECOAT IN Overnight

REMARKS:

*Released to eliminate VM-431.

21.5% NVM Base

FORMULATOR J. E. Southwick

GLD060255

COST	DATE	ANALYSIS		CUSTOMERS Y-1245-S
		PIGMENT 5.6 %		Japalac Enamel - Rich Blue
		VEHICLE 94.4 %		
		100.0%		7/10/61
		PIGMENT		No. 1 Kegel Machine
		Titanium Dioxide	40.55	
		Iron Blue	55.2	No change in analysis
		Alizarine Blue	4.3	
			100.05	
				#1 Enamel Test 7-31-61
				Branches #1-2-4-5-12-14
				8-11 #17-15 #3
		VEHICLE		Hess (Texas) 8-2-61 (#1)
		Soya Alkyd Resin	42%	Japan Lacquer 8-15-62
		Mineral Spirits & Driers	58	
			100%	Costa Rica 6-11-62
		Y-1245	958	

GLD060256

FORMULA RECORD

GOODS: Japalac - Rich Blue — Vila Formula

CONSISTENCY:

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

CUSTOMER: less than 1% Lead

CODE NUMBER	ONE GALLON BATCH PINTS	LBS.	OZS.	LARGE BATCH GALS.	LBS.	OZS.
M-208				(.50)	17.1	
EK-74				(1.56)	23.4	
R-227				(.12)	1.8	
M-218 Premix				(.13)	2.9	
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)	
VR-816				.5	3.6	
CR-359				.18	(1.4)	
Standard Formula, not to be taken from file.						
YIELD				100.15	768.1	

DISCONTINUED

FORMULA NO. Y-1246-T base

LABORATORY NO.

COST CLASS. DATE 7/24/62

STRAINER GRIND 7-8

MILL Pebble WT. OR BE 7.6

IS AGITATOR REQUIRED

VISC. F.B. 90-100" TEMP.

VISC. REQ. TEMP.

VISCOSIMETER #4 Ford Cup

COLOR SHEEN Gloss

NON VOL. FLASH PT. 100 F

MATCH FOR Y-1246

REDUCER S-43

WT. FOR BRUSHING F.B.

SPRAYING TUMBLING

DIPPING DRIP TIME

BAKE TEMP.

AIR DRIES IN 3-4

R. TO RECOAT IN O.N.

REMARKS: Better gloss - less seeding

NV by Wt. 43.3%

NV by Vol. 33.8%

PVC 6.8%

Mill Base 24.4%

FORMULATOR J. K. Southwick

GLD060257

COST	DATE	ANALYSIS	CUSTOMERS
		PIGMENT 5.6 %	Japalac Enamel – Rich Blue
		VEHICLE 94.4 %	
		100.0%	7/25/62
		PIGMENT	No. 1 Label Warning
		Titanium Dioxide 40.5%	
		Iron Blue 55.2	No change in analysis
		Ultramarine Blue 4.3	
		100.0%	
			On V Enamel List 7-27-62 @
			Plants 1-2-4-12-14
			Stamped
			#5-8-11-15-16-17
		VEHICLE	
		Soya Alkyd Resin 42%	
		Mineral Spirits & Driers 58	
		100%	
		V-1245 950	

GLD060258

FORMULA RECORD

GOODS: Japalac - Rich Blue
CONSISTENCY:
FOR USE ON: Mfg. at plants #2-8-16-17
CUSTOMER: Less than 1% Lead

FORMULA NO. Y-1246-T BASE
LABORATORY NO. Tallate Driers
COST CLASS. DATE 7/24/62
STRAINER GRIND 7-8
MILL Pebble WT. OR DE 7.6

CODE NUMBER	ONE GALLON BATCH PINTS	LBS.	OZS.	LARGE BATCH GALS.	LBS.	OZS.
M-208				.50	17.1	
BL-74				1.56	23.4	
R-227				.12	1.8	
M-218) Premix				.13	2.0	
S-91)				.13	1.9	
V-891 (15 gals. in grind)				76.0	(578.0)	
S-43 (7 gals. in grind)				20.1	(131.1)	
Grind to 7-8 and add:						
M-333				.42	5.9	
Grind 15 min.						
VM-524				.45	3.1	
VM-815				.5	3.6	
CH-359				.18	1.4	
DISCONTINUED						
SEE Y-1246-U						
YIELD				100.15	768.1	

Stearates not to be in formula from this date taken

IS AGITATION REQUIRED
VISC. F. 90-100" TEMP.
VISC. RED. TEMP.
VISCOSIMETER #4 Ford Cup
COLOR SHEEN Gloss
NON VOL. FLASH PT 100°F
MATCH FOR Y-1246

REDUCER S-43
AMT. FOR BRUSHING T.B.
SPRAYING TUMBLING
DIPPING DRIP TIME
BAKE TEMP.

AIR DRIES IN 3-4
A. D. TO RECOAT IN O.N.
REMARKS:

NV by Wt. 43.3%
NV by Vol. 33.8%
PVC 6.8
Mill Base 24.4%

FORMULATOR J. E. Southwick

GLD060259

COST	DATE	ANALYSIS		CUSTOMERS Y-1246-T
		PIGMENT	7.0 %	Jamaica Enamel - Rich Blue
		VEHICLE	93.0 %	
			100.0%	7/20/62
		PIGMENT		Warning 11-62 NFPA
		Titanium TR92 R0	40.0%	11-14-62
		Iron Blue	55.8	No change in analysis
		Anthraquinone Blue	4.2	
			100.0%	
		Jak Jayan 2-11-64 R		
		Mexico 2-21-64 R		
		West Indies 3-3-64		
		VEHICLE		
		Soya Alkyd Resin	42.	Panama 9-25-63
		Mineral Spirits & Driers	58	Costa Rica 11-19-62
			100%	Italy 9-3-63
		Guatemala 3-9-64 R		#1 (Byco-LCB-C4) 8-2-62
		Manila 3-31-64		#30 (Southwest - Kingg) "
				Plant #2-8-16-17 8-3-62
				#11 (Inc/Export Pat) 8-8-62
		Y-1246	159	
				#4-5-11-12-14-15 8-29-62 R

GLD060260

GLIDDEN ARCH PRINTED IN U.S.A. FRONT

FORMULA RECORD

GOODS: Japalac - Rich Blue

CONSISTENCY

FOR USE ON: Mfg. plants #1-2-4-5-6-11-12-14-15-16-17

CUSTOMER: Less than 1% lead

FORMULA NO. Y-1246-H

LABORATORY NO.

COST CLASS

DATE 4/7/64

STRAINER

GRIND 7-8

MILL Pebble

WT. OR BE 7.72

CODE NUMBER	ONE GALLON BATCH PNTS	LBS.	OZS.	LARGE BATCH GALS.	LBS.	OZS.
U-208				(0.62)	21.0	
RC-74				1.57	23.5	
R-227				(0.36)	5.6	
U-218	Premix			(0.13)	2.0	
S-93				0.15	(1.0)	
V-291 (15 gals in grind)				75.5	(574.00)	
S-43 (7 gals in grind)				20.15	(131.00)	
Grind to 7-8 Grind - then add:						
M-133				(0.42)	5.9	
Grind 15 min. and add:						
VA-524	Standard Formula,			.45	(3.6)	
VA-816	Not to be taken			.50	3.6	
CA-357	from File			.18	1.4	
Use 369 line for shading if needed.						
	Standard formula, Not to be taken from file.					
YIELD				100.93	772.2	

IS AGITATOR REQUIRED

VISC. F. B. 90-100" TEMP. 77°F

VISC. REQ. TEMP.

VISCOSIMETER #4 Ford Cup

COLOR SHEEN Gloss

NON VOL. FLASH PT. 100°F

MATCH FOR Y-1246

REDUCER S-43

EXT. FOR BRUSHING F.B.

SPRAYING TUMBLING

DIPPING DRIP TIME

BAKE TEMP.

AIR DRIES IN 3-4 hours.

O. K. TO RECOAT IN Overnight

REMARKS: Changed for closer color.

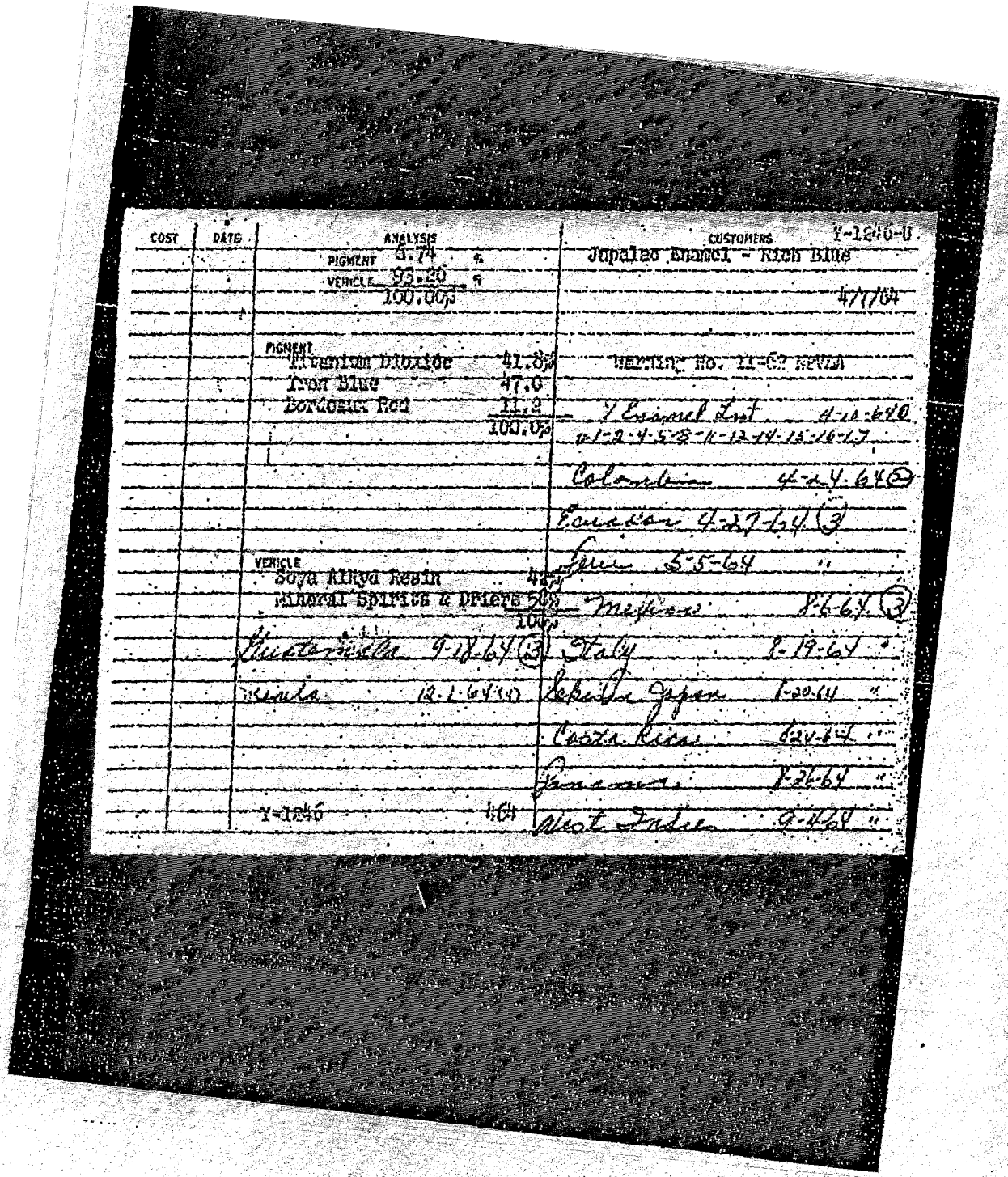
N.V. by wt. 43.8%

PVC 7.9%

NV by Vol. 34.0%

FORMULATOR J. Southwick

GLD060261



COST | DATE | ANALYSIS | CUSTOMERS

ANALYSIS
PIGMENT 6.74 %
VEHICLE 93.26 %
100.00%

PIGMENT
Titanium Dioxide 41.8%
Iron Blue 47.0
Bordeaux Red 11.2
100.0%

VEHICLE
Soya Alkyd Resin 42%
Mineral Spirits & Driers 58%
100%

Guatemala 9-18-64 (3)
Quito 12-1-64 (4)

Y-1246 4-64

CUSTOMERS Y-1246-B
Jupalac Enamel - Rich Blue

4/7/64

MIXING NO. 11-62 REVISED

Y Enamel Lot 4-11-640
#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 "
Mexico 8-6-64 (2)
Italy 8-19-64 "
Lebanon Japan 8-20-64 "
Costa Rica 8-24-64 "
Panama 9-26-64 "
West Indies 9-28-64 "

GLD060262

GLIDDEN 4804H PRINTED IN U.S.A. FRONT

FORMULA RECORD

GLOSS: Japalac - Rich Blue

CONSISTENCY: Brush

FOR USE ON: Mfg. plants #1-2-4-[illegible]-11-12-14-[illegible]

CUSTOMER: less than 1% Lead

CODE NUMBER	ONE GALLON BATCH PINTS	LBS.	OZS.	LARGE BATCH GALS.	LBS.	OZS.
V-290				(0.58)	20.0	
RC-74				(1.57)	23.5	
R-227				(0.36)	5.6	
W-218 Premix				(0.13)	2.0	
S-91				0.15	(1.0)	
V-891 (15 gals. in grind)				75.5	(573.5)	
S-43 (7 gals. in grind)				20.2	(131.1)	
Grind to 7-8 Grind, then add:						
M-333				(0.42)	5.9	
Grind 15 min. and add:						
VM-524				0.45	(3.60)	
VM-816				0.50	(3.60)	
CH-359				0.18	(1.40)	
Use 369 line for shading if needed.						
DISCONTINUED						
SEE Y-1246-V						
YIELD				100.04	771.8	

Stencil Not to be Xerox'd

FORMULA NO. Y-1246-W [illegible]
LABORATORY NO.
COST CLASS DATE 4/30/65
STRAINER GRIND 7-8
MILL Pebble WT. OR BE 7.7#
IS AGITATOR REQUIRED
VISC. F. & 90-100" TEMP. 77°F
VISC. RED. TEMP.
VISCOSIMETER #4 Ford Cup
COLOR Blue SHEEN Gloss
NON VOL 44.5% (Mr) FLASH PT. 100°F
BATCH FOR Y-1246
REDUCER S-43
ADV. FOR BRUSHING P.B.
SPRAYING S-342 TUMBLING
DIPPING DRIP TIME
BAKE TEMP.
AIR DRIES IN 3-4 hours
R. O. TO RECOAT IN Overnight
REMARKS Changed to use W-290

PVC - 8.8%
NV by Vol. - 34.4%
Mill Charge - 24.7%

FORMULATOR J. E. Southwick

GLD060263

COST	DATE	ANALYSIS		CUSTOMERS Y-1246-W
		PIGMENT 7.3 %		Japalac - Rich Blue
		VEHICLE 92.7 %		
		100.0%		4/30/65
		PIGMENT		
		Titanium Dioxide	40.7%	Warning No. 11-62 NPVLA
		Iron Blue	47.9%	
		Bordeaux Red	11.4%	V Paint Dept 5-17-65
			100.0%	#1-2-4-6-8-11-12-14-15-16-17
				Formula shown corrected analysis
				sent to #2-#30) 5-27-65
				#36 (Thinning) 2-23-66
		VEHICLE		
		Soya Alkyd Resin	40.1%	
		Mineral Spirits &		
		Driers	59.9%	
			100.0%	
		Y-1246	564	

GLD060264

GLD060265

Glidden Form 11041 Printed in U.S.A. 4/66 — C & R FORMULA

Product: Japalac - Enamel - Rich Blue

Customer:

CODE NUMBER	100 GALLON BATCH GALLONS	100 GALLON BATCH POUNDS	% BY WEIGHT	MANUFACTURING INSTRUCTIONS
R-290	(0.79)	24.0		
BL-74	(1.92)	28.0		
R-314	(0.30)	3.8		
W-218	(0.20)	3.0		Pre-mix
S-91	0.22	(1.5)		
V-891-A	77.00	(585.2)		(13.0 Gallons in grind)
S-340	18.20	(118.3)		(13.0 Gallons in grind)
R-333	(0.42)	5.8		Add at first let-Down
VM-524	0.45	(3.6)		
VM-816	0.50	(3.6)		
CH-359	0.18	(1.4)		
				Shade with 369
				line bases.
		For 4 x 5 Mill - Make 300 Gals		
		For 5 x 6 Mill - Make 600 Gals.		
		Mill Charge - 29.3%		
Yield	100.03	778.2		

Standard Formula, Not to be taken from File.

Formula Number: Y-1246-X Dark

Laboratory Number:

R.M. Cost: Date 7/25/66

Mill: Pebble Grind 7-8

NPVL.A	Bleed	Less than 1
Label Varnish	11-62	METHOD
Wt./Gal.	7.7#	5-A-1
Flash Ft. °F	80.00	Theor.
N.V.W.	44.7%	Calc.
N.V.Vol.	34.8%	Calc.
Visc. F.	90-100"	4-A-1

Pre-Rel.

Sucer: S-340 Ratio

P.V.C. 8.3% pH

Color: Blue Match: New - Y-1246 (dated July '66)

Gloss: 86 min. Method 9-A-1

Strainer:

Container:

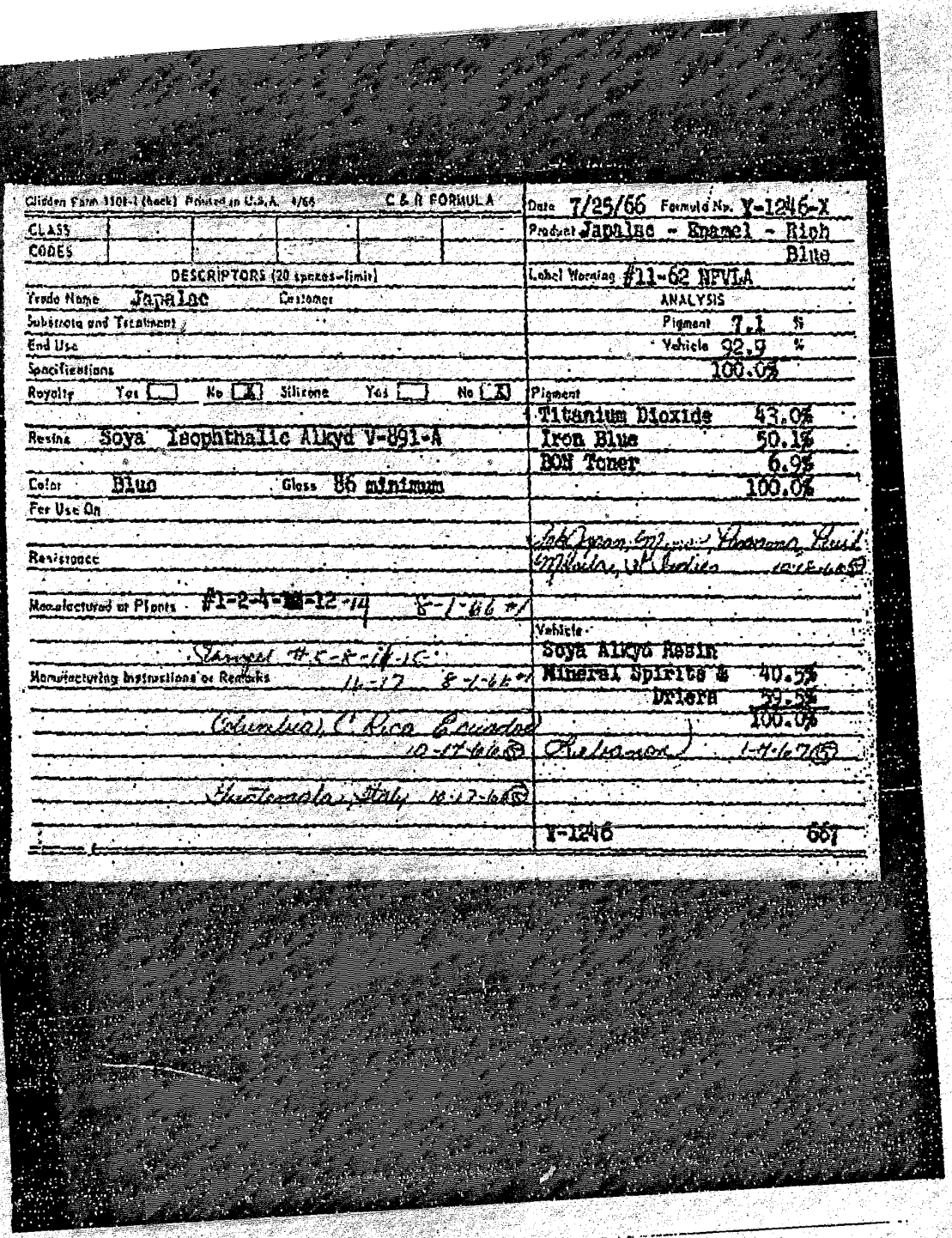
Application: Brush Full Body Spray (S-342)

Cure: Air Dry: 3-4 hrs. Recoat: Overnight

Remarks: Changed to new color std. & to use R-314.

Formulator: Southwick/Bednarik

Approved by: S. Bowell



Glidden Form 3108-1 (Back) Printed in U.S.A. 4/66 — C & R FORMULA

CLASS | | | | | |

CODES | | | | | |

DESCRIPTORS (20 spaces-limit)

Trade Name Japalac — Customer

Substrate and Treatment

End Use

Specifications

Royalty Yes [ ] No [X] Silicone Yes [ ] No [X]

Resins Soya Isophthalic Alkyd V-891-A

Color Blue — Gloss 86 minimum

For Use On

Resistance

Manufactured at Plants #1-2-4-[illegible]-12-14 8-1-66 *1

Stamped #5-8-14-16

Manufacturing Instructions or Remarks 14-17 8-1-66 *1

Columbus, C'Rica Ecuador 10-17-66

Guatemala, Italy 10-17-66

Date 7/25/66 Formula No. Y-1246-X

Product Japalac - Enamel - Rich Blue

Label Warning #11-62 NFVLA

ANALYSIS

Pigment	7.1	%
Vehicle	92.9	%
	100.0%	

Pigment

Titanium Dioxide	43.0%
Iron Blue	50.1%
BON Toner	6.9%
	100.0%

Lake Tyson, Miss., Hanover, Pa., Belvidere, Ill., Bodies 10-17-66

Vehicle

Soya Alkyd Resin	
Mineral Spirits #	40.5%
Driers	59.5%
	100.0%

Belvidere 1-4-67

Y-1246 667

GLD060256

Glidden Form 1109-1 Printed in U.S.A. 4/66 — C S R FORMULA

Product: Japalac Enamel - Rich Blue

Customer:

CODE NUMBER	100 GALLON BATCH GALLONS	100 GALLON BATCH POUNDS	% BY WEIGHT	MANUFACTURING INSTRUCTIONS
V-830	0.70	24.0		
A-200	1.92	28.0		
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	0.44	3.6		
E-392	0.50	3.6		
E-262	0.18	1.4		
Shade with 369 like bases.				
DISCONTINUED				For 4 x 5 Mill - Make 300 Gallons.
SEE Y-9-28				For 5 x 6 Mill - Make 600 Gallons.
Yield	*100.09	778.2		

Formula Number: Y-1246-X

Laboratory Number:

R.M. Cost — Date: 3/1/67

Mill: Pebble — Grind: 7-8

NPVLA (Used) -1

		METHOD
Label Warning	12-62	
Wt./Gal.	7.7#	5-A-1
Flash Pt. °F	100°	Theo.
N.V.M.	44.7%	Calc.
N.V.Vol.	34.8%	Calc.
Visc. F.D.	90-100"	4-A-1
Visc. Red.		
Reducer S-340		Ratio
P.V.C. 8.3%		pH
Color Blue		Match New- Y-1246 (dated July '66
Gloss over 86		Method 9-A-1
Strainer		
Containers		
Application: Brush F.B. Spray: (S-332)		
Cure: Air Dry: 3-4 hrs. Recoat: Overnight		
Remarks: Kill Charge - 129.3#		
Formulator: Southwick/Bednarik		
Approved by: S. Bonell		

GLD060267

Glidden Form 1708-1 (Rev.) Printed in U.S.A. 4/66 C A R FORMULA

CLASS					
CODES					

DESCRIPTORS (20 spaces-limit)

Trade Name Jasaing Customer

Substrate and Treatment

End Use

Specifications

Royalty Yes ☐ No ☒ Silicone Yes ☐ No ☒

Resins Soya Isophthalic Alkyd V-3283

Color Blue Gloss Go Medium

For Use On

Resistance

Manufactured at Plant #1-2-4-12-14 2-16-67

[illegible] 2-16-67

Manufacturing Instructions or Remarks

F30 12-6-66

Date 3/1/67 Formula No. F-1296-X

Product Jasaing Enamel - Rich Blue

Label Warning #11-62 NFPA

ANALYSIS

Pigment 7.1 %

Vehicle 92.9 %

100.0%

Pigment	
Titanium Dioxide	43.0%
Iron Blue	50.1%
Sub Total	6.9%
	100.0%

Vehicle	
Soya Alkyd Resin	40.5%
Mineral Spirits & Driers	59.5%
	100.0%

NO CHANGE IN ANALYSIS

F-1296 667

GLD060268