November 1, 1957
Supersedes Formula TEX-951
dated 7-8-57

PLAINTIFF'S EXHIBIT
GP-1255

ACME, TEXAS PLANT FORMULA

ALL PURPOSE JOINT CEMENT NO. TEX-951

NAME OF MATERIAL — All purpose joint cement for embedding and covering joint tape, for spotting nailheads and for texturing.

FORMULA	Batch	Percent	Ton
Casein No. TEX-991	27.50 lbs.	5.500	110.00 lbs.
Pre-gelatinized starch	10.00 "	2.000	40.00 "
Soda Ash	2.50 "	0.500	10.00 "
Zinc Oxide	1.00 "	0.200	4.00 "
Yellow Oxide	0.25 "	0.050	1.00 "
Santobrite	1.00 "	0.200	4.00 "
Asbestos Floats	25.00 "	5.000	100.00 "
Fine Ground Mica	70.00 "	14.000	280.00 "
-/ Limestone	362.75 "	72.550	1451.00 "
	500.00 lbs.	100.000%	2000.00 lbs.

WORKING CONSISTENCY	Maximum	Minimum	Average
	70	66	68

-/ CRACKING — Each time a new batch of casein is prepared, a cracking test is to be made on one of the first batches of Joint System using this casein. The test is made by first laying a 1/4" diameter metal rod on a 6" x 8" piece of wallboard. The cement at the proper consistency is then placed along one side of the rod. A 3" to 4" wide wedge is then troweled on to the board with a broad knife using the rod on one side and the face of the board on the other side as screeding edges. The formed wedge is then placed in front of a fan with the thin edge facing the fan. The speed of the fan and distance from the sample are regulated so that there is an air movement of 350 to 450 feet per minute across the sample. After two hours the sample shall be examined. There shall be no large fissure cracks in the wedge.

NOTE: This is a low cost all purpose joint system texture which utilizes Pre-Gelatinized starch in place of some of the casein and all of the keltose. It should be tested for bond, application as a topping compound, and stippling as a texture.

ALKALINITY — After the cement has been mixed and stood for 30 minutes, test for alkalinity with the Beckman pH meter. The pH meter shall be standardized at intervals to insure consistently accurate readings. The pH limits for Formula No. TEX-951 are 7.8 to 8.5.

-/ Denotes change in this re-issue. * * *

CWL:cw

June 23, 1965
Supersedes Formula No. TEX-951
Dated 6/8/65

ACME, TEXAS PLANT FORMULA

ALL PURPOSE COMPOUND TEX-951 SPECIAL FOR DALLAS MARKET

DESCRIPTION OF PRODUCT - All Purpose Compound for taping, topping joints, spotting nailheads and texturing; shipped into Dallas market.

FORMULA

Raw Material	Source	R. M. Spec.	%	Lbs./Batch
Sterox CD	Monsanto Chemical Co.		0.025	0.5
Vancide 51Z	R. T. Vanderbilt	126	0.075	1.5
Natrosol 250 HXR (Fine Grind)	Hercules Powder	170	0.25	5.0
Zinc Oxide	Mallinkrodt Co.	119	0.10	2.0
Soda Ash	Open Market	32	0.40	8.0
Borax	Open Market		0.15	3.0
Casein 100M	International Casein Co.	10	4.50	90.0
-/ Asbestos 7RF1		9	6.50	130.0
Mica P80H	Western Mica Co.	11	16.0	320.0
Limestone (Purestone)	Purestone Co.	13	72.0	1440.0
			100.00	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.

-/ Denotes change in this re-issue.

JDR:se

SGP 0017127

June 25, 1965
Supersedes Formula No. TEX-951
Dated 6/23/65

ACME, TEXAS PLANT FORMULA

ALL PURPOSE COMPOUND TEX-951 SPECIAL FOR DALLAS MARKET

DESCRIPTION OF PRODUCT - All Purpose Compound for taping, topping joints, spotting nailheads and texturing; shipped into Dallas market.

FORMULA

Raw Material	Source	R. M. Spec.	%	Lbs./Batch
Sterox CD	Monsanto Chemical Co.		0.025	0.5
Vancide 51Z	R. T. Vandertilt	126	0.075	1.5
Natrosol 250 HXR (Fine Grind)	Hercules Powder	170	0.25	5.0
Zinc Oxide	Mallinkrodt Co.	119	0.10	2.0
Soda Ash	Open Market	32	0.40	8.0
Borax	Open Market		0.15	3.0
Casein 100M	International Casein Co.	10	4.50	90.0
-/ Asbestos 7RF10	Phillip Carey	9	6.50	130.0
Mica P80H	Western Mica Co.	11	16.0	320.0
Limestone (Purestone)	Purestone Co.	13	72.0	1440.0
			100.00	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 ROPERTIES - Refer to Plant Testing Procedur No. 33.
Specifications: Wet mix shall be plastic and buttery working and frse 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 re-issue.

JDR:se

SGP 0017128

September 20, 1977
Formula TEX-951
NEW

ACME, TEXAS, PLANT FORMULA
ALL PURPOSE JOINT COMPOUND FORMULA NO. TEX-951

DESCRIPTION OF PRODUCT - All Purpose compound for taping and finishing joints, spotting nailheads and texturing. For selected market trials and shipment to Memphis only.

FORMULA

Raw Material	Function	RM Spec	Percent	Lbs/Batch
Soda Ash	Viscosity stabilizer		.50	40.0
Gendriv 492-S	Thickener	223	.40	32.0
Vanicide 51Z	Fungicide	126	.05	4.0
Gelvatol 6000	Adhesive	126	1.65	132.0
Attagel 40	Fiber Filler	9	8.13	650.4
Mica p80-H	Anti-cracking agent	11	7.50	600.0
Defoamer M-111	Anti-foaming agent	--	.10	8.0
Land Plaster TEX-25	Filler	--	81.17	6493.6
Alto-White		--	.50	40.0
			100.00	8000.0

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

Maximum	Minimum	Average
70	66	68

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

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

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

COLOR Specifications - White or yellow* Dried compound shall not vary in color from preceding batches.

*For yellow compound, add 8 lbs. of yellow oxide per batch.

HCF:jg

ACME FORMULA #951
ASBESTOS CONTAINING PRODUCTS

SGP 0017125