October 29, 1968
NEW FORMULA

PLAINTIFF'S EXHIBIT
GP-453

ACME, TEXAS PLANT FORMULA

READY MIX JOINT COMPOUND TEX-978-Y (MACHINE TOOLS) (READY MIX "X")

DESCRIPTION OF PRODUCT - Yellow Ready Mix Joint compound used for taping, covering tape, filling cornerbead and spotting nails.

FORMULA

Raw Material	Function	R.M. Spec.	Percent	Lbs./Batch
Water	Solvent	-	-	433.0 (52 gal.)*
Filler TEX-970	Body	-	91.32	700.0
UCAR WC-130	Adhesive	185	8.03	58.3
Benzoflex 50	Plasticizer	183	.52	4.0
Yellow Oxide 2087	Pigment	139	.13	1.0
			100.00	1196.3**

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary ± 2 gallons per batch.)

**One batch yields 18 (±) - 5 gallon pails of Ready Mix Joint Compound at 65.6 lbs/pail.

WORKING CONSISTENCY - Refer to Plant Testing Procedure No. 32.
Specifications for Paste: If paste is not proper working consistency, a maximum of 5 cc water per 150 grams of paste may be added to adjust.

Brabender - 385 ± ~~20~~ 15

WORKING PROPERTIES Specifications : - Refer to Plant Testing Procedure No. 33. Compound shall be plastic, buttery working, and free of any coarse, gritty, or undispersed particles. Material shall be free from lumps due to incomplete mixing.

BONDING PROPERTIES Specifications: - Refer to Plant Testing Procedure No. 35. After compound has dried, tape shall show at least 75% fiber tear when delaminated.

CRACK RESISTANCE - Refer to Plant Testing Procedure No. 37. There shall be no large fissure cracks in the wedge, and no cracks in the thinner half of the wedge.

COLOR Specifications: - Yellow
Dried compound shall match color of standard sample.

RRB:kgc

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ACME FORMULA #978-Y
ASBESTOS CONTAINING PRODUCTS

SGP 0018256