

June 21, 1973
Supersedes Formula V-977
Dated 1/23/73

MILFORD, VIRGINIA PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE TOOLS)

DESCRIPTION OF PRODUCT - White ready mix joint compound used for
taping, topping, and texturing

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Water	Solvent	-		1140(136Gal
PVA Emulsion	Adhesive	185	7.40	148.0
NALCO	Antifoaming Agent	125	.10	2.00
Asbestos 7RF09	Bulking Agent	9	3.92	78.00
Dowicil 100	Bactericide	193	.14	3.0
PV Alcohol	Adhesive	162	.74	15.0
*Thickner	Thickner	170or223	.69	14.0
Mica	Anticracking Agent	11	6.46	129.0
Asbestos SG-210	Bulking Agent	18	1.62	32.0
Limestone	Filler	13	78.70	1575.0
Calgon T	Slip Agent	229	.23	4.0
			100.00	3140.0

*Natrosol 250 HXR or Gendriv 4925

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary
± 4 gallons per batch.

**One batch yields 50 + 1 five gallon pail Ready Mix joint compound at
62 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

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications 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 - Refer to Plant Testing Procedure No. 35.
Specifications After compound has dried, tape shall show at
least 75% fiber tear when delaminated.

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

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

EDO:jg

PLAINTIFF'S EXHIBIT

GP-467

SGP 0018113

July 12, 1973
Supersedes Formula V-977
Dated 6/21/73

MILFORD, VIRGINIA PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE TOOLS)

DESCRIPTION OF PRODUCT - White ready mix joint compound used for
taping, topping, and texturing

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Water	Solvent	-		1140(136Gals) —
PVA Emulsion	Adhesive	185	7.40	148.0
NALCO	Antifoaming Agent	125	.10	2.00
Asbestos 7RF09	Bulking Agent	9	3.92	78.00
Dowicil 100	Bactericide	193	.19	4.0
PV Alcohol	Adhesive	162	.74	15.0
*Thickner	Thickner	170or223	.69	14.0
Mica	Anticracking Agent	11	6.46	129.0
Asbestos SG-210	Bulking Agent	18	1.62	32.0
Limestone	Filler	13	78.65	1574.0
Calgon T	Slip Agent	229	.23	4.0
			100.00	3140.0

*Natrosol 250 HXR or Gendriv 4925

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary
± 4 gallons per batch.

**One batch yields 50 + 1 five gallon pail Ready Mix joint compound at
62 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

WORKING PROPERTIES - Refer to Plant Testing Procedure No. 33.
Specifications 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 - Refer to Plant Testing Procedure No. 35.
Specifications After compound has dried, tape shall show at
least 75% fiber tear when delaminated.

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

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

EDO:jg

SGP 0018114

October 17, 1973
Supersedes Formula V-977
Dated 7/12/73

MILFORD, VIRGINIA, PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE TOOLS)

DESCRIPTION OF PRODUCT - White ready mix joint compound used for
taping, topping, and texturing

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs / batch</u>
Water	Solvent	-		117.0 (136 gal.
PVA Emulsion	Adhesive	185	7.40	112.0
NALCO	Antifoaming Agent	125	.10	2.0
Asbestos 7RF09	Bulking Agent	9	3.92	71.0
-/ Troysan Cmp-10-Sep	Bactericide	193	.10	2.0
PV Alcohol	Adhesive	162	.75	15.0
*Thickner	Thickner	170 or 223	.60	11.0
Mica	Anticracking Agent	11	6.46	122.0
Asbestos SG-210	Bulking Agent	18	1.62	32.0
-/ Limestone	Filler	13	78.97	1499.0
			100.00	3140.0

*Natrosol 250 HXR or Gendriv 4925

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$
4 gallons per batch).

**One batch yields 50 + 1 five gallon pail Ready Mix joint compound at
62 lbs/pail.

WORKING CONSISTENCY
Specifications for
Paste:

- Refer to Plant Testing Procedure No. 32.
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 $\pm$ 20

WORKING PROPERTIES
Specifications

- Refer to Plant Testing Procedure No. 31.
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. 30.
After compound has dried, tape shall show at
least 75% fiber tear when delaminated.

CRACK RESISTANCE
Specifications

- Refer to Plant Testing Procedure No. 31.
There shall be no large fissure cracks in the
Wedge, and no cracks in the thinner half of
the wedge.

COLOR
Specifications

- White
Dried compound shall match color of standard
sample.

WNG:jg

SGP 0018115

October 18, 1973
Supersedes Formula V-977
Dated 10/17/73

MILFORD, VIRGINIA, PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE TOOLS)

DESCRIPTION OF PRODUCT - White ready mix joint compound used for
taping, topping, and texturing

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
-/ **Water	Solvent	-		1140(136gal:
PVA Emulsion	Adhesive	185	7.40	148.0
NALCO	Antifoaming Agent	125	.10	2.0
Asbestos 7RFO9	Bulking Agent	9	3.92	78.0
Troysan Cmp-10-Sep	Bactericide	193	.10	2.0
PV Alcohol	Adhesive	162	.74	15.0
*Thickner	Thickner	170or223	.69	14.0
Mica	Anticracking Agent	11	6.46	129.0
Asbestos SG-210	Bulking Agent	18	1.62	32.0
Limestone	Filler	13	78.97	1580.0
			100.00	3140.0 ***

*Natrosol 250 HXR or Gendriv 4925

-/ **Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$
4 gallons per batch).

***One batch yields 50 $\pm$ 1 five gallon pail Ready Mix joint compound at
62 lbs/pail.

WORKING CONSISTENCY
Specifications for
Paste:

- Refer to Plant Testing Procedure No. 32.
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 $\pm$ 20

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
Specifications

- 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

- White
Dried compound shall match color of standard
sample.

WNG:jg

SGP 0018116

January 15, 1974
Supersedes Formula V-977
Dated 10/18/73

MILFORD, VIRGINIA, PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE TOOLS)

DESCRIPTION OF PRODUCT - White ready mix joint compound used for
taping, topping, and texturing

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
-/ **Water	Solvent	-		1140(136gals
PVA Emulsion	Adhesive	185	7.40	148.0
NALCO	Antifoaming Agent	125	.10	2.0
Asbestos 7RFO9	Bulking Agent	9	3.92	78.0
Troysan Cmp-10-Sep.	Bactericide	193	.10	2.0
PV Alcohol	Adhesive	162	.74	15.0
Natrosol 250 HXR	Thickner	170	.69	14.0
Mica	Anticracking Agent	11	6.46	129.0
Asbestos SG-210	Bulking Agent	18	1.62	32.0
Limestone	Filler	13	78.74	1576.0
Calgon T	Dispersant	229	.23	4.0
			100.00	3140.0***

**Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$
4 gallons per batch).

***One batch yields 50 $\pm$ 1 five gallon pail Ready Mix joint compound at
62 lbs/pail.

WORKING CONSISTENCY
Specifications for
Paste:

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

-/ Brabender: 400 $\pm$ 20

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
Specifications

- 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

- White
Dried compound shall match color of standard
sample.

WNG:ie

SGP 0018117

February 22, 1974
Supersedes Formula V-977
Dated 1/15/74

MILFORD, VIRGINIA, PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE TOOLS)

DESCRIPTION OF PRODUCT - White ready mix joint compound used for
taping, topping, and texturing

-/ FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
**Water	Solvent	-		1140(136gals)
PVA Emulsion	Adhesive	185	7.00	140.0
NALCO	Antifoaming Agent	125	.10	2.0
Asbestos 7RFO9	Bulking Agent	9	3.92	78.0
Troysan Cmp-10-Sep	Bactericide	195	.10	2.0
PV Alcohol	Adhesive	162	.75	15.0
Natrosol 250 HXR	Thickner	170	.70	14.0
Mica	Anticracking Agent	11	8.79	175.0
Asbestos SG-210	Bulking Agent	18	1.25	25.0
Limestone	Filler	13	77.19	1537.0
Calgon T	Dispersant	229	.20	4.0
			100.00	3132.0***

** Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$
4 gallons per batch).

*** One batch yields 50 $\pm$ 1 five gallon pail Ready Mix joint compound at
62 lbs/pail.

WORKING CONSISTENCY
Specifications for
Paste:

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

Brabender:

400 $\pm$ 20

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
Specifications

- 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

- White
Dried compound shall match color of standard
sample.

SGP 0018118

March 6, 1974
Supersedes Formula V-977
Dated 2/22/74

MILFORD, VIRGINIA, PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE TOOLS)

DESCRIPTION OF PRODUCT - White ready mix joint compound used for
taping, topping, and texturing

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
**Water	Solvent	-		1140(136gal
PVA Emulsion	Adhesive	185	7.00	140.0
NALCO	Antifoaming Agent	125	.10	2.0
Asbestos 7RFO9	Bulking Agent	9	3.92	78.0
Troysan Cmp-10-Sep	Bactericide	193	.10	2.0
PV Alcohol	Adhesive	162	.75	15.0
Natrosol 250 HXR	Thickner	170	.70	14.0
Mica	Anticracking Agent	11	8.79	175.0
Asbestos SG-210	Bulking Agent	18	1.25	25.0
Limestone	Filler	13	77.19	1537.0
Calgon T	Dispersant	229	.20	4.0
			100.00	3132.0***

** Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 4 gallons per batch).

*** One batch yields 50 $\pm$ 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

WORKING CONSISTENCY
Specifications for
Paste:

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

Brabender:

400 $\pm$ 20

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 90% fiber tear when delaminated.

CRACK RESISTANCE
Specifications

- 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

- White
Dried compound shall match color of standard
sample.

May 20, 1974
Supersedes Formula V-977
Dated 3/6/74

MILFORD, VIRGINIA, PLANT
READY MIX JOINT COMPOUND V-977 (MACHINE TOOLS)

DESCRIPTION OF PRODUCT - White ready mix joint compound used for
taping, topping, and texturing

-/ FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
**Water	Solvent	-		1140(136gal)
PVA Emulsion	Adhesive	185	7.00	140.0
NALCO	Antifoaming Agent	125	10	2.0
Asbestos 7HFO9	Bulking Agent	9	3.92	78.0
Troysan Cmp-10-Sep	Bactericide	193	.10	2.0
PV Alcohol	Adhesive	162	.375	7.5
Natrosol 250 HXR	Thickner	170	.70	14.0
Mica	Anticracking Agent	11	8.79	175.0
Asbestos SG-210	Bulking Agent	18	1.25	25.0
Limestone	Filler	13	77.565	1544.9
Calgon T	Dispersant	229	.20	4.0
			100.00	3132.0***

** Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 4 gallons per batch).

*** One batch yields 50 $\pm$ 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

WORKING CONSISTENCY
Specifications for
Paste:

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

Brabender:

400 $\pm$ 20

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 90% fiber tear when delaminated.

CRACK RESISTANCE
Specifications

- 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

- White
Dried compound shall match color of standard
sample.

WNG: jg

-/ denotes change

SGP 0018120

**MILFORD FORMULA #977
ASBESTOS CONTAINING PRODUCTS**

• MILFORD FORMULA # 977

• ASBESTOS CONTAINING PRODUCTS

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