BESTWALL GYPSUM COMPANY

For: Ardmore — Aug. 15, 1963 — Paoli Lab

Att: Mr. E. R. Skopal — Subject: READY MIX JOINT SYSTEM OPERATION AT AKRON

C. W. Lehnert/md

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cc: Mr. M. M. Powers - Ardmore
Mr. G. E. Wilson - Paoli
Mr. G. A. Hoggatt - Paoli
Mr. E.J.Cole - Paoli
Mr. J. Di Lorenzo - Akron

PLAINTIFF'S EXHIBIT
GP-631

A small operation for producing Ready Mix Joint Compound has been set up at the Akron plant. The batch size, production rate, and pail contents are different than was originally estimated. We are furnishing you with this information so that a more accurate cost analysis of this product can be made.

FILLER

FORMULATION

Raw Material	Source	%	Lbs/Ton	Lbs/Batch
Gelva D-702	Shawinigan Resins Co.	5.00	100.0	200.0
Gelvatol 20-30 BP	" "	0.15	3.0	6.0
Mica	Hassett Mica Co.	5.50	110.0	220.0
7RF-9 Asbestos	Phillip Carey Co.	5.00	100.0	200.0
Methocel 4000 cps	Dow Chemical	0.30	6.0	12.0
ASP 100 clay	Minerals & Chemicals	10.00	200.0	400.0
Yellow Oxide	C. K. Williams Co.	0.15	3.0	6.0
Limestone	Thompson-Weinman	73.90	1478.0	2956.0
	Total	100.00	2000.0	4000.0

PASTE COMPOUND

Raw Material	Source	%	Lbs/Batch
Filler	Akron	63.46	700.00
Water	"	35.56	392.20
Benzoflex 50	Tennessee Chemical (Velsicol Chem. Corp)	0.63	7.00
Ethylene Glycol	Union Carbide	0.32	3.50
Troysan PMA 30	Troy Chemicals	0.03	0.35
	Total	100.00	1103.05

BATCH SIZE

1 batch yields 17 - 5 gallon pails of Ready Mix.

PAIL CONTENT

Average Pail Weight - 67.88 lbs.

EAS

SGP 0002524

Re: Ready Mix Joint System Operations at Akron

Contents per 5-gallon pail based on average pail weight:

Filler	-	41.17 lbs.
Water	-	23.07 "
Benzoflex 50	-	0.41 "
Ethylene Glycol	-	0.21 "
Troysan	-	0.02 "
5-gal. pail	-	3.00 "
Total		67.88 lbs.

PRODUCTION

16 batches per 8 hour including cleanup time, etc., with a 3-man crew.

Certain minor additions to the equipment (constant level tank for measuring mixing water, feed hopper, and screw or other type pail filling equipment) should increase the production capacity to about 20 batches per 8 hour day with the 3-man crew.

Will you secure the other necessary information from Mr. Di Lorenzo, so that you can compute the F.O.B. cost per pail. We would like you to figure this cost for 16 and 20 batch per day capacities and furnish the information to those receiving copies of this letter.