

CHICAGO, ILLINOIS PLANT FORMULA

LAMINATING COMPOUND NO. C-986

DESCRIPTION OF PRODUCT: - Laminating Compound is an adhesive to be used to laminate two sheets of wallboard together in Hummer System or other double layer construction.

FORMULA:

<u>Raw Material</u>	<u>Source</u>	<u>R.M.Spec.</u>	<u>Percent</u>	<u>Lbs/Ton</u>
K. B. Flour	Knfler-Bates Co.		20.00	400.0
Lime-Hi Calcium	Open Market		1.60	32.0
Tri-Sodium Phosphate	Open Market		2.20	44.0
Vancide 51Z	R. T. Vanderbilt	126	0.10	2.0
Kaysoy 2000	Archer-Daniels-Midland	122	3.00	60.0
Casein 100M	International Casein	10	5.50	110.0
Limestone (Purestone)	Purestone Company	13	67.425	1348.5
Kerosene	Open Market		0.10	2.0
Cottonseed Oil	Open Market		0.025	0.5
Defoamer M111	Nalco Chemical Co.		0.05	1.0
			100.000	2000.0

SPREADING CONSISTENCY: - This is a high alkalinity compound. To determine the proper consistency, mix at a rate of 100 grams to 150 cc water, adding the dry powder slowly with continuous stirring. This procedure should take from 30 to 60 seconds. The laminating compound should mix to about the consistency of a thick pour. Cover with a damp cloth and allow the mixture to soak for 10 minutes. Upon remixing, it should be of thinner consistency and more plastic. Spreading consistency is the amount of water that will allow the glue to be spread easily, by means of a comb type spreader; the ridges formed by the spreader not self-leveling or sagging when the board is held in a vertical position.

SPECIFICATIONS:

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
165	135	150

ALKALINITY:

- After the glue has been reduced to the correct consistency, test for pH by means of Beckman pH meter. The electrodes used should be capable of accurately indicating pH reading in excess of pH 12.

pH SPECIFICATIONS:

<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
12.0	11.0	11.5

BOND TEST:

- The glue shall be applied to a foot square by means of the comb type spreader. The spreader shall have triangular notches 3/16" wide x 3/16" deep, spaced 3/4 on centers. Place two .025 shims parallel and on each side of the application 4"

BOND TEST: (cont.)

- apart. A 4 inch square piece of board shall be placed backside down onto the application of glue and shims. The next day, the 4 inch square piece of board shall be pryed loose by means of a broadknife. There shall be no glue failure, rather a delamination of the board paper or a fracture of the board itself to indicate satisfactory bond.

EDO:dek

SGP 0018349

December 8, 1967
NEW FORMULA

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LAMINATING COMPOUND No. C-986

DESCRIPTION OF PRODUCT - Laminating Compound is an adhesive to be used to laminate two sheets of wallboard together in Hummer System or other double layer construction.

FORMULA

<u>Raw Material</u>	<u>Source</u>	<u>R.M. Spec.</u>	<u>Percent</u>	<u>Lbs./Batch</u>
K. B. Flour	Knifler-Bates Co.		20.000	800.0
Lime - High Calcium	Open Market		1.600	64.0
Tri-Sodium Phosphate	Open Market		2.200	88.0
Vancid 512	R. T. Vanderbilt Co.	126	0.100	4.0
Kaysoy 200C	Archer-Daniels-Midland	122	3.000	120.0
Casein 100M	Paul A. Dunkel	10	5.500	220.0
Limestone	Thompson-Weinman		67.425	2697.0
Kerosene	Open Market		0.100	4.0
Cottonseed Oil	Open Market		0.125	1.0
Nalco 71D5	Nalco Chemical Co.		0.050	2.0
			<u>100.000</u>	<u>4000.0</u>

SPREADING CONSISTENCY - This is a high alkalinity compound. To determine the proper consistency, mix at a rate of 100 grams to 150 cc water, adding the dry powder slowly with continuous stirring. This procedure should take from 30 to 60 seconds. The laminating compound should be to about the consistency of a thick pour. Cover with a damp cloth and allow the mixture to soak for 10 minutes. Upon remixing, it should be of thinner consistency and more plastic. Spreading consistency is the amount of water that will allow the glue to be spread easily by means of a comb type spreader; the ridges formed by the spreader not self-leveling or sagging when the board is held in a vertical position.

Specifications:	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
	165	135	150

ALKALINITY - After the glue has been reduced to the correct consistency, test pH by means of the Beckman pH meter. The electrodes used should be capable of accurately indicating pH readings in excess of pH 12.

pH Specifications:	<u>Maximum</u>	<u>Minimum</u>	<u>Average</u>
	12.0	11.0	11.5

BOND TEST - The glue shall be applied to a foot square area by means of the comb type spreader. The spreader shall have triangular notches 3/16" wide x 3/16" deep, spaced 3/4" on centers. Place two .025 shims parallel and on each side of the application 4 inches apart. A 4 inch square piece of board shall be placed backside down onto the application of glue and shims. The next day the 4 inch square piece of board shall be pryed loose by means of a broadknife. There shall be no glue failure, rather a delamination of the board paper or a fracture of the board itself to indicate satisfactory bond.

**CHICAGO FORMULA #986
ASBESTOS CONTAINING PRODUCTS**