

NEW
 July 2, 1979
 Effective: August 1, 1979

AKRON, NEW YORK, PLANT FORMULA
READY MIX TOPPING COMPOUND AK-977 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Topping Compound used for finishing joint and spotting nail heads.

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>RM Spec</u>	<u>Percent</u>	<u>Lbs/Batch</u>
PMA 30	Preservative		.031	3.75
Filler AK-979	Filler		95.555	4400.00
JCM	Adhesive	185	4.019	185.04 (20.8 gal)
Nalco 71D-5	Defoamer	125	.000	4.60
***Paragum 146	Thickener		.245	11.30
* Water	Solvent			2130.20 (257 gal)
			100.000	6734.89 **

* Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch.

** One batch yields 108 $\pm$ 2 five-gallon pails Ready Mix Joint Compound at 62 lbs/paid.

*** Acrysol ASE-60 can be substituted at a loading of 9.10 lbs/batch (.198%).

SPECIAL MIXING INSTRUCTIONS

- Blend ingredients in following order:
 - 1) Water
 - 2) JCM
 - 3) Nalco
 - 4) Filler Ak-979
 - 5) Mix until filler is thoroughly dispersed
 - 6) Add Paragum 146
 - 7) Mix until Ready Mix is smooth; check viscosity and pH.

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 (520 $\pm$ 20)
pH

For machine tools, add 4 gallons H₂O (470 $\pm$ 20)
 Minimum - 9.0 Maximum - 9.5

WORKING PROPERTIES

Specifications

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

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July 2, 1979
Effective August 1, 1979
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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.
Rating shall be 4 or better.

COLOR

Specification

- White
Dried Compound shall match color of standard sample.

HCF:ps

April 8, 1965
Supersedes AK-976
Dated July 8, 1964

AKRON, NEW YORK PLANT FORMULA

READY MIX JOINT COMPOUND AK-977 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White

Ready Mixed Joint Compound used for taping, covering tape, filling cornerbead and spotting nails.

FORMULA

<u>Raw Material</u>	<u>Source</u>	<u>% Act. Ingr.</u>	<u>Lbs./Batch</u>
Water	Akron Plant	-	324.0 (40 gal.)*
-/ Daxad 30	Dewey & Almy Chemical	.28	2.25
-/ Troysan PMA 30	Troy Chemical Co.	0.05	0.4
-/ Filler AK-972	Akron Plant	88.8	700.0
-/ Elvacet 82-900	DuPont	9.9	77.8
-/ Benzoflex 50	Tennessee Products Chem.	0.98	7.8
		100.00	1122.25**

*Approximately 43 lb./100 lbs. of active ingredients (this may vary $\pm$ 2 gallon per batch).

-/ **One batch yields 16 - 5 gallon pails of Ready Mix Joint Compound at 69.0 lbs./pail.

TESTING CONSISTENCY

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 - 420 $\pm$ 30

Working Properties - Refer to Plant Testing Procedure No. 33.

Compound shall be plastic, buttery working, and free of any coarse, gritty, or undispersed particles. Plaster 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.

June 8, 1965
Supersedes AK-977
Dated April 6, 1965

AKRON, NEW YORK PLANT FORMULA

READY MIX JOINT COMPOUND AK-977 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White

Ready Mixed Joint Compound used for taping, covering tape, filling cornerbead and spotting nails.

<u>FORMULA</u>			
<u>Raw Material</u>	<u>Source</u>	<u>% Act. Ingr.</u>	<u>Lbs./Batch</u>
-/ Water	Akron Plant	-	367.0 (44 gal.)*
Daxad 30	Dewey & Almy Chemical	.28	2.25
Troysan PMA 30	Troy Chemical Co.	0.05	0.4
-/ Filler AK-973	Akron Plant	88.8	700.0
Elvacet 81-900	DuPont	9.9	77.8
Benzoflex 50	Tennessee Products Chem.	0.98	7.8
		<u>100.00</u>	<u>1155.25**</u>

-/ *Approximately 46 lb./100 lbs. of active ingredients (this may vary $\pm$ 2 gallon per batch).

-/ **One batch yields 16 $\pm$ 5 gallon pails of Ready Mix Joint Compound at 68.9 lbs./pail.

TESTING CONSISTENCY

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 - 420 + 30

Working Properties - Refer to Plant Testing Procedure No. 33.

Compound shall be plastic, buttery working, and free of any coarse, gritty, or undispersed particles. Plaster 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

SGP 0018059

Specifications: Dried compound shall match color of standard sample.

April 6, 1965
Supersedes AK-976
Dated July 8, 1964

AKRON, NEW YORK PLANT FORMULA

READY MIX JOINT COMPOUND AK-977 (HAND TOOLS)

DESCRIPTION OF PRODUCT - White

Ready Mixed Joint Compound used for taping,
covering tape, filling cornerbead and spotting
nails.

FORMULA

<u>Raw Material</u>	<u>Source</u>	<u>% Act. Ingr.</u>	<u>Lbs./Batch</u>
Water	Akron Plant	-	334.0 (40 gal.)*
-/ Daxad 30	Dewey & Almy Chemical	.28	2.25
Troysan PMA 30	Troy Chemical Co.	0.05	0.4
-/ Filler AK-972	Akron Plant	88.8	700.0
-/ Elvacet 81-900	DuPont	9.9	77.8
-/ Benzoflex 50	Tennessee Products Chem.	0.98	7.8
		<u>100.00</u>	<u>1122.25**</u>

*Approximately 43 lb./100 lbs. of active ingredients (this may vary
± 2 gallon per batch).

-/ **One batch yields 16 - 5 gallon pails of Ready Mix Joint Compound at
69.0 lbs./pail.

TESTING CONSISTENCY

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 - 420 ± 30

Working Properties - Refer to Plant Testing Procedure No. 33.

Compound shall be plastic, buttery working, and free of any coarse,
gritty, or undispersed particles. Plaster 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.

September 2, 1970
NEW FORMULA

AKRON, NEW YORK PLANT FORMULA

READY MIX JOINT COMPOUND AK-977 (MACHINE TOOLS)

DESCRIPTION OF PRODUCT: - White Ready Mix Joint Compound used for taping, topping and texturing. (Supplied on special request only.)

-/ FORMULA:

<u>Raw Material</u>	<u>Function</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Water	Solvent	-	2165.00*(260 gals.)
Nalco	Anti-Foaming agent	0.1	4.00
Polyvinyl Acetate Emulsion	Adhesive	7.0	280.00
Benzoflex	Plasticizer	0.4	16.00
Filler AK-978	Filler	92.5	3700.00
		100.0	6165.00**

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch.

**One batch yields 95 $\pm$ 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 $\pm$ 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.

February 19, 1971
Supersedes Formula AK-977
Dated 9/2/70

ANRON, NEW YORK PLANT FORMULA

READY MIX JOINT COMPOUND AK-977 (MACHINE TOOLS)

DESCRIPTION OF PRODUCT: - White Ready Mix Joint Compound used for taping, topping and texturing. (Supplied on special request only.)

-/ FORMULA:

<u>Raw Material</u>	<u>Function</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Water	Solvent	-	2165.00*(260 gals.)
Nalco	Anti-Foaming agent	0.1	4.00
Polyvinyl Acetate Emulsion (Pre-Plasticized)	Adhesive	7.56	302.40
Filler AK-973	Filler	92.34	3693.60
		100.0	6165.00**

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch.

**One batch yields 95 $\pm$ 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.

Drabancer: 335 $\pm$ 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.

February 24, 1971
Supersedes Formula AK-977
Dated 2/19/71

AKRON, NEW YORK PLANT FORMULA

READY MIX JOINT COMPOUND AK-977 (MACHINE TOOLS)

DESCRIPTION OF PRODUCT: - White Ready Mix Joint Compound used for taping, topping and texturing. (Supplied on special request only.)

FORMULA:

<u>Raw Material</u>	<u>Function</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Water	Solvent	-	2165.00*(260 gals.)
Nalco	Anti-Foaming agent	0.1	4.00
Polyvinyl Acetate Emulsion (Pre-Plasticized)	Adhesive	7.56	302.40
Filler AK-973	Filler	92.34	3593.60
		100.0	6165.00**

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch.

-/ *One batch yields 97 $\pm$ 1 five gallon pail Ready Mix joint compound at 62 lbs/pail.

WORKING CONSISTENCY:

Specifications for Paste:

Broabender: 385 $\pm$ 20

- 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.

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.

TEAR-OUT 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.

-/ Denotes change in this reissue.

SGP 0018063

February 11, 1972
Supersedes Formula AK-977
Dated 2/24/71

AKRON, NEW YORK PLANT FORMULA

READY MIX JOINT COMPOUND AK-977 (MACHINE TOOLS)

DESCRIPTION OF PRODUCT: - White Ready Mix Joint Compound used for taping, topping and texturing. (Supplied on special request only.)

<u>FORMULA</u>		<u>Function</u>	<u>Percent</u>	<u>Lbs/Batch</u>
<u>-/</u>	<u>Raw Material</u>			
	Water	Solvent	-	2280.00* (275 gals.)
	Nalco	Anti-Foaming agent	0.1	4.00
	Polyvinyl Acetate Emulsion			
	(Pre-Plasticized)	Adhesive	7.4	296.00
	Filler AK-978	Filler	2.50	3700.00
			100.00	6276.00

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch.

-/ **One batch yields 100 $\pm$ 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 $\pm$ 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.

-/ Denotes change in this reissue.

EDO:dek

SGP 0018064

January 15, 1974
Supersedes Formula AK-977
Dated 2/11/72

AKRON, NEW YORK PLANT FORMULA

READY MIX JOINT COMPOUND AK-977 (MACHINE TOOLS)

DESCRIPTION OF PRODUCT: - White Ready Mix Joint Compound used for taping, topping and texturing. (Supplied on special request only.)

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Water	Solvent	-	2280.00* (275 gals.)
Nalco	Anti-Foaming agent	0.1	4.00
Polyvinyl Acetate Emulsion (Pre-Plasticized)	Adhesive	7.4	296.00
Filler AK-978	Filler	92.50	3700.00
		100.00	6276.00

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch.

**One batch yields 100 $\pm$ 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: 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.

-/ Denotes change in this reissue.

WNG:elz

SGP 0018065

March 6, 1974
Supersedes Formula AK-977
Dated 1/15/74

AKRON, NEW YORK PLANT FORMULA

READY MIX JOINT COMPOUND AK-977 (MACHINE TOOLS)

DESCRIPTION OF PRODUCT: - White Ready Mix Joint Compound used for taping, topping and texturing. (Supplied on special request only.)

FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Water	Solvent	-	2280.00* (275 gals.)
Nalco	Anti-Foaming agent	0.1	4.00
Polyvinyl Acetate Emulsion (Pre-Plasticized)	Adhesive	7.4	296.00
Filler AK-978	Filler	92.50	370.00
		100.00	6276.00

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch.

**One batch yields 100 $\pm$ 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: 400 $\pm$ 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 90% 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.

- / Denotes change in this reissue.

WNG:elz

SGP 0018066

March 15, 1974
Supersedes Formula AK-977
Dated 3/6/74

AKRON, NEW YORK PLANT FORMULA

READY MIX JOINT COMPOUND AK-977 (MACHINE TOOLS)

DESCRIPTION OF PRODUCT: - White Ready Mix Joint Compound used for taping, topping and texturing. (Supplied on special request only.)

-/ FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Water	Solvent	-	2280.00* (275 gals.)
Nalco	Anti-Foaming agent	0.1	4.00
Polyvinyl Acetate Emulsion (Pre-Plasticized)	Adhesive	7.0	280.00 (31 gals.)
Filler AK-978	Filler	92.9	3716.00
		100.00	6280.00

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch.

**One batch yields 100 $\pm$ 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: 400 $\pm$ 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 90% 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.

-/ Denotes change in this reissue.

WNG:elz

SGP 0018067

August 14, 1974
Supersedes Formula AK-977
Dated 3/15/74

AKRON, NEW YORK PLANT FORMULA

READY MIX JOINT COMPOUND AK-977 (MACHINE TOOLS)

DESCRIPTION OF PRODUCT: - White Ready Mix Joint Compound used for taping, topping and texturing. (Supplied on special request only.)

<u>FORMULA</u>				
<u>Raw Material</u>	<u>Function</u>	<u>Percent</u>	<u>Lbs/Batch</u>	
-/ Water	Solvent	-	2631.00*	(317 gals.)
Nalco	Anti-Foaming agent	0.1	4.00	
-/ Polyvinyl Acetate Emulsion				
(Pre-Plasticized)	Adhesive	7.0	313.00	(35 gals.)
-/ Filler AK-978	Filler	92.9	4200.00	
		100.00	7148.00**	

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch.

-/ **One batch yields 112 $\pm$ 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: 400 $\pm$ 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 90% 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.

-/ Denotes change in this reissue.

WNG:elz

SGP 0018068

November 20, 1974
Supersedes Formula AK-977
Dated 8/14/74

AKRON, NEW YORK, PLANT FORMULA
READY MIX JOINT COMPOUND AK-977 (MACHINE TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for taping, topping and texturing. (Supplied on special request only.)

-/ FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Water	Solvent	-	2714.00* (327 gals.)
Malco	Anti-foaming agent	0.1	4.00
-/ Elvace 1875	Adhesive	5.0	221.00 (24.5 gals.)
Filler AK-978	Filler	94.9	4200.00
		100.0	7139.00**

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch.)

**One batch yields 112 $\pm$ 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

SGP 0018069

December 22, 1975
Supersedes Formula AK-977
Dated 11/20/74

AKRON, NEW YORK, PLANT FORMULA
READY MIX JOINT COMPOUND AK-977 (MACHINE TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for taping, topping and texturing. (Supplied on special request only.)

-/ FORMULA

<u>Raw Material</u>	<u>Function</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Tamol 731	Dispersant	0.1	4.00
Water	Solvent	-	2714.00* (327 gals.)
Nalco	Anti-foaming agent	0.1	4.00
Elvace 1875	Adhesive	5.0	221.00 (24.5 gals.)
Filler AK-978	Filler	94.8	4200.00
		100.0	7143.00**

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch.)

**One batch yields 112 $\pm$ 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 0018070

June 10, 1976
Supersedes Formula AK-977
Dated 12/22/75

AKRON, NEW YORK, PLANT FORMULA
READY MIX JOINT COMPOUND AK-977 (MACHINE TOOLS)

DESCRIPTION OF PRODUCT - White Ready Mix Joint Compound used for taping, topping and texturing. (Supplied on special request only.)

<u>FORMULA</u>			
<u>Raw Material</u>	<u>Function</u>	<u>Percent</u>	<u>Lbs/Batch</u>
Water	Solvent	-	2274.00* (274 gals.)
Nalco	Anti-foaming agent	0.1	4.00
Elvace 1875	Adhesive	5.5	245.00 (27.5 gals.)
Filler AK-978	Filler	94.4	4200.00
		100.0	6723.00**

*Approximately 56.5 lbs/100 lbs. of active ingredients (this may vary $\pm$ 8 gallons per batch.)

-/ **One batch yields 108 $\pm$ 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 0018071

**AKRON FORMULA #977
ASBESTOS CONTAINING PRODUCTS**

SGP 0018055