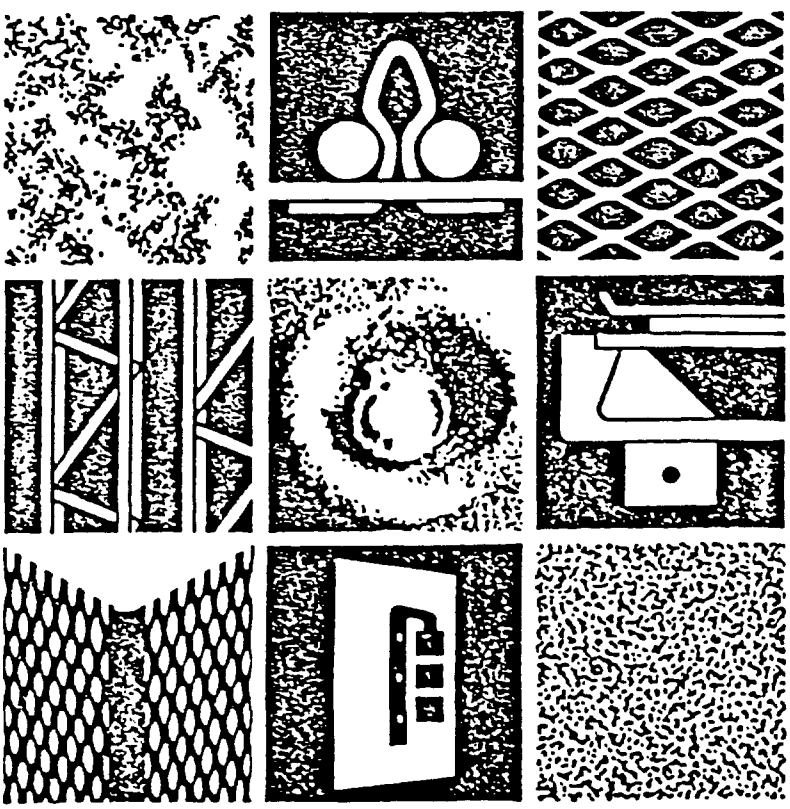
PLAINTIFF'S EXHIBIT

USG-641

INTRA-COMPANY ROUTING SLIP

UNITED STATES GYPSUM

red book of lathing & plastering



P-15 USG Rev 11/69

Printed in U.S.A.

GP041 1768

mixing

A mechanical mixer is preferred to box mixing, because it is easier to assure that the plaster aggregate and water are evenly mixed. Keep the mixer continually clean—a *most* important precaution—because partially set material is a powerful accelerator. Mechanical mixing is mandatory with veneer plaster and RED TOP Radiant Heat Plaster.

When mixing by hand, plaster and sand first should be mixed dry to a uniform color in a mixing box. Then the water is added and the plaster hoed into the water immediately, and thoroughly mixed to a proper consistency.

Proportioning is *weight* of gypsum to *volume* of aggregate.

A No. 2 shovel used to add sand to the plaster mix generally carries 15 lbs., or approximately one-sixth of a cubic foot. Thus, a 100:1 mix would use 6 shovels of sand to 100 pounds of gypsum plaster, a 100:2 mix 12 to 13, and a 100:3 mix 18 to 19 shovels of sand.

Perlite is generally packaged in bags containing 3 or 4 cu. ft. for easy proportioning.

Prepare only one hour's supply of plaster at one time and do not remix if plaster has started to set. All such plaster should be discarded.

finish plasters

Finish coat plasters applied to basecoats provide the surface for final wall or ceiling decoration. Finish coats should be applied only to properly prepared basecoats, except IMPERIAL Finish Plaster that is applied only to IMPERIAL Basecoat Plaster or Plaster Base.

Trowel Finish Coats should be scratched in thoroughly and immediately doubled back to fill out to a smooth, dense surface for decoration, free of surface blemishes and irregularities. Thickness should be 1/16" to 1/8". Keenes cement finishes should be troweled until the material sets.

Float Finish Coats should be scratched in thoroughly and immediately doubled back to a true, even surface. Float, using a shingle, cork, wood, carpet or rubber float to bring aggregate to the surface to produce a finish of uniform texture free of slick spots, cat faces, and other blemishes. Use water sparingly in natural color, and use no water on colored finishes. With ORIENTAL Exterior Finish Stucco, no water should be used in floating or texturing; surface should be fog-sprayed with water for several days after setting.

Machine-Applied Spray Finishes should be uniformly applied to produce a texture approved by the architect.

Acoustical Plasters should be applied in not less than two coats, to full 1/2" grounds, following the manufacturer's directions.

GP041 1770

Two-coat work is acceptable on unperforated gypsum lath and masonry plaster bases.

The UNITED STATES GYPSUM COMPANY maintains a qualified staff of Technical Consultants, Architect Service Representatives, conveniently located in most major markets to assist in resolving specific problems.

NOTE TO THE ARCHITECT

In the preparation of plastering specification consideration should be given to the selection of materials for compatibility and the quality of the structure to be plastered. ASA Specifications and the specifications within the AIA File are based on Minimum Standards. Unfortunately, most plastering specifications are written on a minimum basis, despite the fact that all the elements are available to upgrade plastering for quality installations. It is not possible to be specific without knowing the project under design, the type base, etc., however, it is possible to generalize. The following recommendations are listed in the order of preference:

Finish Coats

1. ORIENTAL Interior (Float Finish only)

Note: Finish 1 , are the only finish recommended for use over a perlited basecoat

Application

Three-coat work is mandatory on all metal lath and edge supported gypsum lath on ceiling construction.

Three-coat work is desirable on all gypsum lath.

GP041 1800

*T.M. Reg. U.S. Pat. Off.

BASECOAT PLASTERS—Cont'd

FINISH COAT PLASTERS

ORIENTAL.* Interior Stucco—A colored finish plaster for a sand float or textured finish. May also be ordered formulated for machine application. Provides excellent hardness and a very durable finish.

FINISH COAT MATERIALS

A chart for the selection of finish coat materials is provided on page 6. The following materials are included:

GP041 1801

*T.M. Reg. U.S. Pat. Off.
(1)T.M. of Plastering Development Center, Inc

FINISH COAT PLASTERS

APPLICATION DATA

DESCRIPTION	FINISH TEXTURE	PHYSICAL PROPERTIES	PROPORTION BY DRY WEIGHT—GAUGING TO LIME	WORKABILITY FACTOR	COMMENTS	COST INDEX
ORIENTAL® Interior Stucco	Colored Float or Texture Finish	Hard and Resistant to Abrasion	Neat	1	Available in white and 6 colors. Mill control of aggregate, size and proportioning.	160

GP041 1802

®T.M. Reg. U.S. Pat. Off.
(1)T.M. of Plastering Development Center, Inc.

V. MATERIALS—Plaster and all cementitious material shall be stored under cover, up off the ground or floor, and kept dry until ready for use.

f. Prepared Finish shall be ORIENTAL Interior Colored Finish as manufactured by the UNITED STATES GYPSUM COMPANY. Colors to be selected by the architect.

GP041 1803

*T.M. Reg. U.S. Pat. Off.

b. ORIENTAL *Interior Colored* Finish shall be mixed with clean water only to proper application consistency.

GP041 1804

*T.M. Reg. U.S. Pat. Off.

FINISH COAT PLASTERS

Finish coat plasters applied to basecoats (generally of gypsum plaster) provide the surface for final wall or ceiling decoration. They are mill prepared, usually requiring the addition of water only.

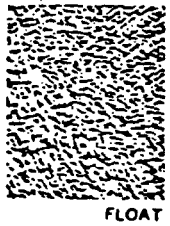
Finish coat plasters are selected according to job requirements for texture, color, hardness, sound absorption and type of basecoat.

Finish coat plasters are ordinarily applied to a minimum thickness of 1/16" for trowel finishes and up to 1/8" for float finishes.

6. ORIENTAL Exterior Finish

USG FINISH PLASTERS—TECHNICAL DATA

product	finish texture	physical properties	proportion by dry weight gauging to lime	comments	bag size (lbs.)	coverage/ton mat'l. (sq. yds.) (1)
ORIENTAL Exterior Stucco	Float or Texture Finish	Extremely Hard and Resistant to Abrasion	Neat	For use over a Portland cement-lime basecoat. Available in white and 11 colors.	100	[illegible]



FLOAT

TROWEL



SPRAY



TEXTURE

(1) 1/16" thickness except as noted.

GP041 1847

GP041 1848

GP041 1869

This book is published as a guide to good lathing and plastering practice *on the job*. Why? Because we all know that a good plastering job is still the most potent sales promoter we in the plastering industry possess!

The RED BOOK is not intended as a complete architectural specification, which is available on special request in another form. Instead, it is designed for Contracting Lathers and Plasterers, Journeyman Lathers and Plasterers, Builders, General Contractors, and Architect's Superintendents—all in the interest of turning out the finest possible plastering work.

Let me remind you that any one of the distinguished USG trademarks listed below is your assurance of: (1) products of uniformly high quality; (2) products carefully researched and rigidly tested; (3) products accepted and trusted by trade and customers alike.

And, you can be sure that United States Gypsum will keep right on guarding the reputation of these products —just as it has been doing ever since the first one was developed and sold 'way back 50 years ago!



Red Tappan
YOUR USG SALESMAN

TRADE-MARK NOTICE: The following trade-marks identify the particular *products manufactured only* by the United States Gypsum Company.

RED TOP Plaster, Finishes and Lime
ROCKLATH Gypsum Lath
BONDCRETE Plaster for Concrete Surfaces
ORIENTAL Colored Plaster and Stucco Finishes
SABINITE Acoustical Plaster
CHAMPION Gauging Plaster
STAR Gauging Plaster
COVER COAT* Finishing Plaster
GRAND PRIZE Finishing Lime
IVORY Finishing Lime
MORTASEAL Masons Lime
PYROBAR Gypsum Partition Tile
COLOR-RITE* Metal Lath
TRUSSTEEL Truss Designed Studs
BRACE-TITE* Attachment Clips
BRIDJOINT Attachment Clips
TEXOLITE Paint Products
USG Gypsum, Lime and Steel
STRUCTO-LITE PLASTER

All but those trade-marks indicated by an are registered in the U. S. Patent Office.*

P-15 Copyright 1951, United States Gypsum Company

The Red Book

of Good Lathing and Plastering Practice

UNITED STATES GYPSUM COMPANY

300 West Adams Street, Chicago 6, Illinois