PLAINTIFF'S EXHIBIT
tabbies
USG-459

SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE Approved: JJ	CONFIDENTIAL DO NOT REPRODUCE OR COPY PRE-FILL MATERIAL (FM-9E)	No. 61-2-29-J Date 6-2-66 Page 3 Cancels Dated NEW

FORMULA

	%
7RF-1 Asbestos	Approx. 7.0%
Tylose	0.5%
MICA JC	(0.7 of Formula V)
B-329 Starch	3.0
Vancide -51Z	0.1
K_2SO_4	0.1
Comm. Retarder	0.01
Vicron 45-3	15.0
Plaster City #3R Stucco	(To make 100%)
TBP	0.2

RAW MATERIALS; Per 61-2-22 except as follows:

Vancide 51Z	Per Bulletin 6-100-1
B-329 Starch	Via Chicago Purchasing Dept.
Plaster City #3R Stucco	Per Bulletin 52-27-2
Potasium Sulfate (Type #2) (Must be screened through 60 Mesh screen before use)	Per Bulletin 6-99-2
Oakfield Comm. Retarder (Double Strength)	Per Bulletin 53-1-10
Tylose Methylcellulose - UM 4000 P	Per Bulletin 6-25-5

MANUFACTURING PROCEDURE

In normal manner used for manufacture of joint compound except a cleanout charge of carbonate fill must be run before the manufacture of this Pre-Fill material. Even small amounts of casein joint compound will severely contaminate the Pre-Fill Material.

The set time of Pre-Fill Material must be checked at both 90-95° F and 40-45° F whenever a new batch of retarder is used. The set time shall not vary more than 30 minutes between 40° and 90° F.

This is a rejection specification.

Special Sampling - A 5 lb. sample of each batch should be sent to Dept. #151 Research - H. P. Ptasienski for duration of this bulletin.

End

USG 00009 0550

Operating Division PRODUCT PROCEDURE	CONFIDENTIAL USG READY-MIXED JOINT COMPOUND TOPPING (JE-851C)	No. 61-2-25-2 Date 8-12-74 Page 1 Cancels Page 1 Dated 5-6-74

DESCRIPTION

Plants to manufacture a special white READY-MIXED Topping Compound for shipment per direction of C.C.P.D. or S.C.P.D. Joint Treatment Product Manager.

MANUFACTURING PLANTS

Chamblee, Gypsum, Jacksonville and Midway.

IDENTIFICATION AND PACKAGING

62 lb. metal or plastic topping pail per PMS 8-29-3 or 8-15-15-3 and 50 lb. topping cartons per PMS 8-10-29.

Chamblee to use the same pails now used for USG Ready Mix All Purpose Joint Compound by applying two pressure sensitive labels to each pail as follows:

Label #1 to be affixed to the front of the container and should read - -

TOPPING

Label #2 to be affixed in the area of the direction panel on the container and should read - -

CAUTION

DO NOT USE TO EMBED TAPE
CAN BE USED TO EMBED FASTENERS,
METAL CORNERBEAD & DRYWALL TRIMS

FINISHED PRODUCT SPECIFICATIONS

A.	Color	- Special White
B.	Viscosity	- 600 ± 30 BB units with pin at 75°F
C.	Bond	- 2 Minimum at 75°F - 50% R.H. - 4 Minimum using Hot Room @ 90°F and 10% R.H.
D.	Wt./Gal.	- 13.5 to 13.7 lbs. per gallon for regular consistency.

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GP01J 0111

Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG READY-MIXED JOINT COMPOUND TOPPING (JE-851C)	No. 61-2-25-2 Date 8-28-74 Page 2 Cancels Page 2 Dated 5-6-74

FORMULA

	R/M#		% N.V.	LBS./2000 LB. N.V.
	61746	325 Mesh W.G. Mica (Note 1)	5.0	100
	61743	ASB. PC7RF-9 (Note 2)	2.0	40
	61774	Pyrax A or		
	61775	Pyrax B	15.0	300
	66458	Methocel 228 (Note 3)	0.7	14
	61453	No. 9 NCS Filler (Note 4)	To make 100%	1,474 (Approx.)
	65272	Ucar 131	3.5	117 (Approx.)
	66685	Troysan 174	0.05	1
	66659	Cosan 158	0.05	1
	67799	Water	———	120-125 Gal.

Note 1: Chamblee and Jacksonville to use Mica P-80F (61747)
Note 2: Midway to use PC TRF-66 (61682)
Chamblee and Jacksonville to use CJM TRF-02 (61741)
Note 3: Chamblee and Jacksonville may use Methocel 65 HG (66465)
Note 4: Midway to use Quincy #3 (61463)
A Gypsum to use a blend of 5 to 10% Terra Alba Filler with 90 to 95% #9NCS or Pfizer FP Carbonate Filler.

RAW MATERIALS

	R/M#		PER
A	61582	Terra Alba	T52-505-2C
	61746	325 W.G. Mica	PMS 6-143-4
	61747	Mica P-80 F	Bulletin 58-61-1
	61743	ASB. PC7RF-9	PMS 6-14-5
	61682	ASB. PC7RF-66	PMS 6-14-10
	61741	ASB. CJM7RF-02	PMS 6-14-10
	61774	Pyrax A	PMS 6-103-1
	61775	Pyrax B	PMS 6-103-2
	66458	Methocel 228	PMS 6-151-16
	66465	Methocel 65HG	PMS 6-25-6
	61453	No. 9 NCS	PMS 6-24-9
	61463	Quincy #3	PMS 6-24-22
	65272	Ucar 131	PMS 6-104-17
	66685	Troysan 174	PMS 6-100-14
	66659	Cosan 158	Cosan Chemical Co.
A	61453	Pfizer FP	PMS 6-24-23

MANUFACTURING PROCEDURE

Per Bulletin 61-2-24.

END.

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TP010 0110

Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND - TOPPING	No. [illegible] Date 10-7-74 Page 2 Cancels NEW Dated

FORMULA - JE-1280C

*R/M #		%	Lbs./500 gals.	
61684	Alsibronz #12 WG Mica	5.0	200	
61971	Windsor 32 Talc	15.0	600	
61741	JMTRF02 Asbestos	3.0	120	
66458	Methocel 228	0.8	32	
66167	Composition T	0.2	8	
61574	No. 1 Terra Alba	72.4	2896	
65272	UCAR 131 (60.0% N.V.)	3.5	140	(25.7 gals.)
66659	Cosan 158 A	0.05	2	
66685	Troysan 174	0.05	2	
67799	Water	- -	275 gals., Hand 310 gals., Machine	

* USG Unified Raw Material Code Number.

RAW MATERIALS

	Per PMS
Alsibronz #12 WG Mica	6-143-4
Windsor 32 Talc	Windsor Minerals Inc.
JMTRF02 Asbestos	6-14-10
Methocel 228	6-151-16
Composition T	Merck Chemical Div., Merck Inc.
No. 1 Terra Alba	52-632-2A
UCAR 131	6-104-55
Cosan 158A	6-100-20
Troysan 174	6-100-14

MANUFACTURING PROCEDURE

Per 61-2-24.

QUALITY CONTROL

Per 61-2-24.

END.

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Rev'd 2530

Originally issued 1-11-74. SPECIAL BULLETIN 2nd Extension

Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND ALL PURPOSE	No. 61-2-24-SS Date 10-7-74 Page 1 Cancels Page 1 Dated 7-26-74

This bulletin to expire 1-1-75.

DESCRIPTION

A softer USG Ready Mixed All Purpose Joint Compound which has bond performance level of a topping compound and is deaerated by processing through a Cornell Versator in vacuo.

MANUFACTURING PLANT

New Brighton

C IDENTIFICATION AND PACKAGING

C D Per PMS _____.

SHIPMENTS

Only to the Baltimore-Washington market and only to accounts approved by N.Y. Dept. #991 during the period of June 1, 1974 through December 31, 1974.

FINISHED PRODUCT SPECIFICATIONS

C C Viscosity: Hand 450-500 B.U.
Machine 300-350 B.U.

Bond: Oven dried at 110° - 120° F, 3 minimum

FORMULA JE1204

R/M #		%	500 Gallon Batch Amount
61747	WHC P80F Mica	16.0	640 lbs.
60265	*New Brighton Terra Alba	76.0	3060 lbs.
61741	JM7RF02 Asbestos	3.0	120 lbs.
66481	Methocel 65HG 4,000 cps	0.8	32 lbs.
61167	Composition T-Merck 98900	0.2	8 lbs.
65272	**UCAR 131 Acetate	3.5	34.85 gals.
66659	**Cosan 158A	.05	2 lbs.
66685	**Troysan 174	.05	2 lbs.
	Water	Approximately 260 gallons for regular consistency.	

*This formula can only be made with Terra Alba.

UP009 1239

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Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND ALL PURPOSE	No. 61-2-24-SS Date 10-7-74 Page 2 Cancels Page 2 Dated 7-26-74

C FORMULA JE1204 (Cont'd.)

The use of Pfizer Limestone will result in gelation and frothing of the batch.

**To prepare emulsion for this formula, at 45% solids containing correct proportions of Cosan 158A and Troysan 174 use the following procedure. To each 100 gallons of UCAR 131 as received (60% N.V.) stir in 37 gallons of H_2O. To this add 7.9 lb. of Cosan 158A and 7.9 lb. of Troysan 174. Do not intermix Cosan 158 and Troysan 174 prior to adding individually into diluted UCAR 131.

RAW MATERIALS

	PMS
WHC P80F Mica	6-143-1
NB Terra Alba	52-632-2A
JMTRF02 Asbestos	6-14-10
Methocel 65HG4,000 cps	6-25-6
Composition T-Merck 98900	Merck Chemical Div. Merck, Inc.
UCAR 131	6-104-55
Cosan 158A	Cosan Chemical
Troysan 174	6-100-14

MANUFACTURING PROCEDURE

Mixing Procedure on Hockmeyer Mixer

Approximately 90% of the total water that will be required is put into the Hockmeyer mixer. Simultaneously the latex and preservative are added with the mixer running. Start vibrating dry ingredients into the batch while the batch water is being added. Time the addition of the dry ingredients so as to be completed simultaneously with completion of the water addition. Batch is then to be mixed at heavy viscosity until all lumps are broken down and all materials thoroughly mixed. Additional water is then added until mix is smooth and homogeneous and watt meter indicates the desired viscosity has been reached.

Deaeration

Batch is then to be processed through the Cornell Versator. Vacuum pressure and processing speed are to be determined by operating personnel based on what is needed to give the most "air void free" product.

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Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND ALL PURPOSE	No. 61-2-24-SS Date 10-7-74 Page 3 Cancels Page 3 Dated 1-11-74

C
C

QUALITY CONTROL

Initial Viscosity

To be determined on each batch as per 61-2-22.

24-Hour Viscosity

To be determined on every 3 to 5 batches, depending on length of run on this formula. A change of ± 100 B.U. is to be rejected.

Application Properties

To match standard.

Grit

No scratching on tight drawdown over gypsum board with board knife.

END.

DP009 1241

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Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND ALL PURPOSE	No. 61-2-74 Date 10-8-74 Page 1 Cancels Page 1 Dated 7-18-74

DESCRIPTION

An All Purpose Joint Compound which has been processed through a Cornell Versator for deaeration. This product will be manufactured in two ready-to-use viscosities (Machine and Hand).

MANUFACTURING PLANT

New Brighton

IDENTIFICATION AND PACKAGING

Per PMS _____.

FINISHED PRODUCT SPECIFICATIONS

Viscosity	Machine - 270-310 Brabender Units Hand - 450-550 Brabender Units
Bond	Oven dried at 110-120F., 6 minimum

TP009 0444

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Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND ALL PURPOSE	No. 61-2-24 Date 10-6-74 Page 2 Cancels Page 2 Dated 4-14-71

FORMULA JE-924

* R/M #		%	Lbs. Per 500 Gals.
61747	WMC P-80F Mica	10.0	400
61763	Narvon CE-F-1	15.0	600
61741	JM7RF02 Asbestos	3.0	120
61898	Huber CWF Clay	5.0	200
66465	Methocel 65HG 4,000 cps.	0.8	32
60245	Mapico Yellow 1000	———	As Required
61574(Note 1)	No. 1 Terra Alba	60.6	2500
65272	UCAR 131 (60.0% N.V.)	5.5	220 (40 gals.)
66685	Troysan 174	0.05	2
66659	Cosan 158A	0.05	2
67799	Water	———	Approx. 280 Gals. for HAND Approx. 320 Gals. for Machine

NOTE 1: FP Limestone (61567) or Rambo No. 4 (61460) may be substituted for No. 1 Terra Alba. Pounds per 500 gallon batch are rounded off at 2500 to accommodate 100 pound bags.

* USG Unified Raw Material Code Number.

RAW MATERIALS

	Per PDS
WMC P-80F Mica	6-143-1
Narvon CE-F-1	6-146-2
JM7RF02 Asbestos	6-14-10
Huber CWF Clay	6-36-5
Methocel 65HG 4,000 cps.	6-25-6
Mapico Yellow 1000	6-94-81
No. 1 Terra Alba	52-632-2A
FP Limestone	6-24-23
Rambo #4	6-24-9
UCAR 131	6-104-55
Troysan 174	6-100-14
Cosan 158A	6-100-20

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Cancels pages 4 and 5 dated 4-14-71.

Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND ALL PURPOSE	No. 61-2-24 Date 10-8-74 Page 3 Cancels Page 3 Dated 12-7-73

MANUFACTURING PROCEDURE

Mixing Procedure on Hockmeyer Mixer

Approximately 90% of the total water that will be required is put into the Hockmeyer mixer. Simultaneously the latex and preservative are added with the mixer running. Start vibrating dry ingredients into the batch while the batch water is being added. Time the addition of the dry ingredients so as to be completed simultaneously with completion of the water addition. Batch is then to be mixed at heavy viscosity until all lumps are broken down and all materials thoroughly mixed. Additional water is then added until mix is smooth and homogeneous and watt meter indicates the desired viscosity has been reached.

Deaeration

Batch is then processed through the Cornell Versator. Vacuum pressure and processing speed are to be determined by operating personnel based on what is needed to give the most "air void free" product.

Filling

All containers to be filled with 62 lbs. of material regardless of consistency.

QUALITY CONTROL

Viscosity - To be determined after the compound has stood for 24 hours, using the following setup.

a. Compound to be at 77F. ± 5F. in a 1/2 pint paint can with pin paddle immersed to mark on the paddle stem.
b. Can spindle to rotate at 75 rpm on VC-3, 250gm. cm. head, Brabender Visco Corder

Application Properties - To match standard sample from Research.

Grit - No scratching on tight drawdown over gypsum board with board knife.

Bond to PERF-A-TAPE - 4 minimum when dried 24 hours at 70-80F., 40-60% R.H.

Rewet Test - 2 normal

Tape Edge Cracking or Check Cracking - None visible on bond test sample.

Odor - Characteristic

NOTE: These tests to be performed in accordance to those outlined for PERF-A-TAPE Compounds in bulletin 61-2-22.

END.

UPCC9 0516

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Operating Division PRODUCT PROCEDURE	CONFIDENTIAL USG CF READY-TO-USE JOINT COMPOUND ALL PURPOSE - SOUTH GATE	No. 61-2-24-4 Date 10-23-74 Page 1 Cancels Page 1 Dated 7-22-74

C

DESCRIPTION

A resin-emulsion base, ready-mixed joint compound. Manufactured using Regular Production Method or the CF Process. All shipments as directed by L. A. #961 Product Manager.

MANUFACTURING PLANT

South Gate

IDENTIFICATION AND PACKAGING

A. Packaging

1. 12 Lb. Pail
C Use 1 gallon plastic pail per PMS _____. Master carton per PMS_____.

2. 62 Lb. Pail
C Per PMS _____.

3. 50 Lb. Carton
C Per PMS 8-10-29-1. Liner per PMS_____.

B. Identification

1. Containers to be labeled as directed by Dept. #147-2.

FINISHED PRODUCT SPECIFICATIONS

C Viscosity - 550 ± 30 BB units
pH - 8.6 ± .3

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OPC09 1530

Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND ALL PURPOSE - SOUTH GATE	No. 61-2-24-4 Date 10-23-74 Page 2 Cancels Page 2 Dated 7-22-74

FORMULA - JE-304C

R/M #		% N.V.	LBS./4000 LBS. N.V.
61747	Mica P-80 F	7.5	300
61772	Chromocal	17.5	700
61740	SG 210 ASB.	2.0	80
66481	Methocel 65HG	0.8	32
66167	Composition T	0.1	4
61583	Landplaster - bulk	to make 100%	2,680 (approx.)
65273	AMSCO 3001P	5.0	333 (approx. 36.6 gal.)
66685	Troysan 174	0.05	2
66664	Troysan EX364 (Note 1)	0.05	2
67799	Water	—	232 gal. (approx.)
61581	Lime Hydrate (Note 2)	0.05	

Note 1: Alternate 66660 Troysan CMP Acetate.
Note 2: Lime Hydrate content to range from 0.025 to 0.05% to obtain pH range of 8.6 ± .3.

RAW MATERIALS

	Per
Mica P-80 F	Bulletin 58-61-1
Chromocal	PMS 6-146-2
Asbestos SG210	PMS 6-14-11
Methocel 65HG	PMS 6-25-6
Composition T	Merck Chemical Co.
Landplaster Bulk	Bulletin 52-301-2B
AMSCO 3001P	PMS 6-104-55
Troysan 174	PMS 6-100-14
Troysan EX364	Troy Chemical Co.
Troysan CMP Acetate	PMS 6-100-5

DP009 1691

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Operating Division PRODUCT PROCEDURE	CONFIDENTIAL USG CF READY-TO-USE JOINT COMPOUND ALL PURPOSE - SOUTH GATE	No. 61-2-24-4 Date 10-23-74 Page 3 Cancels Page 3 Dated 7-22-74

C

MANUFACTURING PROCEDURE

Mixing Procedure on Hockmeyer Mixer:
Approximately 90% of the total amount of water that will be required is put into the Hockmeyer mixer. (The quantity of water used initially should be the smallest amount which can be used without overloading the motor when the dry materials are added). The Preservative is added and the mixer is run for a few turns to disperse this material. The dry materials and plasticized emulsion are then added and the batch is mixed until all lumps are broken down and all materials thoroughly mixed. The mixer is then turned off and the viscosity of a sample is determined on a Brabender viscosimeter. Additional water, as required, is then added and the batch mixed until a smooth, homogeneous mixture is obtained. The mixer is then stopped and another sample is checked on the viscosimeter. If the viscosity is still too high, this procedure is repeated until the proper viscosity is reached. Batch is then "CF" Processed.

Filling
All containers are to be filled by weight.

QUALITY CONTROL

A. Viscosity

1. Compound to be at 77°F. ± 5°F in a standard 1/2 pint paint can with pin paddle immersed to mark on paddle stem.
2. Can spindle to rotate 75 RPM on VC-3, 250 gm. cm. head, Brabender Viscometer.

B. Application Properties - To match standard sample from Research.

C. Grit - None

D. Bond to PERF-A-TAPE - Applied and dried at 70 - 80°F, 40 - 60% R.H. - 5 min.

E. Rewet Test - 2 normal.

F. Tape Edge Cracking or Check-Cracking - (in bond test application) None

G. Color - Formula JE-304C to match the color of Research standard (Natural)

H. Odor - Characteristic

Note - These tests to be performed Per Bulletin 61-2-22.

END

JP009 1692

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Operating Division PRODUCT PROCEDURE	CONFIDENTIAL USG CF READY-TO-USE JOINT COMPOUND TOPPING (JE-851C)	No. 61-2-25-2 Date 10-23-74 Page 1 Cancels Page 1 Dated 8-12-74

C

DESCRIPTION

Plants to manufacture a special white READY-MIXED Topping Compound for shipment per direction of C.C.P.D. or S.C.P.D. Joint Treatment Product Manager.

MANUFACTURING PLANTS

Chamblee, Gypsum, Jacksonville and Midway.

IDENTIFICATION AND PACKAGING

C 62 lb. metal or plastic topping pail per PMS _____ or _____ and 50 lb.
C topping cartons per PMS 8-10-29-1.

Chamblee to use the same pails now used for USG Ready Mix All Purpose Joint Compound by applying two pressure sensitive labels to each pail as follows:

Label #1 to be affixed to the front of the container and should read - -

TOPPING

Label #2 to be affixed in the area of the direction panel on the container and should read - -

CAUTION

DO NOT USE TO EMBED TAPE
CAN BE USED TO EMBED FASTENERS,
METAL CORNERBEAD & DRYWALL TRIMS

FINISHED PRODUCT SPECIFICATIONS

A.	Color	- Special White
C B.	Viscosity (Note 1)	- 600 ± 30 BB units with pin at 75°F
C.	Bond	- 2 Minimum at 75°F - 50% R.H. - 4 Minimum using Hot Room @ 90°F and 10% R.H.
D.	Wt./Gal.	- 13.5 to 13.7 lbs. per gallon for regular consistency.

A Note 1: Chamblee and Jacksonville

Machine	350 - 400 BB units
Hand	500 - 550 BB units
Regular	600 - 650 BB units

TP013 0107

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Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND TOPPING (JE-851C)	No. 61-2-25-2 Date 10-23-74 Page 2 Cancels Page 2 Dated 8-28-74

C

FORMULA

B/M#		% N.V.	LBS./2000 LB. N.V.
61746	325 Mesh W.G. Mica (Note 1)	5.0	100
61743	ASB. PCTRF-9 (Note 2)	2.0	40
61774	Pyrax A or		
61775	Pyrax B	15.0	300
66458	Methocel 228 (Note 3)	0.7	14
61453	No. 9 NCS Filler (Note 4)	To make 100%	1,474 (Approx.)
65272	Ucar 131	3.5	117 (Approx.)
66685	Troysan 174	0.05	1
66659	Cosan 158	0.05	1
67799	Water	———	120-125 Gal.

Note 1: Chamblee and Jacksonville to use Mica P-80F (61747)
Note 2: Midway to use PC TRF-66 (61682)
Chamblee and Jacksonville to use CJM TRF-02 (61741)
Note 3: Chamblee and Jacksonville may use Methocel 65 HG (66465)
Note 4: Midway to use Quincy #3 (61463)
Gypsum to use a blend of 5 to 10% Terra Alba Filler with 90 to 95% #9NCS or Pfizer FP Carbonate Filler.

RAW MATERIALS

	PER
Terra Alba	T52-505-2C
325 W.G. Mica	PMS 6-143-4
Mica P-80 F	Bulletin 58-61-1
ASB. PCTRF-9	PMS 6-14-5
ASB. PCTRF-66	PMS 6-14-10
ASB. CJMTRF-02	PMS 6-14-10
Pyrax A	PMS 6-103-1
Pyrax B	PMS 6-103-2
Methocel 228	PMS 6-151-16
Methocel 65HG	PMS 6-25-6
No. 9 NCS	PMS 6-24-9
Quincy #3	PMS 6-24-22
Ucar 131	PMS 6-104-17
Troysan 174	PMS 6-100-14
Cosan 158	Cosan Chemical Co.
Pfizer FP	PMS 6-24-23

MANUFACTURING PROCEDURE

Per Bulletin 61-2-24.

END

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TP010 0109

Originally issued 5-8-74

Operating Division PRODUCT PROCEDURE	CONFIDENTIAL USG CF READY-TO-USE JOINT COMPOUND TOPPING - JE 1221G	No. 61-2-25-U Date 10-23-74 Page 1 Cancels Page 1 Dated 7-11-74

This bulletin to expire 5-1-75.

DESCRIPTION

A new, lower cost topping compound which utilizes Plaster City classified Terra Alba. Trials and subsequent shipments as directed by WCPD Division Joint Treatment Product Manager.

MANUFACTURING PLANT

South Gate

IDENTIFICATION AND PACKAGING

C 62 lb. plastic pail per PMS _____. Circular plastic sheet per PMS _____ to be laid over the surface of the compound.

C 50 lb. carton per PMS 8-10-29-1. Liner per PMS _____. The letter "K" to follow normal code for identification.

FINISHED PRODUCT SPECIFICATIONS

a.	Color	- natural	
C b.	Viscosity -	- Hand	475 ± 25
		- Machine	400 ± 25
c.	Bond	- 2 minimum	
d.	pH	- 7.3 - 7.8	

1252 5242

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Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND TOPPING - JE 1221G	No. 61-2-25-U Date 10-23-74 Page 2 Cancels Page 2 Dated 7-11-74

C

FORMULA - JE1221G

R/M #		%	LBS./4000 lb. N.V.
61747	Mica P-80 F	1.25	50
66460	Cellosize QP100M	0.7	28
66167	Composition T	0.2	8
61740	SG-210 Asbestos	1.5	60
61561	Lime Hydrate	0.05	2
61457	Landplaster - Bulk	To make 100%	Approx. 3,682
65273	AMSCO 3001P	2.5	166 (approx. 18 gal.)
66685	Troysan 174	0.05	2
66660	Troysan CMP Acetate	0.05	2
67799	Water	——	Approx. 226 gal.

RAW MATERIALS

	PER
Mica P-80 F	PMS 6-143-1
Cellosize QP100M	Union Carbide Corp.
Composition T	Merck Chemical Company
SG-210 Asbestos	PMS 6-14-11
Lime Hydrate	Oro Grande Lime and Stone Corp.
Landplaster - Bulk	USG - Plaster City
Amsco 3001P	PMS 6-104-55
Troysan 174	PMS 6-100-14
Troysan CMP Acetate	PMS 6-100-5
Water	

MANUFACTURING PROCEDURE

Pre-blend mica and thickener prior to addition to reduce thickener lumping tendency. Mix at heavy viscosity originally then add water to adjust viscosity. Batches to be "CP" processed.

END

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USG 2522

Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND TAPING - SOUTH GATE	No. 61-2-24-5 Date 10-23-74 Page 1 Cancels Page 1 Dated 8-30-74

DESCRIPTION

South Gate to manufacture READY-TO-USE Joint Compound, Taping - formula JE-684-P, using the CF process. Shipments to be directed by L.A. #961.

IDENTIFICATION AND PACKAGING

Letter "N" to precede code on all production. Packaging per Purchase Specification Bulletin 8-15-15-4.

Circular Plastic Sheet per PMS 8-5-11, to be laid over the surface of compound in 62 lb. pails.

ATES TAPING TOOL

55 lb. Plastic Pail. (Note: Plant to use 55# Label over 62# net on Pail).

FINISHED PRODUCT SPECIFICATIONS

A. Viscosity - Hand - 275 ± 25 BB
Machine - 180 ± 25 BB

All viscosities run using VC-3 Brabender pin paddle @75 RPM, 250 cm gm torque head.

B. Bond - 5 minimum. Tested as per Bulletin 61-2-24-4.

C. Color - Natural

D. Application and dry appearance - To match plant standards. No grit or lumps in application. No cracking on bond test panel. Testing as per Bulletin 61-2-24-4.

E. pH - 8.0 - 8.5

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NP009 1956

Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND TAPING - SOUTH GATE	No. 61-2-24-5 Date 10-23-74 Page 2 Cancels Page 2 Dated 7-24-74

C

FORMULA (JE-684F)

	R/M #	FORMULA	% N.V.	2000 LBS. N.V.
	61747	Mica P-80 F	1/2 Formula V	140 to 160 approx.
	61759	Mica S (at same level as P-80 F)	7 to 8%	140 to 160 approx.
	61740	SG 210 Asbestos	As Req. for VISC. 3% Normal	60 approx.
	66481	Methocel 65HG	0.8%	16
	61568	Terra Alba	to 100% N.V.	1500 approx.
	65683	Hamaco 267	2.0%	40
	65273	VA 3001P	2.5	83.3
C	66298	Tamol 850 (Note 1)	—	3
C	66664	Troysan EX364 (Note 2)	—	1
	66685	Troysan 174	—	1
		Water	—	160 to 162 gal. approx. for regular viscosity.

NOTES:

1. Add Tamol 850 to water and emulsion and mix before adding dry ingredients. Tamol 850 is not required when "CF" Process is employed.

A 2. Alternate 66660 Troysan CMP Acetate.

RAW MATERIALS

Per bulletin 61-2-24-4. Plus:

R/M #	RAW MATERIAL	PER
66298	Tamol 850	PMS 6-177-9
65683	Hamaco 267	PMS 6-124-11

MANUFACTURING PROCEDURE

General Procedure per bulletin 61-2-24-4.

END

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UP009 1857

Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND ALL PURPOSE - JE-1128C	No. 61-2-24-2-2 Date 10-25-74 Page 1 Cancels Page 1 Dated 1-25-74

C

DESCRIPTION

An emulsion based product containing two-thirds the normal amount of mica in conjunction with DXW Mineralite to alleviate current mica shortage.

MANUFACTURING PLANT

Dallas

IDENTIFICATION AND PACKAGING

C 50 lb. carton per PMS 8-10-29-1.

FINISHED PRODUCT SPECIFICATIONS

C	Viscosity	Regular - 600 ± 30 Brabended units with pin paddle at 77°F. (Note 1)
A		Hand - 475 ± 30 BB (Note 2)
A		Machine - 400 ± 30 BB (Note 2)
	Color	Natural unless pigmented specified.
	Bond-to Tape	5 minimum at 77°F. - 50% RH.
	Weight per gallon	12.8 to 13.0 lbs. per gallon

A Note 1: For Central Construction Products Division only.

A Note 2: Manufactured and shipped only after approval from Dept. #971 or #981.

	RAW MATERIAL NO.	FORMULA	% N.V.	LBS. PER 250 GAL.
	61747	P-80F	2/3 formula V	approx. 200
	61762	DXW Mineralite	15.0%	300
	61741	7RF02 Asbestos	3.5 to 4.0%	70 to 80
	66481	Methocel 65HG	0.8%	16
	61466	Microfill #4	to make 94.5%	To make 1,890 lbs.
	65272	PM-4386 (60%)	5.5	183
	66685	Troysan 174	—	1
C	66659	Cosan 158	—	1
	66167	Composition T	0.2	4.0

RAW MATERIALS

DXW Mineralite	Per PMS 6-146-2
Composition T (Merck 98900)	Merck Chemical Divn., Merck, Inc.

Other raw materials per Bulletin 61-2-24-1.

END

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DP009 1627

Originally issued 6-2-72 SPECIAL BULLETIN 2nd Extension

Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND TOPPING - JR-1010T	No. 61-2-25-Q Date 10-25-74 Page 1 Cancels Page 1 Dated 5-22-74

C

This bulletin expires 6-1-75.

DESCRIPTION

A low shrinkage topping compound, containing Southard Terra Alba, designed for joint finishing with minimum cratering.

MANUFACTURING PLANT

Dallas

IDENTIFICATION AND PACKAGING

C 50 lb. cartons per PMS 8-10-29-1.

FINISHED PRODUCT SPECIFICATIONS

	A.	Color	Natural White
C	B.	Viscosity	Regular - 600 ± 30 BB units with pin at 75°F. (Note 1)
A			Hand - 475 ± 30 BB (Note 2)
A			Machine - 400 ± 30 BB (Note 2)
	C.	Bond	2 minimum
	D.	Weight per Gal.	About 13.1 lbs. per gal.

A Note 1: For Central Construction Products Division only.

A Note 2: Manufactured and shipped only after approval from Dept. #971 or #981.

FORMULA

	% NON-VOLATILE	LBS/2000 LBS N.V.
P-80F Mica	1.25	25
7RF02 Asbestos	2.0	40
Cellosize QP-100M	0.7	14
Southard Terr Alba to make	92.05	1841
PM-4386 (60%)	4.0	133
C CMP Acetate or Cosan 158	-	1
Troysan 174	-	1
Composition T	0.2	4

7P009 2490

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Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND TOPPING - JE-1010T	No. 61-2-25-Q Date 10-25-74 Page 2 Cancels Page 2 Dated

C

RAW MATERIALS

Cellosize QP-100M	Union Carbide
Southard #1 Terra Alba	52-227-2B
P80F Mica	PMS 6-143-1
C Cosan 158	Cosan Chemical Company
Troysan 174	PMS 6-100-14
7RF02 Asbestos	PMS 6-14-10
PM4386 (60% solids)	PMS 6-104-55
Composition T - Merck 98900	Merck Chemical Company
A CMP Acetate	PMS 6-100-5

END

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Operating Division PRODUCT PROCEDURE	CONFIDENTIAL USG CP READY-TO-USE JOINT COMPOUND - ALL PURPOSE - JE-598-D	No. 61-2-24-2-1 Date 12-4-74 Page 3 Cancels Page 3 Dated 12-12-73

C

FORMULA - JE-598-D

	% Non Volatile	Lbs. for 250 gal. batch (2000 lbs. N.V.)
Mica P80F	Formula V	300 approximately
Asbestos (Note 2)	As req'd for correct BB and water content	70 approximately
Carbonate Filler (Note 1)	To make 100% N.V.	To make up 1890 lbs. N.V.
PM-4386 emulsion	5.5%	183.3 lbs.
Methocel 65HG	0.8%	16 lbs.
Cosan 158A	-	1 lb.
Troysan 174	-	1 lb.
Water	- - - - -	approx. 130 gal.

NOTE: 1. Dallas to use Microfil #4.
Midway to use Quincy #3.
Dallas to use Southard's #1 Terra Alba when directed by Product Managers in CCPD or SCPD.

NOTE: 2. Midway to use TRF66 Asbestos, Dallas to use JMTRF02.

RAW MATERIALS

Mica	Per Bulletin 6-143-1
ASBESTOS	Per Bulletin 6-14-10 and 6-14-5
Carbonate Filler	Per Bulletin 6-24-9, 6-24-10 and 6-24-22
Methocel	Per Bulletin 6-25-6
PM-4386	Per Bulletin 6-104-55
#1 Terra Alba	Per Bulletin 52-227-2B
Troysan - 174	Per Bulletin 6-100-14
Cosan 158A	Cosan Chemical Company

DP009 1514

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Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND - ALL PURPOSE - JE-598-D	No. 61-2-24-2-1 Date 12-4-74 Page 4 Cancels Page 4 Dated 3-1-73

MANUFACTURING PROCEDURE

Compound Mixing -

Note - Be sure there is sufficient Ready Mixed Compound from the previous batch left around the outlet gate to insure a water tight seal.

1. Run approx. 100 gal. of water into the mixer. Mix 1/4 minute. The preservative is then added and the mixer is run for a few turns to disperse this material. The emulsion is then added to the mixer.

2. Start the mixer and add the weighed dry powder ingredients. Mix for ten minutes after completing the addition of the dry materials.

3. If at the end of this time the batch is too stiff, up to 2 gal. more water may be added to bring it to consistency; if too thin, up to 20 lbs. more asbestos may be added to stiffen it. Mixing is continued after completing such additions for an least 5 minutes, then the viscosity of the batch is checked. If satisfactory the compound is ready for packing for shipment. If the viscosity is outside the permissible consistency range following the maximum permissible addition of water, or of asbestos, the batch should be reconditioned by working it off in succeeding batches.

   Note: The viscosity of the compound and to some degree the application properties are affected by the total mixing time given the batch. Hence when the best mixing procedure is worked out at the plant it should be closely adhered to in succeeding batches (i.e., the temperature of wet mix, and the total mixing time given the batch prior to packing should both be closely controlled.) During packing the mixer should be on for the minimum possible time to minimize product viscosity difference from the first to the last cans packed.

END.

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NP009 1515

Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE ALL PURPOSE - JE-1320B	No. 61-2-24-4-N Date 11-25-74 Page 2 Cancels NEW Dated

FORMULA

#R/M#		% N.V.	LBS/4000 LBS. (N.V.)
61747	Mica P-80F	1.25	50
66458	Methocel 228	0.7	28
61740	Asbestos SG-210	2.5	100
65683	Hamaco 267	1.0	40
61561	Lime Hydrate	0.05	2
61457	Landplaster, Bulk	91.4	3656
65273	AMSCO 3001P	3.0	200 (approx. 22 gal.)
66660	Troysan CMP Acetate	0.05	2
66685	Troysan 174	0.05	2
67799	Water	As req'd	approx. 270 gal.
60245	Mapico Yellow 1000	As req'd	approx. 2 lbs.

* USG Unified Raw Material Code Number.

RAW MATERIALS

	Per
Mica P-80F	PMS 6-143-1
Methocel 228	PMS 6-151-16
Asbestos SG-210	PMS 6-14-11
Hamaco 267	PMS 6-124-11
Lime Hydrate	PMS 6-69-1
Landplaster, Bulk	52-301-2B
AMSCO 3001P	PMS 6-104-55
Troysan CMP Acetate	PMS 6-100-5
Troysan 174	PMS 6-100-14
Water	- - -
Mapico Yellow 1000	PMS 6-94-81

MANUFACTURING PROCEDURE

Per bulletin 61-2-24-4.

QUALITY CONTROL

Per bulletin 61-2-24-4.

END.

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UP009 1845

Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND TOPPING (JE-851C)	No. 61-2-25-2 Date 12-12-74 Page 1 Cancels Page 1 Dated 10-23-74

DESCRIPTION

Plants to manufacture a special white READY-MIXED Topping Compound for shipment per direction of C.C.P.D. or S.C.P.D. Joint Treatment Product Manager.

MANUFACTURING PLANTS

C Chamblee, Gypsum, and Midway.

IDENTIFICATION AND PACKAGING

C 62 lb. metal or plastic topping pail per PMS 8-29-3-1 or 8-15-15-4 and 50 lb. topping cartons per PMS 8-10-29-1.

Chamblee to use the same pails now used for USG Ready Mix All Purpose Joint Compound by applying two pressure sensitive labels to each pail as follows:

Label #1 to be affixed to the front of the container and should read - -

TOPPING

Label #2 to be affixed in the area of the direction panel on the container and should read - -

CAUTION

DO NOT USE TO EMBED TAPE
CAN BE USED TO EMBED FASTENERS,
METAL CORNERBEAD & DRYWALL TRIMS

FINISHED PRODUCT SPECIFICATIONS

A.	Color	- Special White
B.	Viscosity (Note 1)	- 600 ± 30 BB units with pin at 75°F
C.	Bond	- 2 Minimum at 75°F - 50% R.H. - 4 Minimum using Hot Room @ 90°F and 10% R.H.
D.	Wt./Gal.	- 13.5 to 13.7 lbs. per gallon for regular consistency.

C Note 1: Chamblee

Machine	350 - 400 BB units
Hand	500- 550 BB units
Regular	600 - 650 BB units

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5010 C10aJ

Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND TOPPING (JF-851C)	No. 61-2-25-2 Date 12-12-74 Page 2 Cancels Page 2 Dated 10-23-74

FORMULA

R/M#		% N.V.	LBS./2000 LB. N.V.
61746	325 Mesh W.G. Mica (Note 1)	5.0	100
61743	ASB. PCTRF-9 (Note 2)	2.0	40
61774	Pyrax A or		
61775	Pyrax B	15.0	300
66458	Methocel 228 (Note 3)	0.7	14
61453	No. 9 NCS Filler (Note 4)	To make 100%	1,474 (Approx.)
65272	Ucar 131	3.5	117 (Approx.)
66685	Troysan 174	0.05	1
66659	Cosan 158	0.05	1
67799	Water	———	120-125 Gal.

C Note 1: Chamblee to use Mica P-80F (61747)
Note 2: Midway to use PC TRF-66 (61682)
C Chamblee to use CJM TRF-02 (61741)
C Note 3: Chamblee may use Methocel 65 HG (66465)
Note 4: Midway to use Quincy #3 (61463)
Gypsum to use a blend of 5 to 10% Terra Alba Filler with 90 to 95% #9NCS or Pfizer FP Carbonate Filler.

RAW MATERIALS

	PER
Terra Alba	T52-505-2C
325 W.G. Mica	PMS 6-143-4
Mica P-80 F	Bulletin 58-61-1
ASB. PCTRF-9	PMS 6-14-5
ASB. PCTRF-66	PMS 6-14-10
ASB. CJMTRF-02	PMS 6-14-10
Pyrax A	PMS 6-103-1
Pyrax B	PMS 6-103-2
Methocel 228	PMS 6-151-16
Methocel 65HG	PMS 6-25-6
No. 9 NCS	PMS 6-24-9
Quincy #3	PMS 6-24-22
Ucar 131	PMS 6-104-17
Troysan 174	PMS 6-100-14
Cosan 158	Cosan Chemical Co.
Pfizer FP	PMS 6-24-23

MANUFACTURING PROCEDURE

Per Bulletin 61-2-24.

END.

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Contains portions of material formerly on page 1 dated 10-25-74.

Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND ALL PURPOSE - JE-1128C	No. 61-2-24-2-2 Date 1-20-75 Page 2 Cancels NEW Dated

FORMULA

*R/M #		% N.V.	LBS. PER 250 GAL.
61747	P-80F	2/3 formula V	Approx. 200
61762	99X Mineralite	15.0%	300
61741	TRF02 Asbestos	3.5 to 4.0%	70 to 80
66481	Methocel 65HG	0.8%	16
61466	Microfil #4	To make 94.5%	To make 1,890 lbs.
65272	PM-4386 (60%)	5.5	183
66685	Troysan 174	- - -	1
66659	Cosan 158	- - -	1
66167	Composition T	0.2	4.0

* USG Unified Raw Material Code Number.

RAW MATERIALS

99X Mineralite	Per PMS 6-146-2
Composition T (Merck 98900)	Merck Chemical Divn., Merck, Inc.

Other raw materials per Bulletin 61-2-24-1.

END.

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NP009 1676

Operating Division PRODUCT PROCEDURE	CONFIDENTIAL USG CF READY-TO-USE JOINT COMPOUND TOPPING (JE-851C)	No. 61-2-25-2 Date 1-27-75 Page 1 Cancels Page 1 Dated 1-16-75

DESCRIPTION

Plants to manufacture a special white READY-MIXED Topping Compound for shipment per direction of C.C.P.D. or S.C.P.D. Joint Treatment Product Manager.

MANUFACTURING PLANTS

Chamblee, Gypsum, and Midway.

IDENTIFICATION AND PACKAGING

62 lb. metal or plastic topping pail per PMS 8-29-3-1 or 8-15-15-4 and 50 lb. topping cartons per PMS 8-10-29-1.

Chamblee to use the same pails now used for USG Ready Mix All Purpose Joint Compound by applying two pressure sensitive labels to each pail as follows:

Label #1 to be affixed to the front of the container and should read - -

TOPPING

Label #2 to be affixed in the area of the direction panel on the container and should read - -

CAUTION

DO NOT USE TO EMBED TAPE
CAN BE USED TO EMBED FASTENERS,
METAL CORNERBEAD & DRYWALL TRIMS

FINISHED PRODUCT SPECIFICATIONS

A.	Color	- Special White (Note 2)
B.	Viscosity (Note 1)	- 600 ± 30 BB units with pin at 75°F
C.	Bond	- 2 Minimum at 75°F - 50% R.H. - 4 Minimum using Hot Room @ 90°F and 10% R.H.
D.	Wt./Gal.	- 13.5 to 13.7 lbs. per gallon for regular consistency.

Note 1: Chamblee
C, D Machine 425-475 BB units
C Regular 500-550 BB units

Note 2: Pigmented available at Gypsum in batch size increments. Department #971-C to be notified of all such production.

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7901 0106

Originally issued 5-21-73. SPECIAL BULLETIN 2nd Extension

Operating Division PRODUCT PROCEDURE	CONFIDENTIAL USG CF READY-TO-USE JOINT COMPOUND ALL PURPOSE	No. 61-2-24-PP Date 2-14-75 Page 1 Cancels Page 1 Dated 8-28-74

C

This Bulletin expires 6-1-75.

DESCRIPTION

An emulsion based product.

MANUFACTURING PLANTS

C Gypsum and Midway

IDENTIFICATION AND PACKAGING

Normal code
Packaging per Bulletin 61-2-24-AA.

FINISHED PRODUCT SPECIFICATIONS

C

Viscosity	Regular	- 600 ± 30 BB	
	Hand	- 475 ± 30 BB	(Note 1)
	Machine	- 400 ± 30 BB	(Note 1)
	Extra	- 730 ± 30 BB	(Note 1)

Color - Natural unless pigment specified.
Bond-To-Tape - 4 minimum at 77°F - 50% R.H.
Weight per Gallon - 12.8 to 13.0 lbs. per gallon.

A Note 1: Manufactured and shipped as approved by Dept. #971.

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Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND ALL PURPOSE	No. 61-2-24-FP Date 2-14-75 Page 2 Cancels Page 2 Dated 8-28-74

FORMULA (JE-1281B)

*R/M #		% N.V.	LBS. PER 250 GAL. BATCH
61747	P-80 F Mica	7.5 % Formula V	150
61763	Harvon CE-F-1 Sericite	7.5 %	150
61743	TRF9 Asbestos (Note 1)	3.5	70
66481	Methocel 65HG	.75	15
65683	Hammco 267	1.0	20
61582	Terra Alba (Note 2)	38.75	775
61453)	#9NCS or		
61576)	FP Limestone (Note 2)	38.00	760
65272	UCAR 131	3.0	100 -
66298	Tamol 850	—	2.0
66660	CMP Acetate	0.5	1
66685	Troysan 174	0.5	1
67799	Water		Approx. 132 gals.

NOTES: 1. Midway to use TRF66 Asbestos (61682).

2. Midway to use 76.75% or 1535 lbs. of Quincy #3 (61463) in place of Terra Alba and #9NCS or FP Limestone.

RAW MATERIALS

	Per
P-80 F Mica	PMS 6-143-1
Harvon Sericite	PMS 6-146-2
Terra Alba	T52-505-2C
FP Limestone	PMS 6-24-22
Quincy #3	PMS 6-24-22
CMP Acetate	PMS 6-100-5
TRF66 Asbestos	PMS 6-14-10
#9NCS	PMS 6-24-9

Other raw materials per bulletin 61-2-24-AA.

END.

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DP009 1208

Originally issued 6-2-72. SPECIAL BULLETIN

Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND TOPPING - JE-1010T	No. 61-2-25-Q Date 2-27-75 Page 1 Cancels Page 1 Dated 10-25-74

This bulletin expires 6-1-75.

DESCRIPTION

A low shrinkage topping compound, containing Southard Terra Alba, designed for joint finishing with minimum cratering.

MANUFACTURING PLANT

Dallas

IDENTIFICATION AND PACKAGING

50 lb. cartons per PMS 8-10-29-1.

FINISHED PRODUCT SPECIFICATIONS

A.	Color	Natural White
B.	Viscosity	Regular - 600 ± 30 BB units with pin at 75°F. (Note 1) Hand - 475 ± 30 BB (Note 2) Machine - 400 ± 30 BB (Note 2)
C.	Bond	2 minimum
D.	Weight per Gal.	About 13.1 lbs. per gal.

Note 1: For Central Construction Products Division only.

Note 2: Manufactured and shipped only after approval from Dept. #971 or #981.

D

TP009 2470

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D Indicates Deletion

Contains portions of material formerly on page 1 dated 10-25-74.

Operating Division PRODUCT PROCEDURE	**CONFIDENTIAL** USG CF READY-TO-USE JOINT COMPOUND TOPPING - JE-1010T	No. 61-2-25-Q Date 2-27-75 Page 2 Cancels Page 2 Dated 10-25-74

FORMULA

*R/M #		% N.V.	LBS/2000 LBS. N.V.
61747	P-80F Mica	1.25	25
61741	TRF02 Asbestos	2.0	40
66460	Cellosize QP-100M or		
66487	Natrosol 250 HHXR	0.7	14
61568	Southard Terra Alba	To make 92.05	1841
65272	UCAR 131 (60%)	4.0	133
66660 or	CMP Acetate or		
66659	Cosan 158	—	1
66685	Troysan 174	—	1
66167	Composition T	0.2	4

* USG Unified Raw Material Code Number.

RAW MATERIALS

Cellosize QP-100M	Union Carbide
Southard #1 Terra Alba	52-227-2B
P80F Mica	PMS 6-143-1
Cosan 158	PMS 6-100-20
Troysan 174	PMS 6-100-14
TRF02 Asbestos	PMS 6-14-10
UCAR 131	PMS 6-104-55
Composition T - Merck 98900	Merck Chemical Company
CMP Acetate	PMS 6-100-5
Natrosol 250 HHXR	PMS 6-151-1

END.

DP0C9 2433

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FORMULA

	R/M#		% N.V.	LBS./2000 LB. N.V.
	61746	325 Mesh W.G. Mica (Note 1)	5.0	100
	61743	ASB. PCTRF-9 (Note 2)	2.0	40
	61774	Pyrax A or		
	61775	Pyrax B	15.0	300
	66458	Methocel 228 (Note 3)	0.7	14
	61453	No. 9 NCS Filler (Note 4)	To make 100%	1,474 (Approx.)
	65272	Ucar 131	3.5	117 (Approx.)
C	66685	Troysan 174 (Note 5)	0.05	1
	66659	Cosan 158 or	0.05	1
	66660	CMP Acetate		
	67799	Water	———	120-125 Gal.

Note 1: Chamblee to use Mica P-80F (61747)
Note 2: Midway to use PC TRF-66 (61682)
Chamblee to use CJM TRF-02 (61741)
Note 3: Chamblee may use Methocel 65 HG (66465)
Note 4: Midway to use Quincy #3 (61463)
Gypsum to use a blend of 5 to 10% Terra Alba Filler with 95 to 90% of either Quincy #3 filler (61453), #9NCS or Pfizer FP Carbonate filler for unpigmented. For pigmented, use 2.4 lbs. Ferrite Yellow (60245) with a blend of 50% Stonelite (61571).
A Note 5: Gypsum only may use Dowicil 75 (66676) as an alternate.

D

NP010 0094

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RAW MATERIALS

	PER
Terra Alba	T52-505-2C
325 W.G. Mica	PMS 6-143-4
Mica P-80 F	Bulletin 58-61-1
ASB. PC7RF-9	PMS 6-14-5
ASB. PC7RF-66	PMS 6-14-10
ASB. CJM7RF-02	PMS 6-14-10
Pyrax A	PMS 6-103-1
Pyrax B	PMS 6-103-2
Methocel 228	PMS 6-151-16
Methocel 65HG	PMS 6-25-6
No. 9 NCS	PMS 6-24-9
Quincy #3	PMS 6-24-22
Ucar 131	PMS 6-104-17
Troysan 174	PMS 6-100-14
Cosan 158	PMS 6-100-20
Pfizer FP	PMS 6-24-23
Stonelite	PMS 6-24-2
CMP Acetate	PMS 6-100-5
Ferrite Yellow	PMS 6-94-81
A Dowicil 75	PMS 6-100-15

MANUFACTURING PROCEDURE

Per Bulletin 61-2-24.

END

TP013 0099

A Indicates Addition

Operating Division	* CONFIDENTIAL ** CONFIDENTIAL *	No.	61-2-24-4-J
		Date	7-1-75
PRODUCT PROCEDURE	USG CF READY-TO-USE	Page	1
C	ALL PURPOSE AND TAPING	Cancels	Page 1
	JF-1320B	Dated	11-25-74

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This bulletin expires 12-1-75.

DESCRIPTION

C A lower cost Ready-To-Use All-Purpose Compound and Taping Compound for Ames Taping Tool. South Gate to manufacture for field tests and subsequent shipments as directed by WCPD Product Manager, Dept. #961.

MANUFACTURING PLANT

South Gate

IDENTIFICATION AND PACKAGING

A Regular Consistency per 61-2-24-4. The letter "J" to follow code on All Purpose only.

A Circular plastic sheet per PMS 8-5-11 to be laid over surface of compound in 62# pails.

Ames Taping Tool

55# Plastic Pail (Note: Plant to use 55# Label over 62# net on pail)

FINISHED PRODUCT SPECIFICATIONS

Color	-	Natural on taping.Light yellow tinting on All Purpose
C Viscosity	- Hand	- 275 ± 30 Brabender Units
	- All Purpose	- 500 ± 30 Brabender Units
	- Taping	- 180 ± 30 Brabender Units
Bond-to-Tape	-	5 min. at 75°F. - 50% R.H.
pH	-	9.8 - 10.4 fresh 9.0 - 9.5 after 24 hours.
Dry Shinkage	-	22% max.
Application Properties	-	Good spread with broad knife with no grit present.
Edge Cracking	-	None.

TP009 1942

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FORMULA

R/M#		% M.V.	LBS/4000 LBS. (M.V.)
61747	Mica P-80F	1.25	50
66458	Methocel 228	0.7	28
61740	Asbestos SG-210	2.5	100
65683	Hamaco 267	1.0	40
61561	Lime Hydrate	0.05	2
61457	Landplaster, Bulk	91.4	3656
65273	AMSCO 3001P	3.0	200 (approx. 22 gal)
66660	Troysan CMP Acetate	0.05	2
66685	Troysan 174	0.05	2
67799	Water	As req'd	approx. 270 gal.
60245	Mapico Yellow 1000	As req'd	approx. 2 lbs.

RAW MATERIALS

	Per
Mica P-80F	PMS 6-143-1
Methocel 228	PMS 6-151-16
Asbestos SG-210	PMS 6-14-11
Hamaco 267	PMS 6-124-11
Lime Hydrate	PMS 6-69-1
Landplaster, Bulk	52-301-2B
AMSCO 3001P	PMS 6-104-55
Troysan CMP Acetate	PMS 6-100-5
Troysan 174	PMS 6-100-14
Water	- - - -
Mapico Yellow 1000	PMS 6-94-81

MANUFACTURING PROCEDURE

Per Bulletin 61-2-24-4.

A Omit C-F process when manufacturing for taping consistency

QUALITY CONTROL

Per Bulletin 61-2-24-4.

END

OP009 1943

A Indicates Addition

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FORMULA

R/M #		% N.V.	Lbs/2000 lbs. N.V.
61568	Southard Terra Albe	91.15	1823
61747	P-80F Mica	1.25	25
66460	Cellosize QP-100M-H	0.8	16
61741	7RF02 Asbestos	3.0	60
66167	Composition T	0.2	4
65272	UCAR 131 (60%)	3.5	117
66660 or	CMP Acetate		
66659	Cosan 158	—	1
66685	Troysan 174	—	1
67799	Water		Approx. 108 gals.

RAW MATERIALS

	Per
Southard Terra Albe	52-227-2B
P-80F Mica	PMS 6-143-1
C Cellosize QP-100M-H	PMS 6-151-1-1
7RF02 Asbestos	PMS 6-14-10
Composition T	Merck Chemical Co.
UCAR 131 (60%)	PMS 6-104-55
CMP Acetate	PMS 6-100-5
Cosan 158	PMS 6-100-20
Troysan 174	PMS 6-100-14

MANUFACTURING PROCEDURE

Addition of raw materials and initial mixing methods are the same as present non "CF" processed material (per bulletin 61-2-24-2-1) except batch in mixer should be finished at a brabender of 540 to 560 before vacuuming (this will enable the "CF" viscosity to fall into the 570 to 630 Finished Product Specification range). After the 540 to 560 BB range is obtained, the batch in the mixer is pumped to the overhead surge tank (Dallas has two surge tanks) and placed under a vacuum of 26 to 28 inches for a minimum of 5 minutes. After "CF" treatment, the batch is ready for the filling operation.

END

OPR'd 2534

C Indicates Change

Also cancels Special Bulletin 61-2-24-4-P, dated 8-13-75.
Originally issued 11-25-74.

Operating Division	* CONFIDENTIAL ** CONFIDENTIAL *	No. 61-2-24-4-N
		Date 12-9-75
PRODUCT PROCEDURE	USG CF READY-TO-USE	Page 1
C	ALL PURPOSE "M" FORMULA	Cancels Page 1
		Dated 7-1-75

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C This bulletin expires 6-1-76.

DESCRIPTION

A lower cost Ready-To-Use All-Purpose Compound and Taping Compound for Ames Taping Tool. South Gate to manufacture for field tests and subsequent shipments as directed by WCPD Product Manager, Dept. #961.

MANUFACTURING PLANT

South Gate

IDENTIFICATION AND PACKAGING

Regular Consistency per 61-2-24-4. The letter "J" to follow code on All Purpose only.

Circular plastic sheet per PMS 8-5-11 to be laid over surface of compound in 62# pails.

Ames Taping Tool

55# Plastic Pail (Note: Plant to use 55# Label over 62# net on pail)

FINISHED PRODUCT SPECIFICATIONS

Color	- Natural on taping. Light yellow tinting on All Purpose
Viscosity	- Hand - 275 ± 30 Brabender Units - All Purpose - All Purpose - 500 ± 30 Brabender Units
D Bond-to Tape	- 5 min. at 75°F. - 50% R.H.
pH	- 9.8 - 10.4 fresh 9.0 - 9.5 after 24 hours.
Dry Shrinkage	- 22% max.
Application Properties	- Good spread with broad knife with no grit present.
Edge Cracking	- None.

C Indicates Change D Indicates Deletion

OP009 193R

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FORMULA

	R/M#		% N.V.	LBS./4000 LBS. (N.V.)
	61747	Mica P-80F	1.25	50
C	66458	Methocel 228 or	0.7	28
A	66481	Methocel F4M		
	61740	Asbestos SG-210	2.5	100
	65683	Hamaco 267	1.0	40
	61561	Lime Hydrate	0.05	2
	61457	Landplaster, Bulk	91.4	3656
C	64889	AMSCO SBR4150	3.0	240 (approx. 29 gal.)
C	66660	Troysan CMP Acetate	0.075	3
C	66685	Troysan 174	0.075	3
	67799	Water	As Req'd.	approx. 270 gal.
	60245	Mapico Yellow 1000	As Req'd.	approx. 2 lbs.
A	67063	AMP 95	0.1	4

RAW MATERIALS

		Per
	Mica P-80F	PMS 6-143-1
	Methocel 228	PMS 6-151-16
	Asbestos SG-210	PMS 6-14-11
	Hamaco 267	PMS 6-124-11
	Lime Hydrate	PMS 6-69-1
	Landplaster, Bulk	52-301-2B
C	AMSCO SBR4150	Union Oil Co.
	Troysan CMP Acetate	PMS 6-100-5
	Troysan 174	PMS 6-100-14
	Water	- - - -
	Mapico Yellow 1000	PMS 6-94-81
A	AMP 95	Commercial Solvents Corp.

MANUFACTURING PROCEDURE

Per Bulletin 61-2-24-4.

Omit C-F process when manufacturing for taping consistency

QUALITY CONTROL

Per Bulletin 61-2-24-4.

END.

C Indicates Change A Indicates Addition

UP009 1939

Operating Division	* CONFIDENTIAL ** CONFIDENTIAL *	No.	61-2-25-2
		Date	1-7-76
PRODUCT PROCEDURE	USG CF READY-TO-USE JOINT COMPOUND TOPPING (JE-851C)	Page	1
		Cancels	Page 1
		Dated	1-27-75

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DESCRIPTION

Plants to manufacture a special white READY-MIXED Topping Compound for shipment per direction of C.C.P.D. or S.C.P.D. Joint Treatment Product Manager.

MANUFACTURING PLANTS

C Chamblee, East Chicago and Gypsum.

IDENTIFICATION AND PACKAGING

62 lb. metal or plastic topping pail per PMS 8-29-3-1 or 8-15-15-4 and 50 lb. topping cartons per PMS 8-10-29-1.

Chamblee to use the same pails now used for USG Ready Mix All Purpose Joint Compound by applying two pressure sensitive labels to each pail as follows:

Label #1 to be affixed to the front of the container and should read - -

TOPPING

Label #2 to be affixed in the area of the direction panel on the container and should read - -

CAUTION

DO NOT USE TO EMBED TAPE
CAN BE USED TO EMBED FASTENERS,
METAL CORNEREAD & DRYWALL TRIMS

FINISHED PRODUCT SPECIFICATIONS

A.	Color	- Special White (Note 2)
B.	Viscosity (Note 1)	- 600 ± 30 BB units with pin at 75°F
C.	Bond-	- 2 Minimum at 75°F - 50% R.H. - 4 Minimum using Hot Room @ 90°F and 10% R.H.
D.	Wt./Gal.	- 13.5 to 13.7 lbs. per gallon for regular consistency.

NOTE 1: Chamblee
Machine 425-475 BB units
Regular 500-550 BB units

NOTE 2: Pigmented available at Gypsum in batch size increments. Department #971-C to be notified of all such production.

JP010 0092

C Indicates Change

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FORMULA

R/M #		% N.V.	LBS./2000 LB. N.V.
61746	325 Mesh W.G. Mica (Note 1)	5.0	100
61743	ASB. PC7RF-9 (Note 2)	2.0	40
61774	Pyrax A or		
61775	Pyrax B	15.0	300
66458	Methocel 228 (Note 3)	0.7	14
61453	No. 9 NNCS Filler (Note 4)	To make 100%	1,474 (Approx.)
65272	Ucar 131	3.5	117 (Approx.)
66685	Troysan 174 (Note 5)	0.05	1
66659	Cosan 158 or	0.05	1
66660	CMP Acetate		
67799	Water	-----	120-125 Gal.

C: Note 1: Chamblee to use Mica P-80F (61747). Gypsum to use Foote P80F Mica (61859).
C: Note 2: East Chicago to use PC 7RF-66 (61682)
Chamblee to use CJM 7RF-02 (61741)
Note 3: Chamblee may use Methocel 65 HG (66465)
C: Note 4: East Chicago to use Quincy #3 (61463)
Gypsum to use a blend of 5 to 10% Terra Alba Filler with 95 to 90% of either Quincy #3 filler (61453), #9NCS or Pfizer FP Carbonate filler for unpigmented. For pigmented, use 2.4 lbs. Ferrite Yellow (60245) with a blend of 50% Stonelite (61571).
Note 5: Gypsum only may use Dowicil 75 (66676) as an alternate.

C Indicates Change

9600 010 JC

Originally issued 5-21-73. 4th Extension

Operating Division * CONFIDENTIAL ** CONFIDENTIAL * No. 61-2-24-PP
Date 6-29-76

PRODUCT PROCEDURE USG CF READY-TO-USE JOINT COMPOUND ALL PURPOSE
Page 1
Cancels Page 1
Dated 6-11-75

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C This bulletin expires 12-1-76.

DESCRIPTION

An emulsion based product.

MANUFACTURING PLANTS

C East Chicago and Gypsum

IDENTIFICATION AND PACKAGING

Normal code

C Packaging

	Per PMS
62# pail	8-29-3-1 or 8-15-15-4
50# carton	8-10-29-1

NOTE: Only containers with Asbestos Warning Label are to be used.

FINISHED PRODUCT SPECIFICATIONS

Viscosity - Regular - 600 ± 30 BB
Hand - 475 ± 30 BB (Note 1)
Machine - 400 ± 30 BB (Note 1)
Extra - 730 ± 30 BB (Note 1)

Color - Natural unless pigment specified.
Bond-To-Tape - 4 minimum at 77°F - 50% R.H.
Weight per Gallon - 12.8 to 13.0 lbs. per gallon.

Note 1: Manufactured and shipped as approved by Dept. #971.

jp009 1201

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FORMULA (JE-1281B)

*R/M #		% N.V.	Lbs. Per 250 Gal. Batch
61747	P-80 F Mica	7.5% Formula V	150
61763	Harvon CE-F-1 Sericite	7.5%	150
61743	TRF9 Asbestos (Note 1)	3.5	70
66481	Methocel 65HG	.75	15
65683	Hamaco 267	1.0	20
61582	Terra Alba (Note 2)	38.75	775
61453)	#9NCS or		
61576)	FP Limestone (Note 2)	38.00	760
65272	UCAR 131	3.0	100 -
66298	Tamol 850	—	2.0
66660	CMP Acetate	0.5	1
66685	Troysan 174	0.5	1
67799	Water		Approx. 132 gals.

C NOTES: 1. East Chicago to use TRF66 Asbestos (61682).

C 2. East Chicago to use 76.75% or 1535 lbs. of Quincy #3 (61463) in place of Terra Alba and #9NCS or FP Limestone.

RAW MATERIALS

		Per PMS
	P-80 F Mica	6-143-1
	Harvon Sericite	6-146-2
C	Terra Alba	52-505-2A
C	FP Limestone	
	Quincy #3	6-24-22
	CMP Acetate	6-100-5
	TRF66 Asbestos	6-14-10
	#9NCS	6-24-9
A	Methocel 65HG	6-25-6
A	Hamaco 267	6-124-11
A	Tamol 850	6-177-9
A	Troysan 174	6-100-14
A	Ucar 131	6-104-55

END.

DP009 1294

Originally issued 5-21-73. 4th Extension

Operating Division * CONFIDENTIAL ** CONFIDENTIAL * No. 61-2-24-PP
Date 6-29-76
PRODUCT PROCEDURE USG CF READY-TO-USE JOINT COMPOUND ALL PURPOSE
Page 1
Cancels Page 1
Dated 6-11-75

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C This bulletin expires 12-1-76.

DESCRIPTION

An emulsion based product.

MANUFACTURING PLANTS

C East Chicago and Gypsum

IDENTIFICATION AND PACKAGING

Normal code

C Packaging

	Per PMS
62# pail	8-29-3-1 or 8-15-15-4
50# carton	8-10-29-1

NOTE: Only containers with Asbestos Warning Label are to be used.

FINISHED PRODUCT SPECIFICATIONS

Viscosity - Regular - 600 ± 30 BB
Hand - 475 ± 30 BB (Note 1)
Machine - 400 ± 30 BB (Note 1)
Extra - 730 ± 30 BB (Note 1)

Color - Natural unless pigment specified.
Bond-To-Tape - 4 minimum at 77°F - 50% R.H.
Weight per Gallon - 12.8 to 13.0 lbs. per gallon.

Note 1: Manufactured and shipped as approved by Dept. #971.

DP009 1203

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FORMULA (JE-1281B)

*R/M #		% N.V.	Lbs. Per 250 Gal. Batch
61747	P-80 F Mica	7.5% Formula V	150
61763	Marvon CE-F-1 Sericite	7.5%	150
61743	7RF9 Asbestos (Note 1)	3.5	70
66481	Methocel 65HG	.75	15
65683	Hamaco 267	1.0	20
61582	Terra Alba (Note 2)	38.75	775
61453)	#9NCS or		
61576)	FP Limestone (Note 2)	38.00	760
65272	UCAR 131	3.0	100 -
66298	Tamol 850	---	2.0
66660	CMP Acetate	0.5	1
66685	Troysan 174	0.5	1
67799	Water		Approx. 132 gals.

C NOTES: 1. East Chicago to use 7RF66 Asbestos (61682).

C 2. East Chicago to use 76.75% or 1535 lbs. of Quincy #3 (61463) in place of Terra Alba and #9NCS or FP Limestone.

RAW MATERIALS

		Per PMS
	P-80 F Mica	6-143-1
	Marvon Sericite	6-146-2
C	Terra Alba	52-505-2A
C	FP Limestone	
	Quincy #3	6-24-22
	CMP Acetate	6-100-5
	7RF66 Asbestos	6-14-10
	#9NCS	6-24-9
A	Methocel 65HG	6-25-6
A	Hamaco 267	6-124-11
A	Tamol 850	6-177-9
A	Troysan 174	6-100-14
A	Ucar 131	6-104-55

END.

TP009 1.72

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MANUFACTURING PROCEDURE

Due to the number of very critical, smaller volume ingredients, caution must be taken to insure all the required amount be added to the batch. The light density of some of the materials makes it even more critical in regard to loss of material within dust collection equipment.

General Mixing Procedure on Hockmeyer Mixer: This procedure may vary from plant to plant due to modification based on plant experience. Approximately 90% of the total water that will be required is put into the Hockmeyer mixer. Simultaneously the latex and preservative are added with the mixer running. Start vibrating dry ingredients into the batch while the batch water is being added. Time the addition of the dry ingredients so as to be completed simultaneously with completion of the water addition. Batch is then to be mixed at heavy viscosity until all lumps are broken down and all materials thoroughly mixed. Additional water is then added until mix is smooth and homogeneous and watt meter indicates the desired viscosity has been reached.

CF Process: Vacuum pressure and processing speed are to be determined by operating personnel based on what is needed to give the most "air void free" product.

Filling: All containers to be filled with 62 lbs. of material regardless of consistency.

END.

TP009 1119