

**PLIOBOND™ 25**  
 General-Purpose  
 VOC-Compliant Adhesive

**Technical Datasheet**

Last Revision Date: March 2010  
 Supersedes: July 2006

**GENERAL-PURPOSE, VOC-COMPLIANT ADHESIVE**

**DESCRIPTION:** PLIOBOND 25 adhesive is a general-purpose, VOC-compliant, thermosetting adhesive that can be used to bond virtually all porous and nonporous substrates. When cured, PLIOBOND 25 adhesive provides tough, chip resistant bonds that remain flexible over a wide range of temperatures. Substrates bonded with PLIOBOND 25 adhesive offer excellent resistance to mechanical shock and oxidization. This adhesive offers outstanding dielectric properties and has low water absorption. PLIOBOND 25 adhesive comes ready to use; no conditioner, accelerator or catalyst is required. PLIOBOND 25 adhesive can be applied by spraying, roll coating, knife coating, or brushing.

**SUGGESTED USES:** PLIOBOND 25 adhesive can be used as a sealer, primer, water repellent, or coating for metal, wood, plastic, plastic film, ceramic, bone, ivory, glass, rubber, paper, leather, plaster, drywall, insulation, concrete, brick, and stone. Other applications include:

- Assembling electrical appliances and equipment.
- Doping electric motor armature coils.
- Anchoring nonskid material to floors.
- Waterproofing awnings, tarps, convertible tops, and outdoor furniture.
- Protecting above-water surfaces on watercraft.

**ALTERNATE PRODUCTS:** PLIOBOND 35 and PLIOBOND 45 VOC-compliant adhesives have higher solids and viscosity.

**TYPICAL LIQUID PROPERTIES AT 77 °F**

Base	Synthetic Rubber
Color	Tan
Solids by Weight, %	21 ± 2
Solvent Formulation	Ketone
Viscosity, cps Brookfield RVT Spindle No. 2 at 20 rpm	800 +/- 400
Specific Gravity	0.863
Pounds per Gallon	7.19
Flash Point, °F (SETA)	< 0°F
VOC, Lbs./Gal. (SCAQMD Rule 443/443.1)	2.10
Coverage	215-230 sq ft/gal/dry mil
Application Temperature, °F	40-100
Service Temperature, °F	ASTM D-816 -10 psi at 500°F for 1 hour

\* Typical Values: Based on material tested in our laboratories but varies from sample to sample. Typical values should not be construed as a guaranteed analysis of any specific lot or as specification items.

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**General-Purpose, VOC-Compliant Adhesive**  
**(Continued)**

**METHOD OF APPLICATION:** PLIOBOND 25 adhesive can be applied by spraying, roll coating, knife coating or brushing.

**HANDLING:** PLIOBOND 25 adhesive contains ingredients that could be harmful if mishandled. Contact with skin and eyes should be avoided and necessary protective equipment and clothing should be worn. All five-gallon pails and larger metal containers should be grounded and/or bonded when material is transferred. Vapors are heavier than air and may travel along the ground or may be moved by ventilation and ignited by pilot lights, other flames, sparks, heaters, smoking, electric motors, static discharge, or other ignition sources at locations distant from material handling point. Never use a welding or cutting torch on or near drum (even empty) because product (even residue) can ignite explosively.

**Ashland maintains Material Safety Data Sheets on all of its products. Material Safety Data Sheets contain health and safety information for your development of appropriate product handling procedures to protect your employees and customers.**

**Our Material Safety Data Sheets should be read and understood by all of your supervisory personnel and employees before using Ashland products in your facilities.**

**RECOMMENDED STORAGE:**

original, unopened container between 60°F and 80°F

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