

Pliobond® Special Purpose Contact Adhesives

Traditional and VOC Compliant Formulations

Pliobond provides permanent, flexible bonding and will not get brittle with age. The product resists most acids, gasoline, oil, grease and water.

Traditional formulations employ an MEK solvent and the VOC compliant versions use a blended solvent.

Pliobond 20, 25, 30, and 35 are all purpose, thermosetting contact adhesives with solid contents of pigment reinforced synthetic rubber and synthetic plastic resin. The 20 and 25 versions are most frequently used and contain 20 percent

solids while the 30 and 35 products contain 30 percent solids and form a heavier film with controlled penetration. The latter are most often used on more porous surfaces. The 25, 35 and 45 versions are VOC compliant formulas.

Pliobond 45 consists of 40 percent solids and is available on special orders.

Pliobond HT-30 has the same qualities as Pliobond 30 but it resists higher temperatures while providing permanent flexible bonding. However, it must be heat cured to 300 degrees F.

Proven Professionally—Everyday



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Adhesives &
Sealants

GENERAL INFORMATION

Many shops and plants with variable production and short runs require a versatile adhesive. For these and for "spot-use" applications, PLIOBOND adhesives simplify warehousing and inventory. They produce strong serviceable joints with most materials. The cement is supplied ready to use and requires no conditioning agents, accelerators, or catalysts.

A single method, called wet bond-

ing, can be used for joining virtually all materials with PLIOBOND.

For wet bond: coat both surfaces, allow to dry to a tack free state, recoat one surface then assemble the parts when tacky. Test before use to ensure compatibility with both adherents.

An initial set takes place in PLIOBOND adhesive joints as soon as most of the solvent has evaporated.

The strength of this initial set is usually sufficient to maintain the assembly, and with some adherents, will exceed the strength of the material. Bond strength increases as evaporation of the solvent progresses, reaching a maximum when all solvent has been removed.

In addition to the adhesive applications, PLIOBOND is also used as a primer, coater, and sealer.

HANDLING: PLIOBOND adhesives contain ingredients which could be harmful if mishandled. Contact with skin and eyes should be avoided and necessary protective equipment and clothing should be worn.

For important health, safety and handling information,

consult the Material Safety Data Sheet for each individual adhesive before use.

SHELF LIFE: Twelve months in closed containers under ambient conditions (rotate stock). D.O.T. label required: flammable liquid. Stir before use.

| Physical properties of PLIOBOND VOC Compliant special purpose contact adhesives | | | |
|---|------------------------|---------------|---------------|
| Table 1 | PLIOBOND 25 | PLIOBOND 35 | PLIOBOND 45 |
| Base Polymer | Nitrile Rubber | | |
| Base Resin | Thermosetting Phenolic | | |
| Total Solids, % | 19-23 | 28-32 | 37-42 |
| Viscosity, Cps | 400-1200 | 3,000-10,000 | 40,000-75,000 |
| Specific Gravity | 0.87 | 0.89 | 0.99 |
| Pounds/Gallon | 7.2 | 7.4 | 7.7 |
| Color | Tan | Tan | Tan |
| Solvent(S) | Acetone/Blend | Acetone/Blend | Acetone/Blend |
| Flash Point, °F Sets | 20 | 20 | 20 |

VOC Compliant Formulation

PLIOBOND 45

PC-445 1-Gallon Can
PC-545 5-Gallon Pail
PC-5045 50-Gallon Drum

PLIOBOND 25 LV

P-612-LV 3-oz. Skin-Pack Brush-top Bottle
PBC-25-LV 1/2-Pint Brush-top Can
PC-225-LV Pint Can
PC-325-LV Quart Can
PC-425-LV Gallon Can
PC-525-LV 5-Gallon Pail
PC-5025-LV 50-Gallon

PLIOBOND 35 LV

PBC-35-LV 1/2-Pint Brush-top Can
PC-235-LV Pint Can
PC-335-LV Quart Can
PC-435-LV Gallon Can
PC-535-LV 5-Gallon Pail
PC-5035-LV 50-Gallon Drum

Distributed By:

| Physical properties of PLIOBOND Traditional formulation special purpose contact adhesives | | | |
|---|------------------------|--------------|----------------|
| Table 1 | PLIOBOND 20 | PLIOBOND 30 | PLIOBOND HT-30 |
| Base Polymer | Nitrile Rubber | | |
| Base Resin | Thermosetting Phenolic | | |
| Total Solids, % | 19-23 | 28-32 | 28-32 |
| Viscosity, Cps | 400-1200 | 3,000-10,000 | 3,000-10,000 |
| Specific Gravity | 0.87 | 0.89 | 0.89 |
| Pounds/Gallon | 7.2 | 7.4 | 7.4 |
| Color | Tan | Tan | Tan |
| Solvent(S) | MEX | MEK | MEK/Alcohol |
| Flash Point, °F Sets | 20 | 20 | 21 |

Traditional Formulation

Consumer Packages

PLIOBOND 20

P-141 1 oz. Tube Sifter
P-612 3 oz. Brush Top Bottle
PBC-20 1/2 pint Brush Top Can

Industrial Packages

PLIOBOND 20

P351 1 oz. tube Ind. Pack
PBC-20 1/2 pint brush top can
PC-220 Pint Can
PC-320 Quart Can
PC-420 Gallon Can
PC-520 5-Gallon Pail
PC-5020 50-Gallon Drum

Industrial Packages

PLIOBOND 30

P-3530 1 oz. tube Ind. Pack
PBC-30 1/2 pint brush top can
PC-230 Pint Can
PC-330 Quart Can
PC-430 Gallon Can
PC-530 5-Gallon Pail
PC-5030 50-Gallon Drum

PLIOBOND HT-30

PC-HT200 Pint Can
PC-HT300 Quart Can
PHT 30-4 Gallon Can
PHT30-5 5-Gallon Pail

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Adhesives &
Sealants

Manufactured by:

Ashland Chemical, Inc.
Subsidiary of Ashland Oil, Inc.

PLIOBOND® Registered trademark,
Ashland Oil, Inc.

Order from:

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