

Covinax 324-00

Covinax 324-00 is a surfactant stabilized vinyl acrylic copolymer used for general purpose permanent pressure sensitive adhesives in tape and label applications. Covinax 324-00 has a good balance of peel and tack, which allow it to be used in a wide variety of applications. Covinax 324 exhibits very good converting properties. It exhibits excellent adhesion to corrugated, polyolefin films, glass and metals. It can be tackified with most of the commercially available tackifier dispersions to tailor tack and peel, but it will perform very well as supplied. Covinax 324-00 is FDA compliant under: 21CFR 175.105, 21CFR 176.170, 21CFR 176.180, 16CFR 1500.3(C)(4), and 16CFR 1500.3(C)(2)(i).

PHYSICAL PROPERTIES

Polymer Type: Vinyl acrylic

Protective System: Anionic

Color: White

Viscosity (cps): 50-300 (RVF, Spindle #2/100 RPM/77°F)

Percent Solids: 62.0 - 65.0

pH: 4.0 - 5.0

Weight Per Gallon: 8.58

Shelf Life: 6 months

Freeze/Thaw Stability: Unstable

Glass Transition Temperature (T_g): (DSC): -40.3°C



PERFORMANCE PROPERTIES

A 1 mil (28g/M²) dry film of Covinax 324-00 cast directly onto 1 mil thickness polyester film will exhibit the following average performance properties when tested on #304 stainless steel, which has a #3 surface finish.

Test	Typical Values	Specification Range
180° Peel Adhesion ¹ (lbs)	4.9	3.0 minimum
178° Shear Adhesion ² (minutes)	100	50 minimum
Loop Tack ³ (lbs)	3.0	2.0 minimum

FDA Compliance: 21CFR 175.105;
21CFR 176.170;
21CFR 176.180;
16CFR 1500.3(C)(4);
16CFR 1500.3(C)(2)(i).

¹Franklin International 03QC5002, 30 minute dwell.

²Franklin International 03QC5003, 0.25 square inch, 500 gram load, 10 minute dwell.

³Franklin International 03QC5004, 1 square inch contact, 1 second dwell.



AVERAGE APPLICATION PROPERTIES

TEST/SUBSTRATE	Facestock: Paper				Facestock: BOPP Film			
	LDPE	HDPE	Vinyl	Corrugate	LDPE	HDPE	Vinyl	Corrugate
180° peel (lb/lineal inch width) 30 minute dwell	1.5 A	1.3 A	4.3 PT	0.73 PT	1.6 A	2.8 A	4.5 C	2.2 PT
90° peel (lb/lineal inch width) 30 minute dwell	1.2 A	1.1 A	2.6 PT	1.4 FP	1.5 A	0.93 A	5.0 G/Z	1.6 A
Loop Tack (lb)	1.3	1.7	5.0	2.5	0.94	1.5	3.0	3.16

	Facestock: Paper	Facestock: BOPP Film	Facestock: Mylar
178° Shear (500 g, 0.25 in ²) (minutes)	137 C	100 C	93 C
SAFT Testing (min/temp °C)	66/155 °C	57/61 °C	106/100 °C
Substrate: Stainless Steel		Coat weight: 1.0 mil (+/-0.1 mil)	

A = Adhesive C = Cohesive FP = Fiber pick G/Z = Ghosting/Zippy PT = Paper Tear

ADDITIONAL INFORMATION

Yellowing (Colorimeter "b" value)

UV Exposure (1 week) Mylar		Heat Exposure (1 week @ 140° F) Paper	
Before	After	Before	After
0.83	2.37	-1.59	2.24

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