

Covinax 331-15

Covinax 331-15 is a coater-ready surfactant stabilized acrylic adhesive developed for permanent pressure sensitive applications requiring high tack and peel strength. Covinax 331-15 exhibits excellent adhesion to corrugated board, polyolefin films and most types of foams. It also forms permanent bonds whether at room temperature or refrigerator temperatures. Its wide adhesion range allows it to be used in a variety of different applications, including all-temperature grade labels. Covinax 331-15 is APE-free and FDA compliant under 21CFR 175.105.



PHYSICAL PROPERTIES

Polymer Type: Acrylic

Protective System: Anionic Surfactant

Color: White

Viscosity (cps): 1200 - 1500 (LVF, Spindle #2/12 RPM/77°F)

Percent Solids: 58.0 - 62.0

pH: 4.0 - 5.0

Weight Per Gallon: 8.6

Shelf Life: 3 months

Freeze/Thaw Stability: Unstable

Glass Transition Temperature (T_g): (DSC): -42.3 °C

PERFORMANCE PROPERTIES

A 1 mil (28 g/m²) dry film of Covinax 331-15 cast directly onto 1 mil thickness polyester film will exhibit the following average performance properties when tested on #304 stainless steel with a #3 surface finish.

Test	Typical Values	Specification Range
180° Peel Adhesion ¹ (lb)	4.3	3.5 minimum
178° Shear Adhesion ² (minutes)	25	10 - 60
Loop Tack ³ (lb)	3.1	2.0 minimum

FDA Compliance: 21CFR 175.105

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	1.6 A	1.4 A	3.4 PT	2.1 FP	2.0 A	1.2 A	4.4 C	3.4 C
90° peel (lb/lineal inch width) 30 minute dwell	1.3 A	0.93 A	3.7 A	1.5 FP	1.6 A	1.2 A	5.0 A	2.0 A
Loop Tack (lb)	1.1	1.8	3.3	1.2	1.1	1.4	3.3	1.4

	Facestock: Paper	Facestock: BOPP Film	Facestock: Mylar
178° Shear (500 g, 0.25 in ²) (minutes)	84 C	22 C	23 C
SAFT Testing (min/temp °C)	112/138 °C	21/46 °C	26/56 °C
Substrate: Stainless Steel		Coat weight: 1.0 mil (+/-0.1 mil)	

A = Adhesive C = Cohesive FP = Fiber pick 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
4.60	5.84	2.95	9.09

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