

# Covinax 324-00

## General Purpose Permanent

**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 324-00 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, 16CFR 1500.3(C)(4), and 16CFR 1500.3(C)(2)(i).



### PHYSICAL PROPERTIES

**Polymer Type:** Vinyl Modified Acrylic Copolymer

**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:** 8.6

**Glass Transition Temperature (Tg): (DSC):** -40.3° C

### PERFORMANCE PROPERTIES

A 1 mil (28g/m<sup>2</sup>) 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 <sup>1</sup> (lb)       | 4.6            | 3.0 minimum         |
| 178° Shear Adhesion <sup>2</sup> (minutes) | 85             | 50 minimum          |
| Loop Tack <sup>3</sup> (lb)                | 3.0            | 2.0 minimum         |
| <b>Minimum Application Temperature:</b>    | >32°F          | N/A                 |
| <b>Service (Use) Temperature:</b>          | 20°F to 250°F  | N/A                 |

NOTE: Minimum application and service temperatures are dependent upon many factors including face stock, adhesive coat weight, adhesion, and intended application. We can only offer an estimate based on the Tg and typical performance properties of the adhesive.

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

<sup>1</sup>Franklin International 03QC5002, 30 minute dwell.

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

<sup>3</sup>Franklin 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<br>(lb/lineal inch width)<br>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<br>(lb/lineal inch width)<br>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:<br>Paper | Facestock:<br>BOPP Film | Facestock:<br>Mylar |
|---|---------------------|-------------------------|---------------------|
| 178° Shear<br>(500 g, 0.25 in <sup>2</sup> )<br>(minutes)         | 137 C               | 100 C                   | 85 C                |
| SAFT Testing<br>(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<br>(1 week)<br>Mylar |       | Heat Exposure<br>(1 week @ 140° F)<br>Paper |       |
|----------------------------------|-------|---|-------|
| Before                           | After | Before                                      | After |
| 0.83                             | 2.37  | -1.59                                       | 2.24  |

## STORAGE AND HANDLING

**Shelf life:** Best if used within six months of date of manufacture. Mix before use for best results. Product is not freeze/thaw stable.

For additional questions, Franklin’s technical service team is available at 1.800.877.4583. **24/7** technical service is available online at [www.franklinadhesivesandpolymers.com](http://www.franklinadhesivesandpolymers.com).

### IMPORTANT NOTICE TO CUSTOMER:

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