

Covinax 324-39

Covinax 324-39 is a coater-ready surfactant stabilized vinyl acrylic copolymer for general purpose permanent pressure sensitive adhesives in tape and label applications. Covinax 324-39 has a good balance of peel and tack, which allow it to be used in a wide variety of applications. It exhibits excellent adhesion to corrugated, polyolefin films, glass and metals. It displays excellent converting properties. Covinax 324-39 can be transfer coated on most rod, gravure or roll coaters. Covinax 324-39 is FDA compliant under 21CFR 175.105.



PHYSICAL PROPERTIES

Polymer Type: Vinyl Modified Acrylic Copolymer

Protective System: Anionic

Color: White

Viscosity (cps): 400 Max (RVF, Spindle #2/100 RPM/77° F)

Percent Solids (%): 55.0 - 58.0

pH: 6.0 - 7.0

Weight Per Gallon: 8.6

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

PERFORMANCE PROPERTIES

A 1 mil (28g/m²) dry film of Covinax 324-39 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 (lb)	3.6	No specification
178° Shear Adhesion ² (minutes)	73	50 minimum
Loop Tack ³ (lb)	2.2	No specification
Minimum Application Temperature:	>32°F	N/A
Service (Use) Temperature:	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

¹ Franklin International 03QC5002, 30 minute dwell.

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

³ 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 (lb/lineal inch width) 30 minute dwell	1.1 A	0.64 A	4.5 PT	1.8 FP	0.97 A	0.59 A	4.7 C	2.3 A
90° peel (lb/lineal inch width) 30 minute dwell	0.99 A	0.59 A	3.5 PT	1.0 A	0.96 A	0.59 A	3.2 A	1.2 FP
Loop Tack (lb)	1.0	1.3	3.8	2.4	0.54	0.81	2.9	2.2

	Facestock: Paper	Facestock: BOPP Film	Facestock: Mylar
178° Shear (500 g, 0.25 in ²) (minutes)	87 C	100 C	73 C
SAFT Testing (min/temp° C)	122/155° C	44/76° C	58/90° 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
4.84	7.08	2.83	5.21

STORAGE AND HANDLING

Shelf life: Best if used within four 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.

IMPORTANT NOTICE TO CUSTOMER:

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