

# Covinax 525-78

## High Tack General Purpose Permanent

**Covinax 525-78** is a coater-ready, surfactant stabilized, tackified vinyl acrylic copolymer adhesive developed for high performance permanent pressure sensitive applications. It has an excellent balance of peel adhesion and shear adhesion. Covinax 525-78 is internally crosslinked, giving it superior cohesive strength. It will resist cold flow and will die cut and convert well, giving dry edges to finished sheets and rolls. This product was designed to be transfer coatable on gravure and roll coaters. Covinax 525-78 is FDA compliant under 21CFR 175.105, 16CFR 1500.3(C)(4) and 16CFR 1500.(C)(2)(i).



### PHYSICAL PROPERTIES

**Polymer Type:** Vinyl Modified Acrylic Copolymer

**Protective System:** Anionic

**Color:** Off white

**Viscosity (cps):** 275 - 825 (RVF, Spindle #3/20 RPM/77° F)

**Percent Solids (%):** 52.5 - 54.5

**pH:** 5.8 - 7.0

**Weight Per Gallon:** 8.5

**Glass Transition Temperature (T<sub>g</sub>):(DSC):** -26.5° C

### PERFORMANCE PROPERTIES

A 1 mil (28g/m<sup>2</sup>) dry film of Covinax 525-78 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 (lb)	2.9	2.5 minimum
178° Shear Adhesion (minutes)	340	150 minimum
Loop Tack <sup>3</sup> (lb)	3.8	2.7 minimum

**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 T<sub>g</sub> and typical performance properties of the adhesive.

**FDA Compliance:** 21 CFR 175.105  
16 CFR 1500.3(C)(4)  
16 CFR 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, 30 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 (lb/lineal inch width) 30 minute dwell	3.0 PT	3.3 A	1.2 PT	2.4 PT	2.1 A	1.8 A	4.2 C	0.72 FP
90° peel (lb/lineal inch width) 30 minute dwell	0.97 PT	1.7 A	0.73 PT	1.2 PT	1.7 A	1.9 A	4.8 A	1.3 PT
Loop Tack (lb)	2.2	3.1	4.1	2.4	0.74	1.4	1.0	0.91

	Facestock: Paper	Facestock: BOPP Film	Facestock: Mylar
178° Shear (500 g, 0.25 in <sup>2</sup> ) (minutes)	413 C	307 C	340 C
SAFT Testing (min/temp° C)	110/136° C	47/74° C	67/98° 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
5.72	10.08	3.90	13.72

## STORAGE AND HANDLING

**Shelf life:** Best if used within three 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:

The recommendations and data contained in this Product Data Sheet for use of this product are based on information Franklin believes to be reliable. They are offered in good faith without guarantee, as conditions and methods of use of our product by Customer are beyond Franklin’s control. Customer must determine the suitability of the product for a particular application before adopting it on a commercial scale.

All orders for Franklin products shall be subject to Franklin International, Inc.’s Standard Terms and Conditions of Sale which may be found at [http://www.franklini.com/Terms\\_and\\_Conditions.aspx](http://www.franklini.com/Terms_and_Conditions.aspx) (“Standard Terms”). Different or additional terms proposed by Customer are expressly rejected and shall not become part of the agreement between Customer and Franklin International, Inc. with respect to any order. Contact Franklin International, Inc. immediately if you cannot access our Standard Terms and we will provide you a copy upon request. Any sale of products by Franklin to Customer is expressly conditional upon Customer’s consent to the Standard Terms, and Customer’s acceptance of any performance by, or receipt of products from, Franklin International, Inc. shall constitute Customer’s acceptance of the Standard Terms and Conditions of Sale.

© Copyright 2022. All rights reserved. Franklin International. Revised 06/16/2022.