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(54) Title: MODIFIED AMINOPLAST CROSSLINKERS AND POWDER COATING COMPOSITIONS CONTAINING SUCH CROSSLINKERS

(57) Abstract: The present invention provides a crosslinking agent which may have reactive benzoxazine groups prepared from (a) at least one aromatic compound, (b) at least one aminotriazine compound, and (c) at least one other compound having active hydrogen groups reactive with aminoplast compound (b). The crosslinking agent is essentially free of hydroxyl functionality and has a glass transition temperature of at least 25 °C. The present invention is further directed to a method for preparing the above-described crosslinking agent, and a curable powder coating composition comprising a mixture of (A) a polymer having functional groups reactive with aminotriazine and/or benzoxazine groups having a glass transition temperature of at least 30°C; and (B) the above crosslinking agent. Multilayer composite coating compositions are also provided, as are coated substrates.



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**MODIFIED AMINOPLAST CROSSLINKERS AND POWDER COATING
COMPOSITIONS CONTAINING SUCH CROSSLINKERS**

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FIELD OF THE INVENTION

The present invention relates to crosslinking agents based on modified aminoplast resins and to powder coating compositions containing such crosslinking agents.

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BACKGROUND OF THE INVENTION

In recent years, powder coatings have become increasingly popular because these coatings are inherently low in volatile organic content ("VOC"), which significantly reduces emissions of volatile organic compounds into the atmosphere during application and curing processes.

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Hydroxyl, carboxyl, carbamate and/or epoxy functional resins, such as acrylic and polyester resins having relatively high glass transition temperatures ("T_g"), are commonly used as main film-forming polymers for these coatings. The relatively high T_g of such acrylic polymer systems provides powder coatings having good storage stability. However, when exposed to the extreme temperatures which can be encountered in many geographic areas during shipping and/or storage, even better powder coating stability may be desired. By "storage stability" is meant the ability of the individual powder particles which comprise the powder coating to resist the tendency to adhere to one another, thereby causing "clumping" or "fusing" of the powder coating composition prior to application. Powder coating

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compositions having very poor storage stability can be difficult, if not impossible to apply.

Aminoplast resins are well known in the art as low cost crosslinking agents for hydroxyl, carboxyl and/or carbamate functional polymers in conventional liquid coating compositions. Common aminoplast resins are based on condensation products of formaldehyde with an amino- or amido-group carrying substance. Condensation products obtained from the reaction of alcohols and formaldehyde with melamine, urea or benzoguanamine are most commonly used in liquid coating compositions where they provide enhanced coating properties such as exterior durability, chemical resistance and mar resistance. Such aminoplast resins typically are in liquid form and, as such, generally are not suitable for use in curable powder coating compositions.

The alkoxyated aldehyde condensates of glycoluril, which typically are solid products, are the aminoplast resins most commonly employed as crosslinking agents in powder coating compositions. Although in solid form, these materials nonetheless can depress the T_g of the powder coating composition significantly, even when combined with high T_g film-forming polymers such as the acrylic polymers described above. Such a depression in T_g also can result in poor powder stability.

Moreover, the use of conventional aminoplast resins in curable powder coating compositions can result in the phenomenon commonly referred to as "gassing". "Gassing" can occur as a result of vaporization of the alcohol generated in the thermally induced aminoplast crosslinking reaction. The alcohol vapor can be driven off through the coating film upon heating and, as the viscosity of the coating increases during the curing process, pinholes or craters are formed as gases escape through coating surface.

U.S. Patent Nos. 3,904,623, 4,189,421 and 4,217,377 disclose a solid, non-gelled low molecular weight addition reaction product and a method for preparing the reaction product. The addition reaction product is suitable for use as a crosslinking agent in powder coating compositions when combined

with polymers having various reactive functional groups. The crosslinking agent is the reaction product of 1.8 to 2.2 moles of a monohydroxy-, single-ring aromatic compound, for example phenol, and 1.0 mole of an alkoxymethyl aminotriazine compound, such as hexakis (methoxymethyl) aminotriazine.

U.S. Patent No. 4,393,181 discloses solid, adducts prepared from aminotriazine compounds and a large excess of polyhydric phenols. The adducts, due to their phenolic functionality, are useful as crosslinking agents for epoxy resins in powder coating compositions when used in conjunction with a curing agent accelerator such as an imidazole or benzimidazole.

U.S. Patent No. 3,759,854 discloses heat-fusible powder coating compositions comprising a crosslinker prepared by pre-reacting a thermosetting polyester resin and a suitable conventional aminoplast crosslinking resin such as a condensation product of an aldehyde with melamine, urea or benzoguanamine.

U.S. Patent No. 5,302,462 discloses a similar process for preparing a partially cured powder coating crosslinker. The crosslinker is prepared by partially reacting a less than stoichiometric amount of methoxymethyl aminotriazine with a substantially linear, hydroxyl-terminated polyester.

U.S. Patent No. 3,980,732 discloses a process for preparing a curable powder resin composition having a sintering temperature above 40°C. The method comprises partially reacting a methylolamino compound with an aliphatic alcohol and an aliphatic diamide to produce an aminoplast condensate with a T_g ranging from -10°C to 100°C and blending the aminoplast condensate with an acrylic or polyester resin having a glass transition temperature ranging from 60°C to 100°C.

U.S. Patent No. 4,185,045 discloses a powder coating composition comprising a solid crosslinking agent having a softening point ranging from 50°C to 120°C and prepared by heating 40 to 75% by weight of an acrylic polyol and 60 to 25% by weight of an alkoxyaminotriazine at 50° to 120°, and a base resin having a softening point ranging from 60°C to 130°C.

U.S. Patent No. 4,230,829 discloses a solid crosslinking agent having a softening point of 50°C to 120°C and prepared by heating 40 to 70% by weight of a polyester polyol and 60 to 30% by weight of an alkoxyaminotriazine.

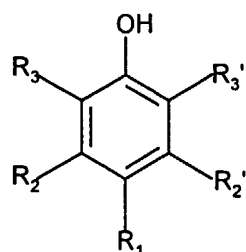
5 While the above-described prior art aminoplast-based crosslinkers for powder coating compositions can provide some improvement in gassing and powder stability over their liquid aminoplast counterparts, the powder coating compositions containing these crosslinkers can, nonetheless, exhibit some of the aforementioned deficiencies. In addition, most of the crosslinkers
 10 disclosed in the prior art are high molecular weight, high viscosity or partially cured and, thereby, unstable mixtures. Further, the crosslinkers described in U.S. Patent Nos. 3,904,623, 4,189,421, and 4,217,377 contain a significant amount of unreacted phenol impurity, which significantly limit their use in the powder coatings industry.

15 Thus, there remains a need for an aminoplast crosslinking agent suitable for use in curable powder coating compositions which provides a storage stable powder composition having the desirable coating properties usually associated with aminoplast-based liquid coatings without causing coating surface defects due to gassing.

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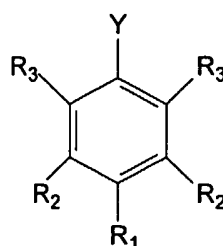
SUMMARY OF THE INVENTION

In accordance with the present invention, provided is a crosslinking agent comprising an ungelled reaction product of (a) at least one compound having the following structure (I-A) or (I-B):



(I-A)

or

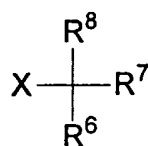


(I-B)

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wherein R_1 represents a monovalent hydrocarbon group, COOR_5 where R_5 represents H or a monovalent hydrocarbon group, NO_2 , halogen or XR_4 , where X represents O or S and R_4 represents a monovalent hydrocarbon group having 1 to 8 carbon atoms; R_3 , R_3' , R_2 and R_2' can be the same or different and each independently represents a substituent selected from H, a monovalent hydrocarbon group, COOR_5 , NO_2 , halogen and XR_4 , provided that at least one of R_3 and R_3' is H; or, when R_3 is other than H (i.e., "non-hydrogen substituted") and R_3' is H, R_1 and R_2 taken together, R_1 and R_2' taken together, or R_2 taken together with the non-hydrogen substituted R_3 represent fused aliphatic or aromatic ring structures; or, when R_3' is non-hydrogen substituted and R_3 is H, R_1 and R_2 taken together, R_1 and R_2' taken together, or R_2 taken together with the non-hydrogen substituted R_3' represent fused aliphatic or aromatic ring structures; and Y represents an active hydrogen-containing group selected from the group consisting of amino, thiol, and urea. Note that urea groups may include N-substituted urea groups. N-substituents include alkyl, cycloalkyl, aryl, alkaryl, or aralkyl having 1 to 12 carbon atoms; (b) at least one aminoplast compound; and (c) at least one compound different from (a) having active hydrogen groups reactive with aminoplast compound (b). The active hydrogen group-containing compound (c) is selected from at least one of:

(1) compounds having the following structure (II):

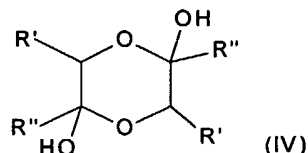
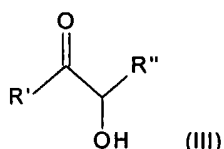


(II)

wherein X is aromatic; R^6 , R^7 , and R^8 can be the same or different and each independently represents H, (cyclo)alkyl having from 1 to 12 carbon atoms, aryl, alkaryl, aralkyl, or an active hydrogen-containing group,

provided that at least one of R^6 , R^7 , and R^8 represents an active hydrogen-containing group which is reactive with the aminoplast resin (b);

(2) compounds having the following structure (III) or (IV):



where R' and R'' are the same or different and each independently represents an aromatic group or an alkyl group having 1 to 12 carbon atoms; and

(3) compounds different from (1) and (2) and having a melting point of at least 80°C.

The crosslinking agent is essentially free of hydroxyl functionality and has a glass transition temperature of at least 25°C.

The present invention is further directed to methods for preparing the above-described crosslinking agent. One method comprises the steps of (1) combining (a) at least one mono-hydroxy aromatic compound having the structure (I-A) where R_1 , R_2 , R_2' , R_3 and R_3' are as described above for that structure (b) at least one aminoplast compound having one or less non-alkylated NH group, and (c) at least one compound different from (a) having active hydrogen groups reactive with aminoplast compound (b), as described above, to form a reaction admixture; (2) heating the reaction admixture formed in step (1) to a temperature ranging from 90°C to 135°C; and (3) maintaining the temperature achieved in step (2) for a time sufficient to produce an ungelled reaction product having a glass transition temperature of at least 25°C which is essentially free of hydroxyl functionality as determined by infrared spectroscopy.

The present invention is also directed to a curable powder coating composition comprising a solid particulate, film-forming mixture of (A) a

polymer having functional groups reactive with benzoxazine groups, the polymer having a glass transition temperature of at least 30°C; and (B) the previously described crosslinking agent.

Multilayer composite coating compositions are also provided. The multilayer composite coating composition comprises a base coat deposited from a pigmented film-forming composition and a transparent topcoat over the base coat. The topcoat is deposited from the curable powder coating composition described above.

The present invention further provides coated substrates.

DETAILED DESCRIPTION OF THE INVENTION

Other than in the operating examples, or where otherwise indicated, all numbers expressing quantities of ingredients, reaction conditions and so forth used in the specification and claims are to be understood as being modified in all instances by the term "about." Accordingly, unless indicated to the contrary, the numerical parameters set forth in the following specification and attached claims are approximations that may vary depending upon the desired properties sought to be obtained by the present invention. At the very least, and not as an attempt to limit the application of the doctrine of equivalents to the scope of the claims, each numerical parameter should at least be construed in light of the number of reported significant digits and by applying ordinary rounding techniques.

Notwithstanding that the numerical ranges and parameters setting forth the broad scope of the invention are approximations, the numerical values set forth in the specific examples are reported as precisely as possible. Any numerical values, however, inherently contain certain errors necessarily resulting from the standard deviation found in their respective testing measurements.

Also, it should be understood that any numerical range recited herein is intended to include all sub-ranges subsumed therein. For example, a range of "1 to 10" is intended to include all sub-ranges between (and

including) the recited minimum value of 1 and the recited maximum value of 10, that is, having a minimum value equal to or greater than 1 and a maximum value of equal to or less than 10.

As mentioned above, the crosslinking agent of the present invention
5 comprises an ungelled reaction product of (a) at least one aromatic compound, usually a mono-hydroxy aromatic compound, having the structure (I-A) as described above, (b) at least one aminoplast compound (described in detail below), and (c) at least one compound different from (a) having active hydrogen groups reactive with aminoplast compound (b). The compound (c)
10 is selected from at least one of (1) compounds having the structure (II) above, where X, R⁶, R⁷, and R⁸ are as described above for that structure, and (2) compounds having the structure (III) or (IV) above, where R' and R'' are as described above for the structures, and (3) compounds different from (1) and (2) and having a melting point of at least 80°C. The crosslinking agent has a
15 glass transition temperature of at least 10°C and is essentially free of functional groups which are reactive with aminoplast resin.

By "ungelled" is meant that the reaction product can be dissolved in a suitable solvent or resin and has an intrinsic viscosity when so dissolved. The intrinsic viscosity of the reaction product is an indication of its molecular
20 weight. A gelled reaction product, on the other hand, since it is of essentially infinitely high molecular weight, will have an intrinsic viscosity too high to measure. Moreover, the reaction product can be melted, solidified and remelted.

The substituent group R₁ in structures (I-A) and (I-B) of the aromatic
25 compound (a) represents a monovalent hydrocarbon, COOR₅ where R₅ represents H or a monovalent hydrocarbon group, NO₂, halogen or XR₄, where X represents O or S and R₄ represents a monovalent hydrocarbon group, preferably having 1 to 8 carbon atoms.

By "monovalent hydrocarbon group" is meant an organic group
30 containing essentially carbon and hydrogen. The hydrocarbon groups may be aliphatic, aromatic, cyclic or acyclic and may contain from 1 to 24 (in the

case of aromatic from 3 to 24) carbon atoms. Optionally, the hydrocarbon groups can be heteroatomic hydrocarbon groups, that is, the hydrocarbon groups can be substituted with heteroatoms, typically oxygen or nitrogen. Non-limiting examples of such monovalent hydrocarbon groups include alkyl, 5 alkoxy, aryl, alkylaryl or alkoxyaryl groups.

By "alkyl" is meant acyclic or cyclic alkyl groups having a carbon chain length of from C_1 to C_{25} . By "alkoxy" is meant an alkyl group containing at least one oxygen atom, such as an ether oxygen, and having a carbon chain length of from C_2 to C_{25} , preferably of from C_2 to C_8 . By alkylaryl is meant an 10 acyclic alkyl group having a carbon chain length of from C_2 to C_{25} and containing at least one aryl group, typically phenyl. The aryl group(s) may optionally be substituted. Suitable substituent groups can include hydroxyl, benzyl, carboxylic acid and aliphatic groups.

The substituent groups R_3 , R_3' , R_2 and R_2' can be the same or different 15 and each independently represents a substituent selected from H, monovalent hydrocarbon groups, $COOR_5$ where R_5 represents H or a monovalent hydrocarbon group, NO_2 , halogen and XR_4 where X represents O or S and R_4 represents a monovalent hydrocarbon group, preferably having 1 to 8 carbon atoms, provided that at least one of R_3 and R_3' is H. In one 20 embodiment of the present invention, R_3 and R_3' both represent H.

In another embodiment of the present invention, R_1 is an aryl group and R_2 , R_2' , R_3 and R_3' are the same or different and each independently represents H, monovalent hydrocarbon groups, $COOR_5$ where R_5 represents H or a monovalent hydrocarbon group, NO_2 , halogen and XR_4 where X 25 represents O or S and R_4 represents a monovalent hydrocarbon group, preferably having 1 to 8 carbon atoms, provided that at least one of R_3 and R_3' is H.

Non-limiting examples of mono-hydroxy aromatic compounds (structure (I-A)) suitable for use as reactant (a) in the present invention 30 include p-cresol, 4-methoxyphenol, 4-tert-butyl phenol, 2,4-di-tert-butyl phenol, 4-nitrophenol, 4-fluorophenol, 2-phenyl phenol, 4-phenyl phenol, 1-

naphthol, and 2-naphthol. The preferred mono-hydroxy aromatic compound comprises 4-tert-butyl phenol, 2,4-di-tert-butyl phenol, and 4-phenyl phenol.

Alternatively, when R_3 represents a substituent other than H (i.e., is "non-hydrogen substituted") and R_3' is H, R_1 and R_2 taken together, R_1 and R_2' taken together, or R_2 taken together with the non-hydrogen substituted R_3 represent fused aliphatic or aromatic ring structures; or when R_3' is non-hydrogen substituted and R_3 is H, R_1 and R_2 taken together, R_1 and R_2' taken together, or R_2 taken together with the non-hydrogen substituted R_3' represent fused aliphatic or aromatic ring structures.

In one embodiment of the present invention, R_1 represents an electron-withdrawing group selected from aryl, alkylaryl, COOH, NO₂, halogen, and an alkoxyl group.

The aminoplast resins suitable for use in the preparation of the crosslinking agent of the present invention as component (b) include those which are or are derived from at least one of glycoluril, aminotriazine and benzoguanamine. Such compounds include, for example, alkoxyalkyl derivatives of melamine, glycoluril, benzoguanamine, acetoguanamine, formoguanamine, spiroguanamine, and the like.

Aminoplast resins are based on the condensation products of formaldehyde, with an amino- or amido-group carrying substance. Condensation products obtained from the reaction of alcohols and formaldehyde with melamine, urea or benzoguanamine are most common. However, condensation products of other amines and amides can also be employed, for example, aldehyde condensates of triazines, diazines, triazoles, guanadines, guanamines and alkyl- and aryl-substituted derivatives of such compounds, including alkyl- and aryl-substituted ureas and alkyl- and aryl-substituted melamines. Some examples of such compounds are N,N'-dimethyl urea, benzourea, dicyandiamide, formaguanamine, acetoguanamine, glycoluril, ammeline, 2-chloro-4,6-diamino-1,3,5-triazine, 6-methyl-2,4-diamino-1,3,5-triazine, 3,5-diaminotriazole, triaminopyrimidine, 2-mercapto-4,6-diaminopyrimidine and 3,4,6-tris(ethylamino)-1,3,5 triazine.

While the aldehyde employed is most often formaldehyde, other similar condensation products can be prepared from other aldehydes such as acetaldehyde, crotonaldehyde, acrolein, benzaldehyde, furfural and glyoxal.

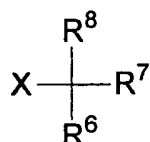
The aminoplast resins can contain methylool or other alkylol groups, and in most instances, at least a portion of these alkylol groups are etherified by a reaction with an alcohol. Any monohydric alcohol can be employed for this purpose, including alcohols such as methanol, ethanol, propanol, butanol, pentanol, hexanol, heptanol and others, as well as, benzyl alcohol and other aromatic alcohols, cyclic alcohols such as cyclohexanol, monoethers of glycols, and halogen-substituted or other substituted alcohols, such as 3-chloropropanol and butoxyethanol. Commonly employed aminoplast resins include those substantially alkylated with methanol or butanol.

In one embodiment of the present invention, the aminoplast resins comprise highly alkylated, low imino aminoplast resins which have a degree of polymerization ("DP") of less than 3.75, often less than 3.0, and typically less than 2.0. Generally, the number average degree of polymerization is defined as the average number of structural units per polymer chain (see George Odian, *Principles of Polymerization*, John Wiley & Sons (1991)). For purposes of the present invention, for example, a DP of 1.0 would indicate a completely monomeric triazine structure, while a DP of 2.0 indicates two triazine rings joined by a methylene or methylene-oxy bridge. It should be understood that the DP values reported herein and in the claims represent average DP values as determined by gel permeation chromatography data.

Non-limiting examples of suitable aminotriazine compounds include alkoxyalkyl aminotriazines, such as (methoxymethyl) melamine-formaldehyde resin, for example, RESIMENE® CE-7103, 745, and 747 commercially available from Solutia, Inc. and CYMEL® 300, 303; ethylated-methylated benzoguanimine-formaldehyde resin, for example CYMEL® 1123; ethylated-methylated melamine-formaldehyde resin, for example CYMEL® 1116; and methylated-butylated melamine-formaldehyde resin, for example CYMEL®

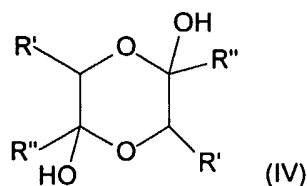
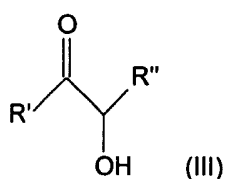
1135, 1133, 1168 commercially available from Cytec Industries, Inc and RESIMENE® 755, 757 commercially available from Solutia, Inc.

As aforementioned, in addition to the aromatic compound (a) and the aminoplast compound (b) described immediately above, the reactants used to form the crosslinking agent of the present invention further comprise (c) at least one compound different from (a) having active hydrogen groups reactive with aminoplast compound (b). As previously discussed, compound (c) is selected from at least one of (1) compounds having the following structure (II):



(II)

wherein X is aromatic; R⁶, R⁷, and R⁸ can be the same or different and each independently represents H, (cyclo)alkyl having from 1 to 12 carbon atoms, aryl, alkaryl, aralkyl, or an active hydrogen-containing group which is reactive with the aminoplast compound (b), provided that at least one of R⁶, R⁷, and R⁸ represents an active hydrogen-containing group which is reactive with the aminoplast compound (b); (2) compounds having the following structure (III) or (IV):



where R' and R'' are the same or different and each independently represents an aromatic group or an alkyl group having 1 to 12 carbon atoms; and (3) compounds different from (1) and (2) and having a melting point of at least 80°C. Mixtures of any combination of compounds (1), (2) and (3) can be

used. As used herein, by "(cyclo)alkyl" is meant both alkyl and cycloalkyl groups.

In one embodiment of the present invention, compound (c) comprises at least one of compound (1) having the previously described structure (II).

As aforementioned, the substituent group X represents an aromatic group, for example, phenyl, or a cycloaliphatic group, for example, cyclohexyl.

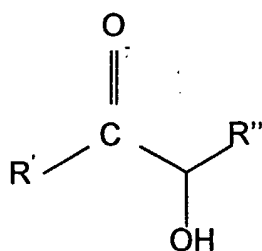
These groups can be any fused or bridged ring structures such as naphthyl, anthracyl, and benzofuranyl. Also, the aromatic or cycloaliphatic groups can be unsubstituted or substituted with heteroatoms, for example O, N and S.

Non-limiting examples of aromatic or cycloaliphatic groups suitable as the substituent include phenyl, naphthyl, anthracyl, pyrene, benzofuranyl, and the like.

As previously mentioned, at least one of R^6 , R^7 , and R^8 represents a group comprising an active hydrogen-containing group such as a group selected from hydroxyl, amide, amine, carboxylic acid, carbamate, urea, thiol, and combinations thereof. In one embodiment of the present invention, compound (c) comprises at least one compound having the structure (II) above and at least one of R^6 , R^7 , and R^8 represents a group comprising at least one hydroxyl group.

Nonlimiting examples of active hydrogen-containing compounds suitable for use as the reactant (c)(1) include benzyl alcohol and substituted benzyl alcohols such as 3-phenoxybenzyl alcohol and 4-methoxybenzyl alcohol, phenethyl alcohol, benzopinacol, N-benzylformamide, benzyl lactate, benzyl mandelate, benzyl mercaptan, N-benzylmethamine, 3-furanmethanol, furfuryl alcohol, pyridylcarbinols, for example, 2-pyridylcarbinol, and 3-pyridylcarbinol, 1-pyrenemethanol, 9-anthrancenemethanol, 9-fluorenemethanol, 9-hydroxyfluorene, 9-hydroxyxanthene, 9-phenylxanthene-9-ol, 4-stilbenemethanol and triphenylmethanol.

In another embodiment of the present invention, the active hydrogen-containing compound (c)(2) comprises compounds having the following structure (III):



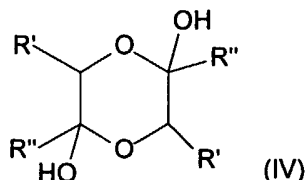
(III)

or dimer derivatives thereof as discussed below, where R' and R'' are the same or different and each independently represents an alkyl group having 1 to 12 carbon atoms. In one embodiment of the present invention, one or both of the substituent groups R' and R'' are aromatic groups, for example phenyl, naphthyl, methoxy phenyl, and dimethylaminophenyl groups.

Also, suitable aromatic groups can contain one or more heteroatoms, such as O, N and S, either internal or external to the aromatic ring. The heteroatoms external to the ring may be attached directly to the ring or indirectly through one or more carbon atoms. One or more heteroatoms may be present in each such substituent and one or more substituents may be attached to the aromatic ring. The heteroatom containing substituent group(s) may be attached to the aromatic ring in any position or combination of positions on the ring. Suitable heteroatomic substituent groups include but are not limited to amines, ethers, esters, ketones, amides, halides, sulfonamides, nitro and carboxylic acid groups. Heteroatoms internal to the aromatic ring may be present in any position or combination of positions. For example, such heteroaromatic groups can include but are not limited to furans, pyridines, thiophenes, triazines, imidazoles, oxazoles, thiazoles, pyrazoles and triazoles. Non-limiting examples of such compounds include anisoin, pyridoin, furoin, and bufyroid.

In one particular embodiment of the present invention, the active hydrogen-containing compound (c)(2) comprises an active hydrogen-containing compound selected from benzoin, hydroxycyclohexyl phenylketone, and mixtures thereof.

Compounds having the general structure (III) above are known to form dimeric derivatives, particularly when R' and R'' are alkyl (Merck Index, 11ed, p 10, 55).



- 5 Such dimer derivatives can have the structure (IV) above where R and R' are as described above for the structure (III).

In yet another embodiment of the present invention, the active hydrogen-containing compound (c) comprises at least one of compound (3), which is different from both (1) and (2) and has a melting point of at least
 10 80°C. The melting point of a compound can be determined by using a standard capillary melting point apparatus or by thermal analysis (ASTM E974-95).

Generally, the melting point of the active hydrogen-containing compound (c)(3) is less than 250°C, usually less than 220°C, and typically
 15 less than 200°C. Also, the melting point of the active hydrogen-containing compound (c)(3) generally is at least 80°C, usually at least 90°C, and typically at least 100°C. The melting point of the active hydrogen-containing compound (c)(3) can range between any combination of these values inclusive of the recited values. Non-limiting examples of compounds suitable
 20 for use as reactant (c)(3) include mono-alcohols such as borneol, norborneol, isoborneol, 1-adamantanemethanol, 1-adamantanol, 2-methyl-2-adamantanol and 5-norbornen-2-ol; secondary amides, such as aliphatic cyclic amides such as 1-methylhydantoin, 2,4-thiazolidinedione, 2-azacyclotridecanone, 3,4,5,6,7,8-hexahydro-2(1H)-quinoline, 4-azatricyclo(4.3.1.1(3,8))undecan-5-
 25 one and 4-methoxy-3-pyrrolin-2-one; aliphatic open chain amides, such as N-(1-adamantyl)acetamide) and N-tert-butylacrylamide; aromatic (poly)cyclic amides, include lactams, such as 1-acetamidopyrene, 2-acetamide-3-nitro-9-fluorenone, 2-acetoamide-7-fluorfluorene, 2-acetamidofluorene, 4-acetamido-

9-fluorenone, naphthol AS acetate, 1-phenyl-3-pyrazolidinone, 2,3-dimethyl-1-(4-methylphenyl)-3-pyrazolin-5-one, 3,4-dimethyl-1-phenyl-3-pyrazolin-5-one, 3-(4-ethoxyphenyl)-1-(2-nitrophenyl)-hydantoin, 4-acetamidoantipyrine, and 4-acetamidobenzaldehyde; aromatic open chain amides, such as 3-acetamidocoumarin and p-acetophenetidide; and mono-urethanes such as those obtained by reacting high melting point mono-alcohols (such as those described immediately above) with suitable mono-isocyanates.

The active hydrogen-containing compound (c) can comprise one or more of compounds (c)(1), (c)(2), and (c)(3). Inclusion of the active hydrogen-containing compound (c) as a reactant in the preparation of the crosslinking agent of the present invention can provide several advantages. First, reaction of the active hydrogen-containing compound (c) with the aminoplast compound (b) can generally increase the T_g of the resultant crosslinking agent as compared to an analogous crosslinking agent having no such modification. Also, compounds such as (c)(1), (c)(2) and (c)(3) described above can allow for the reaction of more alkoxy groups of the aminoplast compound (b) without resulting in a gelled reaction product. Such a crosslinking agent when incorporated into curable powder coating compositions can result in less gassing upon thermal curing of the composition. Furthermore, when crosslinking agents of the present invention are used in curable powder coating compositions, the degassing agent can be released *in situ*. This can reduce adverse effects, for example, yellowing of the film, often caused by the presence of the degassing agent during curing processes.

The present invention is also directed to a method for preparing the above-described crosslinking agent. The mono-hydroxy aromatic compound (a), the aminoplast compound (b), and the active hydrogen-containing compound (c) generally are combined in a suitably equipped reaction vessel, typically with a suitable solvent and an appropriate strong acid as catalyst. Any suitable solvent can be used, but aromatic solvents are typically employed. Non-limiting examples of suitable aromatic solvents include

xylene, toluene, and mixtures thereof. Non-limiting examples of strong acids suitable for use as a catalyst include, but are not limited to, para-toluene sulfonic acid and dodecyl benzene sulfonic acid. Normal condensation techniques as are well-known in the art can be used.

5 The reaction admixture can be heated to a temperature ranging from 90°C to 135°C, typically from 100°C to 120°C, and held at that temperature for a period sufficient to obtain an ungelled product having a Tg of at least 25°C. The reaction is terminated when a pre-determined end point (e.g., the disappearance of the OH signal) is detected by infrared spectroscopy or other
10 suitable analytical technique.

 In the preparation of the crosslinking agent of the present invention, the aromatic compound (a), the aminoplast resin (b), and the active hydrogen-containing compound (c) are combined such that the equivalents of aminoplast resin (b) are in excess relative to the combined equivalents of the
15 aromatic compound (a) and the active hydrogen-containing compound (c). This results in a stable crosslinking agent which is essentially free of functional groups that are reactive with aminoplast resin and/or benzoxazine groups. The reaction is monitored for the disappearance of such functionality relative to an internal standard via infrared spectroscopy or other appropriate
20 analytical technique (e.g., the hydroxyl signal is compared to the signal of a structure which will remain essentially unchanged as the reaction proceeds to completion, for example, the C-H stretch signal). By "stable" crosslinking agent is meant that the crosslinking agent is essentially free of any functionalities that can be reactive with the aminoplast resin and no further
25 reaction will occur when the composition is continuously heated at the designated temperatures; i.e., the crosslinking agent will not self-condense.

 Generally, in the preparation of the crosslinking agent of the present invention, the ratio of moles of aminoplast resin (b) to the moles of the aromatic compound (a) ranges from 1.5 to 5.0:1, often from 1.8 to 4.0:1, and
30 typically from 1.9 to 3.6:1. Additionally, when the aminoplast resin (b) comprises an (alkoxyalkyl)aminotriazine, it should be understood that the

theoretical molecular weight of the monomeric aminotriazine (that is, where DP=1) is used to calculate the "molar ratio".

The above-described reaction generally results in a crosslinking agent having both reactive aminoplast groups (for example, (methoxymethyl) aminotriazine groups) and benzoxazine groups. The benzoxazine structures formed in the syntheses described above may be confirmed by NMR spectroscopy data.

In an alternative embodiment of the invention, the aromatic compound (a) and aminoplast compound (b) are combined and heated to a temperature ranging from 90°C to 135°C. The temperature is maintained until no free hydroxyl functionality remains as determined by suitable analytical techniques. The active hydrogen-containing compound (c) is then added and the mixture heated once again, if necessary, to a temperature of 90°C to 135°C. This temperature is again maintained until an end point is reached, yielding an ungelled product having a Tg of at least 25°C.

The crosslinking agent of the present invention can have a glass transition temperature of at least 25°C, usually at least 30°C, often at least 35°C, and typically at least 40°C. Also, the crosslinking agent can have a glass transition temperature less than 120°C, usually less than 100°C, often less than 90°C, and typically less than 85°C. The glass transition temperature of the crosslinking agent can range between any combination of these values, inclusive of the recited values. The Tg of the crosslinking agent can be measured experimentally using differential scanning calorimetry (rate of heating 10°C per minute, Tg taken at the first inflection point). Unless otherwise indicated, the stated Tg as used herein refers to the measured Tg.

The present invention is also directed to curable powder coating compositions comprising a solid, particulate film-forming mixture of (A) a polymer having functional groups reactive with benzoxazine groups, as well as aminotriazine groups, and having a glass transition temperature of at least 30°C, and (B) the crosslinking agent described above. Curable powder coatings are particulate compositions that are solid and free flowing at ambient

room temperature. As mentioned above, the curable powder coating compositions of the present invention comprise, as a first component (A), at least one aminoplast- and/or benzoxazine- reactive functional group-containing polymer having a glass transition temperature of at least 30°C, e.g., a hydroxyl and/or an epoxide functional acrylic polymer, and as a second component (B), the crosslinking agent described above. The components (A) and (B) of the curable powder coating composition may each independently comprise one or more functional species, and are each present in amounts sufficient to provide cured coatings having a desirable combination of physical properties, e.g., smoothness, optical clarity, scratch resistance, solvent resistance and hardness.

As used herein, the term "reactive" refers to a functional group that forms a covalent bond with another functional group under suitable reaction conditions.

As used herein, the term "cure" as used in connection with a composition, e.g., "a curable composition," shall mean that any crosslinkable components of the composition are at least partially crosslinked. In certain embodiments of the present invention, the crosslink density of the crosslinkable components, i.e., the degree of crosslinking, ranges from 5% to 100% of complete crosslinking. In other embodiments, the crosslink density ranges from 35% to 85% of full crosslinking. In other embodiments, the crosslink density ranges from 50% to 85% of full crosslinking. One skilled in the art will understand that the presence and degree of crosslinking, i.e., the crosslink density, can be determined by a variety of methods, such as dynamic mechanical thermal analysis (DMTA) using a Polymer Laboratories MK III DMTA analyzer conducted under nitrogen. This method determines the glass transition temperature and crosslink density of free films of coatings or polymers. These physical properties of a cured material are related to the structure of the crosslinked network.

According to this method, the length, width, and thickness of a sample to be analyzed are first measured, the sample is tightly mounted to the

Polymer Laboratories MK III apparatus, and the dimensional measurements are entered into the apparatus. A thermal scan is run at a heating rate of 3°C/min, a frequency of 1 Hz, a strain of 120%, and a static force of 0.01N, and sample measurements occur every two seconds. The mode of
5 deformation, glass transition temperature, and crosslink density of the sample can be determined according to this method. Higher crosslink density values indicate a higher degree of crosslinking in the coating.

Also, as used herein, the term "polymer" is meant to refer to oligomers and both homopolymers and copolymers. Unless stated otherwise, as used
10 in the specification and the claims, molecular weights are number average molecular weights for polymeric materials indicated as "Mn" and obtained by gel permeation chromatography using a polystyrene standard in an art-recognized manner.

The polymer (A) can be any of a variety of polymers having
15 aminotriazine- and/or benzoxazine-reactive functional groups as are well known in the art, so long as the Tg of the polymer is sufficiently high to permit the formation of a stable, solid particulate composition. The Tg of the polymer (A) can be at least 30°C, usually at least 40°C, often at least 60°C, and typically at least 90°C. The Tg of the polymer (A) also can be less than
20 200°C, usually less than 150°C, often less than 130°C, and typically less than 110°C. The Tg of the functional group-containing polymer (A) can range between any combination of these values inclusive of the recited values.

Non-limiting examples of polymers having aminoplast and/or benzoxazine-reactive functional groups useful in the curable powder coating
25 compositions of the invention include those selected from acrylic, polyester, polyurethane, polyepoxide and polyether polymers. The polymer (A) can comprise a wide variety of alkoxyalkyl aminotriazine - and /or benzoxazine-reactive functional groups, for example hydroxyl, carboxyl, anhydride, epoxy, thiol, phenolic, amine and/or amide functional groups. The polymer (A) can
30 comprise aminoplast- and/or benzoxazine-reactive functional groups selected the group consisting of hydroxyl, epoxy, carboxyl and/or carbamate functional

groups, with hydroxyl and/or carbamate functional groups most often being employed.

In one embodiment of the present invention, the polymer (A) comprises hydroxyl and/or carbamate functional groups. Hydroxyl and/or carbamate functional group-containing acrylic polymers and/or polyester polymers are suitable for use as the polymer (A). In another embodiment of the invention, the polymer (A) comprises epoxy and/or hydroxyl functional groups.

Suitable functional group-containing acrylic polymers include copolymers prepared from one or more alkyl esters of acrylic acid or methacrylic acid and, optionally, one or more other polymerizable ethylenically unsaturated monomers. Suitable alkyl esters of acrylic or methacrylic acid include methyl (meth)acrylate, ethyl (meth)acrylate, butyl (meth)acrylate. As used herein, by "(meth)acrylate" and like terms is meant both methacrylates and acrylates. Ethylenically unsaturated carboxylic acid functional monomers, for example acrylic acid and/or methacrylic acid, can also be used when a carboxylic acid functional acrylic polymer is desired. Amide functional acrylic polymers can be formed by polymerizing ethylenically unsaturated acrylamide monomers, such as N-butoxymethyl acrylamide and N-butoxyethyl acrylamide with other polymerizable ethylenically unsaturated monomers. Non-limiting examples of suitable other polymerizable ethylenically unsaturated monomers include vinyl aromatic compounds, such as styrene and vinyl toluene; nitriles, such as acrylonitrile and methacrylonitrile; vinyl and vinylidene halides, such as vinyl chloride and vinylidene fluoride and vinyl esters, such as vinyl acetate.

In one embodiment, the acrylic polymers contain hydroxyl functionality which can be incorporated into the acrylic polymer through the use of hydroxyl functional monomers such as hydroxyethyl (meth)acrylate and hydroxypropyl (meth)acrylate which may be copolymerized with the other acrylic monomers mentioned above.

The acrylic polymer can be prepared from ethylenically unsaturated, beta-hydroxy ester functional monomers. Such monomers are derived from

the reaction of an ethylenically unsaturated acid functional monomer, such as monocarboxylic acids, for example, acrylic acid, and an epoxy compound which does not participate in the free radical initiated polymerization with the unsaturated acid monomer. Examples of such epoxy compounds are glycidyl ethers and esters. Suitable glycidyl ethers include glycidyl ethers of alcohols and phenols, such as butyl glycidyl ether, octyl glycidyl ether, phenyl glycidyl ether and the like. Suitable glycidyl esters include those which are commercially available from Shell Chemical Company under the tradename CARDURA® E; and from Exxon Chemical Company under the tradename GLYDEXX®-10.

Alternatively, the beta-hydroxy ester functional monomers are prepared from an ethylenically unsaturated, epoxy functional monomer, for example glycidyl methacrylate and allyl glycidyl ether, and a saturated carboxylic acid, such as a saturated monocarboxylic acid, for example, isostearic acid.

The hydroxyl group-containing acrylic polymers useful in the compositions of the present invention can have a hydroxyl value ranging from 10 to 150, usually from 15 to 90, and typically from 20 to 50.

The acrylic polymer is generally prepared by solution polymerization techniques in the presence of suitable initiators such as organic peroxides or azo compounds, for example, benzoyl peroxide or N,N-azobis(isobutyronitrile). The polymerization can be carried out in an organic solution in which the monomers are soluble by techniques conventional in the art.

Pendent and/or terminal carbamate functional groups can be incorporated into the acrylic polymer by copolymerizing the acrylic monomer with a carbamate functional vinyl monomer, such as a carbamate functional alkyl ester of methacrylic acid. These carbamate functional alkyl esters are prepared by reacting, for example, a hydroxyalkyl carbamate, such as the reaction product of ammonia and ethylene carbonate or propylene carbonate, with methacrylic anhydride. Other carbamate functional vinyl monomers can

include the reaction product of hydroxyethyl methacrylate, isophorone diisocyanate and hydroxypropyl carbamate. Still other carbamate functional vinyl monomers may be used, such as the reaction product of isocyanic acid (HNCO) with a hydroxyl functional acrylic or methacrylic monomer such as hydroxyethyl acrylate, and those carbamate functional vinyl monomers described in U.S. Patent No. 3,479,328.

Carbamate groups can also be incorporated into the acrylic polymer by a "transcarbamoylation" reaction in which a hydroxyl functional acrylic polymer is reacted with a low molecular weight carbamate derived from an alcohol or a glycol ether. The carbamate groups can exchange with the hydroxyl groups yielding the carbamate functional acrylic polymer and the original alcohol or glycol ether.

The low molecular weight carbamate functional material derived from an alcohol or glycol ether is first prepared by reacting the alcohol or glycol ether with urea in the presence of a catalyst such as butyl stannic acid. Suitable alcohols include lower molecular weight aliphatic, cycloaliphatic and aromatic alcohols, such as methanol, ethanol, propanol, butanol, cyclohexanol, 2-ethylhexanol and 3-methylbutanol. Suitable glycol ethers include ethylene glycol methyl ether and propylene glycol methyl ether.

Also, hydroxyl functional acrylic polymers can be reacted with isocyanic acid yielding pendent carbamate groups. Note that the production of isocyanic acid is disclosed in U.S. Patent No. 4,364,913. Likewise, hydroxyl functional acrylic polymers can be reacted with urea to give an acrylic polymer with pendent carbamate groups.

Epoxide functional acrylic polymers are typically prepared by polymerizing one or more epoxide functional ethylenically unsaturated monomers, e.g., glycidyl (meth)acrylate and allyl glycidyl ether, with one or more ethylenically unsaturated monomers that are free of epoxide functionality, e.g., methyl (meth)acrylate, isobornyl (meth)acrylate, butyl (meth)acrylate and styrene. Examples of epoxide functional ethylenically unsaturated monomers that may be used in the preparation of epoxide

functional acrylic polymers include, but are not limited to, glycidyl (meth)acrylate, 3,4-epoxycyclohexylmethyl (meth)acrylate, 2-(3,4-epoxycyclohexyl)ethyl (meth)acrylate and allyl glycidyl ether. Examples of ethylenically unsaturated monomers that are free of epoxide functionality include those described above as well as those described in U.S. Patent 5,407,707 at column 2, lines 17 through 56, which disclosure is incorporated herein by reference. In one embodiment of the present invention, the epoxide functional acrylic polymer is prepared from a majority of (meth)acrylate monomers.

The functional group-containing acrylic polymer can have a M_n ranging from 500 to 30,000 and typically from 1000 to 5000. If carbamate functional, the acrylic polymer can have a calculated carbamate equivalent weight within the range of 15 to 150, and typically less than 50, based on equivalents of reactive carbamate groups.

Non-limiting examples of functional group-containing polyester polymers suitable for use as the polymer (A) in the curable powder coating compositions of the present invention can include linear or branched polyesters having hydroxyl, carboxyl and/or carbamate functionality. Such polyester polymers are generally prepared by the polyesterification of a polycarboxylic acid or anhydride thereof with polyols and/or an epoxide using techniques known to those skilled in the art. Usually, the polycarboxylic acids and polyols are aliphatic or aromatic dibasic acids and diols. Transesterification of polycarboxylic acid esters using conventional techniques is also possible.

The polyols which usually are employed in making the polyester (or the polyurethane polymer, as described below) include alkylene glycols, such as ethylene glycol and other diols, such as neopentyl glycol, hydrogenated Bisphenol A, cyclohexanediol, butyl ethyl propane diol, trimethyl pentane diol, cyclohexanedimethanol, caprolactonediol, for example, the reaction product of epsilon-caprolactone and ethylene glycol, hydroxy-alkylated bisphenols, polyether glycols, for example, poly(oxytetramethylene) glycol and the like.

Polyols of higher functionality may also be used. Examples include trimethylolpropane, trimethylolethane, pentaerythritol, tris-hydroxyethylisocyanurate and the like.

The acid component used to prepare the polyester polymer can include, monomeric carboxylic acids or anhydrides thereof having 2 to 18 carbon atoms per molecule. Among the acids which are useful are cycloaliphatic acids and anhydrides, such as phthalic acid, isophthalic acid, terephthalic acid, tetrahydrophthalic acid, hexahydrophthalic acid, methylhexahydrophthalic acid, 1,3-cyclohexane dicarboxylic acid and 1,4-cyclohexane dicarboxylic acid. Other suitable acids include adipic acid, azelaic acid, sebacic acid, maleic acid, glutaric acid, decanoic diacid, dodecanoic diacid and other dicarboxylic acids of various types. The polyester may include minor amounts of monobasic acids such as benzoic acid, stearic acid, acetic acid and oleic acid. Also, there may be employed higher carboxylic acids, such as trimellitic acid and tricarballic acid. Where acids are referred to above, it is understood that anhydrides thereof which exist may be used in place of the acid. Also, lower alkyl esters of diacids such as dimethyl glutarate and dimethyl terephthalate can be used. Because it is readily available and low in cost, terephthalic acid often is used.

Pendent and/or terminal carbamate functional groups may be incorporated into the polyester by first forming a hydroxyalkyl carbamate which can be reacted with the polyacids and polyols used in forming the polyester. The hydroxyalkyl carbamate is condensed with acid functionality on the polyester yielding carbamate functionality. Carbamate functional groups may also be incorporated into the polyester by reacting a hydroxyl functional polyester with a low molecular weight carbamate functional material via a transcarbamoylation process similar to the one described above in connection with the incorporation of carbamate groups into the acrylic polymers or by reacting isocyanic acid with a hydroxyl functional polyester.

Epoxide functional polyesters can be prepared by art-recognized methods, which typically include first preparing a hydroxy functional polyester

that is then reacted with epichlorohydrin. Polyesters having hydroxy functionality may be prepared by art-recognized methods, which include reacting carboxylic acids (and/or esters thereof) having acid (or ester) functionalities of at least 2, and polyols having hydroxy functionalities of at least 2. As is known to those of ordinary skill in the art, the molar equivalents ratio of carboxylic acid groups to hydroxy groups of the reactants is selected such that the resulting polyester has hydroxy functionality and the desired molecular weight.

The functional group-containing polyester polymer can have a M_n ranging from 500 to 30,000, typically 1000 to 5000. If carbamate functional, the polyester polymer can have a calculated carbamate equivalent weight within the range of 15 to 150, typically 20 to 75, based on equivalents of reactive pendent or terminal carbamate groups.

Non-limiting examples of suitable polyurethane polymers having pendent and/or terminal hydroxyl and/or carbamate functional groups include the polymeric reaction products of polyols, which are prepared by reacting the polyester polyols or acrylic polyols, such as those mentioned above, with a polyisocyanate such that the OH/NCO equivalent ratio is greater than 1:1 such that free hydroxyl groups are present in the product. Such reactions employ typical conditions for urethane formation, for example, temperatures of 60°C to 90°C and up to ambient pressure, as known to those skilled in the art.

The organic polyisocyanates which can be used to prepare the functional group-containing polyurethane polymer include aliphatic or aromatic polyisocyanates or a mixture of the two. Diisocyanates are preferred, although higher polyisocyanates can be used in place of or in combination with diisocyanates.

Examples of suitable aromatic diisocyanates include 4,4'-diphenylmethane diisocyanate and toluene diisocyanate. Examples of suitable aliphatic diisocyanates include straight chain aliphatic diisocyanates, such as 1,6-hexamethylene diisocyanate and trimethyl hexamethylene. Also,

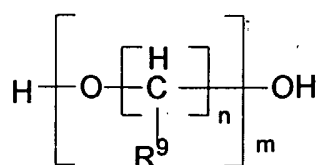
cycloaliphatic diisocyanates can be employed. Examples include isophorone diisocyanate, tetramethyl xylenediisocyanate and 4,4'-methylene-bis-(cyclohexyl isocyanate). Examples of suitable higher polyisocyanates include 1,2,4-benzene triisocyanate and polymethylene polyphenyl isocyanate.

5 Terminal and/or pendent carbamate functional groups can be incorporated into the polyurethane by reacting a polyisocyanate with a polyester polyol containing the terminal/pendent carbamate groups. Alternatively, carbamate functional groups can be incorporated into the polyurethane by reacting a polyisocyanate with a polyester polyol and a
10 hydroxyalkyl carbamate or isocyanic acid as separate reactants. Carbamate functional groups can also be incorporated into the polyurethane by reacting a hydroxyl functional polyurethane with a low molecular weight carbamate functional material via a transcarbamoylation process similar to the one described above in connection with the incorporation of carbamate groups
15 into the acrylic polymer.

 The hydroxyl and/or carbamate functional group-containing polyurethane polymers can have a Mn ranging from 500 to 20,000, typically from 1000 to 5000. If carbamate functional, the polyurethane polymer can have a carbamate equivalent weight within the range of 15 to 150, typically 20
20 to 75, based on equivalents of reactive pendent or terminal carbamate groups.

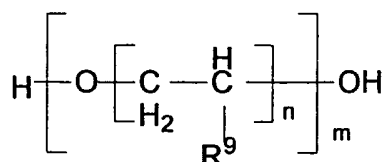
 For some applications it may be desirable to employ a functional group-containing polyether polymer in the curable powder coating compositions of the present invention. Suitable hydroxyl and/or carbamate
25 functional polyether polymers can be prepared by reacting a polyether polyol with urea under reaction conditions well known to those skilled in the art. Most often, the polyether polymer is prepared by a transcarbamoylation reaction similar to the reaction described above in connection with the incorporation of carbamate groups into the acrylic polymers.

30 Examples of polyether polyols are polyalkylene ether polyols which include those having the following structural formulae (V) and (VI):



(V)

or



(VI)

- 5 where the substituent R^9 is hydrogen or lower alkyl containing from 1 to 5 carbon atoms including mixed substituents, n is typically from 2 to 6, and m is from 8 to 100 or higher. Note that the hydroxyl groups, as shown in structures (V) and (VI) above, are terminal to the molecules. Included are poly(oxytetramethylene) glycols, poly(oxytetraethylene) glycols, poly(oxy-1,2-
10 propylene) glycols and poly(oxy-1,2-butylene) glycols.

Also useful are polyether polyols formed from oxyalkylation of various polyols, for example, diols, such as ethylene glycol, 1,6-hexanediol, Bisphenol A and the like, or other higher polyols, such as trimethylolpropane, pentaerythritol and the like. Polyols of higher functionality which can be
15 utilized as indicated can be made, for instance, by oxyalkylation of compounds, such as sucrose or sorbitol. One commonly utilized oxyalkylation method is reaction of a polyol with an alkylene oxide, for example, propylene or ethylene oxide, in the presence of a conventional acidic or basic catalyst as known to those skilled in the art. Typical
20 oxyalkylation reaction conditions may be employed. Suitable polyethers include those sold under the names TERATHANE® and TERACOL®, available from E. I. du Pont de Nemours and Company, Inc. and POLYMEG®, available from Q O Chemicals, Inc., a subsidiary of Great Lakes Chemical Corp.

Epoxide functional polyethers can be prepared from a hydroxy
25 functional monomer, e.g., a diol, and an epoxide functional monomer, and/or

a monomer having both hydroxy and epoxide functionality. Suitable epoxide functional polyethers include, but are not limited to, those based on 4,4'-isopropylidenediphenol (Bisphenol A), a specific example of which is EPON® RESIN 2002 available commercially from Shell Chemicals.

5 Suitable functional group-containing polyether polymers can have a number average molecular weight (M_n) ranging from 500 to 30,000 and typically from 1000 to 5000. If carbamate functional, the polyether polymers can have a carbamate equivalent weight of within the range of 15 to 150, usually 25 to 75, based on equivalents of reactive pendent and/or terminal
10 carbamate groups and the solids of the polyether polymer.

 It should be understood that the carbamate functional group-containing polymers can contain residual hydroxyl functional groups which provide additional crosslinking sites. The carbamate/hydroxyl functional group-containing polymer (A) can have a residual hydroxyl value ranging from 0.5 to
15 10, usually from 1 to 10, and typically from 2 to 10 (mg KOH per gram).

 The functional group-containing polymer (A) can be present in the curable powder coating compositions of the present invention in an amount ranging from at least 5 percent by weight, usually at least 20 percent by weight, often at least 30 percent by weight, and typically at least 40 percent
20 by weight based on the total weight of the film-forming composition. The functional group-containing polymer (A) also can be present in the curable powder coating compositions of the present invention in an amount less than 95 percent by weight, usually less than 90 percent by weight, often less than 80 percent by weight, and typically less than 75 percent by weight based on
25 the total weight of the curable powder coating composition. The amount of the functional group-containing polymer (A) present in the powder coating compositions of the present invention can range between any combination of these values inclusive of the recited values.

 As mentioned above, the curable powder coating compositions of the
30 present invention further comprise, as component (B), the crosslinking agent described above. The crosslinking agent (B) can be present in the curable

powder coating compositions of the present invention in an amount ranging from at least 5 percent by weight, usually at least 10 percent by weight, often at least 20 percent by weight, and typically at least 25 percent by weight based on the total weight of the powder coating composition. The

5 crosslinking agent (B) also can be present in the curable powder coating compositions of the present invention in an amount less than 95 percent by weight, usually less than 80 percent by weight, often less than 70 percent by weight, and typically less than 60 percent by weight based on the total weight of the powder coating composition. The amount of the crosslinking agent (B)
10 present in the curable powder coating compositions of the present invention can range between any combination of these values inclusive of the recited values.

If desired, the curable powder coating compositions of the present invention also can include an adjuvant curing agent which is different from the
15 crosslinking agent (B). The adjuvant curing agent can be any compound having functional groups reactive with the functional groups of the polymer (A) and/or the crosslinking agent (B) described above. Non-limiting examples of suitable adjuvant curing agents include, for example, blocked isocyanates, triazine compounds, glycoluril resins, and mixtures thereof.

20 The blocked isocyanates suitable for use as the adjuvant curing agent in the powder coating compositions of the invention are known compounds and can be obtained from commercial sources or may be prepared according to published procedures. Upon being heated to cure the curable powder coating compositions, the isocyanates are unblocked and the isocyanate
25 groups become available to react with the functional groups of the polymer (A).

Any suitable aliphatic, cycloaliphatic or aromatic alkyl monoalcohol known to those skilled in the art can be used as a blocking agent for the isocyanate. Other suitable blocking agents include oximes and lactams.

30 Non-limiting examples of suitable blocked isocyanate curing agents include those based on isophorone diisocyanate blocked with ϵ -caprolactam; toluene

2,4-toluene diisocyanate blocked with ϵ -caprolactam; or phenol-blocked hexamethylene diisocyanate. The blocked isocyanates mentioned immediately above are described in detail in U.S. Patent No. 4,988,793 at column 3, lines 1 to 36. Preferred blocked isocyanate curing agents include
5 BF-1530, which is the reaction product of epsilon- caprolactam blocked T1890, a trimerized isophorone diisocyanate ("IPDI") with an isocyanate equivalent weight of 280, and BF-1540, a uretidione of IPDI with an isocyanate equivalent weight of 280, all of which are available from Creanova of Somerset, NJ.

10 Conventional aminoplast crosslinkers can be used as the adjuvant curing agent provided that the Tg of the coating is not lowered to an undesirable extent. One such class of aminoplast resins include the aldehyde condensates of glycoluril, such as those described above. Glycoluril resins suitable for use as the adjuvant curing agent in the curable powder coating
15 compositions of the invention include POWDERLINK® 1174 commercially available from Cytec Industries, Inc. of Stamford, Connecticut.

When employed, the adjuvant curing agent typically is present in the curable powder coating compositions of the present invention in an amount ranging from 0.5 to 20 percent by weight, and often from 1 to 15 percent by
20 weight based on the total weight of the curable powder coating composition.

Also suitable for use as an adjuvant curing agent in the curable powder coating compositions of the present invention are triazine compounds, such as the tricarbamoyl triazine compounds described in detail in U.S. Patent No. 5,084,541. When used, the triazine curing agent can be present in the
25 powder coating composition of the present invention in an amount ranging up to about 20 percent by weight, and usually from about 1 to 20 percent by weight based on the total weight of the powder coating composition.

Mixtures of the above-described adjuvant curing agents also can be used advantageously.

30 Also, it should be understood that for purposes of the present invention, the curable powder coating compositions which contain epoxy

group-containing polymers typically also include an epoxide-reactive curing (i.e., crosslinking) agent, usually an acid functional curing agent, in addition to the crosslinking agent (B). A secondary hydroxyl group can be generated upon reaction of each epoxy functional group with a functional group of the epoxide-reactive curing agent. These secondary hydroxyl groups are then available for subsequent reaction with the aminoplast-based crosslinking agent (B) and/or any adjuvant curing agents if employed.

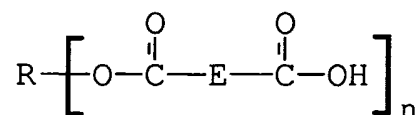
Epoxide-reactive curing agents which can be used in curable powder coating compositions comprising an epoxide functional polymer can have functional groups selected from the group consisting of hydroxyl, thiol, primary amines, secondary amines, acid (e.g. carboxylic acid) and mixtures thereof. Useful epoxide reactive curing agents having amine functionality include, for example, dicyandiamide and substituted dicyandiamides. Preferably, the epoxide reactive curing agent has carboxylic acid groups.

In one embodiment of the present invention, the epoxide reactive crosslinking agent has carboxylic acid functionality and is substantially crystalline. By "crystalline" is meant that the co-reactant contains at least some crystalline domains, and correspondingly may contain some amorphous domains. While not necessary, it is preferred that the epoxide reactive crosslinking agent have a melt viscosity less than that of the epoxy functional polymer (i.e., at the same temperature). As used herein and in the claims, by "epoxide reactive crosslinking agent" is meant that the epoxide reactive crosslinking agent has at least two functional groups that are reactive with epoxide functionality.

Preferably, the epoxide reactive crosslinking agent is a carboxylic acid functional curing agent, which contains from 4 to 20 carbon atoms. Examples of carboxylic acid functional crosslinking agents useful in the present invention include, but are not limited to, dodecanedioic acid, azelaic acid, adipic acid, 1,6-hexanedioic acid, succinic acid, pimelic acid, sebacic acid, maleic acid, citric acid, itaconic acid, aconitic acid and mixtures thereof.

Other suitable carboxylic acid functional curing agents include those represented by the following general formula (VII),

(VII)



5

In general formula (VII), R is the residue of a polyol, E is a divalent linking group having from 1 to 10 carbon atoms, and n is an integer of from 2 to 10. Examples of polyols from which R of general formula (VII) may be derived include, but are not limited to, ethylene glycol, di(ethylene glycol),

10 trimethylolethane, trimethylolpropane, pentaerythritol, di-trimethylolpropane, di-pentaerythritol and mixtures thereof. Divalent linking groups from which E may be selected include, but are not limited to, methylene, ethylene, propylene, isopropylene, butylene, pentylene, hexylene, heptylene, octylene, nonylene, decylene, cyclohexylene, e.g., 1,2-cyclohexylene, substituted
15 cyclohexylene, e.g., 4-methyl-1,2-cyclohexylene, phenylene, e.g., 1,2-phenylene, and substituted phenylene, e.g., 4-methyl-1,2-phenylene and 4-carboxylic acid-1,2-phenylene. The divalent linking group E typically is aliphatic.

The curing agent represented by general formula (VII) typically is
20 prepared from a polyol and a dibasic acid or cyclic anhydride. For example, trimethylol propane and hexahydro-4-methylphthalic anhydride are reacted together in a molar ratio of 1:3 respectively, to form a carboxylic acid functional curing agent. This particular curing agent can be described with reference to general formula (VII) as follows, R is the residue of trimethylol
25 propane, E is the divalent linking group 4-methyl-1,2-cyclohexylene, and n is 3. Carboxylic acid functional curing agents described herein with reference to general formula (VII) also are meant to include any unreacted starting materials and/or co-products, e.g., oligomeric species, resulting from their preparation and contained therein.

Curable powder coating compositions comprising an epoxide functional polymer and an epoxide reactive curing agent can also include one or more cure catalysts as are well known in the art for catalyzing the reaction between the reactive functional groups of the crosslinking agent and the epoxide groups of the polymer. Examples of cure catalysts for use with acid functional crosslinking agents include tertiary amines, e.g., methyl dicocoamine, and tin compounds, e.g., triphenyl tin hydroxide. When employed, the curing catalyst is can be present in the curable powder coating composition in an amount of less than 5 percent by weight, e.g., from 0.25 percent by weight to 2.0 percent by weight, based on total weight of the composition.

Curable powder coating compositions comprising epoxide functional polymers and epoxide reactive curing agents typically contain both in a total amount ranging from 50 percent to 99 percent by weight based on total weight of the composition, e.g., from 70 percent to 85 percent by weight, based on total weight of the composition. The epoxide reactive curing agent typically is present in the curable powder coating composition in an amount corresponding to a portion of these recited ranges, i.e., 5 to 40, particularly 15 to 30, percent by weight based on the total weight of the composition. The equivalent ratio of epoxide equivalents in the epoxide functional polymer to the equivalents of reactive functional groups in the curing agent is typically from 0.5:1 to 2:1, e.g., from 0.8:1 to 1.5:1.

Curable powder coating compositions of the present invention comprising an epoxide functional polymer as reactant (A) and an epoxide reactive curing agent can contain the crosslinking agent (B) in an amount ranging from 1 to 50 weight percent, typically from 15 to 30 weight percent based on total weight of the powder coating composition.

The curable powder coating compositions of the present invention can further include additives as are commonly known in the art. Typical additives include benzoin, used to reduce entrapped air or volatiles; flow aids or flow control agents which aid in the formation of a smooth and/or glossy surface,

for example, MODAFLOW® available from Monsanto Chemical Co., waxes such as MICROWAX® C available from Hoechst, fillers such as calcium carbonate, barium sulfate and the like; colorants, such as pigments (e.g., carbon black or Shepard Black pigments) and dyes; UV light stabilizers such as TINUVIN® 123 or TINUVIN® 900 available from CIBA Specialty Chemicals and catalysts to promote the various crosslinking reactions.

Such additives typically are present in the curable powder coating compositions of the present invention in an amount ranging from 1 to 20 weight percent based on total weight of the powder coating composition.

The curable powder coating compositions of the invention typically are prepared by blending the functional group-containing polymer (A) and the crosslinking agent (B), along with any adjuvants, additives and catalyst, if employed, for approximately 1 minute in a Henschel blade blender. The mixture is then extruded through a Baker-Perkins twin screw extruder at a temperature ranging from 158°F to 266°F (70°C to 130°C). The resultant chip is usually ground and classified to an appropriate particle size, typically between 20 and 200 microns, in a cyclone grinder/sifter.

The curable powder coating compositions of the invention can be applied to a variety of substrates including metallic substrates, for example, aluminum and steel substrates, and non-metallic substrates, for example, thermoplastic or thermoset composite substrates. The curable powder coating compositions are typically applied by spraying, and in the case of a metal substrate, by electrostatic spraying which is preferred, or by the use of a fluidized bed. The powder coating can be applied in a single sweep or in several passes to provide a film having a thickness after cure of from about 1 to 10 mils (25 to 250 micrometers), usually about 2 to 4 mils (50 to 100 micrometers).

Generally, after application of the curable powder coating composition, the powder coated substrate is heated to a temperature sufficient to cure the coating, typically to a temperature ranging from 250°F to 500°F (121.1°C to

260.0°C) for 1 to 60 minutes, and preferably from 300°F to 400°F (148.9°C to 204.4°C) for 15 to 30 minutes.

The curable powder coating composition can be applied as a primer or primer surfacer, or as a topcoat, for example, a "monocoat". The curable powder coating composition of the invention also can be advantageously employed as a topcoat in a multi-component composite coating composition. Such a multi-component composite coating composition generally comprises a base coat deposited from a film-forming composition and a topcoat applied over the base coat, the topcoat being deposited from the curable powder coating composition of the present invention as described above. In a preferred embodiment, the multi-component composite coating composition is a color-plus-clear system where the basecoat is deposited from a pigmented film-forming coating composition and the topcoat is deposited from a curable powder coating composition which is substantially pigment-free, i.e., a clear coat.

The film-forming composition from which the base coat is deposited can be any of the compositions useful in coatings applications for example, in automotive applications where color-plus-clear systems are most often used. A film-forming composition conventionally comprises a resinous binder and a pigment to serve as a colorant. Particularly useful resinous binders include acrylic polymers, polyesters including alkyds, and polyurethanes.

The resinous binders for the base coat can be organic solvent-based materials, such as those described in U.S. Patent No. 4,220,679. Water-based coating compositions, such as those described in U.S. Patent Nos. 4,403,003; 4,147,679; and 5,071,904, also can be used as the base coat composition.

As mentioned above, the base coat compositions also contain pigments of various types as colorants. Suitable metallic pigments include aluminum flake, bronze flake, copper flake and the like. Other examples of suitable pigments include mica, iron oxides, lead oxides, carbon black, titanium dioxide, talc, as well as a variety of color pigments.

Optional ingredients for the base coat film-forming compositions include those which are well known in the art of surface coatings and include surfactants, flow control agents, thixotropic agents, fillers, anti-gassing agents, organic co-solvents, catalysts and other suitable adjuvants.

5 The base coat film-forming compositions can be applied to the substrate by any of the conventional coating techniques, such as brushing, spraying, dipping or flowing, but they are most often spray-applied. The usual spray techniques and equipment for air spraying, airless spraying and electrostatic spraying can be used.

10 The base coat film-forming compositions are typically applied to the substrate such that a cured base coat having a film thickness ranging from 0.5 to 4 mils (12.5 to 100 micrometers) is formed thereon.

After forming a film of the base coat on the substrate, the base coat can be cured or alternatively given a drying step in which solvent, i.e., organic solvent and/or water, is driven off by heating or an air drying step before application of the clear coat. Suitable drying conditions will depend on the particular base coat film-forming composition and on the ambient humidity with certain water-based compositions. In general, a drying time ranging from 1 to 15 minutes at a temperature of 75°F to 200°F (21°C to 93°C) is adequate.

15 The curable powder topcoating composition can be applied over at least a portion of the base coat by any of the methods of application described above. As discussed above, the clear coat can be applied to a cured or a dried base coat before the base coat has been cured. In the latter case, the clear coat and the base coat are cured simultaneously.

20 The curable powder topcoating composition can be applied over at least a portion of the base coat by any of the methods of application described above. As discussed above, the clear coat can be applied to a cured or a dried base coat before the base coat has been cured. In the latter case, the clear coat and the base coat are cured simultaneously.

25 Illustrating the invention are the following examples which are not to be considered as limiting the invention to their details. Unless otherwise indicated, all parts and percentages in the following examples, as well as throughout the specification, are by weight.

EXAMPLES

Examples A, E, and F are control examples, describing the preparation of crosslinking agents that do not contain the active hydrogen-containing compound (c). The remaining examples describe the preparation of crosslinking agents in accordance with the present invention. The crosslinking agents were prepared by modifying an appropriate aminoplast resin.

EXAMPLE A-M

Example A - Control

The following ingredients were added to a two-liter four-necked reaction kettle equipped with a thermometer, a mechanical stirrer, nitrogen inlet, and means for removing the methanol by-product: 640.0 parts of Cymel® 300 available from Cytec Industries, Inc., 340.4 parts of 4-phenyl phenol, 420.4 parts of xylene, and 0.35 part of p-toluenesulfonic acid. The mixture was heated to a temperature of 80°C and held for 20 minutes at which time the mixture became homogeneous. It was then further heated to 120°C and the temperature was maintained while the methanol by-product was removed from the system. The reaction progress was monitored by measuring the IR spectra of the mixture and was terminated when the end point was detected. Thereafter, the mixture was concentrated at a temperature of 100°C to 130°C in a vacuum of 3-50 mm Hg to remove the xylene solvent. The product thus obtained was a pale yellow solid with a softening temperature of around 45°C. The benzoxazine structure formed in the product was confirmed by NMR spectroscopy.

Example B

The following ingredients were added to a two-liter four-necked reaction kettle equipped with a thermometer, a mechanical stirrer, nitrogen inlet, and means for removing the by-product (methanol): 640.0 parts of Cymel® 300, 340.4 parts of 4-phenyl phenol, 106.0 parts of benzoin, 420.4

parts of xylene, and 0.35 part of p-toluenesulfonic acid. The mixture was heated to 80°C and held for 20 minutes until the mixture became homogeneous. It was then further heated to 120°C and the temperature was maintained while the methanol by-product was removed from the system. The reaction progress was monitored by measuring the IR spectra of the mixture and was terminated when the end point was detected. Thereafter, the mixture was concentrated at a temperature of 100°C to 130 °C in a vacuum of 3-50 mm Hg to remove the xylene solvent. The product thus obtained was a pale yellow solid with a softening temperature of around 50°C. The benzoxazine structure formed in the product was confirmed by NMR spectroscopy.

Example C

The following ingredients were added to a two-liter four-necked reaction kettle equipped with a thermometer, a mechanical stirrer, nitrogen inlet, and means for removing the by-product (methanol): 640.0 parts of Cymel® 300, 340.4 parts of 4-phenyl phenol, 77.0 parts of isoborneol, 420.4 parts of xylene, and 0.35 part of p-toluenesulfonic acid. The mixture was heated to 80°C and held for 20 minutes until the mixture became homogeneous. It was then further heated to 120°C and the temperature was maintained while the methanol by-product was removed from the system. The reaction progress was monitored by measuring the IR spectra of the mixture and was terminated when the end point was detected. Thereafter, the mixture was concentrated at a temperature of 100°C to 130 °C in a vacuum of 3-50 mm Hg to remove the xylene solvent. The product thus obtained was a pale yellow solid with a softening temperature of around 48°C. The benzoxazine structure formed in the product was confirmed by NMR spectroscopy.

Example D

The following ingredients were added to a two-liter four-necked reaction kettle equipped with a thermometer, a mechanical stirrer, nitrogen inlet, and means for removing the by-product (methanol): 640.0 parts of

Cymel® 300, 340.4 parts of 4-phenyl phenol, 106.0 parts of benzoin, 77.0 parts of isoborneol, 420.4 parts of xylene, and 0.35 part of p-toluenesulfonic acid. The mixture was heated to 80°C and held for 20 minutes until the mixture became homogeneous. It was then further heated to 120°C and the temperature was maintained while the methanol by-product was removed from the system. The reaction progress was monitored by measuring the IR spectra of the mixture and was terminated when the end point was detected. Thereafter, the mixture was concentrated at a temperature of 100°C to 130°C in a vacuum of 3-50 mm Hg to remove the xylene solvent. The product thus obtained was a pale yellow solid with a softening temperature of around 56°C. The benzoxazine structure formed in the product was confirmed by NMR spectroscopy.

Example E - Control

The following ingredients were added to a two-liter four-necked reaction kettle equipped with a thermometer, a mechanical stirrer, nitrogen inlet, and means for removing the by-product (methanol): 480.0 parts of Cymel® 300, 300.0 parts of 4-tert-butyl phenol, 334.4 parts of xylene, and 0.3 part of p-toluenesulfonic acid. The mixture was heated to 80°C and held for 20 minutes until the mixture became homogeneous. It was then further heated to 120°C and the temperature was maintained while the methanol by-product was removed from the system. The reaction progress was monitored by measuring the IR spectra of the mixture and was terminated when the end point was detected. Thereafter, the mixture was concentrated at a temperature of 100°C to 130°C in a vacuum of 3-50 mm Hg to remove the xylene solvent. The product thus obtained was a pale yellow solid with a softening temperature of around 75°C. The benzoxazine structure formed in the product was confirmed by NMR spectroscopy.

Example F - Control

The following ingredients were added to a two-liter four-necked reaction kettle equipped with a thermometer, a mechanical stirrer, nitrogen inlet, and means for removing the by-product (methanol): 480.0 parts of Cymel® 300, 288.3 parts of 2-naphthol, 329.4 parts of xylene, and 0.3 part of p-toluenesulfonic acid. The mixture was heated to 80°C and held for 20 minutes until the mixture became homogeneous. It was then further heated to 120°C and the temperature was maintained while the methanol by-product was removed from the system. The reaction progress was monitored by measuring the IR spectra of the mixture and was terminated when the end point was detected. Thereafter, the mixture was concentrated at a temperature of 100°C to 130°C in a vacuum of 3-50 mm Hg to remove the xylene solvent. The product thus obtained was a pale yellow solid with a softening temperature of around 44°C. The benzoxazine structure formed in the product was confirmed by NMR spectroscopy.

Example G

The following ingredients were added to a two-liter four-necked reaction kettle equipped with a thermometer, a mechanical stirrer, nitrogen inlet, and means for removing the by-product (methanol): 640.0 parts of Cymel® 303, 185.7 parts of 2,4-di-tert-butylphenol, 84.8 parts of benzoin, 129.6 parts of benzyl alcohol, 446.5 parts of xylene, and 0.40 part of p-toluenesulfonic acid. The mixture was heated to 80°C and held for 20 minutes until the mixture became homogeneous. It was then further heated to 120°C and the temperature was maintained while the methanol by-product was removed from the system. The reaction progress was monitored by measuring the IR spectra of the mixture and was terminated when the end point was detected. Thereafter, the mixture was concentrated at a temperature of 100°C to 130°C in a vacuum of 3-50 mm Hg to remove the xylene solvent. The product thus obtained was a pale yellow solid with a

softening temperature of around 33°C. The benzoxazine structure formed in the product was confirmed by NMR spectroscopy.

Example H

5 The following ingredients were added to a two-liter four-necked reaction kettle equipped with a thermometer, a mechanical stirrer, nitrogen inlet, and means for removing the by-product (methanol): 640.0 parts of Cymel® 303, 225.3 parts of 4-tert-butylphenol, 400.0 parts of xylene, and 0.40
10 part of p-toluenesulfonic acid. The mixture was heated to 80°C and held for 20 minutes until the mixture became homogeneous. It was then further heated to 120°C and the temperature was maintained while the methanol by-product was removed from the system. The reaction progress was monitored by measuring the IR spectra of the mixture and was terminated when the end
15 point was detected. Then, the reaction mixture was cooled down to 100°C and 95.4 parts of benzoin, 184.8 parts of isoborneol and 91.5 parts of xylene were charged to the reactor. The mixture was further heated to 120°C and the temperature was maintained while the methanol by-product was removed from the system. The reaction progress was monitored by measuring the IR
20 spectra of the mixture and was terminated when the end point was detected. Thereafter, the mixture was concentrated at a temperature of 100°C to 130°C in a vacuum of 3-50 mm Hg to remove the xylene solvent. The product thus obtained was a pale yellow solid with a softening temperature of around 54°C. The benzoxazine structure formed in the product was confirmed by NMR
25 spectroscopy.

Example I

30 The following ingredients were added to a two-liter four-necked reaction kettle equipped with a thermometer, a mechanical stirrer, nitrogen inlet, and means for removing the by-product (methanol): 640.0 parts of Cymel® 1133, 225.3 parts of 4-tert-butylphenol, 400.0 parts of xylene, and 0.40 part of p-toluenesulfonic acid. The mixture was heated to 80°C and held

for 20 minutes until the mixture became homogeneous. It was then further heated to 120°C and the temperature was maintained while the methanol by-product was removed from the system. The reaction progress was monitored by measuring the IR spectra of the mixture and was terminated when the end point was detected. Then, the reaction mixture was cooled down to 100°C and 95.4 parts of benzoin, 184.8 parts of isoborneol and 91.5 parts of xylene were charged to the reactor. The mixture was further heated to 120°C and the temperature was maintained while the methanol by-product was removed from the system. The reaction progress was monitored by measuring the IR spectra of the mixture and was terminated when the end point was detected, Thereafter, the mixture was concentrated at a temperature of 100°C to 130°C in a vacuum of 3-50 mm Hg to remove the xylene solvent. The product thus obtained was a pale yellow solid with a softening temperature of around 55°C.

Example J

The following ingredients were added to a two-liter four-necked reaction kettle equipped with a thermometer, a mechanical stirrer, nitrogen inlet, and means for removing the by-product (methanol): 640.0 parts of Cymel® 1116, 225.3 parts of 4-tert-butylphenol, 400.0 parts of xylene, and 0.40 part of p-toluenesulfonic acid. The mixture was heated to 80°C and held for 20 minutes until the mixture became homogeneous. It was then further heated to 120°C and the temperature was maintained while the methanol by-product was removed from the system. The reaction progress was monitored by measuring the IR spectra of the mixture and was terminated when the end point was detected. Then, the reaction mixture was cooled down to 100°C and 95.4 parts of benzoin, 184.8 parts of isoborneol and 91.5 parts of xylene were charged to the reactor. The mixture was further heated to 120°C and the temperature was maintained while the methanol by-product was removed from the system. The reaction progress was monitored by measuring the IR spectra of the mixture and was terminated when the end point was detected, Thereafter, the mixture was concentrated at a temperature of 100°C to 130°C

in a vacuum of 3-50 mm Hg to remove the xylene solvent. The product thus obtained was a pale yellow solid with a softening temperature of around 56°C.

Example K

5 The following ingredients were added to a two-liter four-necked reaction kettle equipped with a thermometer, a mechanical stirrer, nitrogen inlet, and means for removing the by-product (methanol): 640.0 parts of Cymel® 1168, 225.3 parts of 4-tert-butylphenol, 400.0 parts of xylene, and
10 0.40 part of p-toluenesulfonic acid. The mixture was heated to 80°C and held for 20 minutes until the mixture became homogeneous. It was then further heated to 120°C and the temperature was maintained while the methanol by-product was removed from the system. The reaction progress was monitored by measuring the IR spectra of the mixture and was terminated when the end
15 point was detected. Then, the reaction mixture was cooled down to 100°C and 95.4 parts of benzoin, 184.8 parts of isoborneol, and 91.5 parts of xylene were charged to the reactor. The mixture was further heated to 120°C and the temperature was maintained while the methanol by-product was removed from the system. The reaction progress was monitored by measuring the IR
20 spectra of the mixture and was terminated when the end point was detected. Thereafter, the mixture was concentrated at a temperature of 100°C to 130°C in a vacuum of 3-50 mm Hg to remove the xylene solvent. The product thus obtained was a pale yellow solid with a softening temperature of around 65°C.

Example L

25 The following ingredients were added to a two-liter four-necked reaction kettle equipped with a thermometer, a mechanical stirrer, nitrogen inlet, and means for removing the by-product (methanol): 640.0 parts of
30 Cymel® 1135, 225.3 parts of 4-tert-butylphenol, 400.0 parts of xylene, and 0.40 part of p-toluenesulfonic acid. The mixture was heated to 80°C and held for 20 minutes until the mixture became homogeneous. It was then further heated to 120°C and the temperature was maintained while the methanol by-

product was removed from the system. The reaction progress was monitored by measuring the IR spectra of the mixture and was terminated when the end point was detected. Then, the reaction mixture was cooled down to 100°C and 95.4 parts of benzoin, 184.8 parts of isoborneol, and 91.5 parts of xylene were charged to the reactor. The mixture was further heated to 120°C and the temperature was maintained while the methanol by-product was removed from the system. The reaction progress was monitored by measuring the IR spectra of the mixture and was terminated when the end point was detected. Thereafter, the mixture was concentrated at a temperature of 100°C to 130°C in a vacuum of 3-50 mm Hg to remove the xylene solvent. The product thus obtained was a pale yellow solid with a softening temperature of around 56°C.

Example M

The following ingredients were added to a two-liter four-necked reaction kettle equipped with a thermometer, a mechanical stirrer, nitrogen inlet, and means for removing the by-product (methanol): 640.0 parts of Cymel® 303, 225.3 parts of 4-tert-butylphenol, 95.4 parts of benzoin, 129.6 parts of benzyl alcohol, 468.0 parts of xylene, and 0.40 part of p-toluenesulfonic acid. The mixture was heated to 80°C and hold for 20 minutes until the mixture became homogeneous. It was then further heated to 120°C and the temperature was maintained while the methanol by-product was removed from the system. The reaction progress was monitored by measuring the IR spectra of the mixture and was terminated when the end point was detected. Thereafter, the mixture was concentrated at a temperature of 100°C to 130°C in a vacuum of 3-50 mm Hg to remove the xylene solvent. The product thus obtained was a pale yellow solid with a softening temperature of around 39°C. The benzoxazine structure formed in the product was confirmed by NMR spectroscopy.

POWDER COATING COMPOSITIONSEXAMPLES 1 THROUGH 5

Example 1 is a control using a control crosslinker. For each of the powder coating compositions of Examples 1-5, all of the listed components were blended for 10 seconds at 3500 rpm in a PRISM blender. The powders were then fed through a 19 millimeter, twin screw extruder available from b&p Process Equipment and Systems, by way of an ACCU-RATE auger feeder.

The resulting chip was classified to a median particle size of approximately 40 microns.

Example No	1	2	3	4	5
Crycoat 291 ¹	270g	270g	270g	270g	270g
Example A crosslinker	40g				
Example B crosslinker		40g			
Example C crosslinker			40g		
Example D crosslinker				40g	
Example M crosslinker					40g
Morpholine Tosylate ²	0.35g	0.35g	0.35g	0.35g	0.35g
Resiflow PL 200 ³	4g	4g	4g	4g	4g
Microwax C ⁴	3.0g	3.0g	3.0g	3.0g	3.0g
R706 ⁵	170g	170g	170g	170g	170g

1. Crycoat 291 is a 30 hydroxyl functional resin from UCB Chemical Corp.

2. Morpholine Tosylate is a blocked acid catalyst from Cytec Industries, Inc.

3. Resiflow PL 200 is an acrylic flow aid from Monsanto Chemical Co.

4. Microwax C is a stearamide wax from Hoechst Aktiengesellschaft

5. R706 is TiO₂ from E.I. duPont de Nemours and Company

TESTING PROCEDURES:

The powder storage stability of each powder coating composition was evaluated by storing a 20g sample of each powder coating composition at a temperature of 40°C for a 24 hour period. The stability of the powder was determined upon visual inspection. Powder stability results are reported from best to worst as follows: excellent, good, slightly cakey, cakey, slightly clumpy, clumpy, fused and sintered.

The propensity of the coating composition to "gas" upon curing was tested by increasing the cured film thickness of the powder coating on a test panel until surface defects (i.e., pinholes) formed due to the escape of gases

through the coating surface during the cure process. Values reported represent the maximum film thickness achieved just prior to the development of the pinholes in the coating surface.

Chemical resistance was evaluated by double rubs using methyl ethyl ketone. Results reported are the extent of film surface marring or softening in the area contacted with the methyl ethyl ketone after 100 double rubs.

Mar resistance was evaluated as follows. The initial 20° gloss the cured powder coating of the present invention was measured using a 20° NOVO-GLOSS 20 statistical glossmeter, available from Gardner Instrument Company, Inc. Each coated substrate was then subjected to scratch testing by linearly scratching the cured coating surface to which an abrasive, such as BON AMI® had been applied, for ten double rubs using an Atlas AATCC Scratch Tester, Model CM-5, available from Atlas Electrical Devices Company of Chicago, Illinois. The test panels were then rinsed with tap water and carefully patted dry with a paper towel. The 20° gloss was measured on the scratched area of each test panel. The number reported is the percent of the initial gloss retained after scratch testing, i.e., $100\% \times \text{scratched gloss} / \text{initial gloss}$.

The degree of gloss and the degree of haziness (or lack of film clarity) of the cured powder coating was measured using BYK HAZE/GLOSS instrument from BYK Chemical. Higher numbers indicate a higher degree of gloss and haziness.

Flexibility and impact resistance (both direct and reverse impact) was evaluated using a Gardner Impact Tester in accordance with ASTM-D-2794.

Two sets of test panels were prepared. Test results are reported in the following Table 1 for the set of test panels coated with each of the powder coating compositions of Examples 1 through 5 which were cured at 380°F (193.3°C) for 20 minutes. Test results for an analogous set of coated test panels which were cured at 320°F (160°C) for 20 minutes are reported below in the following Table 2.

Table 1

	1	2	3	4	5
MEK double rubs	100 no mar	100 no mar	100 barely marred	100 barely marred	100 slight mar
Gas resistance	2.1 mil	4.5 mil	3.4 mil	2.4 mil	4.1 mil
Powder stability/40C 1 day	Excellent	Excellent	Excellent	Excellent	SI Clumpy
Powder stability/40C 1 week	Clumpy-fused	Cakey	Clumpy	Cakey	
Direct Impact (in-lbs)	> 140	> 140	> 140	> 140	> 140
Reverse Impact (in-lbs)	> 140	> 140	> 140	> 140	100
Gel Times	2:30	3:00	2:55	2:20	2:40
Mar (20 Crockmeter)	98	96	98	97	98
Mar (30 Soft Scrub)	58	56	79	65	59
Gloss 20°/ 60°	54.6/87.2	68.7/91.6	51.1/85.5	55.0/87.3	53.1/88.5
Pencil Hardness	B	B	B	B	F

*Mar is reported as % gloss retention

5

Table 2

	1	2	3	4	5
MEK double rubs	100 slight mar	100 marred	100 marred	100 slight mar	38 smear
Direct Impact (in-lbs)	20	< 20	< 20	< 20	<20
Reverse Impact (in-lbs)	< 20	< 20	< 20	< 20	< 20
Mar (20 Crockmeter)	85	105	105	104	98
Mar (30 Soft Scrub)	50	60	68	72	41
Gloss 20°/ 60°	38.4/67.5	50.0/74.6	33.1/61.1	32.9/58.0	55.1/87.2
Pencil Hardness	HB	HB	HB	HB	HB

*Mar is reported as % gloss retention

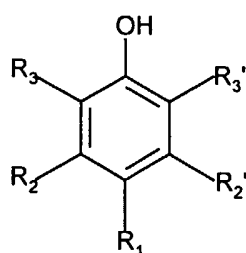
10 It will be appreciated by those skilled in the art that changes could be made to the embodiments described above without departing from the broad inventive concept thereof. It is understood, therefore, that this invention is not limited to the particular embodiments disclosed, but it is intended to cover modifications which are within the spirit and scope of the invention, as defined

15 by the appended claims.

THEREFORE WE CLAIM:

1. A crosslinking agent having reactive benzoxazine groups comprising an ungelled reaction product of the following reactants:

- 5 (a) at least one mono-hydroxy aromatic compound having the following structure (I-A):



(I-A)

- 10 wherein R_1 represents a monovalent hydrocarbon group, COOR_5 where R_5 represents H or a monovalent hydrocarbon group, NO_2 , halogen or XR_4 , where X represents O or S and R_4 represents a monovalent hydrocarbon group having 1 to 8 carbon atoms;

- 15 R_3 , R'_3 , R_2 and R'_2 can be the same or different and each independently represents a substituent selected from H, a monovalent hydrocarbon group, COOR_5 , NO_2 , halogen and XR_4 , provided that at least one of R_3 and R'_3 is H; or

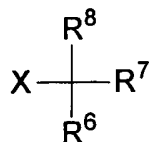
- when R_3 is non-hydrogen substituted and R'_3 is H, R_1 and R_2 taken together, R_1 and R'_2 taken together, or R_2 taken together with
20 the non-hydrogen substituted R_3 represent fused aliphatic or aromatic ring structures, or

- when R'_3 is non-hydrogen substituted and R_3 is H, R_1 and R_2 taken together, R_1 and R'_2 taken together, or R'_2 taken together with
25 the non-hydrogen substituted R'_3 represent fused aliphatic or aromatic ring structures;

- (b) at least one aminoplast compound ; and

(c) at least one compound different from (a) having active hydrogen groups reactive with aminoplast compound (b), said compound (c) selected from at least one of:

(1) compounds having the following structure (II):

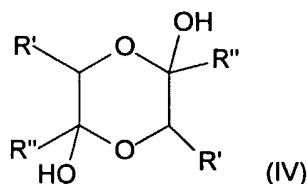
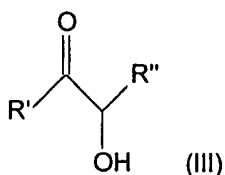


(II)

wherein X is aromatic; R⁶, R⁷, and R⁸ can be the same or different and each independently represents H, (cyclo)alkyl having from 1 to 12 carbon atoms, aryl, alkaryl, aralkyl, or an active hydrogen-containing group,

provided that at least one of R⁶, R⁷, and R⁸ represents an active hydrogen-containing group which is reactive with the aminoplast resin (b);

(2) compounds having the following structure (III) or (IV):



where R' and R'' are the same or different and each independently represents an aromatic group or an alkyl group having 1 to 12 carbon atoms; and

(3) compounds different from (1) and (2) and having a melting point of at least 80°C;

wherein said crosslinking agent is essentially free of hydroxyl functionality and has a glass transition temperature of at least 25°C.

2. The crosslinking agent of claim 1, wherein R_1 represents an electron-withdrawing group selected from aryl, alkylaryl, COOH, NO₂, halogen and an alkoxy group.
- 5 3. The crosslinking agent of claim 1 wherein both R_3 and R'_3 are H.
4. The crosslinking agent of claim 1, wherein R_1 is an aryl group and R_2 , R'_2 , R_3 and R'_3 are the same or different and each independently represents H, alkyl or aryl, or a heteroatomic monovalent hydrocarbon group, provided that
- 10 at least one of R_3 and R'_3 is H.
5. The crosslinking agent of claim 4, wherein reactant (a) comprises at least one of 4-tert-butylphenol, 2,4-di-tert-butylphenol, and 4-phenyl phenol.
- 15 6. The crosslinking agent of claim 1, wherein reactant (a) comprises at least one of 4-tert-butylphenol, 2,4-di-tert-butylphenol, and 4-phenyl phenol.
7. The crosslinking agent of claim 1, wherein reactant (a) comprises a mono-hydroxy aromatic compound selected from at least one of p-cresol, 4-methoxyphenol, 4-tert-butyl phenol, 2,4-di-tert-butylphenol, 4-nitrophenol, 4-fluorophenol, 2-phenyl phenol, 4-phenyl phenol, 1-naphthol, and 2-naphthol.
- 20 8. The crosslinking agent of claim 1, wherein the aminoplast compound (b) is or is derived from at least one of glycoluril, aminotriazine and benzoguanamine.
- 25 9. The crosslinking agent of claim 8, wherein the aminoplast compound (b) comprises alkoxyated aldehyde condensate of glycoluril.
- 30 10. The crosslinking agent of claim 9, wherein the aminoplast compound (b) comprises tetramethoxy methylglycoluril.

11. The crosslinking agent of claim 8, wherein the aminoplast compound (b) comprises (alkoxyalkyl) aminotriazine having one or less non-alkylated NH bond per triazine ring.

5

12. The crosslinking agent of claim 11, wherein the aminoplast compound (b) comprises (methoxymethyl) aminotriazine.

13. The crosslinking agent of claim 11, wherein the (alkoxyalkyl) aminotriazine has a degree of polymerization of 3.75 or less.

10

14. The crosslinking agent of claim 1, wherein the compound (c) comprises at least one compound having the structure (II).

15. The crosslinking agent of claim 14, wherein at least one of R⁶, R⁷, and R⁸ represents a group comprising an active hydrogen-containing group selected from hydroxyl, amide, amine, carboxylic acid, carbamate, urea, thiol, and mixtures thereof.

15

16. The crosslinking agent of claim 15, wherein at least one of R⁶, R⁷, and R⁸ represents a group comprising at least one hydroxyl group.

20

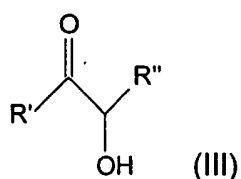
17. The crosslinking agent of claim 14, wherein the compound (c) comprises benzyl alcohol.

25

18. The crosslinking agent of claim 1, wherein the compound (c) comprises at least one of compound (c)(2).

19. The crosslinking agent of claim 18, wherein the compound (c) comprises a hydroxyl functional group-containing compound having the following structure (III):

30



or dimer derivatives thereof, wherein R' and R'' are the same or different and each independently represents an (cyclo)alkyl group having 1 to 12 carbon atoms or an aromatic group.

5

20. The crosslinking agent of claim 19, wherein one or both of R' and R'' represent aromatic groups.

21. The crosslinking agent of claim 19, wherein the compound (c) comprises a compound selected from benzoin, hydroxycyclohexyl phenyl ketone and mixtures thereof.

10

22. The crosslinking agent of claim 21, wherein the compound (c) comprises benzoin.

15

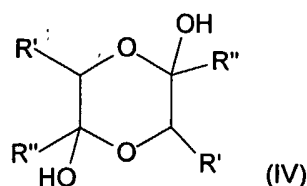
23. The crosslinking agent of claim 21, wherein the compound (c) comprises hydroxycyclohexyl phenyl ketone.

24. The crosslinking agent of claim 19, wherein one or both of R' and R'' are aromatic groups containing at least one heteroatom selected from furyl, pyridyl, methoxy phenyl, and dimethylaminophenyl groups.

20

25. The crosslinking agent of claim 18, wherein the active hydrogen group-containing compound (c) comprises a compound having the following structure (IV):

25



wherein R' and R'' are the same or different and each independently represents an alkyl group having 1 to 12 carbon atoms or an aromatic group.

5 26. The crosslinking agent of claim 1, wherein the compound (c) comprises at least one of compound (c)(3).

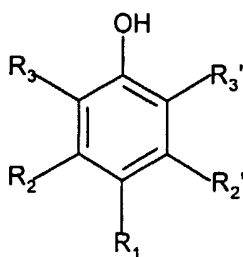
27. The crosslinking agent of claim 26, wherein compound (c) comprises an aliphatic mono-functional alcohol selected from at least one of borneol,
10 norborneol, isoborneol, 1-adamantanemethanol, 1-adamantanol, 2-methyl-2-adamantanol and 5-norbornen-2-ol.

28. The crosslinking agent of claim 1, wherein the compound (c) is selected from at least one of benzoin, isoborneol, triphenylmethanol, N-tert-butylacrylamide, p-acetophenetidine and mixtures thereof.
15

29. A method for forming a powder crosslinking agent having reactive benzoxazine groups comprising the following steps:

(1) combining the following reactants:

20 (a) at least one mono-hydroxy aromatic compound having the following structure (I):



(I)

wherein R_1 represents a monovalent hydrocarbon group, COOR_5 where R_5 represents H or a monovalent hydrocarbon group, NO_2 , halogen or XR_4 , where X represents O or S and R_4 represents a monovalent hydrocarbon group having 1 to 8 carbon atoms;

R_3 , R'_3 , R_2 and R'_2 can be the same or different and each independently represents a substituent selected from H, a monovalent hydrocarbon group, COOR_5 , NO_2 , halogen and XR_4 , provided that at least one of R_3 and R'_3 is H; ,or

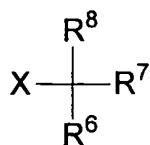
when R_3 is non-hydrogen substituted and R'_3 is H, R_1 and R_2 taken together, R_1 and R'_2 taken together, or R_2 taken together with the non-hydrogen substituted R_3 represent fused aliphatic or aromatic ring structures, or

when R'_3 is non-hydrogen substituted and R_3 is H, R_1 and R_2 taken together, R_1 and R'_2 taken together, or R'_2 taken together with the non-hydrogen substituted R'_3 represent fused aliphatic or aromatic ring structures;

(b) at least one aminoplast compound; and

(c) at least one compound different from (a) having active hydrogen groups reactive with aminoplast compound (b), said compound (c) selected from at least one of:

(i) compounds having the following structure (II):

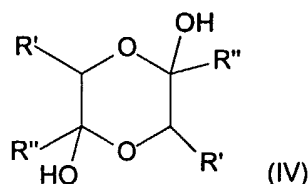
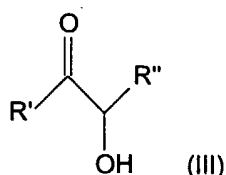


(II)

wherein X is aromatic; R^6 , R^7 , and R^8 can be the same or different and each independently represents H, (cyclo)alkyl having from 1 to 12 carbon atoms, aryl, alkaryl, aralkyl, or an active hydrogen-containing group,

provided that at least one of R^6 , R^7 , and R^8 represents an active hydrogen-containing group which is reactive with the aminoplast compound (b);

(ii) compounds having the following structure (III) or (IV):



where R' and R'' are the same or different and each independently represents an aromatic group or an alkyl group having 1 to 12 carbon atoms; and

(iii) compounds different from (i) and (ii) and having a melting point of at least 80°C to form a reaction admixture;

(2) heating the reaction admixture formed in step (1) to a temperature ranging from 90°C to 135°C; and

(3) maintaining the temperature achieved in step (2) for a time sufficient to produce an ungelled reaction product having a glass transition temperature of at least 25°C which is essentially free of hydroxyl functionality as determined by infrared spectroscopy.

30. The method of claim 29, wherein R_1 represents an electron-withdrawing group selected from at least one of aryl, alkylaryl, COOH, NO₂, halogen and an alkoxy group.

31. The method of claim 29, wherein R_3 and R'_3 are both H.

32. The method of claim 30, wherein R_1 is an aryl group and R_2 , R'_2 , R_3 and R'_3 are the same or different and each independently represents H, alkyl or aryl, or a heteroatomic monovalent hydrocarbon group, provided that at least one of R_3 and R'_3 is H.

33. The method of claim 32, wherein reactant (a) comprises at least one of 4-tert-butylphenol, 2,4-di-tert-butylphenol, and 4-phenyl phenol.

5 34. The method of claim 29, wherein reactant (a) comprises a mono-hydroxy aromatic compound selected from at least one of p-cresol, 4-methoxyphenol, 4-tert-butyl phenol, 2,4-di-tert-butylphenol, 4-nitrophenol, 4-fluorophenol, 2-phenyl phenol, 4-phenyl phenol, 1-naphthol, and 2-naphthol.

10 35. The method of claim 29, wherein the aminoplast compound (b) is or is derived from at least one of glycoluril, aminotriazine and benzoguanamine.

36. The method of claim 35, wherein the aminoplast compound (b) comprises alkoxyated aldehyde condensate of glycoluril.

15

37. The method of claim 36, wherein the aminoplast compound (b) comprises tetramethoxy methylglycoluril.

38. The method of claim 35, wherein the aminoplast compound (b) comprises (alkoxyalkyl) aminotriazine having one or less non-alkylated NH bond per triazine ring.

20

39. The method of claim 38, wherein the aminoplast compound (b) comprises (methoxymethyl) aminotriazine.

25

40. The method of claim 38, wherein the (alkoxyalkyl) aminotriazine has a degree of polymerization of 3.75 or less.

41. The method of claim 29, wherein the compound (c) comprises at least one compound having the structure (II).

30

42. The method of claim 41, wherein at least one of R⁶, R⁷, and R⁸ represents a group comprising an active hydrogen-containing group selected from hydroxyl, amide, amine, carboxylic acid, carbamate, urea, thiol, and mixtures thereof.

5

43. The method of claim 42, wherein at least one of R⁶, R⁷, and R⁸ represents a group comprising at least one hydroxyl group.

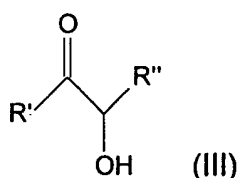
44. The method of claim 41, wherein the compound (c) comprises benzyl alcohol.

10

45. The method of claim 29, wherein the compound (c) comprises at least one of compound (c)(ii).

46. The method of claim 45, wherein the compound (c) comprises a hydroxyl functional group-containing compound having the following structure (III):

15



or dimer derivatives thereof, wherein R' and R'' are the same or different and each independently represents an (cyclo)alkyl group having 1 to 12 carbon atoms or an aromatic group.

20

47. The method of claim 46, wherein one or both of R' and R'' represent aromatic groups.

25

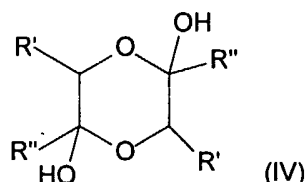
48. The method of claim 46, wherein the compound (c) comprises a compound selected from benzoin, hydroxycyclohexyl phenyl ketone and mixtures thereof.

49. The method of claim 48, wherein the compound (c) comprises benzoin.

50. The method of claim 48, wherein the compound (c) comprises
5 hydroxycyclohexyl phenyl ketone.

51. The method of claim 46, wherein one or both of R' and R'' are aromatic groups containing at least one heteroatom selected from furyl, pyridyl, methoxy phenyl, and dimethylaminophenyl groups.

52. The method of claim 45, wherein the active hydrogen group-containing compound (c) comprises a compound having the following structure (IV):



wherein R' and R'' are the same or different and each independently
15 represents an alkyl group having 1 to 12 carbon atoms or an aromatic group.

53. The method of claim 29, wherein the compound (c) comprises at least one of compound (c)(iii).

54. The method of claim 53, wherein compound (c) comprises an aliphatic mono-functional alcohol selected from borneol, norborneol, isoborneol, 1-adamantanemethanol, 1-adamantanol, 2-methyl-2-adamantanol and 5-norbornen-2-ol.

55. The method of claim 29, wherein the compound (c) is selected from benzoin, isoborneol, triphenylmethanol, N-tert-butylacrylamide, p-acetophenetidide and mixtures thereof.

56. A method for forming a powder crosslinking agent, having reactive benzoxazine groups comprising the following steps:

(1) combining the following reactants:

5 (a) at least one mono-hydroxy aromatic compound selected from at least one of 4-tert-butylphenol, 2,4-di-tert-butylphenol, 2-phenyl phenol, 4-phenyl phenol, 1-naphthol, and 2-naphthol;

(b) at least one (methoxymethyl) aminotriazine compound having one or less non-alkylated NH group and a degree of polymerization of 3.0 or less; and

10 (c) at least one compound selected from benzoin, hydroxycyclohexyl phenyl ketone, isoborneol, triphenylmethanol, N-tert-butylacrylamide, and p-acetophenetidide to form a reaction admixture;

15 (2) heating the reaction admixture formed in step (1) to a temperature ranging from 90°C to 135°C; and

(3) maintaining the temperature achieved in step (2) for a time sufficient to produce an ungelled reaction product having a glass transition temperature of at least 25°C which is essentially free of hydroxyl functionality

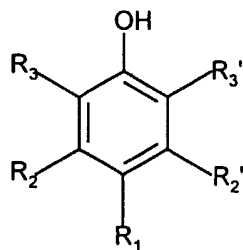
20 as determined by infrared spectroscopy.

57. A curable powder coating composition comprising a solid particulate, film-forming mixture of the following components:

(A) a polymer having functional groups reactive with benzoxazine groups, said polymer having a glass transition temperature of at least 30°C; and

(B) a crosslinking agent having reactive benzoxazine groups comprising an ungelled reaction product of the following reactants:

30 (1) at least one mono-hydroxy aromatic compound having the following structure (I):



(I)

wherein R_1 represents a monovalent hydrocarbon group,
 5 COOR_5 where R_5 represents H or a monovalent hydrocarbon group, NO_2 ,
 halogen or XR_4 , where X represents O or S and R_4 represents a monovalent
 hydrocarbon group having 1 to 8 carbon atoms;

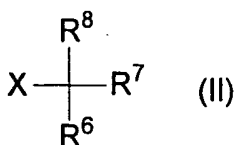
R_3 , R'_3 , R_2 and R'_2 can be the same or different and each
 independently represents a substituent selected from H, a monovalent
 10 hydrocarbon group, COOR_5 , NO_2 , halogen and XR_4 , provided that at least
 one of R_3 and R'_3 is H; or

when R_3 is non-hydrogen substituted and R'_3 is H,
 R_1 and R_2 taken together, R_1 and R'_2 taken together, or R_2 taken together with
 the non-hydrogen substituted R_3 represent fused aliphatic or aromatic ring
 15 structures, or

when R'_3 is non-hydrogen substituted and R_3 is H,
 R_1 and R_2 taken together, R_1 and R'_2 taken together, or R'_2 taken together with
 the non-hydrogen substituted R'_3 represent fused aliphatic or aromatic ring
 structures;

20 (2) at least one aminoplast compound ; and
 (3) at least one compound different from (1) having active
 hydrogen groups reactive with aminoplast compound (2), said
 compound (3) selected from at least one of:

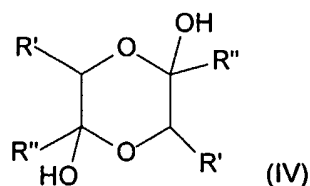
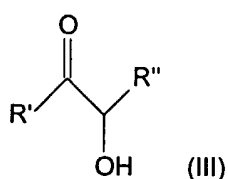
(a) compounds having the following structure (II):



wherein X is aromatic; R^6 , R^7 , and R^8 can be the same or different and each independently represents H, (cyclo)alkyl having from 1 to 12 carbon atoms, aryl, alkaryl, aralkyl, or an active hydrogen-containing group,

provided that at least one of R^6 , R^7 , and R^8 represents an active hydrogen-containing group which is reactive with the aminoplast compound (2);

(b) compounds having the following structure (III) or (IV):



where R' and R'' are the same or different and each independently represents an aromatic group or an alkyl group having 1 to 12 carbon atoms; and

(c) compounds different from (a) and (b) and having a melting point of at least 80°C;

wherein said crosslinking agent is essentially free of hydroxyl functionality and has a glass transition temperature of at least 25°C.

58. The curable powder coating composition of claim 57, wherein the polymer (A) is selected from the group consisting of acrylic, polyester, polyurethane, polyepoxide and polyether polymers and mixtures thereof.

59. The curable powder coating composition of claim 57, wherein the polymer (A) comprises functional groups selected from at least one of

hydroxyl, primary and secondary amine, carbamate, amide, thiol, phenolic, carboxyl and epoxy functional groups and mixtures thereof.

60. The curable powder coating composition of claim 59, wherein the
5 polymer (A) comprises hydroxyl and/or carbamate functional groups.

61. The curable powder coating composition of claim 57, wherein the polymer (A) has a glass transition temperature ranging from 30°C to 110°C.

10 62. The curable powder coating composition of claim 57, wherein the polymer (A) is present in an amount ranging from 5 to 95 percent by weight based on total weight of the composition.

15 63. The curable powder coating composition of claim 57, wherein R_1 represents an electron-withdrawing group selected from at least one of aryl, alkylaryl, COOH, NO₂, halogen, and an alkoxy group.

64. The curable powder coating composition of claim 57, wherein R_3 and R'_3 are both H.

20 65. The curable powder coating composition of claim 57, wherein R_1 is an aryl group and R_2 , R'_2 , R_3 and R'_3 are the same or different and each independently represents H, alkyl or aryl, or a heteroatomic monovalent hydrocarbon group, provided that at least one of R_3 and R'_3 is H.

25 66. The curable powder coating composition of claim 65, wherein R_1 comprises a phenyl group.

30 67. The curable powder coating composition of claim 57, wherein reactant (1) comprises a mono-hydroxy aromatic compound selected from at least one of p-cresol, 4-methoxyphenol, 4-tert-butyl phenol, 2,4-di-tert-butylphenol, 4-

nitrophenol, 4-fluorophenol, 2-phenyl phenol, 4-phenyl phenol, 1-naphthol, and 2-naphthol.

68. The curable powder coating composition of claim 57, wherein the aminoplast compound (2) is or is derived from at least one of glycoluril, aminotriazine and benzoguanamine.

69. The curable powder coating composition of claim 68, wherein the aminoplast compound (2) comprises alkoxylated aldehyde condensate of glycoluril.

70. The curable powder coating composition of claim 69, wherein the aminoplast compound (2) comprises tetramethoxy methylglycoluril.

71. The curable powder coating composition of claim 68, wherein the aminoplast compound (2) comprises (alkoxyalkyl) aminotriazine having one or less non-alkylated NH bond per triazine ring.

72. The curable powder coating composition of claim 71, wherein the aminoplast compound (2) comprises (methoxymethyl) aminotriazine.

73. The curable powder coating composition of claim 57, wherein the aminotriazine compound (2) has a degree of polymerization of 3.0 or less.

74. The curable powder coating composition of claim 57, wherein the compound (3) comprises at least one compound having the structure (II).

75. The curable powder coating composition of claim 74, wherein at least one of R^6 , R^7 , and R^8 represents a group comprising an active hydrogen-containing group selected from hydroxyl, amide, amine, carboxylic acid, carbamate, urea, thiol, and mixtures thereof.

76. The curable powder coating composition of claim 75, wherein at least one of R⁶, R⁷, and R⁸ represents a group comprising at least one hydroxyl group.

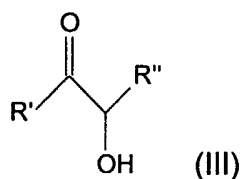
5

77. The curable powder coating composition of claim 74, wherein the compound (3) comprises benzyl alcohol.

10

78. The curable powder coating composition of claim 57, wherein the compound (3) comprises at least one of compound (3)(b).

79. The curable powder coating composition of claim 78, wherein the compound (3) comprises a hydroxyl functional group-containing compound having the following structure (III):



15

or dimer derivatives thereof, wherein R' and R'' are the same or different and each independently represents an (cyclo)alkyl group having 1 to 12 carbon atoms or an aromatic group.

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80. The curable powder coating composition of claim 79, wherein one or both of R' and R'' represent aromatic groups.

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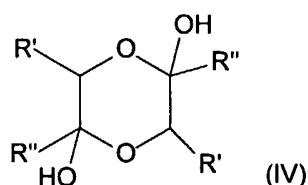
81. The curable powder coating composition of claim 79, wherein the compound (3) comprises a compound selected from benzoin, hydroxycyclohexyl phenyl ketone and mixtures thereof.

82. The curable powder coating composition of claim 81, wherein the compound (3) comprises benzoin.

83. The curable powder coating composition of claim 81, wherein the compound (3) comprises hydroxycyclohexyl phenyl ketone.

5 84. The curable powder coating composition of claim 79, wherein one or both of R' and R'' are aromatic groups containing at least one heteroatom selected from furyl, pyridyl, methoxy phenyl, and dimethylaminophenyl groups.

10 85. The curable powder coating composition of claim 78, wherein the active hydrogen group-containing compound (3) comprises a compound having the following structure (IV):



15 wherein R' and R'' are the same or different and each independently represents an alkyl group having 1 to 12 carbon atoms or an aromatic group.

86. The curable powder coating composition of claim 57, wherein the compound (3) comprises at least one of compound (3)(c)

20 87. The curable powder coating composition of claim 86, wherein compound (3) comprises an aliphatic mono-functional alcohol selected from borneol, norborneol, isoborneol, 1-adamantanemethanol, 1-adamantanol, 2-methyl-2-adamantanol and 5-norbornen-2-ol.

25 88. The curable powder coating composition of claim 57, wherein the compound (3) is selected from benzoin, isoborneol, triphenylmethanol, N-tert-butylacrylamide, p-acetophenetidide and mixtures thereof.

89. The curable powder coating composition of claim 57, wherein the crosslinking agent (B) is present in an amount ranging from 5 to 95 weight percent based on total weight of the powder coating composition.

5

90. The curable powder coating composition of claim 59, wherein the polymer (A) comprises hydroxyl and/or epoxy functional groups.

10

91. The curable powder coating composition of claim 90, further comprising a crosslinking agent having carboxylic acid functional groups.

92. The powder coating composition of claim 91, wherein the powder topcoating composition comprises a solid particulate, film-forming mixture of the following components:

15

5 to 95 weight percent of (A) a polymer having reactive epoxy functional groups; and

5 to 95 weight percent of (B) a crosslinking agent having reactive benzoxazine groups comprising the ungelled reaction product of

20

(1) at least one mono-hydroxy aromatic compound selected from p-cresol, 4-methoxyphenol, 4-tert-butyl phenol, 2,4-di-tert-butylphenol, 4-nitrophenol, 4-fluorophenol, 2-phenyl phenol, 4-phenyl phenol, 1-naphthol, and 2-naphthol;

25

(2) at least one (methoxymethyl)aminotriazine compound having one or less non-alkylated NH group and a degree of polymerization of less than 3.0; and

(3) at least one compound selected from benzoin, hydroxycyclohexyl phenyl ketone, isoborneol, triphenylmethanol, N-tert-butylacrylamide, and p-acetophenetidide; and

30

0.5 to 20 weight percent (C) a crosslinking agent having carboxylic acid functional groups, where weight percents are based on total weight of the powder coating composition.

93. A multilayer composite coating composition comprising a base coat deposited from a film-forming base coat composition and topcoat over the base coat, the topcoat deposited from a transparent curable powder

5 topcoating composition,

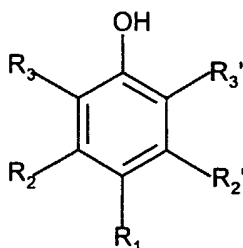
the curable powder topcoating composition comprising a film-forming, solid particulate mixture of the following components:

(A) a polymer having functional groups reactive with benzoxazine groups, said polymer having a glass transition temperature of at least 30°C;

10 and

(B) a crosslinking agent having reactive benzoxazine groups comprising the ungelled reaction product of the following reactants:

(1) at least one mono-hydroxy aromatic compound having the following structure (I):



15 (I)

wherein R_1 represents a monovalent hydrocarbon group, COOR_5 where R_5 represents H or a monovalent hydrocarbon group, NO_2 , halogen or XR_4 , where X represents O or S and R_4 represents a monovalent hydrocarbon group having 1 to 8 carbon atoms;

20 R_3 , R'_3 , R_2 and R'_2 can be the same or different and each independently represents a substituent selected from H, a monovalent hydrocarbon group, COOR_5 , NO_2 , halogen and XR_4 , provided that at least one of R_3 and R'_3 is H; or

when R_3 is non-hydrogen substituted and R'_3 is H,

R_1 and R_2 taken together, R_1 and R'_2 taken together, or R_2 taken together with the non-hydrogen substituted R_3 represent fused aliphatic or aromatic ring structures, or

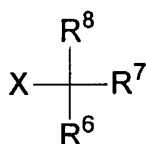
when R'_3 is non-hydrogen substituted and R_3 is H,

- 5 R_1 and R_2 taken together, R_1 and R'_2 taken together, or R'_2 taken together with the non-hydrogen substituted R_3 represent fused aliphatic or aromatic ring structures; and

(2) at least one aminoplast compound ; and

- (3) at least one compound different from (1) having active
10 hydrogen groups reactive with aminoplast compound (2), said compound (3) selected from at least one of:

(a) compounds having the following structure (II):

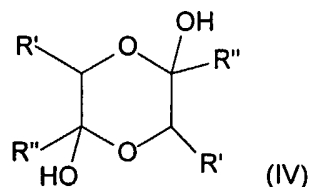
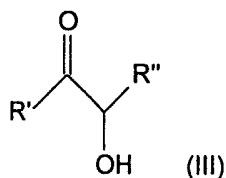


(II)

- 15 wherein X is aromatic; R^6 , R^7 , and R^8 can be the same or different and each independently represents H, (cyclo)alkyl having from 1 to 12 carbon atoms, aryl, alkaryl, aralkyl, or an active hydrogen-containing group,

- provided that at least one of R^6 , R^7 , and R^8 represents an active hydrogen-containing group which is reactive with the
20 aminoplast compound (2);

(b) compounds having the following structure (III) or (IV):



where R' and R'' are the same or different and each independently represents an aromatic group or an alkyl group having 1 to 12 carbon atoms; and

(c) compounds different from (a) and (b) and having a melting point of at least 80°C;

wherein said crosslinking agent is essentially free of hydroxyl functionality and has a glass transition temperature of at least 25°C.

94. The multilayer composite coating composition of claim 93, wherein the polymer (A) is selected from the group consisting of acrylic, polyester, polyurethane, polyepoxide and polyether polymers and mixtures thereof.

95. The multilayer composite coating composition of claim 93, wherein the polymer (A) comprises functional groups selected from the group consisting of hydroxyl, primary and secondary amine, carbamate, amide, thiol, phenolic, carboxyl and epoxy functional groups and mixtures thereof.

96. The multilayer composite coating composition of claim 95, wherein the polymer (A) comprises hydroxyl and/or carbamate functional groups.

97. The multilayer composite coating composition of claim 93, wherein the polymer (A) has a glass transition temperature ranging from 30° to 110°C.

98. The multilayer composite coating composition of claim 93, wherein the polymer (A) is present in the powder topcoating composition in an amount ranging from 5 to 95 percent by weight based on total weight of the powder topcoating composition.

99. The multilayer composite coating composition of claim 93, wherein R₁ represents an electron-withdrawing group selected from aryl, alkylaryl, COOH, NO₂, halogen and an alkoxy group.

100. The multilayer composite coating composition of claim 93, wherein R_3 and R'_3 are both H.

5 101. The multilayer composite coating composition of claim 93, wherein R_1 is an aryl group and R_2 , R'_2 , R_3 and R'_3 are the same or different and each independently represents H, alkyl, aryl, or a heteroatomic monovalent hydrocarbon group, provided that at least one of R_3 and R'_3 is H.

10 102. The multilayer composite coating composition of claim 101, wherein R_1 comprises a phenyl group.

103. The multilayer composite coating composition of claim 93, wherein reactant (1) comprises a mono-hydroxy aromatic compound selected from at
15 least one of p-cresol, 4-methoxyphenol, 4-tert-butyl phenol, 2,4-di-tert-butylphenol, 4-nitrophenol, 4-fluorophenol, 2-phenyl phenol, 4-phenyl phenol, 1-naphthol, and 2-naphthol.

104. The multilayer composite coating composition of claim 93, wherein the
20 aminoplast compound (2) is or is derived from at least one of glycoluril, aminotriazine and benzoguanamine.

105. The multilayer composite coating composition of claim 104, wherein
25 the aminoplast compound (2) comprises alkoxylated aldehyde condensate of glycoluril.

106. The multilayer composite coating composition of claim 105, wherein the aminoplast compound (2) comprises tetramethoxy methylglycoluril.

107. The multilayer composite coating composition of claim 104, wherein the aminoplast compound (2) comprises (alkoxyalkyl) aminotriazine having one or less non-alkylated NH bond per triazine ring.

5 108. The multilayer composite coating composition of claim 107, wherein the aminoplast compound (2) comprises (methoxymethyl) aminotriazine.

109. The multilayer composite coating composition of claim 93, wherein the aminoplast compound (2) has a degree of polymerization of 3.0 or less.

10

110. The multilayer composite coating composition of claim 93, wherein the compound (3) comprises at least one compound having the structure (II).

15

111. The multilayer composite coating composition of claim 110, wherein at least one of R^6 , R^7 , and R^8 represents a group comprising an active hydrogen-containing group selected from hydroxyl, amide, amine, carboxylic acid, carbamate, urea, thiol, and mixtures thereof.

20

112. The multilayer composite coating composition of claim 111, wherein at least one of R^6 , R^7 , and R^8 represents a group comprising at least one hydroxyl group.

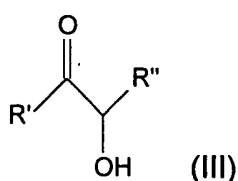
25

113. The multilayer composite coating composition of claim 110, wherein the compound (3) comprises benzyl alcohol.

114. The multilayer composite coating composition of claim 93, wherein the compound (3) comprises at least one of compound (3)(b).

30

115. The multilayer composite coating composition of claim 114, wherein the compound (3) comprises a hydroxyl functional group-containing compound having the following structure (III):



or dimer derivatives thereof, wherein R' and R'' are the same or different and each independently represents an (cyclo)alkyl group having 1 to 12 carbon atoms or an aromatic group.

5

116. The multilayer composite coating composition of claim 115, wherein one or both of R' and R'' represent aromatic groups.

10

117. The multilayer composite coating composition of claim 115, wherein the compound (3) comprises a compound selected from benzoin, hydroxycyclohexyl phenyl ketone and mixtures thereof.

118. The multilayer composite coating composition of claim 117, wherein the compound (3) comprises benzoin.

15

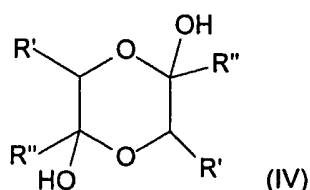
119. The multilayer composite coating composition of claim 117, wherein the compound (3) comprises hydroxycyclohexyl phenyl ketone.

20

120. The multilayer composite coating composition of claim 115, wherein one or both of R' and R'' are aromatic groups containing at least one heteroatom selected from furyl, pyridyl, methoxy phenyl, and dimethylaminophenyl groups.

25

121. The multilayer composite coating composition of claim 114, wherein the active hydrogen group-containing compound (3) comprises a compound having the following structure (IV):



wherein R' and R'' are the same or different and each independently represents an alkyl group having 1 to 12 carbon atoms or an aromatic group.

5 122. The multilayer composite coating composition of claim 93, wherein the compound (3) comprises at least one of compound (3)(c).

123. The multilayer composite coating composition of claim 122, wherein compound (3) comprises an aliphatic mono-functional alcohol selected from
10 borneol, norborneol, isborneol, 1-adamantanemethanol, 1-adamantanol, 2-methyl-2-adamantanol and 5-norbornen-2-ol.

124. The multilayer composite coating composition of claim 93, wherein the compound (3) is selected from benzoin, isborneol, triphenylmethanol, N-tert-
15 butylacrylamide, p-acetophenetidide and mixtures thereof.

125. The multilayer composite coating composition of claim 93, wherein the crosslinking agent (B) is present in the powder topcoating composition in an amount ranging from 5 to 95 weight percent based on total weight of the
20 powder topcoating composition.

126. The multilayer composite coating composition of claim 95, wherein the polymer (A) comprises hydroxyl and/or epoxy functional groups.

25 127. The multilayer composite coating composition of claim 126, wherein the powder topcoating composition further comprises a crosslinking agent having carboxylic acid functional groups.

128. The multilayer composite coating composition of claim 127, wherein
30 the powder topcoating composition comprises a solid particulate, film-forming mixture of the following components:

5 to 95 weight percent of (A) a polymer having reactive epoxy functional groups; and

5 to 95 weight percent of (B) a crosslinking agent having reactive benzoxazine groups comprising the ungelled reaction product of

(1) at least one mono-hydroxy aromatic compound selected from p-cresol, 4-methoxyphenol, 4-tert-butyl phenol, 2,4-di-tert-butylphenol, 4-nitrophenol, 4-fluorophenol, 2-phenyl phenol, 4-phenyl phenol, 1-naphthol, and 2-naphthol;

(2) at least one (methoxymethyl)aminotriazine compound having one or less non-alkylated NH group and a degree of polymerization of less than 3.0; and

(3) at least one compound selected from benzoin, hydroxycyclohexyl phenyl ketone, isoborneol, triphenylmethanol, N-tert-butylacrylamide, and p-acetophenetidide; and

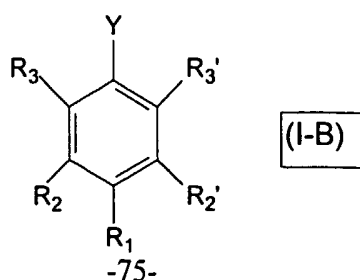
0.5 to 20 weight percent (C) a crosslinking agent having carboxylic acid functional groups, where weight percents are based on total weight of the powder topcoating composition.

129. A substrate coated with the curable powder coating composition of claim 57.

130. A substrate coated with the multilayer composite coating composition of claim 93.

131. A crosslinking agent comprising an ungelled reaction product of the following reactants:

(a) at least one aromatic compound having the following structure (I-B):



wherein R_1 represents a monovalent hydrocarbon group, COOR_5
 wherein R_5 represents H or a monovalent hydrocarbon group, NO_2 , halogen
 or XR_4 , where X represents O or S and R_4 represents a monovalent
 hydrocarbon group having 1 to 8 carbon atoms;

5 R_3 , R'_3 , R_2 and R'_2 can be the same or different and each
 independently represents a substituent selected from H, a monovalent
 hydrocarbon group, COOR_5 , NO_2 , halogen and XR_4 , provided that at least
 one of R_3 and R'_3 is H; or

when R_3 is non-hydrogen substituted and R'_3 is H, R_1 and R_2
 10 taken together, R_1 and R'_2 taken together, or R_2 taken together with the non-
 hydrogen substituted R_3 represent fused aliphatic or aromatic ring structures,
 or

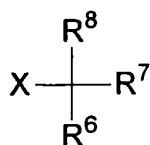
when R'_3 is non-hydrogen substituted and R_3 is H, R_1 and R_2
 taken together, R_1 and R'_2 taken together, or R'_2 taken together with the non-
 15 hydrogen substituted R'_3 represent fused aliphatic or aromatic ring structures;

Y represents an active hydrogen-containing group selected from
 amino, thiol, and urea;

(b) at least one aminoplast compound ; and

(c) at least one compound different from (a) having active hydrogen
 20 groups reactive with aminoplast compound (b), said compound (c) selected
 from at least one of:

(1) compounds having the following structure (II):

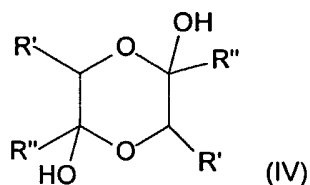
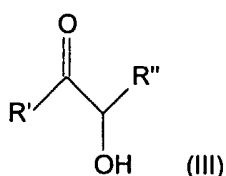


(II)

wherein X is aromatic; R^6 , R^7 , and R^8 can be the same or
 25 different and each independently represents H, (cyclo)alkyl
 having from 1 to 12 carbon atoms, aryl, alkaryl, aralkyl, or an
 active hydrogen-containing group,

provided that at least one of R^6 , R^7 , and R^8 represents an active hydrogen-containing group which is reactive with the aminoplast resin (b);

(2) compounds having the following structure (III) or (IV):



where R' and R'' are the same or different and each independently represents an aromatic group or an alkyl group having 1 to 12 carbon atoms; and

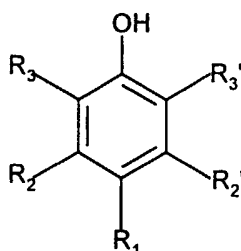
(3) compounds different from (1) and (2) and having a melting point of at least 80°C;

wherein said crosslinking agent is essentially free of hydroxyl functionality and has a glass transition temperature of at least 25°C.

132. A method for forming a powder crosslinking agent having reactive benzoxazine groups comprising the following steps:

(1) combining the following reactants:

(a) at least one mono-hydroxy aromatic compound having the following structure (I-A):



wherein R_1 represents a monovalent hydrocarbon group, $COOR_5$ where R_5 represents H or a monovalent hydrocarbon group, NO_2 ,

halogen or XR_4 , where X represents O or S and R_4 represents a monovalent hydrocarbon group having 1 to 8 carbon atoms;

R_3 , R'_3 , R_2 and R'_2 can be the same or different and each independently represents a substituent selected from H, a monovalent hydrocarbon group, COOR_5 , NO_2 , halogen and XR_4 , provided that at least one of R_3 and R'_3 is H; or

when R_3 is non-hydrogen substituted and R'_3 is H,

R_1 and R_2 taken together, R_1 and R'_2 taken together, or R_2 taken together with the non-hydrogen substituted R_3 represent fused aliphatic or aromatic ring

structures, or

when R'_3 is non-hydrogen substituted and R_3 is H,

R_1 and R_2 taken together, R_1 and R'_2 taken together, or R'_2 taken together with the non-hydrogen substituted R'_3 represent fused aliphatic or aromatic ring structures; and

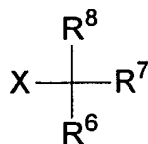
(b) at least one aminoplast compound to form a reaction admixture;

(2) heating the reaction admixture formed in step (1) to a temperature ranging from 90°C to 135°C ;

(3) maintaining the temperature achieved in step (2) until no free hydroxyl functionality remains;

(4) adding to the reaction admixture formed in step (1) at least one compound different from (a) having active hydrogen groups reactive with aminoplast compound (b), said compound selected from at least one of:

(i) compounds having the following structure (II):



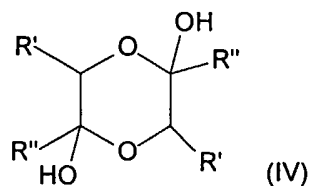
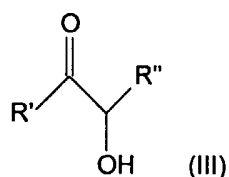
(II)

wherein X is aromatic; R^6 , R^7 , and R^8 can be the same or different and each independently represents H, (cyclo)alkyl

having from 1 to 12 carbon atoms, aryl, alkaryl, aralkyl, or an active hydrogen-containing group,

provided that at least one of R^6 , R^7 , and R^8 represents an active hydrogen-containing group which is reactive with the aminoplast resin (b);

(ii) compounds having the following structure (III) or (IV):



where R' and R'' are the same or different and each independently represents an aromatic group or an alkyl group having 1 to 12 carbon atoms; and

(iii) compounds different from (i) and (ii) and having a melting point of at least 80°C to form a second reaction admixture;

(5) heating the second reaction admixture formed in step (4) to a temperature ranging from 90°C to 135°C; and

(6) maintaining the temperature achieved in step (5) for a time sufficient to produce an ungelled reaction product having a glass transition temperature of at least 25°C which is essentially free of hydroxyl functionality as determined by infrared spectroscopy.