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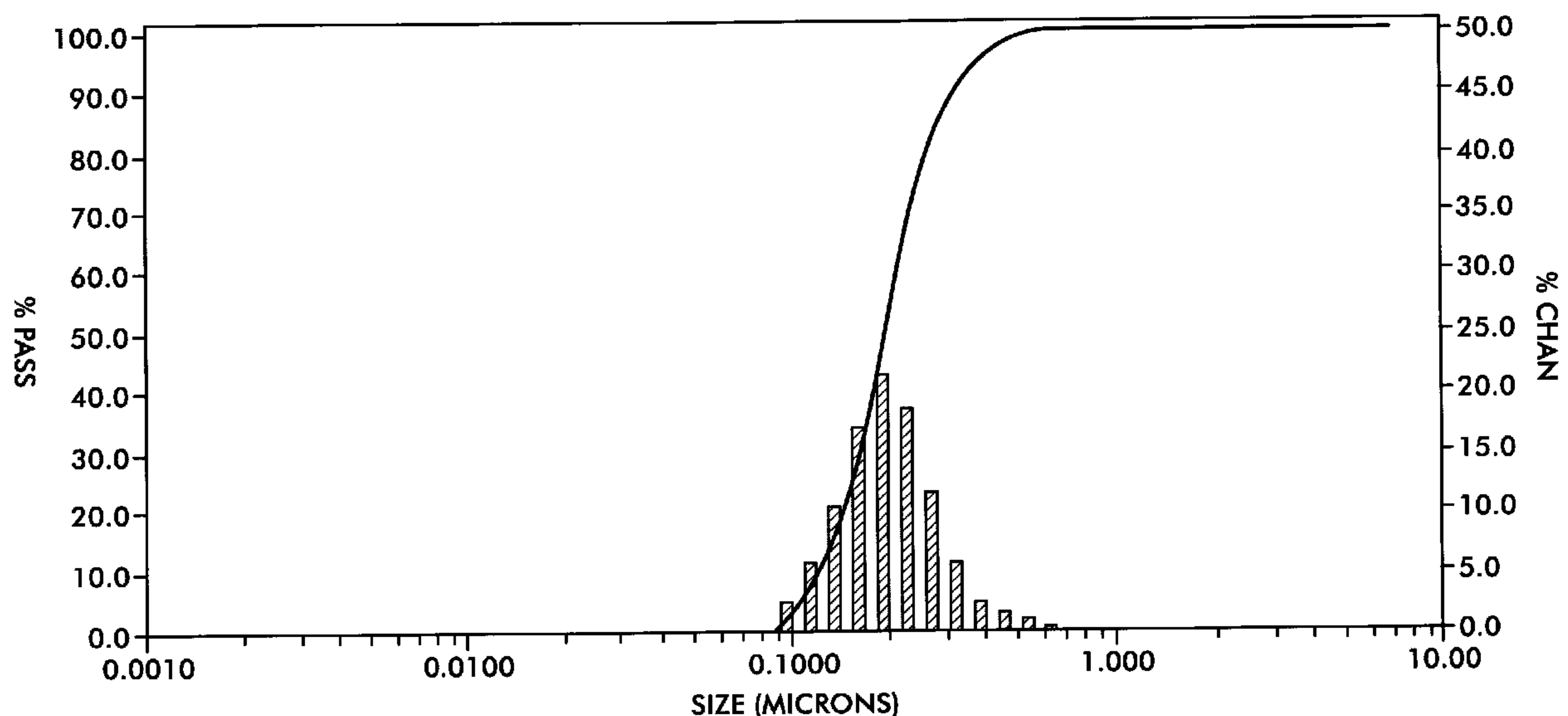
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(54) Titre : METHODE D'INVERSION DE PHASE SANS SOLVANT PERMETTANT DE PRODUIRE DES EMULSIONS DE RESINE

(54) Title: SOLVENT-FREE PHASE INVERSION PROCESS FOR PRODUCING RESIN EMULSIONS



(57) Abrégé/Abstract:

A process for making a resin emulsion suitable for use in forming toner particles includes melt mixing a resin possessing acid groups at a temperature higher than the glass transition temperature of the resin, optionally adding a surfactant before, prior to, during, or after melt mixing the resin, and adding a basic neutralization agent and water to the resin to form an emulsion. In embodiments, the resin emulsion thus produced may be utilized to form a toner.

ABSTRACT

[00106] A process for making a resin emulsion suitable for use in forming toner particles includes melt mixing a resin possessing acid groups at a temperature higher than the glass transition temperature of the resin, optionally adding a surfactant before, prior to, during, or after melt mixing the resin, and adding a basic neutralization agent and water to the resin to form an emulsion. In embodiments, the resin emulsion thus produced may be utilized to form a toner.

Patent Application

SOLVENT-FREE PHASE INVERSION PROCESS FOR PRODUCING RESIN EMULSIONS

BACKGROUND

[0001] The present disclosure relates to processes for producing resin emulsions useful in producing toners suitable for electrostatographic apparatuses.

[0002] Numerous processes are within the purview of those skilled in the art for the preparation of toners. Emulsion aggregation (EA) is one such method. These toners may be formed by aggregating a colorant with a latex polymer formed by emulsion polymerization. For example, U.S. Patent No. 5,853,943, the disclosure of which is hereby incorporated by reference in its entirety, is directed to a semi-continuous emulsion polymerization process for preparing a latex by first forming a seed polymer. Other examples of emulsion/aggregation/coalescing processes for the preparation of toners are illustrated in U.S. Patent Nos. 5,403,693, 5,418,108, 5,364,729, and 5,346,797, the disclosures of each of which are hereby incorporated by reference in their entirety. Other processes are disclosed in U.S. Patent Nos. 5,527,658, 5,585,215, 5,650,255, 5,650,256 and 5,501,935, the disclosures of each of which are hereby incorporated by reference in their entirety.

[0003] Polyester EA toners have also been prepared utilizing emulsions prepared by solvent containing processes, for example solvent flash emulsification and solvent-based phase inversion emulsification. In both cases, large amounts of organic solvents such as ketones or alcohols have been used to dissolve the resins. The solvents need to be

evaporated at the end of the emulsification, which usually takes a long time to complete. Other drawbacks with these processes include: 1) the solvent containing process is not environmentally friendly; 2) waste treatment and solvent recovery adds extra cost to the EA toner process; and 3) the residual amount of solvent may vary, which will affect both the toner process and the toner produced by the process.

[0004] Improved methods for producing toners, which reduce the number of stages and materials, remain desirable. Such processes may reduce production costs for such toners and may be environmentally friendly.

SUMMARY

[0005] The present disclosure provides methods for producing toners. In embodiments, processes of the present disclosure include melt mixing a resin in the absence of an organic solvent, optionally adding a surfactant to the resin, and adding to the resin a basic agent and water to form an emulsion of resin particles

[0006] In other embodiments, a process of the present disclosure may include melt mixing a resin in the absence of a organic solvent, optionally adding a surfactant to the resin, optionally adding one or more additional ingredients of a toner composition to the resin, adding to the resin a basic agent and water, performing a phase inversion to create a phase inversed emulsion including a disperse phase comprising toner-sized droplets including the molten resin and the optional ingredients of the toner composition, and solidifying the toner-sized droplets to result in toner particles.

[0007] In yet other embodiments, a process of the present disclosure may include melt mixing a polyester resin possessing acid groups in the absence of an organic solvent,

adding a surfactant to the resin, and adding to the resin a basic neutralization agent and water to form an emulsion.

BRIEF DESCRIPTION OF THE FIGURES

[0008] Various embodiments of the present disclosure will be described herein below with reference to the figures wherein:

[0009] FIG. 1 is a graph depicting particle sizes of resins produced in accordance with the present disclosure; and

[0010] FIG. 2 is a graph depicting particle sizes of resins produced in accordance with the present disclosure.

DETAILED DESCRIPTION

[0011] The present disclosure provides processes for producing resin emulsions which may be utilized to make toners. In embodiments, a process of the present includes melt mixing a resin in the absence of an organic solvent; optionally adding a surfactant either before, during or after melt mixing the resin; and adding a basic agent and water to form an emulsion of the resin particles.

[0012] The present disclosure also provides processes for producing toner particles. In embodiment, a process of the present disclosure includes melt mixing a resin in the absence of an organic solvent; optionally adding a surfactant either before, during or after melt mixing the resin; optionally adding one or more additional ingredients of a toner composition such as colorant, wax, and other additives to the above mixture; adding a basic agent and water; performing a phase inversion to create a phase inversed emulsion

including a disperse phase including toner-sized droplets including the molten resin and the optional ingredients of the toner composition; and solidifying the toner-sized droplets to result in toner particles.

[0013] As used herein, "the absence of an organic solvent" means that organic solvents are not used to dissolve the polyester resin for emulsification. However, it is understood that minor amounts of such solvents may be present in such resins as a consequence of their use in the process of forming the resin.

Resins

[0014] Any toner resin may be utilized in the processes of the present disclosure. Such resins, in turn, may be made of any suitable monomer or monomers via any suitable polymerization method. In embodiments, the resin may be prepared by a method other than emulsion polymerization. In further embodiments, the resin may be prepared by condensation polymerization. In embodiments, the resin may be an amorphous resin, a crystalline resin, and/or a mixture of crystalline and amorphous resins. The crystalline resin may be present in the mixture of crystalline and amorphous resins, for example, in an amount of from 0 to about 50 percent by weight of the total toner resin, in embodiments from 5 to about 35 percent by weight of the toner resin. The amorphous resin may be present in the mixture, for example, in an amount of from about 50 to about 100 percent by weight of the total toner resin, in embodiments from 95 to about 65 percent by weight of the toner resin. In embodiments, the resin may be a polyester, polyimide, polyolefin, polyamide, polycarbonate, epoxy resin, and/or copolymers thereof.

In embodiments, the resin may be a polyester crystalline and/or a polyester amorphous resin.

[0015] In embodiments, the polymer utilized to form the resin may be a polyester resin, including the resins described in U.S. Patent Nos. 6,593,049 and 6,756,176, the disclosures of each of which are hereby incorporated by reference in their entirety. Suitable resins may also include a mixture of an amorphous polyester resin and a crystalline polyester resin as described in U.S. Patent No. 6,830,860, the disclosure of which is hereby incorporated by reference in its entirety.

[0016] In embodiments, the resin may be a polyester resin formed by reacting a diol with a diacid in the presence of an optional catalyst. For forming a crystalline polyester, suitable organic diols include aliphatic diols with from about 2 to about 36 carbon atoms, such as 1,2-ethanediol, 1,3-propanediol, 1,4-butanediol, 1,5-pentanediol, 1,6-hexanediol, 1,7-heptanediol, 1,8-octanediol, 1,9-nonanediol, 1,10-decanediol, 1,12-dodecanediol and the like; alkali sulfo-aliphatic diols such as sodio 2-sulfo-1,2-ethanediol, lithio 2-sulfo-1,2-ethanediol, potassio 2-sulfo-1,2-ethanediol, sodio 2-sulfo-1,3-propanediol, lithio 2-sulfo-1,3-propanediol, potassio 2-sulfo-1,3-propanediol, mixture thereof, and the like.

The aliphatic diol may be, for example, selected in an amount of from about 40 to about 60 mole percent, in embodiments from about 42 to about 52 mole percent of the resin, in other embodiments from about 45 to about 50 mole percent of the resin, and the alkali sulfo-aliphatic diol can be selected in an amount of from about 0 to about 10 mole percent of the resin, in embodiments from about 0.5 to about 4 percent of the resin. In further embodiments, the polyester resin may lack an alkali sulfo-aliphatic group, as the presence of alkali sulfo-aliphatic groups may induce sensitivity of toner to moisture.

[0017] Examples of organic diacids or diesters selected for the preparation of the crystalline resins include oxalic acid, succinic acid, glutaric acid, adipic acid, suberic acid, azelaic acid, sebacic acid, phthalic acid, isophthalic acid, terephthalic acid, naphthalene-2,6-dicarboxylic acid, naphthalene-2,7-dicarboxylic acid, cyclohexane dicarboxylic acid, malonic acid and mesaconic acid, a diester or anhydride thereof; and an alkali sulfo-organic diacid such as the sodio, lithio or potassio salt of dimethyl-5-sulfo-isophthalate, dialkyl-5-sulfo-isophthalate-4-sulfo-1,8-naphthalic anhydride, 4-sulfo-phthalic acid, dimethyl-4-sulfo-phthalate, dialkyl-4-sulfo-phthalate, 4-sulfophenyl-3,5-dicarbomethoxybenzene, 6-sulfo-2-naphthyl-3,5-dicarbomethoxybenzene, sulfo-terephthalic acid, dimethyl-sulfo-terephthalate, 5-sulfo-isophthalic acid, dialkyl-sulfo-terephthalate, sulfoethanediol, 2-sulfopropanediol, 2-sulfobutanediol, 3-sulfopentane-1,2-diol, 2-sulfohexane-1,2-diol, 3-sulfo-2-methylpentane-1,2-diol, 2-sulfo-3,3-dimethylpentane-1,2-diol, sulfo-p-hydroxybenzoic acid, N,N-bis(2-hydroxyethyl)-2-amino ethane sulfonate, or mixtures thereof. The organic diacid may be selected in an amount of, for example, from about 40 to about 52 mole percent, in embodiments from about 45 to about 50 mole percent, of the resin, and the alkali sulfo-aliphatic diacid can be selected in an amount of from 0 to about 10 mole percent, in embodiments from about 0.5 to about 4 percent, of the resin.

[0018] Examples of crystalline resins include polyesters, polyamides, polyimides, polyolefins, polyethylene, polybutylene, polyisobutyrate, ethylene-propylene copolymers, ethylene-vinyl acetate copolymers, polypropylene, mixtures thereof, and the like. Specific crystalline resins may be polyester based, such as poly(ethylene-adipate), poly(propylene-adipate), poly(butylene-adipate), poly(pentylene-adipate), poly(hexylene-adipate), poly(octylene-adipate), poly(ethylene-succinate), poly(propylene-succinate),

poly(butylene-succinate), poly(pentylene-succinate), poly(hexylene-succinate),
 poly(octylene-succinate), poly(ethylene-sebacate), poly(propylene-sebacate),
 poly(butylene-sebacate), poly(pentylene-sebacate), poly(hexylene-sebacate),
 poly(octylene-sebacate), alkali copoly(5-sulfoisophthaloyl)-copoly(ethylene-adipate),
 alkali copoly(5-sulfoisophthaloyl)-copoly(propylene-adipate), alkali copoly(5-
 sulfoisophthaloyl)-copoly(butylene-adipate), alkali copoly(5-sulfo-isophthaloyl)-
 copoly(pentylene-adipate), alkali copoly(5-sulfo-isophthaloyl)-copoly(hexylene-adipate),
 alkali copoly(5-sulfo-isophthaloyl)-copoly(octylene-adipate), alkali copoly(5-sulfo-
 isophthaloyl)-copoly(ethylene-adipate), alkali copoly(5-sulfo-isophthaloyl)-copoly
 (propylene-adipate), alkali copoly(5-sulfo-isophthaloyl)-copoly(butylene-adipate), alkali
 copoly(5-sulfo-isophthaloyl)-copoly(pentylene-adipate), alkali copoly(5-sulfo-
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 copoly(octylene-adipate), alkali copoly(5-sulfoisophthaloyl)-copoly(ethylene-succinate),
 alkali copoly(5-sulfoisophthaloyl)-copoly(propylene-succinate), alkali copoly(5-
 sulfoisophthaloyl)-copoly(butylenes-succinate), alkali copoly(5-sulfoisophthaloyl)-
 copoly(pentylene-succinate), alkali copoly(5-sulfoisophthaloyl)-copoly(hexylene-
 succinate), alkali copoly(5-sulfoisophthaloyl)-copoly(octylene-succinate), alkali
 copoly(5-sulfo-isophthaloyl)-copoly(ethylene-sebacate), alkali copoly(5-sulfo-
 isophthaloyl)-copoly(propylene-sebacate), alkali copoly(5-sulfo-isophthaloyl)-
 copoly(butylene-sebacate), alkali copoly(5-sulfo-isophthaloyl)-copoly(pentylene-
 sebacate), alkali copoly(5-sulfo-isophthaloyl)-copoly(hexylene-sebacate), alkali
 copoly(5-sulfo-isophthaloyl)-copoly(octylene-sebacate), alkali copoly(5-sulfo-
 isophthaloyl)-copoly(ethylene-adipate), alkali copoly(5-sulfo-isophthaloyl)-

copoly(propylene-adipate), alkali copoly(5-sulfo-isophthaloyl)-copoly(butylene-adipate), alkali copoly(5-sulfo-isophthaloyl)-copoly(pentylene-adipate), alkali copoly(5-sulfo-isophthaloyl)-copoly(hexylene-adipate), poly(octylene-adipate), wherein alkali is a metal like sodium, lithium or potassium. Examples of polyamides include poly(ethylene-adipamide), poly(propylene-adipamide), poly(butylenes-adipamide), poly(pentylene-adipamide), poly(hexylene-adipamide), poly(octylene-adipamide), poly(ethylene-succinamide), and poly(propylene-sebecamide). Examples of polyimides include poly(ethylene-adipimide), poly(propylene-adipimide), poly(butylene-adipimide), poly(pentylene-adipimide), poly(hexylene-adipimide), poly(octylene-adipimide), poly(ethylene-succinimide), poly(propylene-succinimide), and poly(butylene-succinimide).

[0019] The crystalline resin can possess various melting points of, for example, from about 30° C to about 120° C, in embodiments from about 50° C to about 90° C. The crystalline resin may have a number average molecular weight (M_n), for example, from about 1,000 to about 50,000, in embodiments from about 2,000 to about 25,000, and a weight average molecular weight (M_w) of, for example, from about 2,000 to about 100,000, in embodiments from about 3,000 to about 80,000, as determined by Gel Permeation Chromatography (GPC) using polystyrene standards. The molecular weight distribution (M_w/M_n) of the crystalline resin may be, for example, from about 2 to about 6, in embodiments from about 2 to about 4.

[0020] Examples of diacid or diesters selected for the preparation of amorphous polyesters include dicarboxylic acids or diesters such as terephthalic acid, phthalic acid, isophthalic acid, fumaric acid, maleic acid, succinic acid, itaconic acid, succinic acid,

succinic anhydride, dodecylsuccinic acid, dodecylsuccinic anhydride, glutaric acid, glutaric anhydride, adipic acid, pimelic acid, suberic acid, azelaic acid, dodecanediacid, dimethyl terephthalate, diethyl terephthalate, dimethylisophthalate, diethylisophthalate, dimethylphthalate, phthalic anhydride, diethylphthalate, dimethylsuccinate, dimethylfumarate, dimethylmaleate, dimethylglutarate, dimethyladipate, dimethyl dodecylsuccinate, and combinations thereof. The organic diacid or diester may be selected, for example, from about 40 to about 52 mole percent, in embodiments from about 45 to about 50 mole percent of the resin.

[0021] Examples of diols utilized in generating the amorphous polyester include ethylene glycol, 1,2-propanediol, 1,3-propanediol, 1,2-butanediol, 1,3-butanediol, 1,4-butanediol, pentanediol, hexanediol, 2,2-dimethylpropanediol, 2,2,3-trimethylhexanediol, heptanediol, dodecanediol, bis(hydroxyethyl)-bisphenol A, bis(2-hydroxypropyl)-bisphenol A, 1,4-cyclohexanedimethanol, 1,3-cyclohexanedimethanol, xylenedimethanol, cyclohexanediol, diethylene glycol, bis(2-hydroxyethyl) oxide, dipropylene glycol, dibutylene, and combinations thereof. The amount of organic diol selected can vary, and may be, for example, from about 40 to about 60 mole percent, in embodiments from about 42 to about 52 mole percent, in other embodiments from about 45 to about 50 mole percent of the resin.

[0022] Polycondensation catalysts which may be utilized for either the crystalline or amorphous polyesters include tetraalkyl titanates, dialkyltin oxides such as dibutyltin oxide, tetraalkyltins such as dibutyltin dilaurate, dialkyltin oxide hydroxides such as butyltin oxide hydroxide, aluminum alkoxides, alkyl zinc, dialkyl zinc, zinc oxide, stannous oxide, or combinations thereof. Such catalysts may be utilized in amounts of,

for example, from about 0.01 mole percent to about 5 mole percent based on the starting diacid or diester used to generate the polyester resin.

[0023] In embodiments, suitable amorphous resins include polyesters, polyamides, polyimides, polyolefins, polyethylene, polybutylene, polyisobutyrate, ethylene-propylene copolymers, ethylene-vinyl acetate copolymers, polypropylene, mixtures thereof, and the like. Examples of amorphous resins which may be utilized include poly(styrene-acrylate) resins, crosslinked, for example, from about 25 percent to about 70 percent, poly(styrene-acrylate) resins, poly(styrene-methacrylate) resins, crosslinked poly(styrene-methacrylate) resins, poly(styrene-butadiene) resins, crosslinked poly(styrene-butadiene) resins, alkali sulfonated-polyester resins, branched alkali sulfonated-polyester resins, alkali sulfonated-polyimide resins, branched alkali sulfonated-polyimide resins, alkali sulfonated poly(styrene-acrylate) resins, crosslinked alkali sulfonated poly(styrene-acrylate) resins, poly(styrene-methacrylate) resins, crosslinked alkali sulfonated-poly(styrene-methacrylate) resins, alkali sulfonated-poly(styrene-butadiene) resins, and crosslinked alkali sulfonated poly(styrene-butadiene) resins. Alkali sulfonated polyester resins may be useful in embodiments, such as the metal or alkali salts of copoly(ethylene-terephthalate)-copoly(ethylene-5-sulfo-isophthalate), copoly(propylene-terephthalate)-copoly(propylene-5-sulfo-isophthalate), copoly(diethylene-terephthalate)-copoly(diethylene-5-sulfo-isophthalate), copoly(propylene-diethylene-terephthalate)-copoly(propylene-diethylene-5-sulfoisophthalate), copoly(propylene-butylene-terephthalate)-copoly(propylene-butylene-5-sulfo -isophthalate), copoly(propoxylated bisphenol-A-fumarate)-copoly(propoxylated bisphenol A-5-sulfo-isophthalate), copoly(ethoxylated bisphenol-A-fumarate)-copoly(ethoxylated bisphenol-A-5-sulfo-

isophthalate), and copoly(ethoxylated bisphenol-A-maleate)-copoly(ethoxylated bisphenol-A-5-sulfo-isophthalate), and wherein the alkali metal is, for example, a sodium, lithium or potassium ion.

[0024] The amorphous resin can possess various glass transition temperatures (T_g) of, for example, from about 40° C to about 100° C, in embodiments from about 50° C to about 70° C. The crystalline resin may have a number average molecular weight (M_n), for example, from about 1,000 to about 50,000, in embodiments from about 2,000 to about 25,000, and a weight average molecular weight (M_w) of, for example, from about 2,000 to about 100,000, in embodiments from about 3,000 to about 80,000, as determined by Gel Permeation Chromatography (GPC) using polystyrene standards. The molecular weight distribution (M_w/M_n) of the crystalline resin may be, for example, from about 2 to about 6, in embodiments from about 2 to about 4.

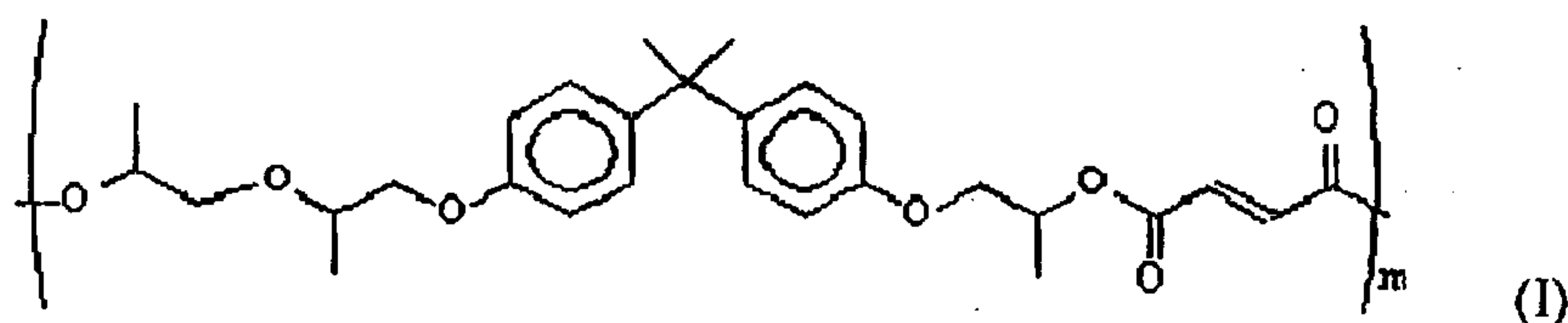
[0025] Examples of other suitable toner resins or polymers which may be utilized include, but are not limited to, poly(styrene-butadiene), poly(methylstyrene-butadiene), poly(methyl methacrylate-butadiene), poly(ethyl methacrylate-butadiene), poly(propyl methacrylate-butadiene), poly(butyl methacrylate-butadiene), poly(methyl acrylate-butadiene), poly(ethyl acrylate-butadiene), poly(propyl acrylate-butadiene), poly(butyl acrylate-butadiene), poly(styrene-isoprene), poly(methylstyrene-isoprene), poly(methyl methacrylate-isoprene), poly(ethyl methacrylate-isoprene), poly(propyl methacrylate-isoprene), poly(butyl methacrylate-isoprene), poly(methyl acrylate-isoprene), poly(ethyl acrylate-isoprene), poly(propyl acrylate-isoprene), poly(butyl acrylate-isoprene); poly(styrene-propyl acrylate), poly(styrene-butyl acrylate), poly(styrene-butadiene-acrylic acid), poly(styrene-butadiene-methacrylic acid), poly(styrene-butadiene-

acrylonitrile-acrylic acid), poly(styrene-butyl acrylate-acrylic acid), poly(styrene-butyl acrylate-methacrylic acid), poly(styrene-butyl acrylate-acrylonitrile), and poly(styrene-butyl acrylate-acrylonitrile-acrylic acid), and combinations thereof. The polymer may be block, random, or alternating copolymers.

[0026] In embodiments, an unsaturated polyester resin may be utilized as a toner resin.

Examples of such resins include those disclosed in U.S. Patent No. 6,063,827, the disclosure of which is hereby incorporated by reference in its entirety. Exemplary unsaturated polyester resins include, but are not limited to, poly(propoxylated bisphenol co-fumarate), poly(ethoxylated bisphenol co-fumarate), poly(butyloxyated bisphenol co-fumarate), poly(co-propoxylated bisphenol co-ethoxylated bisphenol co-fumarate), poly(1,2-propylene fumarate), poly(propoxylated bisphenol co-maleate), poly(ethoxylated bisphenol co-maleate), poly(butyloxyated bisphenol co-maleate), poly(co-propoxylated bisphenol co-ethoxylated bisphenol co-maleate), poly(1,2-propylene maleate), poly(propoxylated bisphenol co-itaconate), poly(ethoxylated bisphenol co-itaconate), poly(butyloxyated bisphenol co-itaconate), poly(co-propoxylated bisphenol co-ethoxylated bisphenol co-itaconate), poly(1,2-propylene itaconate), and combinations thereof.

[0027] In embodiments, a suitable polyester resin may be a poly(propoxylated bisphenol A co-fumarate) resin having the following formula (I):



wherein m may be from about 5 to about 1000, in embodiments from about 10 to about 500, in other embodiments from about 15 to about 200.

[0028] An example of a linear propoxylated bisphenol A fumarate resin which may be utilized as a toner resin is available under the trade name SPARII from Resana S/A Industrias Quimicas, Sao Paulo Brazil. Other propoxylated bisphenol A fumarate resins that may be utilized and are commercially available include GTUF and FPESL-2 from Kao Corporation, Japan, and EM181635 from Reichhold, Research Triangle Park, North Carolina and the like.

[0029] One, two, or more toner resins may be used. In embodiments where two or more toner resins are used, the toner resins may be in any suitable ratio (e.g., weight ratio) such as for instance about 10% (first resin)/90% (second resin) to about 90% (first resin)/10% (second resin).

[0030] In embodiments the resin may possess acid groups which, in embodiments, may be present at the terminal of the resin. Acid groups which may be present include carboxylic acid groups, and the like. The number of carboxylic acid groups may be controlled by adjusting the materials utilized to form the resin and reaction conditions.

[0031] In embodiments, the resin may be a polyester resin having an acid number from about 2mg KOH/g of resin to about 200 mg KOH/g of resin, in embodiments from about 5 mg KOH/g of resin to about 50 mg KOH/g of resin. The acid containing resin may be dissolved in tetrahydrofuran solution. The acid number may be detected by titration with KOH/ methanol solution containing phenolphthalein as the indicator. The acid number may then be calculated based on the equivalent amount of KOH/methanol required to neutralize all the acid groups on the resin identified as the end point of the titration.

[0032] In embodiments, a pre-made resin may be utilized to form the resin emulsion.

Basic agent

[0033] Once obtained, the resin may be melt-mixed at an elevated temperature, and base or basic agent may be added thereto. The base may be a solid or, in embodiments, added in the form of an aqueous solution. In embodiments, an aqueous alkaline solution utilized in forming a resin emulsion in accordance with the present disclosure includes water, in embodiments deionized water (DIW), and at least one basic agent to provide the aqueous alkaline solution with an alkaline pH. In embodiments, the basic agent is used to neutralize acid groups in the resins, so a basic agent herein may also be referred to as a "basic neutralization agent." Any suitable basic neutralization reagent may be used in accordance with the present disclosure. In embodiments, suitable basic neutralization agents include both inorganic basic agents and organic basic agents. Exemplary basic agents include ammonium hydroxide, potassium hydroxide, sodium hydroxide, sodium carbonate, sodium bicarbonate, lithium hydroxide, potassium carbonate, organoamines such as triethyl amine, combinations thereof, and the like.

[0034] The basic agent may be present in an amount of from about 0.001 % by weight to 100% (pure basic agent) by weight of the aqueous alkaline solution, in embodiments from about 0.01% by weight to 100 % by weight of the aqueous alkaline solution, in embodiments from about 0.001% by weight to 10 % by weight of the aqueous alkaline solution, in embodiments from about 0.01% by weight to 1 % by weight of the aqueous alkaline solution, or in embodiments from about 50% to 100% by weight of the aqueous alkaline solution.

[0035] Utilizing the above basic neutralization agent in combination with a resin possessing acid groups, a neutralization ratio of from about 50% to about 300% may be

achieved, in embodiments from about 70 % to about 200 %. In embodiments, the neutralization ratio may be calculated using the following equation:

Neutralization ratio in an equivalent amount of $10\% \text{NH}_3/\text{resin(g)}/\text{resin acid value}/0.303*100$.

[0036] As noted above, the basic neutralization agent may be added to a resin possessing acid groups. The addition of the basic neutralization agent may thus raise the pH of an emulsion including a resin possessing acid groups to from about 5 to about 9, in embodiments from about 6 to about 8. The neutralization of the acid groups may, in embodiments, enhance formation of the emulsion.

Surfactants

[0037] In embodiments, the process of the present disclosure optionally includes adding a surfactant before, during, or after, melt-mixing the resin at an elevated temperature. In embodiments, the surfactant may be added after melt-mixing the resin at an elevated temperature. Where utilized, a resin emulsion may include one, two, or more surfactants. The surfactants may be selected from ionic surfactants and nonionic surfactants. Anionic surfactants and cationic surfactants are encompassed by the term "ionic surfactants." In embodiments, the surfactant may be added as an aqueous solution with a concentration from about 5% to 100% (pure surfactant) by weight, or from about 30% to 100% by weight. In embodiments, the surfactant may be utilized so that it is present in an amount of from about 0.01% to about 20% by weight of the resin, for example from about 0.1% to about 10% by weight of the resin, in embodiments from about 1% to about 8% by weight of the resin.

[0038] Examples of nonionic surfactants that can be utilized for the processes illustrated herein and that may be included in the emulsion are, for example, polyacrylic acid, methalose, methyl cellulose, ethyl cellulose, propyl cellulose, hydroxy ethyl cellulose, carboxy methyl cellulose, polyoxyethylene cetyl ether, polyoxyethylene lauryl ether, polyoxyethylene octyl ether, polyoxyethylene octylphenyl ether, polyoxyethylene oleyl ether, polyoxyethylene sorbitan monolaurate, polyoxyethylene stearyl ether, polyoxyethylene nonylphenyl ether, dialkylphenoxy poly(ethyleneoxy) ethanol, available from Rhone-Poulenc as IGEPAL CA-210™, IGEPAL CA-520™, IGEPAL CA-720™, IGEPAL CO-890™, IGEPAL CO-720™, IGEPAL CO-290™, IGEPAL CA-210™, ANTAROX 890™ and ANTAROX 897™. Other examples of suitable nonionic surfactants include a block copolymer of polyethylene oxide and polypropylene oxide, including those commercially available as SYNPERONIC PE/F, in embodiments SYNPERONIC PE/F 108.

[0039] Anionic surfactants which may be utilized include sulfates and sulfonates, sodium dodecylsulfate (SDS), sodium dodecylbenzene sulfonate, sodium dodecyl-naphthalene sulfonate, dialkyl benzene sulfates and sulfonates, acids such as abietic acid available from Aldrich, NEOGEN R™, NEOGEN SC™ obtained from Daiichi Kogyo Seiyaku, combinations thereof, and the like. Other suitable anionic surfactants include, in embodiments, DOWFAX™ 2A1, an alkyldiphenyloxide disulfonate from The Dow Chemical Company, and/or TAYCA POWER BN2060 from Tayca Corporation (Japan), which are branched sodium dodecyl benzene sulfonates. Combinations of these surfactants and any of the foregoing anionic surfactants may be utilized in embodiments.

[0040] Examples of the cationic surfactants, which are usually positively charged, include, for example, alkylbenzyl dimethyl ammonium chloride, dialkyl benzenealkyl ammonium chloride, lauryl trimethyl ammonium chloride, alkylbenzyl methyl ammonium chloride, alkyl benzyl dimethyl ammonium bromide, benzalkonium chloride, cetyl pyridinium bromide, C₁₂, C₁₅, C₁₇ trimethyl ammonium bromides, halide salts of quaternized polyoxyethylalkylamines, dodecylbenzyl triethyl ammonium chloride, MIRAPOL™ and ALKAQUAT™, available from Alkaril Chemical Company, SANIZOL™ (benzalkonium chloride), available from Kao Chemicals, and the like, and mixtures thereof.

Processing

[0041] As noted above, the present process includes melt mixing a resin at an elevated temperature, wherein an organic solvent is not utilized in the process. More than one resin may be utilized in forming the aqueous emulsion. The resin may be an amorphous resin, a crystalline resin, or a combination thereof. In embodiments, the resin may be an amorphous resin and the elevated temperature is a temperature above the glass transition temperature of the resin. In other embodiments, the resin may be a crystalline resin and the elevated temperature is a temperature above the melting point of the resin. In further embodiments, the resin may be a mixture of amorphous and crystalline resins and the temperature is above the glass transition temperature of the mixture.

[0042] Thus, in embodiments, the process of making the aqueous emulsion includes heating at least one resin to an elevated temperature, stirring the mixture, and, while maintaining the temperature at the elevated temperature, metering aqueous alkaline

solution, optional surfactant and/or water into the mixture until phase inversion occurs to form a phase inversed aqueous emulsion.

[0043] In embodiments, a surfactant may be added to the one or more ingredients of the resin composition before, during, or after melt-mixing, thereby enhancing formation of the phase inversed emulsion of the present disclosure. In embodiments, a surfactant may be added before, during, or after the addition of the basic agent. In embodiments, the surfactant may be added prior to the addition of the basic agent. In other embodiments, water may be subsequently added in forming the emulsion. The addition of aqueous alkaline solution, optional surfactant and/or water forms an emulsion including a disperse phase possessing droplets of the surfactant and/or water composition and a continuous phase including the molten ingredients of the resin.

[0044] In embodiments, a phase inversed emulsion may be formed. Phase inversion can be accomplished by continuing to add the aqueous alkaline solution, optional surfactant and/or water compositions to create a phase inversed emulsion including a disperse phase including droplets possessing the molten ingredients of the resin composition and a continuous phase including the surfactant and/or water composition.

[0045] In embodiments, a process of the present disclosure may include heating one or more ingredients of a resin composition to an elevated temperature, stirring the resin composition, and, while maintaining the temperature at the elevated temperature, adding the base, optionally in an aqueous alkaline solution, and optional surfactant into the mixture to enhance formation of the emulsion including a disperse phase and a continuous phase including the resin composition, and continuing to add the aqueous

alkaline solution and optional surfactant until phase inversion occurs to form the phase inversed emulsion.

[0046] In the above-mentioned heating, the heating to an elevated temperature may be from about 30°C to about 300°C, in embodiments from about 50°C to about 200°C, in other embodiments from about 70°C to about 150°C. The heating need not be held at a constant temperature, but may be varied. For example, the heating may be slowly or incrementally increased during heating until a desired temperature is achieved.

[0047] While the temperature is maintained in the aforementioned range, the aqueous alkaline composition and optional surfactant may be metered into the heated mixture at least until phase inversion is achieved. In other embodiments, the aqueous alkaline composition and optional surfactant may be metered into the heated mixture, followed by the addition of an aqueous solution, in embodiments deionized water, until phase inversion is achieved.

[0048] Stirring may be utilized to enhance formation of the phase inversed emulsion.

Any suitable stirring device may be utilized. The stirring need not be at a constant speed, but may be varied. For example, as the heating of the mixture becomes more uniform, the stirring rate may be increased. In embodiments, the stirring may be at from about 10 revolutions per minute (rpm) to about 5,000 rpm, in embodiments from about 20 rpm to about 2,000 rpm, in other embodiments from about 50 rpm to about 1,000 rpm. In embodiments, a homogenizer (that is, a high shear device), may be utilized to form the phase inversed emulsion, but in other embodiments, the process of the present disclosure may take place without the use of a homogenizer. Where utilized, a homogenizer may operate at a rate of from about 3,000 rpm to about 10,000 rpm.

[0049] In embodiments, the process of the present disclosure may include stirring at a rate of from about 50 rpm to about 200 rpm during heating to the molten state, and stirring at a rate of from about 600 rpm to about 1,000 rpm during the addition of any surfactant and the aqueous alkaline composition to perform the phase inversion.

[0050] As noted above, in accordance with the present disclosure, an aqueous alkaline solution may be added to the resin after it has been melt mixed. The addition of an aqueous alkaline solution may be useful, in embodiments, where the resin utilized possesses acid groups. The aqueous alkaline solution may neutralize the acidic groups of the resin, thereby enhancing the formation of the phase-inversed emulsion and formation of particles suitable for use in forming toner compositions.

[0051] Prior to addition, the basic neutralization agent may be at any suitable temperature, including room temperature of from about 20° C to about 25° C, or an elevated temperature, for example, the elevated temperature mentioned above.

[0052] In embodiments, the basic neutralization agent and optional surfactant may be added at a rate of from about 0.01% to about 10% by weight of the resin every 10 minutes, in embodiments from about 0.5% to about 5% by weight of the resin every 10 minutes, in other embodiments from about 1% to about 4% by weight of the resin every 10 minutes. The rate of addition of the basic neutralization agent and optional surfactant need not be constant, but can be varied. Thus, for example, for a 700 gram toner resin, the aqueous alkaline composition and optional surfactant may be added at a rate of from about 0.07 gram to about 70 grams every 10 minutes, in embodiments from about 3.5 grams to about 35 grams every 10 minutes, in other embodiments from about 7 grams to about 28 grams every 10 minutes.

[0053] In embodiments, where the process further includes adding water after the addition of basic neutralization agent and optional surfactant, the water may be metered into the mixture at a rate of about 0.01% to about 10% by weight of the resin every 10 minutes, in embodiments from about 0.5% to about 5% by weight of the resin every 10 minutes, in other embodiments from about 1% to about 4% by weight of the resin every 10 minutes. The rate of water addition need not be constant, but can be varied. Thus, for example for a 700 gram mixture of resins and surfactant(s), the water may be added at a rate of from about 0.07 gram to about 70 grams every 10 minutes, in embodiments from about 3.5 to about 35 grams every 10 minutes, in other embodiments from about 7 to about 28 grams every 10 minutes.

[0054] Although the point of phase inversion may vary depending on the components of the emulsion, the temperature of heating, the stirring speed, and the like, phase inversion may occur when basic neutralization agent, optional surfactant, and optional water has been added so that the resulting resin is present in an amount from about 30% to about 70% by weight of the emulsion, in embodiments from about 35% to about 65% by weight of the emulsion, in other embodiments from about 40% to about 60% by weight of the emulsion.

[0055] At phase inversion, the resin particles become emulsified and dispersed within the aqueous phase. That is, an oil-in-water emulsion of the resin particles in the aqueous phase is formed. Phase inversion may be confirmed by, for example, measuring via any of the techniques described in, for example, Z. Yang et al., "Preparations of Waterborne Dispersions of Epoxy Resin by the Phase-Inversion Emulsification Technique," Colloid Polym Sci, vol. 278, pgs 1164-1171 (2000), incorporated herein by reference.

[0056] The aqueous emulsion is formed, for example, by a process involving phase inversion. Such method permits the emulsion to be formed at temperatures avoiding premature crosslinking of the resin of the emulsion.

[0057] Following phase inversion, additional surfactant, water, and/or aqueous alkaline solution may optionally be added to dilute the phase inverted emulsion, although this is not required. Any additional surfactant, water, or aqueous alkaline solution may be added at a more rapid rate than the metered rate above. Following phase inversion, the phase inverted emulsion may be cooled to room temperature, for example from about 20°C to about 25°C.

[0058] The emulsified resin particles in the aqueous medium may have a submicron size, for example of about 1 μm or less, in embodiments about 500 nm or less, such as from about 10 nm to about 500 nm, in embodiments from about 50 nm to about 400 nm, in other embodiments from about 100 nm to about 300 nm, in some embodiments about 200 nm.

[0059] In accordance with the present disclosure, it has been found that the processes herein may produce emulsified resin particles that retain the same molecular weight properties of the starting resin, in embodiments bulk or pre-made resin utilized in forming the emulsion.

[0060] In further embodiments, the present invention also provides processes for producing toner particles without an organic solvent. In embodiments, a process of the present disclosure includes melt mixing a resin at an elevated temperature in the absence of an organic solvent as discussed above; optionally adding a surfactant either before, during or after melt mixing the resin; optionally adding one or more additional

ingredients of a toner composition such as colorant, wax, and other additives; adding a basic agent and water; performing a phase inversion to create a phase inversed emulsion including a disperse phase comprising toner-sized droplets including the molten resin and the optional ingredients of the toner composition; and solidifying the toner-sized droplets to result in toner particles.

[0061] In embodiments, the optional additional ingredients of a toner composition including colorant, wax, and other additives may be added before, during or after the melt mixing the resin. The additional ingredients can be added before, during or after the addition of the optional surfactant. In further embodiments, the colorant may be added before the addition of the optional surfactant.

[0062] "Toner-sized" indicates that the droplets have a size comparable to toner particles used in xerographic printers and copiers, wherein "toner sized" in embodiments indicates a volume average diameter of, for example, from about 4 μm to about 25 μm , in embodiments from about 3 μm to about 15 μm , in other embodiments from about 3 μm to about 10 μm . As it may be difficult to directly measure droplet size in the emulsion, the droplet size in the emulsion may be determined by solidifying the toner-sized droplets and then measuring the resulting toner particles.

[0063] Because the droplets may be toner-sized in the disperse phase of the phase inversed emulsion, in embodiments there may be no need to aggregate the droplets to increase the size thereof prior to solidifying the droplets to result in toner particles. However, such aggregation/coalescence of the droplets is optional and can be employed in embodiments of the present disclosure, including the aggregation/coalescence

techniques described in, for example, U.S. Patent Application Publication No. 2007/0088117, the disclosure of which is hereby incorporated by reference in its entirety.

Catalyst

[0064] In embodiments, the phase inversed emulsion may also have included therein a hardener or catalyst for crosslinking the resin. The catalyst may be a thermal crosslinking catalyst, for example a catalyst that initiates crosslinking at temperatures of, for example, about 160°C or less such as about 50°C to about 160°C or from about 100°C to about 160°C. Examples of suitable crosslinking catalysts (to crosslink for instance an epoxy resin) include, for example, blocked acid catalysts such as available from King Industries under the name NACURE, for example including NACURE SUPER XC-7231 and NACURE XC-AD230. Other known catalysts to initiate crosslinking may also be used, for example including catalysts such as aliphatic amines and alicyclic amines, for example bis(4-aminocyclohexyl)methane, bis(aminomethyl)cyclohexane, m-xylenediamine, and 3,9-bis(3-aminopropyl)-2,4,8, 10-tetraspiro[5,5]undecane; aromatic amines, for example metaphenylene diamine, diaminodiphenylmethane, and diaminodiphenyl sulfone; tertiary amines and corresponding salts, for example benzyldimethylamine, 2,4,6-tris(dimethylaminomethyl)phenol, 1,8-diazabicyclo(5,4,0)undecene-7, 1,5-diazabicyclo(4,3,0)nonene-7; aromatic acid anhydrides, for example phthalic anhydride, trimellitic anhydride, and pyromellitic anhydride; alicyclic carboxylic anhydrides, for example tetrahydrophthalic anhydride, methyltetrahydrophthalic anhydride, hexahydrophthalic anhydride, methylhexahydrophthalic anhydride, methylenedimethylenetetrahydrophthalic anhydride,

dodecenylsuccinic anhydride, and trialkyltetrahydrophthalic anhydrides; polyvalent phenols, for example catechol, resorcinol, hydroquinone, bisphenol F, bisphenol A, bisphenol S, biphenol, phenol novolac compounds, cresol novolac compounds, novolac compounds of divalent phenols such as bisphenol A, trishydroxyphenylmethane, aralkylpolyphenols, and dicyclopentadiene polyphenols; imidazoles and salts thereof, for example 2-methylimidazole, 2-ethyl-4-methylimidazole, and 2-phenylimidazole; BF_3 complexes of amine; Bronsted acids, for example aliphatic sulfonium salts and aromatic sulfonium salts; dicyandiamide; organic acid hydrazides, for example adipic acid dihydrazide and phthalic acid dihydrazide; resols; polycarboxylic acids, for example adipic acid, sebacic acid, terephthalic acid, trimellitic acid, polyester resins containing carboxylic groups; organic phosphines; combinations thereof and the like. The catalyst may be included in an amount of from, for example, about 0.01% to about 20% by weight of the phase inversed emulsion, such as from about 0.05% to about 10% or from about 0.1% to about 10% by weight of the phase inversed emulsion.

[0065] If a catalyst is used, the catalyst may be incorporated into the toner composition by for instance melt mixing prior to the phase inversion. In other embodiments, the catalyst may be added to the toner composition subsequent to the phase inversion.

[0066] In embodiments, the phase inversed emulsion has good storage stability, for example being able to remain substantially stable over time at room temperature conditions.

Toner

[0067] The emulsion thus formed as described above may be utilized to form toner compositions. Such toner compositions may include optional colorants, waxes, and other additives. Toners may be formed utilizing any method within the purview of those skilled in the art.

Colorants

[0068] As the colorant to be added, various known suitable colorants, such as dyes, pigments, mixtures of dyes, mixtures of pigments, mixtures of dyes and pigments, and the like, may be included in the toner. The colorant may be included in the toner in an amount of, for example, about 0.1 to about 35 percent by weight of the toner, or from about 1 to about 20 weight percent of the toner, or from about 3 to about 15 percent by weight of the toner.

[0069] As examples of suitable colorants, mention may be made of carbon black like REGAL 330[®]; magnetites, such as Mobay magnetites MO8029[™], MO8060[™]; Columbian magnetites; MAPICO BLACKS[™] and surface treated magnetites; Pfizer magnetites CB4799[™], CB5300[™], CB5600[™], MCX6369[™]; Bayer magnetites, BAYFERROX 8600[™], 8610[™]; Northern Pigments magnetites, NP-604[™], NP-608[™]; Magnox magnetites TMB-100[™], or TMB-104[™]; and the like. As colored pigments, there can be selected cyan, magenta, yellow, red, green, brown, blue or mixtures thereof. Generally, cyan, magenta, or yellow pigments or dyes, or mixtures thereof, are used. The pigment or pigments are generally used as water based pigment dispersions.

[0070] Specific examples of pigments include SUNSPERSE 6000, FLEXIVERSE and AQUATONE water based pigment dispersions from SUN Chemicals, HELIOGEN BLUE L6900™, D6840™, D7080™, D7020™, PYLAM OIL BLUE™, PYLAM OIL YELLOW™, PIGMENT BLUE 1™ available from Paul Uhlich & Company, Inc., PIGMENT VIOLET 1™, PIGMENT RED 48™, LEMON CHROME YELLOW DCC 1026™, E.D. TOLUIDINE RED™ and BON RED C™ available from Dominion Color Corporation, Ltd., Toronto, Ontario, NOVAPERM YELLOW FGL™, HOSTAPERM PINK E™ from Hoechst, and CINQUASIA MAGENTA™ available from E.I. DuPont de Nemours & Company, and the like. Generally, colorants that can be selected are black, cyan, magenta, or yellow, and mixtures thereof. Examples of magentas are 2,9-dimethyl-substituted quinacridone and anthraquinone dye identified in the Color Index as CI 60710, CI Dispersed Red 15, diazo dye identified in the Color Index as CI 26050, CI Solvent Red 19, and the like. Illustrative examples of cyans include copper tetra(octadecyl sulfonamido) phthalocyanine, x-copper phthalocyanine pigment listed in the Color Index as CI 74160, CI Pigment Blue, and Anthrathrene Blue, identified in the Color Index as CI 69810, Special Blue X-2137, and the like. Illustrative examples of yellows are diarylide yellow 3,3-dichlorobenzidene acetoacetanilides, a monoazo pigment identified in the Color Index as CI 12700, CI Solvent Yellow 16, a nitrophenyl amine sulfonamide identified in the Color Index as Foron Yellow SE/GLN, CI Dispersed Yellow 33 2,5-dimethoxy-4-sulfonanilide phenylazo-4'-chloro-2,5-dimethoxy acetoacetanilide, and Permanent Yellow FGL. Colored magnetites, such as mixtures of MAPICO BLACK™, and cyan components may also be selected as colorants. Other known colorants can be selected, such as Levanyl Black A-SF (Miles, Bayer) and Sunspers Carbon Black LHD

9303 (Sun Chemicals), and colored dyes such as Neopen Blue (BASF), Sudan Blue OS (BASF), PV Fast Blue B2G01 (American Hoechst), Sunspere Blue BHD 6000 (Sun Chemicals), Irgalite Blue BCA (Ciba-Geigy), Paliogen Blue 6470 (BASF), Sudan III (Matheson, Coleman, Bell), Sudan II (Matheson, Coleman, Bell), Sudan IV (Matheson, Coleman, Bell), Sudan Orange G (Aldrich), Sudan Orange 220 (BASF), Paliogen Orange 3040 (BASF), Ortho Orange OR 2673 (Paul Uhlich), Paliogen Yellow 152, 1560 (BASF), Lithol Fast Yellow 0991K (BASF), Paliotol Yellow 1840 (BASF), Neopen Yellow (BASF), Novopern Yellow FG 1 (Hoechst), Permanent Yellow YE 0305 (Paul Uhlich), Lumogen Yellow D0790 (BASF), Sunspere Yellow YHD 6001 (Sun Chemicals), Suco-Gelb L1250 (BASF), Suco-Yellow D1355 (BASF), Hostapern Pink E (American Hoechst), Fanal Pink D4830 (BASF), Cinquasia Magenta (DuPont), Lithol Scarlet D3700 (BASF), Toluidine Red (Aldrich), Scarlet for Thermoplast NSD PS PA (Ugine Kuhlmann of Canada), E.D. Toluidine Red (Aldrich), Lithol Rubine Toner (Paul Uhlich), Lithol Scarlet 4440 (BASF), Bon Red C (Dominion Color Company), Royal Brilliant Red RD-8192 (Paul Uhlich), Oracet Pink RF (Ciba-Geigy), Paliogen Red 3871K (BASF), Paliogen Red 3340 (BASF), Lithol Fast Scarlet L4300 (BASF), combinations of the foregoing, and the like.

Wax

[0071] Optionally, a wax may also be included with the resin emulsion, or combined with the resin and a colorant in forming toner particles. When included, the wax may be present in an amount of, for example, from about 1 weight percent to about 30 weight

percent of the toner particles, in embodiments from about 5 weight percent to about 25 weight percent of the toner particles.

[0072] Waxes that may be selected include waxes having, for example, a weight average molecular weight of from about 500 to about 20,000, in embodiments from about 1,000 to about 10,000. Waxes that may be used include, for example, polyolefins such as polyethylene, polypropylene, and polybutene waxes such as commercially available from Allied Chemical and Petrolite Corporation, for example POLYWAX™ polyethylene waxes from Baker Petrolite, wax emulsions available from Michaelman, Inc. and the Daniels Products Company, EPOLENE N-15™ commercially available from Eastman Chemical Products, Inc., and VISCOL 550-P™, a low weight average molecular weight polypropylene available from Sanyo Kasei K. K.; plant-based waxes, such as carnauba wax, rice wax, candelilla wax, sumacs wax, and jojoba oil; animal-based waxes, such as beeswax; mineral-based waxes and petroleum-based waxes, such as montan wax, ozokerite, ceresin, paraffin wax, microcrystalline wax, and Fischer-Tropsch wax; ester waxes obtained from higher fatty acid and higher alcohol, such as stearyl stearate and behenyl behenate; ester waxes obtained from higher fatty acid and monovalent or multivalent lower alcohol, such as butyl stearate, propyl oleate, glyceride monostearate, glyceride distearate, and pentaerythritol tetra behenate; ester waxes obtained from higher fatty acid and multivalent alcohol multimers, such as diethyleneglycol monostearate, dipropyleneglycol distearate, diglyceryl distearate, and triglyceryl tetrastearate; sorbitan higher fatty acid ester waxes, such as sorbitan monostearate, and cholesterol higher fatty acid ester waxes, such as cholesteryl stearate. Examples of functionalized waxes that may be used include, for example, amines, amides, for example AQUA SUPERSLIP

6550™, SUPERSLIP 6530™ available from Micro Powder Inc., fluorinated waxes, for example POLYFLUO 190™, POLYFLUO 200™, POLYSILK 19™, POLYSILK 14™ available from Micro Powder Inc., mixed fluorinated, amide waxes, for example MICROSPERSION 19™ also available from Micro Powder Inc., imides, esters, quaternary amines, carboxylic acids or acrylic polymer emulsion, for example JONCRYL 74™, 89™, 130™, 537™, and 538™, all available from SC Johnson Wax, and chlorinated polypropylenes and polyethylenes available from Allied Chemical and Petrolite Corporation and SC Johnson wax. Mixtures of waxes may also be used. Waxes may be included as, for example, fuser roll release agents.

Toner Preparation

[0073] In embodiments, a toner prepared with the resin emulsion of the present disclosure may include a resin, optionally a colorant (the toner composition is referred to as "colorless" or "clear" where a colorant is not used), optionally a wax, and optionally a charge control agent. In embodiments, prior to performing the phase inversion described above, all of the toner ingredients, for example resin, aqueous alkaline solution, wax, colorant, and charge control agent, may be combined so that toner particles are formed upon phase inversion. In other embodiments, the phase inversion may be performed as described above to produce a resin emulsion, with the remaining toner ingredients added subsequent to the emulsion to form toner particles by any suitable manner within the purview of one skilled in the art.

[0074] Thus, in embodiments, prior to performing the phase inversion, "internal" toner ingredients, including resin, colorant, wax, and internal charge control agent, may be

present in the mixture and it is optional to include the "external" toner ingredients prior to performing the phase inversion. The terms "internal" and "external" refer to whether the toner ingredients are found throughout the resulting toner particles or just on the surface thereof. In embodiments, prior to performing the phase inversion, the ingredients of the toner composition may be blended by melt-mixing at any suitable temperature of from about 60° C to about 200° C, time of from about 10 minutes to about 10 hours, and stirring speed of from about 100 rpm to about 800 rpm.

[0075] For the phase inversed emulsion, the ingredient(s) of the toner composition may be present in an amount by weight of from about 5% to about 35% of the phase inversed emulsion, in embodiments from about 5% to about 20% of the phase inversed emulsion, in other embodiments from about 10% to about 20% of the phase inversed emulsion.

[0076] In other embodiments, toners may be prepared by a process that includes aggregating a mixture of a colorant, optionally a wax and any other desired or required additives, and the phase inversed emulsion including the resin, and then optionally coalescing the aggregated particles.

[0077] In embodiments, a method of making the toner particles including the resin may include admixing and heating the phase inversed emulsion of resin described above and a colorant dispersion, an optional wax dispersion and other additives and adding thereto an aqueous solution containing an aggregating agent, and optionally cooling and optionally adding the wax, and other additives. For example, the toner may be formed in a process including admixing the phase inversed emulsion of resins and a colorant dispersion at a temperature of from about 30°C to about 100°C, in embodiments from about 40°C to about 90°C, in other embodiments from about 45°C to about 80°C, and adding thereto an

aggregating agent solution until aggregated particles of a desired volume average diameter are achieved, cooling and isolating the resulting toner, optionally washing with water, and drying the toner. The aforementioned temperatures for aggregation may be from about 3°C to about 15°C below the glass transition temperature of the resin, for example from about 4°C to about 10°C below the glass transition temperature or from about 5°C to about 8°C below the glass transition temperature.

[0078] For forming toner particles, the solids content of the starting phase inversed resin emulsion may be from about 5% to about 50% of the phase inversed emulsion, in embodiments from about 5% to about 20% of the phase inversed emulsion, in other embodiments from about 10% to about 30% of the phase inversed emulsion. To achieve this solids content, the phase inversed emulsion may be diluted during formation as discussed above, or additional water may be added as discussed above to effect dilution during the toner particle formation process.

[0079] The dry toner particles, exclusive of external surface additives, may have a volume average diameter of about 3 to about 25 μm , from about 3 to about 12 μm or about 5 to about 10 μm . The particles may also have a geometric size distribution (GSD) (number and/or volume) of, for example, about 1.05 to about 1.35, such as about 1.10 to about 1.30 or about 1.15 to about 1.25. Herein, the geometric size distribution refers, for example, to the square root of D84 divided by D16, and is measured by a Coulter Counter. The particle diameters at which a cumulative percentage of, for example, 16 percent of particles are attained, refer to the volume and/or number D16 percent, and the particle diameters at which a cumulative percentage of 84 percent are attained are referred to as volume and/or number D84.

Aggregation and Coalescence

[0080] In embodiments, emulsion aggregation methods, for example wherein submicron sized particles of a binder resin in an emulsion are aggregated to toner particle size in the presence of an aggregating agent or coagulant, may be utilized to produce toner particles at temperatures of about 100°C or less, such as from about 30°C to about 100°C, in embodiments from about 40°C to about 90°C.

[0081] Any suitable aggregating agent may be utilized to form a toner. Suitable aggregating agents include, for example, halides such as chloride, bromide or iodide, or anions such as acetates, acetoacetates or sulfates, of vanadium, niobium, tantalum, chromium, molybdenum, tungsten, manganese, iron, ruthenium, cobalt, nickel, copper, zinc, cadmium and/or silver; aluminum salts such as aluminum sulfate, aluminum acetate, polyaluminum chloride and/or aluminum halides; mixtures thereof and the like. Alkali (II) metal salts, that is divalent alkali metal salts, that may be used as aggregating agents may include, for example, beryllium chloride, beryllium bromide, beryllium iodide, beryllium acetate, beryllium sulfate, magnesium chloride, magnesium bromide, magnesium iodide, magnesium acetate, magnesium sulfate, calcium chloride, calcium bromide, calcium iodide, calcium acetate, calcium sulfate, strontium chloride, strontium bromide, strontium iodide, strontium acetate, zinc acetate, strontium sulfate, barium chloride, barium bromide, barium iodide, or mixtures thereof.

[0082] The aggregating agent may be added to the mixture utilized to form a toner in an amount of, for example, from about 0.1% to about 8% by weight, in embodiments from about 0.2% to about 5% by weight, in other embodiments from about 0.5% to about 5%

by weight, of the resin in the mixture. This provides a sufficient amount of agent for aggregation.

[0083] In order to control aggregation and coalescence of the particles, in embodiments the aggregating agent may be metered into the mixture over time. For example, the agent may be metered into the mixture over a period of from about 5 to about 240 minutes, in embodiments from about 30 to about 200 minutes, although more or less time may be used as desired or required. The addition of the agent may also be done while the mixture is maintained under stirred conditions, in embodiments from about 50 rpm to about 1,000 rpm, in other embodiments from about 100 rpm to about 500 rpm, and elevated temperature as discussed above.

[0084] The particles may be permitted to aggregate and/or coalesce until a predetermined desired particle size is obtained. A predetermined desired size refers to the desired particle size to be obtained as determined prior to formation, and the particle size being monitored during the growth process until such particle size is reached. Samples may be taken during the growth process and analyzed, for example with a Coulter Counter, for average particle size. The aggregation/coalescence thus may proceed by maintaining the elevated temperature, or slowly raising the temperature to, for example, from about 30°C to about 100°C, and holding the mixture at this temperature for a time from about 0.5 hours to about 10 hours, in embodiments from about 1 hour to about 5 hours, while maintaining stirring, to provide the aggregated particles. Once the predetermined desired particle size is reached, then the growth process is halted. In embodiments, the predetermined desired particle size is within the toner particle size ranges mentioned above.

[0085] The growth and shaping of the particles following addition of the aggregation agent may be accomplished under any suitable conditions. For example, the growth and shaping may be conducted under conditions in which aggregation occurs separate from coalescence. For separate aggregation and coalescence stages, the aggregation process may be conducted under shearing conditions at an elevated temperature, for example of from about 40°C to about 90°C, in embodiments from about 45°C to about 80°C, which may be below the glass transition temperature of the resin as discussed above.

[0086] Following aggregation to the desired particle size, the particles may then be coalesced to the desired final shape, the coalescence being achieved by, for example, heating the mixture to a temperature of from about 50°C to about 105°C, in embodiments from about 65°C to about 100°C, which may be at or above the glass transition temperature of the resin, and/or increasing the stirring, for example to from about 400 rpm to about 1,000 rpm, in embodiments from about 500 rpm to about 800 rpm. Higher or lower temperatures may be used, it being understood that the temperature is a function of the resins used for the binder. Coalescence may be accomplished over a period of from about 0.01 to about 10 hours, in embodiments from about 0.1 to about 6 hours.

[0087] After aggregation and/or coalescence, the mixture may be cooled to room temperature, such as from about 20°C to about 25°C. The cooling may be rapid or slow, as desired. A suitable cooling method may include introducing cold water to a jacket around the reactor. After cooling, the toner particles may be optionally washed with water, and then dried. Drying may be accomplished by any suitable method for drying including, for example, freeze-drying.

Additives

[0088] In embodiments, the toner particles may also contain other optional additives, as desired or required. For example, the toner may include positive or negative charge control agents, for example in an amount of from about 0.1 to about 10 percent by weight of the toner, in embodiments from about 1 to about 3 percent by weight of the toner. Examples of suitable charge control agents include quaternary ammonium compounds inclusive of alkyl pyridinium halides; bisulfates; alkyl pyridinium compounds, including those disclosed in U.S. Patent No. 4,298,672, the disclosure of which is hereby incorporated by reference in its entirety; organic sulfate and sulfonate compositions, including those disclosed in U.S. Patent No. 4,338,390, the disclosure of which is hereby incorporated by reference in its entirety; cetyl pyridinium tetrafluoroborates; distearyl dimethyl ammonium methyl sulfate; aluminum salts such as BONTRON E84™ or E88™ (Hodogaya Chemical); combinations thereof, and the like.

[0089] There can also be blended with the toner particles external additive particles including flow aid additives, which additives may be present on the surface of the toner particles. Examples of these additives include metal oxides such as titanium oxide, silicon oxide, tin oxide, mixtures thereof, and the like; colloidal silicas, such as AEROSIL®, metal salts and metal salts of fatty acids inclusive of zinc stearate, aluminum oxides, cerium oxides, and mixtures thereof. Each of these external additives may be present in an amount of from about 0.1 percent by weight to about 5 percent by weight of the toner, in embodiments of from about 0.25 percent by weight to about 1 percent by weight of the toner. Suitable additives include those disclosed in U.S. Patent

Nos. 3,590,000, 3,800,588, and 6,214,507, the disclosures of each of which are hereby incorporated by reference in their entirety.

[0090] In embodiments, the dry toner particles, exclusive of external surface additives, may have the following characteristics:

[0091] (1) Volume average diameter (also referred to as "volume average particle diameter") of from about 3 to about 25 μm , in embodiments from about 5 to about 15 μm , in other embodiments from about 7 to about 12 μm .

[0092] (2) Number Average Geometric Size Distribution (GSD_n) and/or Volume Average Geometric Size Distribution (GSD_v) of from about 1.05 to about 1.45, in embodiments from about 1.1 to about 1.4.

[0093] (3) Circularity of from about 0.9 to about 1 (measured with, for example, a Sysmex FPIA 2100 analyzer).

[0094] In embodiments, the above toner particle characteristics may be determined subsequent to the solidifying the toner-sized droplets to result in the toner particles and after any optional processing, such as filtering.

[0095] The characteristics of the toner particles may be determined by any suitable technique and apparatus. Volume average particle diameter D_{50v} , GSD_v, and GSD_n may be measured by means of a measuring instrument such as a Beckman Coulter Multisizer 3, operated in accordance with the manufacturer's instructions. Representative sampling may occur as follows: a small amount of toner sample, about 1 gram, may be obtained and filtered through a 25 micrometer screen, then put in isotonic solution to obtain a concentration of about 10%, with the sample then run in a Beckman Coulter Multisizer 3.

Developers

[0096] The toner particles may be formulated into a developer composition. The toner particles may be mixed with carrier particles to achieve a two-component developer composition. The toner concentration in the developer may be from about 1% to about 25% by weight of the total weight of the developer, in embodiments from about 2% to about 15% by weight of the total weight of the developer.

Carriers

[0097] Examples of carrier particles that can be utilized for mixing with the toner include those particles that are capable of triboelectrically obtaining a charge of opposite polarity to that of the toner particles. Illustrative examples of suitable carrier particles include granular zircon, granular silicon, glass, steel, nickel, ferrites, iron ferrites, silicon dioxide, and the like. Other carriers include those disclosed in U.S. Patent Nos. 3,847,604, 4,937,166, and 4,935,326.

[0098] The selected carrier particles can be used with or without a coating. In embodiments, the carrier particles may include a core with a coating thereover which may be formed from a mixture of polymers that are not in close proximity thereto in the triboelectric series. The coating may include fluoropolymers, such as polyvinylidene fluoride resins, terpolymers of styrene, methyl methacrylate, and/or silanes, such as triethoxy silane, tetrafluoroethylenes, other known coatings and the like. For example, coatings containing polyvinylidene fluoride, available, for example, as KYNAR 301F™, and/or polymethylmethacrylate, for example having a weight average molecular weight of about 300,000 to about 350,000, such as commercially available from Soken, may be

used. In embodiments, polyvinylidene fluoride and polymethylmethacrylate (PMMA) may be mixed in proportions of from about 30 to about 70 weight % to about 70 to about 30 weight %, in embodiments from about 40 to about 60 weight % to about 60 to about 40 weight %. The coating may have a coating weight of, for example, from about 0.1 to about 5% by weight of the carrier, in embodiments from about 0.5 to about 2% by weight of the carrier.

[0099] In embodiments, PMMA may optionally be copolymerized with any desired comonomer, so long as the resulting copolymer retains a suitable particle size. Suitable comonomers can include monoalkyl, or dialkyl amines, such as a dimethylaminoethyl methacrylate, diethylaminoethyl methacrylate, diisopropylaminoethyl methacrylate, or t-butylaminoethyl methacrylate, and the like. The carrier particles may be prepared by mixing the carrier core with polymer in an amount from about 0.05 to about 10 percent by weight, in embodiments from about 0.01 percent to about 3 percent by weight, based on the weight of the coated carrier particles, until adherence thereof to the carrier core by mechanical impaction and/or electrostatic attraction.

[00100] Various effective suitable means can be used to apply the polymer to the surface of the carrier core particles, for example, cascade roll mixing, tumbling, milling, shaking, electrostatic powder cloud spraying, fluidized bed, electrostatic disc processing, electrostatic curtain, combinations thereof, and the like. The mixture of carrier core particles and polymer may then be heated to enable the polymer to melt and fuse to the carrier core particles. The coated carrier particles may then be cooled and thereafter classified to a desired particle size.

[00101] In embodiments, suitable carriers may include a steel core, for example of from about 25 to about 100 μm in size, in embodiments from about 50 to about 75 μm in size, coated with about 0.5% to about 10% by weight, in embodiments from about 0.7% to about 5% by weight, of a conductive polymer mixture including, for example, methylacrylate and carbon black using the process described in U.S. Patent Nos. 5,236,629 and 5,330,874.

[00102] The carrier particles can be mixed with the toner particles in various suitable combinations. The concentrations are may be from about 1% to about 20% by weight of the toner composition. However, different toner and carrier percentages may be used to achieve a developer composition with desired characteristics.

Imaging

[00103] The toners can be utilized for electrostatographic or xerographic processes, including those disclosed in U.S. Patent No. 4,295,990, the disclosure of which is hereby incorporated by reference in its entirety. In embodiments, any known type of image development system may be used in an image developing device, including, for example, magnetic brush development, jumping single-component development, hybrid scavengeless development (HSD), and the like. These and similar development systems are within the purview of those skilled in the art.

[00104] Imaging processes include, for example, preparing an image with a xerographic device including a charging component, an imaging component, a photoconductive component, a developing component, a transfer component, and a fusing component. In embodiments, the development component may include a developer prepared by mixing

a carrier with a toner composition described herein. The xerographic device may include a high speed printer, a black and white high speed printer, a color printer, and the like.

[00105] Once the image is formed with toners/developers via a suitable image development method such as any one of the aforementioned methods, the image may then be transferred to an image receiving medium such as paper and the like. In embodiments, the toners may be used in developing an image in an image-developing device utilizing a fuser roll member. Fuser roll members are contact fusing devices that are within the purview of those skilled in the art, in which heat and pressure from the roll may be used to fuse the toner to the image-receiving medium. In embodiments, the fuser member may be heated to a temperature above the fusing temperature of the toner, for example to temperatures of from about 70°C to about 210°C, in embodiments from about 80°C to about 205°C, in other embodiments from about 90°C to about 200°C, after or during melting onto the image receiving substrate.

[00106] In embodiments where the toner resin is crosslinkable, such crosslinking may be accomplished in any suitable manner. For example, the toner resin may be crosslinked during fusing of the toner to the substrate where the toner resin is crosslinkable at the fusing temperature. Crosslinking also may be effected by heating the fused image to a temperature at which the toner resin will be crosslinked, for example in a post-fusing operation. In embodiments, crosslinking may be effected at temperatures of from about 160°C or less, in embodiments from about 70°C to about 160°C, in other embodiments from about 80°C to about 140°C.

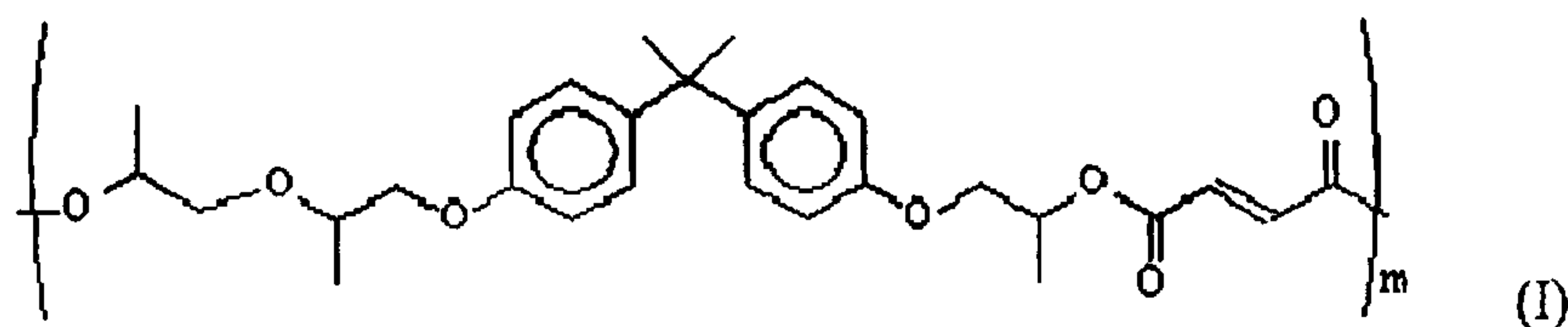
[00107] The following Examples are being submitted to illustrate embodiments of the present disclosure. These Examples are intended to be illustrative only and are not

intended to limit the scope of the present disclosure. Also, parts and percentages are by weight unless otherwise indicated. As used herein, "room temperature" refers to a temperature of from about 20 ° C to about 25° C.

EXAMPLES

EXAMPLE 1

[00108] A 2 Liter Buchi reactor was charged with about 500 grams of a poly(propoxylated bisphenol A co-fumarate) resin having the following formula:



wherein the molecular weight of the resin was about 12,500 (12.5K). The resin was heated to about 95 °C with stirring from about 20 rpm increased to about 1000 rpm, followed by addition of about 53.2 grams of anionic surfactant (DOWFAX™ 2A1, an alkyldiphenyloxide disulfonate from The Dow Chemical Company at about 47 wt%) at an addition rate of about 2 grams/minute. The maximum temperature reached was about 127° C. Thereafter, about 300 grams of deionized water (DIW) containing about 25.77 grams of about 10 wt% ammonium hydroxide was pumped into the reactor using a FMI lab pump at a rate of about 3 grams/minute. The amount of ammonium hydroxide was estimated based on the neutralization ratio according to the following equation:

Neutralization ratio in an equivalent amount of 10% NH₃/resin(g)/resin acid value/
0.303*100.

[00109] About 500 grams more water was then added to the above emulsion. The emulsion obtained had a particle size of about 191.3 nm (as seen in Figure 1) and a pH of about 7.33.

[00110] Gel permeation chromatography was conducted on the resulting dried emulsion and the original resin. A summary of the results obtained are set forth below in Table 1.

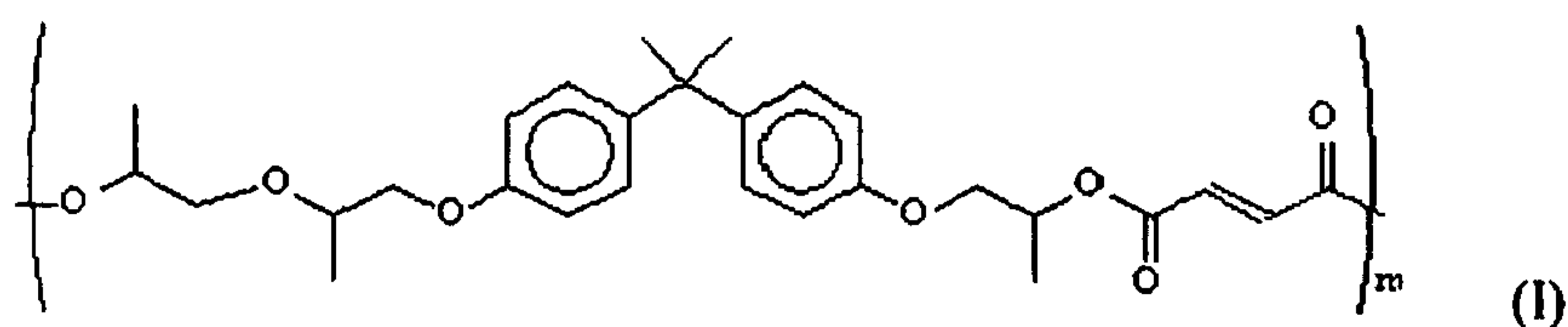
Table 1

Emulsion	Mw	Mn
Dried Example 1	12.1K	4.4K
Original resin	12.5K	4.4K

[00111] As can be seen in Table 1, no degradation of the resin occurred using the emulsification method of the present disclosure.

EXAMPLE 2

[00112] A 2 Liter Buchi reactor was charged with about 500 grams of a poly(propoxylated bisphenol A co-fumarate) resin having the following formula:

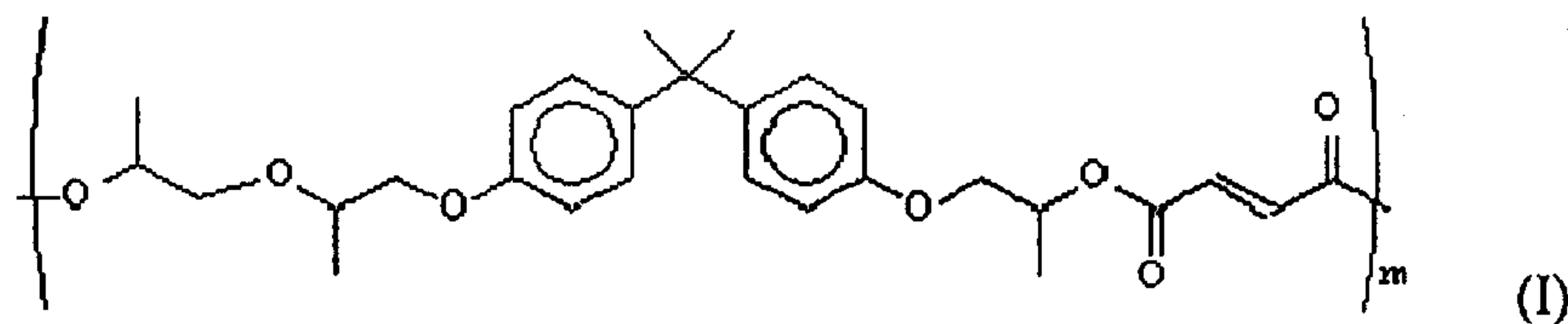


wherein the molecular weight of the resin was about 12.5K. The resin was heated to about 95 °C with stirring at about 20 rpm, which was increased to about 1000 rpm. About 26.6 grams of anionic surfactant (DOWFAX™ 2A1, an alkyl diphenyloxide disulfonate from The Dow Chemical Company at about 47 wt%), which was about half of the amount utilized in Example 1, was added at an addition rate of about 2 grams per minute. Thereafter, about 300 grams of deionized water (DIW) containing about 25.77 grams of about 10 wt% ammonium hydroxide was pumped into the reactor using a FMI lab pump at a rate of about 3 grams/minute. About 500 grams more water was then

added to the above emulsion. The emulsion obtained had a particle size of about 255.1 nm (the results of particle size and particle size distribution data are summarized in Figure 2).

COMPARATIVE EXAMPLE 1

[00113] Similar to Example 1, a 2 Liter Buchi reactor was charged with about 500 grams of a poly(propoxylated bisphenol A co-fumarate) resin having the following formula:



wherein the molecular weight of the resin was about 12.5K. The resin was heated to about 95 °C with stirring from about 20 rpm increased to about 1000 rpm, followed by addition of about 53.2 grams of anionic surfactant (DOWFAX™ 2A1, an alkyldiphenyloxide disulfonate from The Dow Chemical Company at about 47 wt%) at an addition rate about 2 grams/minute. About 300 grams of DIW was then pumped in using a FMI lab pump at a rate of about 3 grams/minute. This Example differed from Examples 1 and 2 above in that no ammonium hydroxide was added. The resin could not be emulsified without the use of ammonium hydroxide.

[00114] It will be appreciated that variations of the above-disclosed and other features and functions, or alternatives thereof, may be desirably combined into many other different systems or applications. Also that various presently unforeseen or unanticipated alternatives, modifications, variations or improvements therein may be subsequently made by those skilled in the art which are also intended to be encompassed by the

following claims. Unless specifically recited in a claim, steps or components of claims should not be implied or imported from the specification or any other claims as to any particular order, number, position, size, shape, angle, color, or material.

WHAT IS CLAIMED IS:

1. A process comprising:
melt mixing a resin in the absence of an organic solvent;
optionally adding a surfactant to the resin; and
adding to the resin a basic agent and water to form an emulsion of resin particles.
2. The process according to claim 1, wherein the resin comprises a polyester resin possessing acid groups selected from the group consisting of amorphous resins, crystalline resins, and combinations thereof.
3. The process according to claim 2, wherein the resin is an amorphous resin and the melt mixing is performed at a temperature above the glass transition temperature of the resin.
4. The process according to claim 2, wherein the resin is a crystalline resin and the melt mixing is performed at a temperature above the melting point of the resin.
5. The process according to claim 2, wherein the resin is a mixture of amorphous resins and crystalline resins and the melt mixing is performed at a temperature above the glass transition temperature of the mixture.
6. The process according to claim 1, wherein melt mixing the resin occurs at temperature of from about 30°C to about 200°C and a rate of from about 10 rpm to about 5,000 rpm.

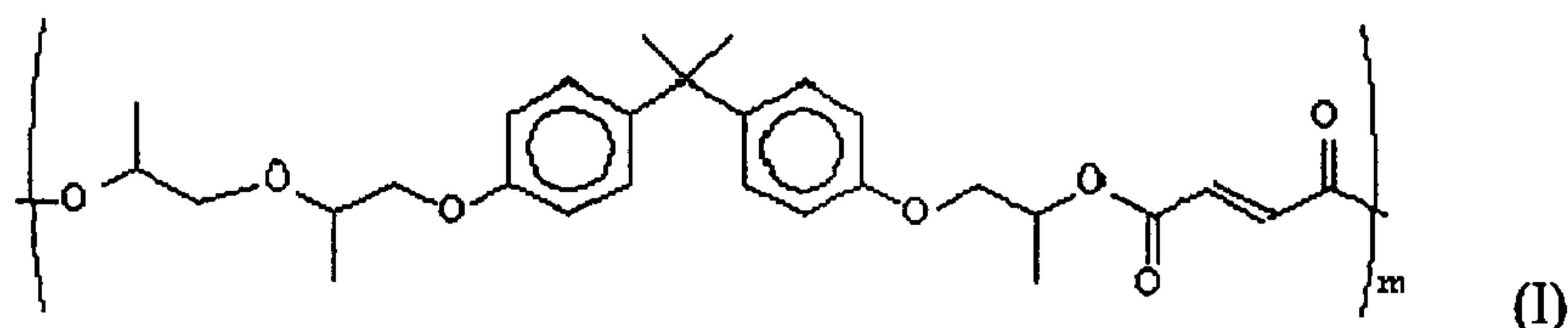
7. The process according to claim 1, wherein the basic agent is added in the form of an aqueous solution.

8. The process according to claim 1, wherein the basic agent is selected from the group consisting of ammonium hydroxide, potassium hydroxide, sodium hydroxide, sodium carbonate, sodium bicarbonate, lithium hydroxide, potassium carbonate, organoamines, and combinations thereof.

9. The process according to claim 1, wherein the surfactant is selected from the group consisting of anionic surfactants, nonionic surfactants, cationic surfactants, and combinations thereof, and the surfactant is present in an amount from about 0.01% to about 20% by weight of the resin.

10. The process according to claim 1, wherein the addition of the basic agent raises the pH of the emulsion of resin particles to from about 5 to about 9.

11. The process according to claim 1, wherein the resin is of the formula:



wherein m is from about 5 to about 300, and the resin particles in the emulsion are of a size of from about 10 nanometers to about 500 nanometers.

12. A process comprising:

melt mixing a resin in the absence of an organic solvent;

optionally adding a surfactant to the resin;
optionally adding one or more additional ingredients of a toner composition to the resin;
adding to the resin a basic agent and water;
performing a phase inversion to create a phase inversed emulsion including a disperse phase comprising toner-sized droplets including the molten resin and the optional ingredients of the toner composition; and
solidifying the toner-sized droplets to result in toner particles.

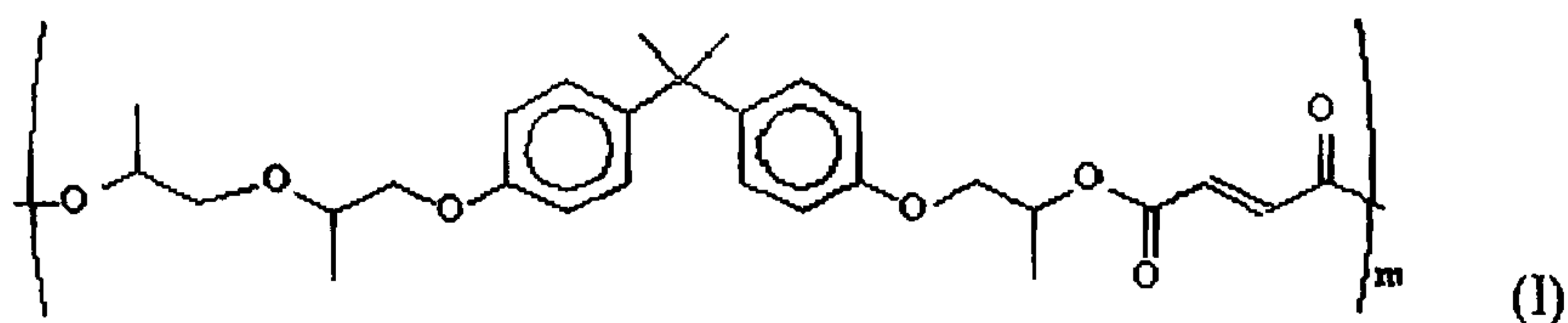
13. The process according to claim 12, wherein melt mixing the resin occurs at a temperature of from about 50° C to about 150° C and at a rate of from about 10 rpm to about 2,000 rpm.

14. The process according to claim 12, wherein the resin comprises a polyester resin possessing acid groups.

15. The process according to claim 12, wherein the surfactant is selected from the group consisting of anionic surfactants, nonionic surfactants, cationic surfactants, and combinations thereof, and the surfactant is present in an amount from about 0.1% to about 10% by weight of the resin.

16. The process according to claim 12, wherein the addition of the basic agent raises the pH of the emulsion of resin particles to from about 6 to about 8.

17. The process of claim 12, wherein the resin is of the formula:



wherein m is from about 10 to about 200, and the one or more additional ingredients of the toner composition are selected from the group consisting of colorants, optional waxes, optional charge control agents, and combinations thereof.

18. A process comprising:

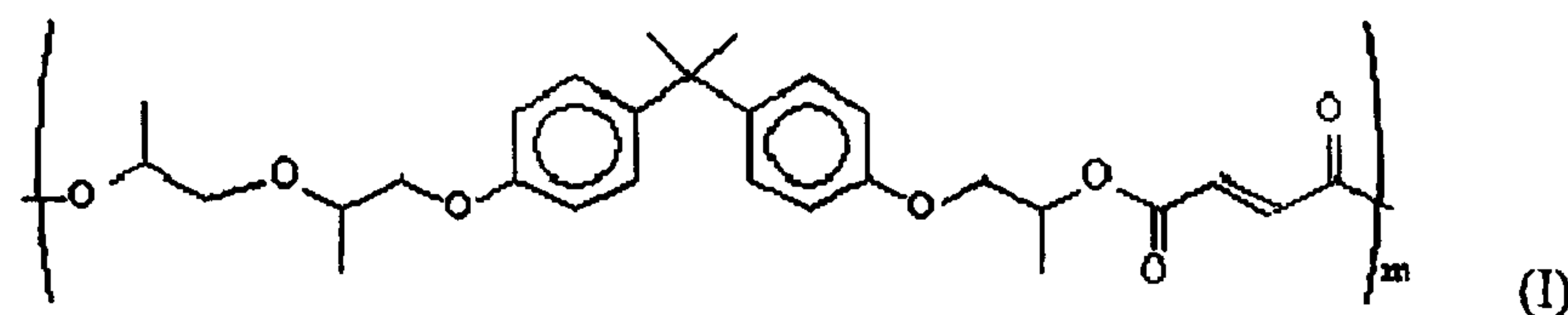
melt mixing a polyester resin possessing acid groups in the absence of an organic solvent;

adding a surfactant to the resin;

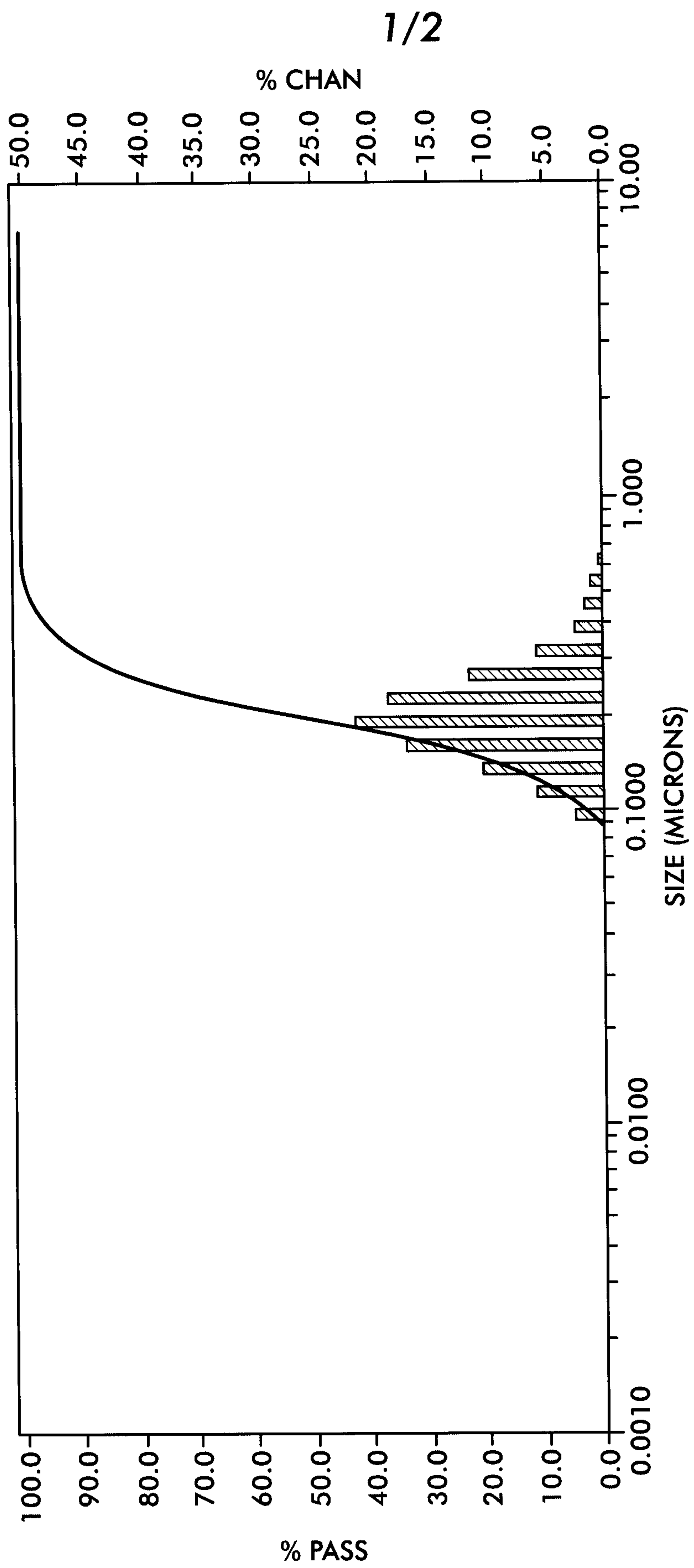
and adding to the resin a basic neutralization agent and water to form an emulsion.

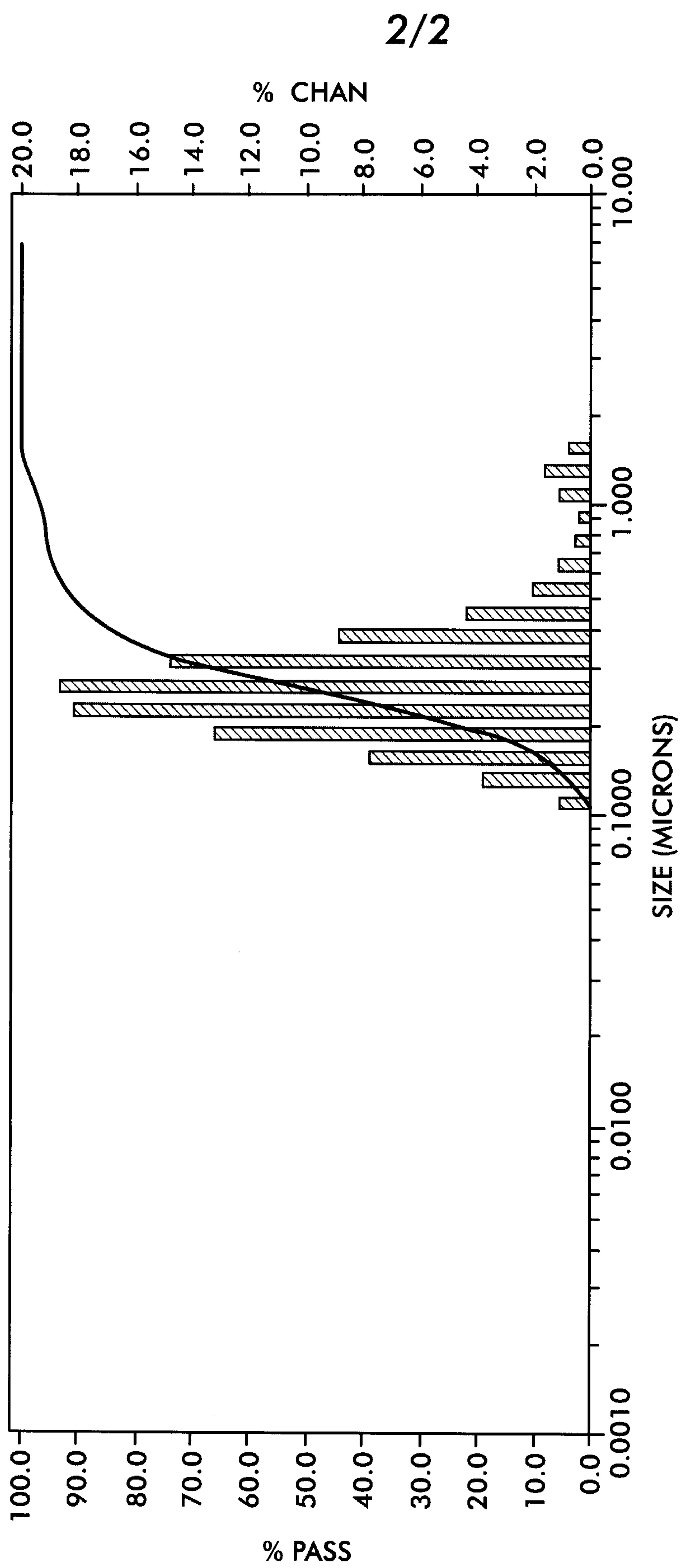
19. The process of claim 18, wherein the polyester resin has an acid number from about 2 mg KOH / g resin to about 200 mg KOH / g resin, and wherein the neutralization ratio is from about 50% to about 300%.

20. The process according to claim 18, wherein the resin is of the formula:



wherein m is from about 10 to about 200, and the surfactant is selected from the group consisting of anionic surfactants, nonionic surfactants, cationic surfactants, and combinations thereof.

**FIG. 1**

**FIG. 2**

