

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization
International Bureau



(43) International Publication Date
6 July 2006 (06.07.2006)

PCT

(10) International Publication Number
WO 2006/069928 A2

(51) International Patent Classification: **Not classified**

(21) International Application Number: **PCT/EP2005/056891**

(22) International Filing Date: **19 December 2005 (19.12.2005)**

(25) Filing Language: **English**

(26) Publication Language: **English**

(30) Priority Data: **04107037.6 29 December 2004 (29.12.2004) EP**

(71) Applicant (for all designated States except US): **CIBA SPECIALTY CHEMICALS HOLDING INC. [CH/CH]; Klybeckstrasse 141, CH-4057 Basel (CH).**

(72) Inventors; and

(75) Inventors/Applicants (for US only): **RUCH, Thomas [CH/CH]; Rue Du Crêt 15, CH-2800 Delémont (CH). LUTERBACHER, Ursula [CH/CH]; Talackerstrasse 36, CH-4153 Reinach (CH).**

(74) Common Representative: **CIBA SPECIALTY CHEMICALS HOLDING INC.; Patent Department, Klybeckstrasse 141, CH-4057 Basel (CH).**

(81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BW, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KN, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, LY, MA, MD, MG, MK, MN, MW, MX, MZ, NA, NG, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, SM, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, YU, ZA, ZM, ZW.

(84) Designated States (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IS, IT, LT, LU, LV, MC, NL, PL, PT, RO, SE, SI, SK, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

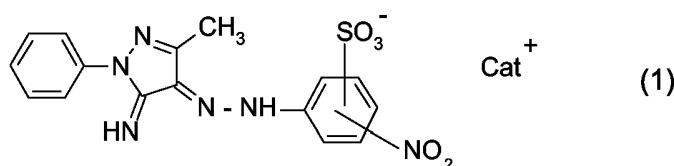
Published:

— without international search report and to be republished upon receipt of that report

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

WO 2006/069928 A2

(54) Title: DYES THAT ARE SOLUBLE IN ORGANIC SOLVENTS



(57) Abstract: The present invention relates to dyes of formula (1) that are soluble in organic solvents, wherein Cat^+ is an organic cation, to a process for their preparation and to their use in the production of coloured plastics or polymeric colour particles, printing colorants, printing pastes and printing inks.

Dyes that are soluble in organic solvents

The present invention relates to azo-compound-based dyes that are soluble in organic solvents, to a process for their preparation and to their use in the production of coloured

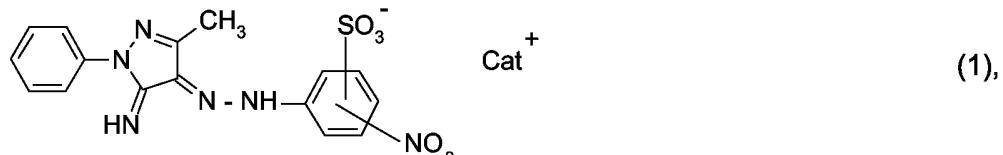
5 plastics or polymeric colour particles and also as printing inks and printing colorants, coating compositions and wood stains.

The object of the present invention is to provide heavy-metal-free dyes that are very soluble in organic solvents, having good solubility, high colour strength and good fastness to light,

10 can be used, for example, as soluble printing dyes and wood stains and in the colouring of polar plastics, and are only sparingly soluble in water. This cannot be achieved using the heavy-metal-free compounds known today.

It has now been found, surprisingly, that the dyes according to the invention, which are in the 15 form of specific organic salts, achieve the above-mentioned object to a substantial degree.

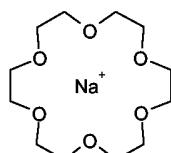
The present invention accordingly relates to dyes of formula



20 wherein

Cat^+ is an organic cation.

The organic cation Cat^+ is, for example, 18-crown-6 Na^+ (a compound of formula



) or $\text{N}(\text{R}_5, \text{R}_6, \text{R}_7, \text{R}_8)$, wherein R_5 to R_8 are each independently of the others

25 hydrogen, $\text{C}_1\text{-C}_{16}$ alkyl or $\text{C}_1\text{-C}_4$ alcohol.

- 2 -

Cat⁺ is preferably the ammonium cation $\begin{array}{c} \text{R}_2 \\ | \\ \text{R}_1-\text{N}^+-\text{R}_3 \\ | \\ \text{R}_4 \end{array}$ of an amine of formula $\begin{array}{c} \text{R}_2 \\ | \\ \text{N}-\text{R}_3 \\ | \\ \text{R}_4 \end{array}$ or of an ammonium compound of formula $\begin{array}{c} \text{R}_2 \quad \text{X}^- \\ | \quad | \\ \text{R}_1-\text{N}^+-\text{R}_3 \\ | \\ \text{R}_4 \end{array}$ wherein

R₁, R₂, R₃ and R₄ are each independently of the others hydrogen or linear or branched C₂-C₁₄alkyl unsubstituted or hydroxy- or amino-substituted, and optionally interrupted by an oxygen atom, at least one of the substituents R₁ to R₄ being linear or branched C₂-C₁₄alkyl unsubstituted or hydroxy- or amino-substituted, and optionally interrupted by an oxygen atom, and

X is halogen or -OH.

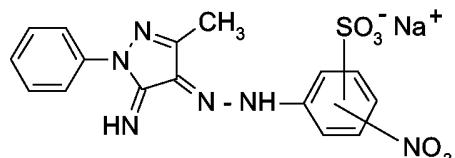
10 As Cat⁺ there is especially preferred a cation derived from Primene81R[®], a commercial product of Rohm & Haas, a primary amine mixture with a heavily branched C₁₂-C₁₄alkyl side chain, or of C₁-C₁₄tetraalkylammonium hydroxide, especially tetrabutylammonium hydroxide. The cations Cat⁺ may also be in the form of mixtures.

15 Cat⁺ is more especially +N(CH₂CH₂CH₂CH₃)₄.

Preference is likewise given to dyes of formula (1) wherein Cat⁺ is an organic cation containing at least one branched radical.

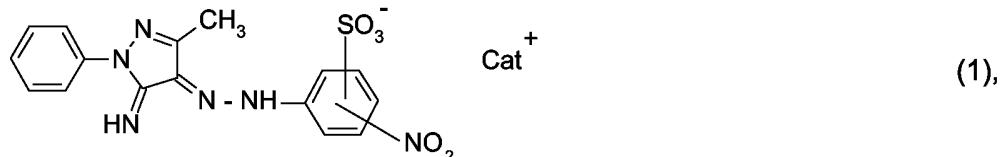
In the context of the present invention, an organic cation Cat⁺ containing at least one branched radical is understood to mean, for example, a primary amine having a branched C₃-C₁₄alkyl chain or a secondary, tertiary or quaternary amine having at least one linear or branched C₃-C₁₄alkyl chain .

25 The dyes of formula (1) can be prepared according to methods known *per se*. They are obtained, for example, by salt conversion of the dye of formula



(1a)

in an organic solvent/water medium, using an organic ammonium compound containing the cation Cat^+ , to form the dye of formula



5 Cat^+ having the definition and preferred meanings given above.

Solvents in that case can be polar organic solvents, such as, for example, alcohols, amides, ketones, carboxylates, such as ethyl acetate, chlorinated hydrocarbons, such as CH_2Cl_2 or CHCl_3 , hydrocarbons, for example hexane, heptane, toluene or xylene, or also amines. The
 10 reaction temperature can generally be from room temperature (about 20°C) to the boiling point of the solvent employed.

The compounds of formula (1a) are known or can be prepared in a manner known *per se*.

15 The organic solvents in which the dyes according to the invention are soluble are, for example, linear, branched or cyclic alcohols, linear, branched or cyclic ketones, carboxylates, toluene, xylene and chlorinated hydrocarbons, such as, for example, CH_2Cl_2 or CHCl_3 .

The dyes according to the invention have especially good solubility in polar solvents,
 20 especially in methanol, ethanol, ethyl acetate, butyl acetate, methyl ethyl ketone and isobutyl methyl ketone.

The present invention relates also to a process for the production of coloured plastics or polymeric colour particles, which comprises blending with one another a high molecular
 25 weight organic material and a tinctorially effective amount of at least one dye of formula (1).

The colouring of high molecular weight, organic substances using the dye of formula (1) is effected, for example, by admixing such a dye with such substrates using roll mills or mixing or grinding apparatuses, with the result that the dye is dissolved or finely distributed in the
 30 high molecular weight material. The high molecular weight organic material with the admixed dye is then processed according to methods known *per se*, such as, for example, calendering, compression moulding, extrusion, coating, spinning, pouring or injection

moulding, whereby the coloured material acquires its final shape. Admixture of the dye can also be effected immediately prior to the actual processing step, for example by continuously simultaneously feeding pulverulent dye and a granulated or pulverulent high molecular weight organic material and, optionally, also additional ingredients, such as additives, directly 5 into the intake zone of an extruder, the constituents being mixed just prior to processing. Generally, however, preference is given to mixing the dye into the high molecular weight organic material beforehand, because more evenly coloured substrates can be obtained.

In order to produce non-rigid mouldings or to reduce their brittleness, it is frequently desirable 10 to incorporate so-called plasticisers into the high molecular weight compounds prior to shaping. There may be used as plasticisers, for example, esters of phosphoric acid, phthalic acid or sebacic acid. In the process according to the invention, the plasticisers can be incorporated into the polymers before or after the incorporation of the colorant. It is also possible, in addition to adding the dye of formula (1) to the high molecular weight organic 15 materials, to add further dyes or other colorants in desired amounts in order to achieve different colour shades, optionally together with further additives, for example fillers or siccatives.

Preference is given to the dyeing of thermoplastic plastics, especially in the form of fibres or 20 films.

Preferred high molecular weight organic materials that can be coloured in accordance with the invention are, very generally, polymers having a dielectric constant ≥ 2.5 , especially polyesters, polycarbonate (PC), polystyrene (PS), polymethyl methacrylate (PMMA), polyamide, polyethylene, polypropylene, styrene/acrylonitrile (SAN) and acrylonitrile/butadiene/styrene (ABS). Especially preferred are polyesters and polyamide. More especially preferred are linear aromatic polyesters obtainable by polycondensation of terephthalic acid 25 and glycols, especially ethylene glycol, or condensation products of terephthalic acid and 1,4-bis(hydroxymethyl)cyclohexane, for example polyethylene terephthalate (PET) or polybutylene terephthalate (PBTP); also polycarbonates, e.g. those obtained from α,α -di- 30 methyl-4,4-dihydroxy-diphenylmethane and phosgene, or polymers based on polyvinyl chloride and on polyamide, e.g. polyamide-6 or polyamide-6,6.

The dyes according to the invention impart to the above-mentioned materials, especially the polyester and polyamide materials, shades of strong colour having very good in-use fastness properties, especially a good fastness to light.

- 5 The dyes of formula (1) according to the invention can also be used in the printing of semi-synthetic and, especially, synthetic hydrophobic fibre materials, more especially textile materials, and also in the printing of paper, plastics films or metal foils, especially aluminium foils.
- 10 Semi-synthetic textile materials that come into consideration are especially cellulose 2½ acetate and cellulose triacetate.

Synthetic hydrophobic textile materials consist especially of linear, aromatic polyesters, for example polyesters of terephthalic acid and glycols, especially ethylene glycol, or

- 15 condensation products of terephthalic acid and 1,4-bis(hydroxymethyl)cyclohexane; of polycarbonates, e.g. polycarbonates obtained from α,α -dimethyl-4,4'-dihydroxy-diphenyl-methane and phosgene, and of fibres based on polyvinyl chloride and on polyamide.

- 20 The dyes according to the invention are also highly suitable for the printing of polyester/wool and polyester/cellulosic fibre blends.

The said textile material can be in a variety of processing forms, e.g. in the form of fibres, yarns or non-wovens, in the form of woven fabrics or knitted fabrics.

- 25 It is advantageous to convert the dyes according to the invention into a dye preparation prior to use. For that purpose, the dye is so ground that its particle size is on average from 0.1 to 10 microns. Grinding can be carried out in the presence of dispersants. For example, the dried dye is ground with a dispersant or is kneaded into paste form with a dispersant and then dried *in vacuo* or by atomisation. The preparations so obtained can be used, after the 30 addition of water, to prepare printing colorants or printing pastes.

The present invention relates also to the use of the dyes according to the invention in the preparation of printing colorants or printing pastes, optionally also together with other dyes, as well as to the printing colorants or printing pastes obtained.

The amount of dyes to be added to the printing colorants or printing pastes is dependent on the desired colour strength; in general, amounts of from 0.01 to 15% by weight, especially from 0.02 to 10% by weight, based on the material to be printed, have proved suitable.

5

For printing, the customary thickeners will be used, e.g. modified or unmodified natural products, for example alginates, British gum, gum arabic, crystal gum, carob flour, tragacanth, carboxymethyl cellulose, hydroxyethyl cellulose, starch or synthetic products, for example polyacrylamides, polyacrylic acid or copolymers thereof, or polyvinyl alcohols.

10

The printing pastes also comprise, if desired, acid donors, such as butyrolactone or sodium hydrogen phosphate, preservatives, sequestering agents, emulsifiers, organic solvents, e.g. alcohols, esters, toluene and xylene, binders, e.g. nitrocellulose and vinyl copolymers, softeners, e.g. citric acid, oxidising agents, deaerating agents, light stabilisers and UV

15 stabilisers.

For printing, the printing paste is applied directly to the entire surface of the material to be printed or to parts thereof, printing machines of the customary type, e.g. flexographic/intaglio printing, offset printing, rotary or flat-film printing machines, advantageously being used. The 20 printing pastes according to the invention are also suitable for transfer printing.

The dyes according to the invention impart to the mentioned materials, especially to polyester materials, level colour shades having very good in-use fastness properties.

25 The present invention relates also to the use of the dyes of formula (1) in the preparation of printing inks, preferably inks used in an ink-jet method.

The present invention relates also to the aqueous inks used in the ink-jet printing method that comprise at least one dye of formula (1).

30

The total amount of dyes present in the inks is preferably from 0.5 to 35% by weight, especially from 1 to 30% by weight and more especially from 1 to 20% by weight, based on the total weight of the ink. The especially preferred lower limit is 1.2% by weight, especially

1.5% by weight. The especially preferred upper limit is 15% by weight, especially 10% by weight.

The inks preferably comprise a solubiliser or a humectant, such as a water-miscible organic solvent, for example a C₁-C₄alcohol, such as methanol, ethanol, n-propanol, isopropanol, n-butanol, sec-butanol, tert-butanol or isobutanol; an amide, e.g. dimethylformamide or di-methyl acetamide; a ketone or ketone alcohol, e.g. acetone, methyl isobutyl ketone, di-acetone alcohol; an ether, e.g. tetrahydrofuran or dioxane; a nitrogen-containing heterocyclic compound, e.g. N-methyl-2-pyrrolidone or 1,3-dimethyl-2-imidazolidone; a polyalkylene glycol, preferably a low molecular weight polyethylene glycol having a molecular weight of from 100 to 800, e.g. diethylene glycol, triethylene glycol, tetraethylene glycol, polyethylene glycol 200, polyethylene glycol 300, polyethylene glycol 400 or polyethylene glycol 600, especially having a molecular weight of from 150 to 400, or a low molecular weight poly-propylene glycol, e.g. dipropylene glycol, tripropylene glycol, polypropylene glycol P 400 or polypropylene glycol P 425; a C₁-C₄alkyl ether of a polyalkylene glycol, e.g. diethylene glycol monobutyl ether, 2-(2-methoxyethoxy)ethanol, 2-(2-ethoxyethoxy)ethanol, 2-[2-(2-methoxyethoxy)ethoxy]ethanol or 2-[2-(2-ethoxyethoxy)ethoxy]ethanol; a C₂-C₆alkylene glycol or a thioglycol, e.g. ethylene glycol, propylene glycol, butylene glycol, 1,5-pentanediol, thioglycol, hexylene glycol; further a polyol, e.g. glycerol or 1,2,6-hexanetriol; or a C₁-C₄alkyl ether of a polyhydric alcohol, e.g. 2-methoxyethanol or 1-methoxypropan-2-ol.

More especially, the inks comprise at least one solubiliser or humectant from the group consisting of polyethylene glycols having a molecular weight of from 150 to 400, diethylene glycol monobutyl ether, N-methyl-2-pyrrolidone and glycerol and especially tetraethylene glycol, polyethylene glycol 400, diethylene glycol monobutyl ether and glycerol, usually in an amount of from 2 to 30% by weight, especially from 5 to 25% by weight and more especially from 20 to 25% by weight, based on the total weight of the ink.

The inks may in addition comprise solubilisers, e.g. ϵ -caprolactam.

As humectants in the inks according to the invention there also come into consideration, for example, urea or a mixture of sodium lactate (advantageously in the form of a 50 to 60% aqueous solution) and glycerol and/or propylene glycol in amounts of preferably from 0.1 to 30% by weight, especially from 2 to 30% by weight.

The inks may comprise thickeners of natural or synthetic origin, *inter alia* for adjusting the viscosity.

- 5 Examples of thickeners that may be mentioned include commercially available alginate thickeners, starch ethers and carob flour ethers, especially sodium alginate on its own or in admixture with modified cellulose, for example methyl, ethyl, carboxymethyl, hydroxyethyl, methylhydroxyethyl, hydroxypropyl or hydroxypropylmethyl cellulose, especially with preferably from 20 to 25 percent by weight of carboxymethyl cellulose. There may
- 10 furthermore be mentioned as synthetic thickeners, for example, those based on poly(meth)-acrylic acids or poly(meth)acrylamides.

The inks contain such thickeners in an amount of, for example, from 0.01 to 2% by weight, especially from 0.01 to 1% by weight and more especially from 0.01 to 0.5% by weight, 15 based on the total weight of the ink.

The inks may also comprise buffer substances, for example borax, borate, phosphate, polyphosphate or citrate. Examples that may be mentioned are borax, sodium borate, sodium tetraborate, sodium dihydrogen phosphate, disodium hydrogen phosphate, sodium tripolyphosphate, sodium pentapolypophosphate and also sodium citrate. They are used especially in amounts of from 0.1 to 3% by weight, more especially from 0.1 to 1% by weight, based on the total weight of the ink, to establish a pH value of, for example, from 4 to 9, especially from 20 5 to 8.5.

- 25 Further additives that may be present in the inks are surfactants or wetting agents.

Surfactants or wetting agents that come into consideration are the commercially available anionic or non-ionic surfactants.

- 30 Furthermore, the inks may in addition comprise customary additives, e.g. anti-foams or especially substances that inhibit fungal and/or bacterial growth. Such additives are usually used in amounts of from 0.01 to 1% by weight, based on the total weight of the ink.

Preservatives that come into consideration are formaldehyde-yielding agents, e.g. paraformaldehyde and trioxane, especially aqueous formaldehyde solutions, for example 30 to 40 percent by weight formaldehyde solutions, imidazole compounds, e.g. 2-(4-thiazolyl)-benzimidazole, thiazole compounds, e.g. 1,2-benzisothiazolin-3-one or 2-n-octyl-isothiazolin-5 3-one, iodine compounds, nitriles, phenols, haloalkylthio compounds or pyridine derivatives, especially 1,2-benzisothiazolin-3-one or 2-n-octyl-isothiazolin-3-one.

The inks can be prepared in customary manner by mixing together the individual components, for example in the desired amount of ethanol or water. Suspended matter and 10 insoluble components present in the inks are removed, for example, by filtration through filters having a pore size of from 0.2 to 0.5 μm .

Preference is given to inks having a viscosity of from 1 to 40 mPa·s, especially from 1 to 20 mPa·s and more especially from 1 to 10 mPa·s.

15 The inks according to the invention are suitable for use in recording systems in which the ink is expressed from a small aperture in the form of droplets and directed onto a planar substrate on which an image is formed. Suitable substrates include, for example, paper, plastics films or textile fibre materials, preferably paper or plastics films and especially a 20 plastics-coated paper. Suitable recording systems include, for example, commercially available ink-jet printers for use in paper printing or textile printing.

As examples of paper that can be printed with the inks according to the invention there may be mentioned commercially available ink-jet paper, photo paper, glossy paper, plastics-25 coated paper, e.g. Epson Ink-jet Paper, Epson Photo Paper, Epson Glossy Paper, Epson Glossy Film, HP Special Ink-jet Paper, Encad Photo Gloss Paper and Ilford Photo Paper. Plastics films that can be printed with the inks according to the invention are, for example, transparent or cloudy/opaque. Suitable plastics films are, for example, 3M Transparency Film. Preference is given to glossy paper, such as, for example, Epson Glossy Paper.

30 As textile fibre materials there come into consideration especially nitrogen-containing or hydroxy group-containing fibre materials, for example woven textile fabric made of cellulose, silk, wool or synthetic polyamides, especially silk.

- 10 -

In the case of the ink-jet printing method, individual droplets of ink are sprayed onto a substrate from a nozzle in a controlled manner. It is mainly the continuous ink-jet method and the drop-on-demand method that are used for that purpose. In the case of the continuous ink-jet method, the droplets are produced continuously, droplets not required for the printing 5 operation being discharged into a receptacle and recycled. In the case of the drop-on-demand method, on the other hand, droplets are generated as desired and used for printing; that is to say, droplets are generated only when required for the printing operation. The production of the droplets can be effected, for example, by means of a piezo ink-jet head or by thermal energy (bubble jet). For the process according to the invention, printing by means 10 of a piezo ink-jet head is preferred, but preference is given also to printing according to the continuous ink-jet method.

The present invention relates also to the above-mentioned uses of the dyes according to the invention, such as in a method of printing semi-synthetic or synthetic hydrophobic fibre 15 material, especially textile material, which comprises applying the dyes according to the invention to the said material. The mentioned hydrophobic fibre material is preferably textile polyester material. Further substrates that can be treated by the process according to the invention and also preferred process conditions can be found hereinabove in the more detailed explanation of 20 the use of the dyes according to the invention.

The invention relates also to the hydrophobic fibre material, preferably polyester textile material, paper and plastics films or metal foils, printed using the said process.

25 The dyes of formula (1) according to the invention are furthermore suitable for other recording methods, for example thermotransfer printing.

The following Examples serve to illustrate the invention. Unless otherwise indicated, parts 30 are parts by weight and percentages are percentages by weight. The temperatures are given in degrees Celsius. The relationship between parts by weight and parts by volume is the same as that between grams and cubic centimetres.

Example 1:Diazotisation

In a sulfonating flask, 10.94 g of 2-sulfo-4-nitroaniline sodium/ammonium salt (86%) are stirred into 160 ml of demineralised water and then 14 ml of 37% hydrochloric acid are

5 added. Cooling to from 0 to 5°C is then carried out using an ice bath, and 10 ml of 4M sodium nitrite are added over the course of 15 minutes. The mixture is stirred for a further fifteen minutes. The excess of sodium nitrite is destroyed using 1M aminosulfonic acid.

Coupling

550 ml of demineralised water are introduced as the initial charge into a glass beaker. 7.14 g

10 of amino-3-methyl-phenylpyrazole (97%) are suspended therein. The beige suspension is heated to 60°C and the pH value, which is about 7.1, is adjusted to 4.0 using 10 ml of 1N hydrochloric acid. The solution is then transferred into a 750 ml sulfonating flask and cooled to about 5°C. The diazo suspension is then added to the coupler solution over the course of 2 hours using a feed beaker, during which the pH value is maintained at 4.5 using

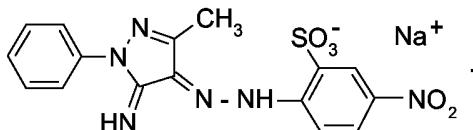
15 14.3 ml of sodium hydroxide solution (30%). The temperature remains in the region of 5°C.

An orange-red suspension is obtained which in addition is then stirred for about one hour.

200 ml of sodium chloride (10%) are then added and stirring is carried out for a further

12 hours. The suspension is subsequently filtered and then washed with 100 ml of 20% sodium chloride solution. The filter cake is dried in a vacuum cabinet for 12 hours at 70°C. A

20 crude product is obtained which contains 27.7 g of the compound of formula



(50)

Example 2:Diazotisation

In a reaction flask, 46.8 g of 2-sulfo-4-nitroaniline (85.5%) are stirred into 800 ml of demineralised water and then 5 ml of 37% hydrochloric acid are added. Cooling to from 0 to 5°C is then carried out using an ice bath, and 45 ml of 4M sodium nitrite are fed in over the course of 40 minutes with the simultaneous addition of a small amount (about 2 ml) of

30 hydrochloric acid. The mixture is stirred for a further 45 minutes. The excess of sodium nitrite is destroyed using 1M aminosulfonic acid.

- 12 -

Coupling

100 ml of demineralised water and 150 ml of 2-ethoxyethanol (ethyl cellosolve/ethylene glycol monoethyl ether) are introduced as the initial charge into a glass beaker. 30.3 g of amino-3-methyl-phenylpyrazole (97%) are dissolved therein. 2 drops of 30% sodium

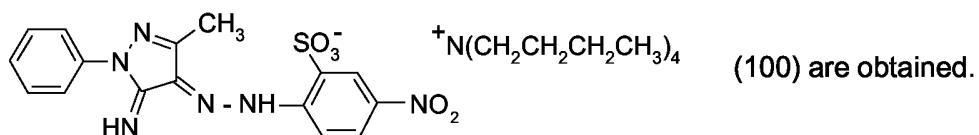
5 hydroxide solution are then added and the mixture is stirred for 45 minutes. The coupler solution is subsequently added over the course of 30 minutes to the ice-cooled diazonium solution, during which the pH value is maintained at from 2.8 to 3.8 by adding sodium hydrogen carbonate. A viscous orange-red suspension is obtained which is diluted with a total of 500 ml of demineralised water. The pH value of the diluted suspension is then
10 adjusted to 6.0 using sodium hydrogen carbonate, and the suspension is further stirred for 90 minutes, filtered and then washed with 400 ml of 12% sodium chloride solution. The filter cake is dried *in vacuo* for 12 hours at 70°C. A crude product is obtained which contains 94.7 g of the compound of formula (50).

15 Salt conversion (0.01 mol)

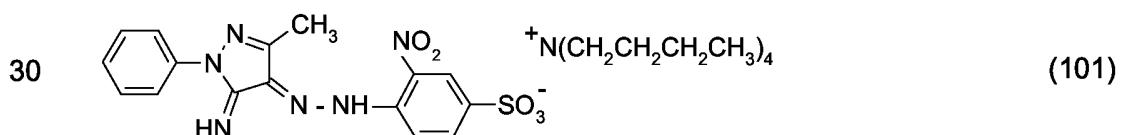
620 ml of demineralised water are introduced as the initial charge into a 4-necked sulfonating flask. 10 g of the compound of formula (50) (content 53%) are added thereto. The suspension is heated to 78°C and adjusted to pH 7.0 using sodium hydroxide solution (30%), whereupon it becomes a solution. 500 ml of isobutyl methyl ketone and 4 g of tetrabutyl-

20 ammonium bromide (98%) are then added in succession. The product moves into the organic phase. The pH value is then adjusted to 3.5 using formic acid (100%) and is subsequently stirred for from 15 to 20 minutes. The organic phase is separated off in a separating funnel and fully concentrated using a rotary evaporator. 8.0 g (95.3% of theory) of pure dye of formula

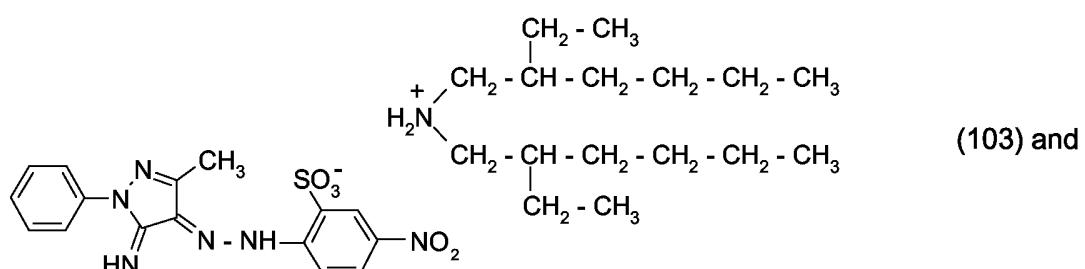
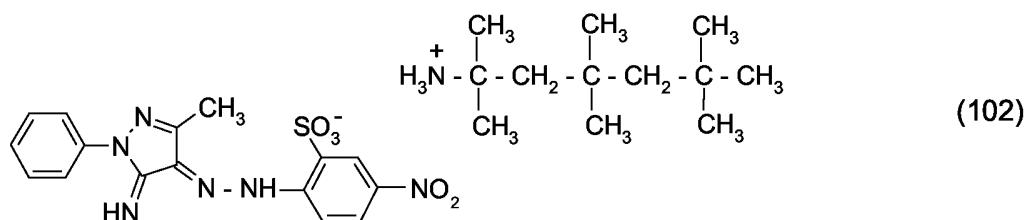
25



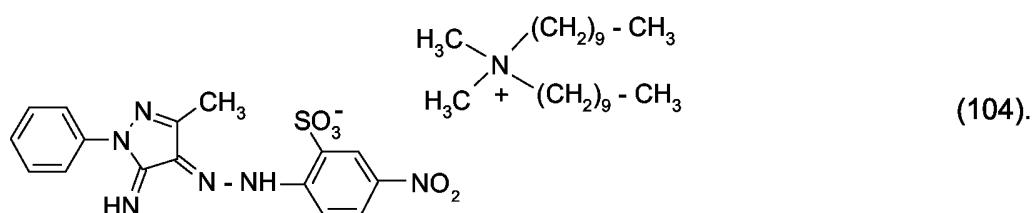
Dyes of the formulae below are prepared analogously to Examples 1 and 2:



- 13 -

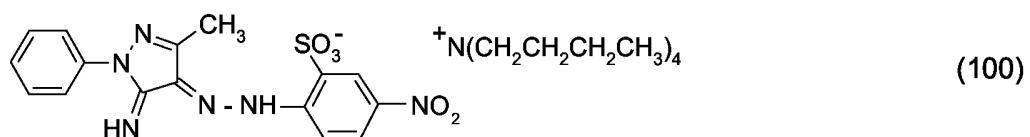


5



Example 1 of a printing colorant:

10 3.0% by weight of the dye of formula



are stirred into

97.0% by weight of a formulation consisting of

15 12.0% by weight of NC AH 27 (20% ATBC) [a nitrocellulose, soluble in ethanol, containing 20% by weight of acetyl tributyl citrate],
2.0% by weight of Hercolyn DE [a water-repellent agent],
10.0% by weight of ethoxypyropanol,
20.0% by weight of ethyl acetate and
20 56.0% by weight of ethanol

until homogeneous.

The printing colorant gives a brilliant intense orange coloration on paper, plastics films or metal foils.

5 Example 2 of a printing colorant:

3.0% by weight of the dye of formula (100)

are stirred into

97.0% by weight of a formulation consisting of

14.0% by weight of vinylite VYHH (UCC) [a vinyl chloride/vinyl acetate copolymer

10 (85%/15%)],

10.0% by weight of ethoxypropanol and

76.0% by weight of MEK [methyl ethyl ketone]

until homogeneous.

The printing colorant gives a brilliant intense orange coloration on paper, plastics films or

15 metal foils.

Example 3 of a printing colorant:

3.0% by weight of the dye of formula (101)

are stirred into

20 97.0% by weight of a formulation consisting of

12.0% by weight of NC AH 27 (20% ATBC) [a nitrocellulose, soluble in ethanol, containing
20% by weight of acetyl tributyl citrate],

2.0% by weight of Herclyn DE [a water-repellent agent],

10.0% by weight of ethoxypropanol,

25 20.0% by weight of ethyl acetate and

56.0% by weight of ethanol

until homogeneous.

The printing colorant gives a brilliant intense orange coloration on paper, plastics films or

metal foils.

30

Example 4 of a printing colorant:

3.0% by weight of the dye of formula (100)

are stirred into

97.0% by weight of a formulation consisting of

- 15 -

11.0% by weight of nitrocellulose A400,
9.0% by weight of Dowanol PM(A) (methoxypropyl acetate),
20.0% by weight of ethyl acetate and
60.0% by weight of ethyl alcohol

5 until homogeneous.

The printing colorant gives a brilliant intense orange coloration on paper, plastics films or metal foils.

Example 5 of a printing colorant:

10 3.0% by weight of the dye of formula (101)
are stirred into
97.0% by weight of a formulation consisting of
6.5% by weight of Movital B20H (a vinyl chloride/vinyl acetate copolymer),
1.5% by weight of Foralyn 5020-F (additive for gloss improvement),
15 30.0% by weight of ethoxypropanol,
40.0% by weight of Dowanol PMA (methoxypropyl acetate) and
22.0% by weight of diacetone alcohol
until homogeneous.

The printing colorant gives a brilliant intense orange coloration on paper, plastics films or
20 metal foils.

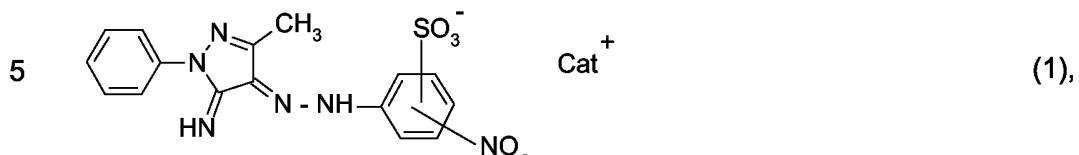
Example of a solvent-containing wood stain:

3.0 parts by weight of the azo dye of formula (100),
40.0 parts by weight of ethyl alcohol,
25 40.0 parts by weight of 1-methoxy-2-propanol and
17.0 parts by weight of isopropanol

The wood stain obtained according to the above Example is applied to a 10x5.5 cm piece of
ash wood using a paint brush. The stained piece of wood is dried in air for 12 hours.

What is claimed is:

1. A dye of formula



wherein

 Cat^+ is an organic cation.

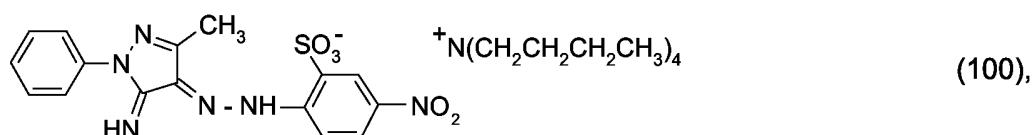
2. A dye according to claim 1, wherein Cat^+ is the ammonium cation $\begin{matrix} \text{R}_2 \\ | \\ \text{R}_1-\text{N}^+-\text{R}_3 \\ | \\ \text{R}_4 \end{matrix}$ of an amine

10 of formula $\begin{matrix} \text{R}_2 \\ | \\ \text{N}-\text{R}_3 \\ | \\ \text{R}_4 \end{matrix}$ or of an ammonium compound of formula $\begin{matrix} \text{R}_2 & \text{X}^- \\ | & \\ \text{R}_1-\text{N}^+-\text{R}_3 \\ | \\ \text{R}_4 \end{matrix}$, wherein R_1 , R_2 ,

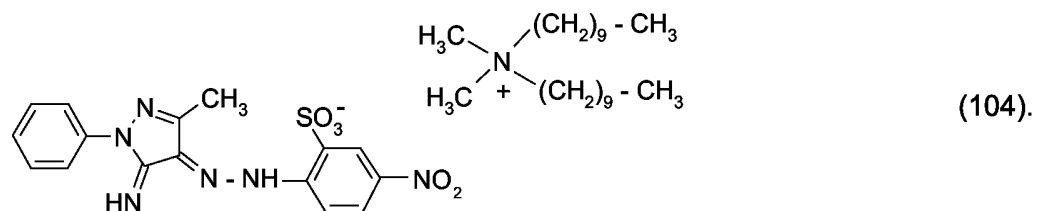
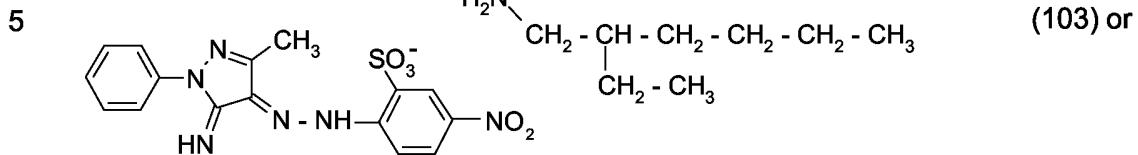
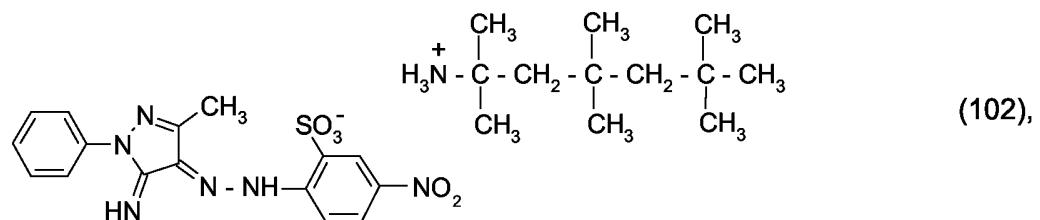
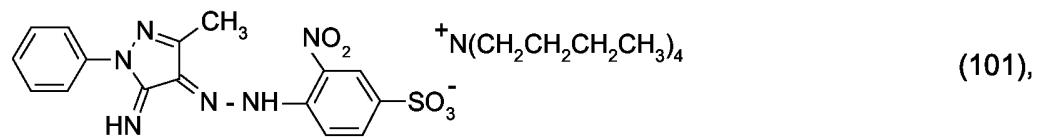
R_3 and R_4 are each independently of the others hydrogen or linear or branched $\text{C}_2\text{-C}_{14}$ alkyl unsubstituted or hydroxy- or amino-substituted, and optionally interrupted by an oxygen atom, at least one of the substituents R_1 to R_4 being linear or branched $\text{C}_2\text{-C}_{14}$ alkyl unsubstituted or hydroxy- or amino-substituted, and optionally interrupted by an oxygen atom, and X is halogen or $-\text{OH}$.

15 3. A dye according to either claim 1 or claim 2, wherein Cat^+ is derived from $\text{C}_1\text{-C}_{14}$ -tetraalkylammonium hydroxide.

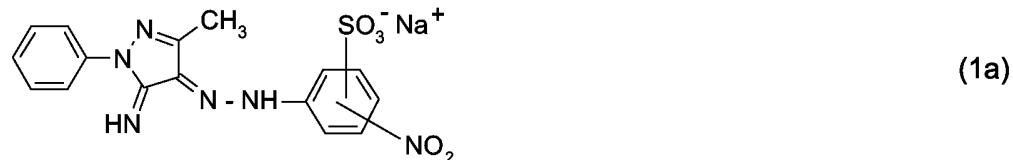
20 4. A dye according to claim 1 of formula



- 17 -

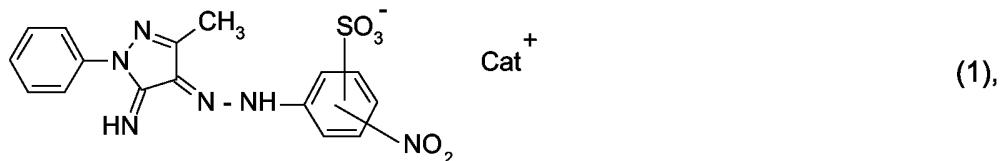


5 5. A process for the preparation of a dye of formula (1) according to claim 1, which comprises
10 salt conversion of the dye of formula



15 in an organic solvent/water medium, using an organic ammonium compound containing the cation Cat+, to form the dye of formula

- 18 -



wherein Cat^+ is an organic cation.

- 5 6. A printing colorant comprising a dye of formula (1) according to any one of claims 1 to 4.
- 7. A printing paste comprising a dye of formula (1) according to any one of claims 1 to 4.
- 8. A printing ink comprising a dye of formula (1) according to any one of claims 1 to 4.
- 10 9. A method of dyeing or printing semi-synthetic or synthetic hydrophobic fibre material, especially textile material, which comprises applying to or incorporating in the said material one or more dyes of formula (1) according to any one of claims 1 to 4.
- 15 10. A method according to claim 9, wherein the semi-synthetic or synthetic hydrophobic fibre material, preferably textile material, consists of polyester fibres.
- 11. A method of colouring or printing paper, plastics films or metal foils, preferably aluminium foils, which comprises applying to or incorporating in the said material one or more dyes of
- 20 12. Use of a dye of formula (1) according to any one of claims 1 to 4 in the colouring or printing of semi-synthetic or synthetic hydrophobic fibre material, paper, plastics films or metal foils, preferably aluminium foils.
- 25 13. The material coloured or printed according to claims 9 to 12.
- 14. Use of a printing ink according to claim 8 in an ink-jet printer.