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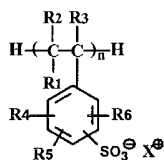
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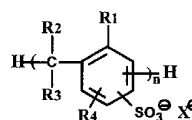
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- (71) Applicant: **KODAK POLYCHROME GRAPHICS LLC** [US/US]; 401 Merritt 7, Norwalk, CT 06851 (US).
- (72) Inventor: **TAO, Tingting**; 7308 Avondale Road, Fort Collins, CO 80525 (US).
- (74) Agents: **POLITIS, Pamela, D.** et al.; RatnerPrestia, Nemours Building, 1007 Orange Street, Suite 1100, P.O. Box 1596, Wilmington, DE 19899 (US).
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(54) Title: RADIATION-SENSITIVE COMPOSITIONS CONTAINING POLYMERIC SULFONATE ACID GENERATORS AND THEIR USE IN IMAGING



(I)



(II)

(57) **Abstract:** A radiation-sensitive patterning composition comprising: (1) at least one acid generating compound selected from compounds of formula (I) and formula (II) wherein: R₁, R₂, R₃, R₄, R₅, and R₆, are independently selected from the group consisting of hydrogen, nitro, hydroxyl, carbonyl, halogen, cyano, unsubstituted and substituted alkyl groups, unsubstituted and substituted cycloalkyl groups; unsubstituted and substituted alkoxy groups, and unsubstituted and substituted aryl groups; wherein: X⁺ is an onium ion selected from the group consisting of diazonium, iodonium, sulfonium, phosphonium, bromonium, chloronium, oxysulfoxonium, oxysulfonium, sulfoxonium, selenium, tellurium and arsenium; and n is an integer from 4 to 100; (2) at least one cross-linking agent cross-linkable by an acid; (3) at least one polymer compound capable of reacting with the cross-linking agent; and (4) at least one infrared absorbing compound.

RADIATION-SENSITIVE COMPOSITIONS CONTAINING POLYMERIC SULFONATE
ACID GENERATORS AND THEIR USE IN IMAGING

5 BACKGROUND OF THE INVENTION

This invention relates to selected acid generating agents useful in radiation-sensitive patterning compositions. The invention relates to such radiation-sensitive patterning compositions as well as methods of imaging radiation-sensitive elements containing such radiation-sensitive patterning compositions.

Thermally sensitive, negative working printing plates are generally made with radiation-sensitive patterning compositions that are imaged on a substrate. These patterning compositions commonly contain radiation-sensitive material that is a mixture of an acid generator, a cross-linking resin or compound, a binder resin and an infrared (IR) absorber. Many of the acid generators previously employed in these patterning compositions either contain ozone depletion elements such as fluorine or contain heavy metal such as antimony (Sb) or arsenic (As), which may cause serious environmental contamination problems. Also, some of these previously used acid generators produce volatile acids (e.g., HF, HCl, HBr, HI) that can be easily volatilized and lost under conditions of thermal imaging and subsequent optional baking, thereby reducing the cure rate. Such volatile acid loss decreases the efficiency of the printing plates.

Examples of these prior art acid generators are reported in the following:

U.S. 4,708,925 (Newman) describes a photosolubilizable composition comprising an alkali-soluble phenolic resin and an onium salt. The onium salt imparts a solvent resistance to the phenolic resin that is removed upon exposure to radiation thereby providing a solubility differential between exposed and unexposed areas of the composition. Suitable iodonium salts include iodonium, sulphonium, bromonium, chloronium, oxysulphonium, sulphoxonium, selenium, telluronium, phosphonium and arsenium salts. Preferably, the acid from which the anion is derived has a $pK_a < 5$. Suitable inorganic anions include halide anions, bisulfate, tetrafluoroborate, hexafluorophosphate, hexafluoroarsenate and hexafluoroantimonate. Suitable organic anions include those of the formulae: R^1COO^- and $R^1SO_3^-$, in which R^1 is an alkyl or aryl. Again, this reference does not teach or suggest the particular acid generators of the invention.

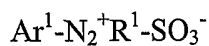
U.S. 5,372,907 (Haley et al.) describes a radiation-sensitive patterning composition.

comprising a mixture of (1) a resole, (2) a novolac resin, (3) a latent Bronsted acid (i.e., acid generating agent) and (4) an infrared absorber. In the specification, the latent Bronsted acids in the invention include onium salts, in particular iodonium, sulfonium, phosphonium, selenium, diazonium and arsenium, with anions such as
5 hexafluorophosphate, hexafluoroantimonate and trifluoromethane sulfonate. However, this reference does not disclose or suggest any latent Bronsted acids of the invention.

U.S. 5,919,601 (Nguyen et al.) describes a printing plate composition comprising a thermal-activated acid generator; a cross-linking resin; a binder resin comprising a polymer containing reactive pendant groups selected from hydroxyl, carboxylic acid,
10 sulfonamide, and alkoxymethylamide; and an infrared absorber. The composition claims that acid generator is selected from halo alkyl substituted S-triazines and salts containing an onium cation and non-nucleophilic anion, wherein the onium cation is selected from iodonium, sulphonium, phosphonium, oxysulphoxonium, oxysulphonium, sulphoxonium, ammonium and diazonium; the non-nucleophilic anion is selected from tetrafluoroborate,
15 hexafluorophosphate, hexafluoroantimonate, hexafluoroarsenate, triflate, tetrakis(pentafluorophenyl)borate, pentafluoroethyl sulfonate, p-methylbenzenesulfonate, ethyl sulfonate, trifluoromethylacetate and pentafluoroethyl acetate. This reference does not disclose or suggest the acid generators of the invention.

U.S. 5,945,250 (Aoi et al.) teaches a positive-type photosensitive composition that
20 contains a polymeric sulfonate resin of an iodonium or sulfonium salt and which generates a sulfonic acid upon receiving light. This light-exposed resin increases in solubility in an alkali developer to provide a positive resist pattern.

U.S. 5,965,319 (Kobayashi) describes certain onium salt compounds having sulfonic acid as the counter ion to generate sulfonic acid decomposed by light or heat.
25 These onium salts include diazonium sulfonates represented by the following structural formula:



wherein R^1 represents a hydrocarbon group having 20 or fewer carbon atoms which may be substituted; and Ar^1 represents an aryl group having 20 or fewer carbon
30 atoms which may be substituted. This reference does not teach or suggest any of the acid generators of the invention.

U.S. 6,042,987 (Kobayashi) describes a photosensitive negative image recording material for printing plate having a image recording layer containing a compound which is degraded by the action of light or heat to generate an acid, including an onium salt having

a halide, ClO_4^- , PF_6^- , BF_4^- or sulfonate as a counter ion. There is no knowledge of using the compounds with formulae (I)-(III) in the invention.

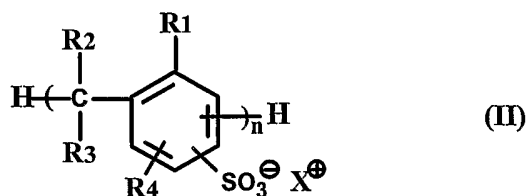
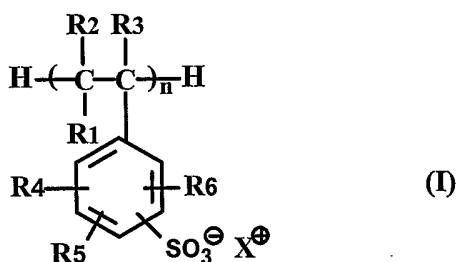
WO 00/17711 (IBF Industria Brasileira De Filmes S/A) describes a composition comprising a dual polymer system, an infrared absorbing material, an acid generating compound, and an acid stabilizing compound. The acid generating compounds named therein include, as anions, chloride, bisulfate, hexafluoroantimonate, hexafluorophosphate, tetrafluoroborate, methane sulfonate and mesitylene sulfonate. However, this reference does not teach or suggest acid generating compounds in the invention.

Accordingly, there is a need for better acid generators that can be used in radiation-sensitive patterning compositions that do not contain environmental questionable elements or produce undesirable volatile acids, yet have a high photolysis efficiency and good photo sensitivity. The invention provides a solution to that need. In particular, the invention provides an improved cure rate, processing latitude, processing robustness and long shelf life while maintaining moderate energy requirements of the acid generation step.

BRIEF SUMMARY OF THE INVENTION

In one aspect, the invention is a radiation-sensitive patterning composition comprising:

(1) at least one acid generating compound selected from compounds of formula (I) and formula (II):



wherein:

R_1 , R_2 , R_3 , R_4 , R_5 , and R_6 , are independently selected from the group consisting of hydrogen, nitro, hydroxyl, carbonyl, halogen, cyano, unsubstituted and substituted alkyl groups, unsubstituted and substituted cycloalkyl groups; unsubstituted and substituted

alkoxy groups, and unsubstituted and substituted aryl groups;

wherein:

X^+ is an onium ion selected from the group consisting of diazonium, iodonium, sulfonium, phosphonium, bromonium, chloronium, oxysulfoxonium, oxysulfonium, sulfoxonium, selenium, tellurium and arsenium; and

n is an integer from 4 to 100;

(2) at least one cross-linking agent cross-linkable by an acid;

(3) at least one polymer compound capable of reacting with the cross-linking agent; and

(4) at least one infrared absorbing compound.

In another aspect, the invention is a radiation-sensitive imaging element comprising a lithographic substrate having a coating of the radiation-sensitive composition thereon.

In yet another aspect, the invention is a process of imaging a radiation-sensitive element comprising the steps of:

(1) providing a photosensitive imaging element comprising a lithographic substrate having a layer of the photosensitive composition thereon;

(2) imagewise exposing the radiation-sensitive imaging element;

(3) removing unexposed areas of the photosensitive composition layer from the lithographic substrate.

Optionally, the imaged radiation-sensitive imaging element may be baked after step (2) and before step (3) at a temperature and time period sufficient to produce a cured element.

One of the advantages of the invention is that the acid generators do not contain either ozone depletion elements such as fluorine or heavy metals such as antimony (Sb) or arsenic (As), which may cause environmental contamination problems if improperly used. Another advantage that the generated acids are non-volatile at elevated operating temperatures, thus the loss of acid by evaporation is minimized. Still further, the photosensitive compositions provide excellent photographic sensitivity and photolysis efficiency. In particular, the invention allows for improved curing rate, processing latitude and robustness of thermal preheated negative working patterning compositions especially printing plates, while maintaining adequate shelf life.

The radiation-sensitive composition can be used in various types of lithography including photomask lithography, imprint lithography, microelectronic and microoptical

devices, printed circuit boards and especially radiation-sensitive lithographic plates.

DETAILED DESCRIPTION OF THE INVENTION

I. Radiation-Sensitive Patterning Compositions

As stated above, the radiation-sensitive patterning compositions comprise a mixture of at least four components plus optionally other compounds. These ingredients are preferably as follows:

(A) Acid Generating Compounds

Examples of the alkyl groups represented by R_1 to R_6 in formulae (I) and (II) include an alkyl group having 1 to 20 carbon atoms (e.g. methyl, ethyl, n-propyl, isopropyl, allyl, n-butyl, sec-butyl, t-butyl, hexyl, cyclohexyl, octyl, 2-ethylhexyl, and dodecyl), which may be unsubstituted or substituted.

Examples of the cycloalkyl groups represented by R_1 to R_6 in formulae (I) and (II) include cycloalkyl groups having 3 to 8 carbon atoms (e.g. cyclopropyl, cyclopentyl, and cyclohexyl), which may be unsubstituted or substituted.

Examples of the alkoxy groups represented by R_1 to R_6 in formulae (I) and (II) include these having 1 to 8 carbon atoms (e.g. methoxy, ethoxy, hydroxyethoxy, propoxy, n-butoxy, isobutoxy, sec-butoxy, t-butoxy, hexyloxy, and octyloxy), which may be unsubstituted or substituted.

Examples of aryl groups represented by R_1 to R_6 in formula (I) or (II) include those having 6 to 14 carbon atoms (e.g. phenyl, tolyl, methoxyphenyl and naphthyl), which may be unsubstituted or substituted.

Examples of the halogen atom include fluorine, chlorine, bromine and iodine.

The substituents on these alkyl groups, cycloalkyl groups, alkoxy groups and aryl groups include halogen, hydroxy, alkoxy, aryloxy, nitro, cyano, carbonyl, carboxyl, alkoxycarbonyl, anilino, and acetamido.

The preferred cationic portion of the onium salts represented by X^+ in the general formulas (I) and (II), include an iodonium ion, sulfonium ion, and diazonium ion, most preferably, 2-methoxy-4-(phenylamino)-benzenediazonium.

R_1 to R_6 are preferably hydrogen, hydroxyl and unsubstituted alkyl groups having 1 to 20 carbon atoms.

Preferably, n is an integer from 4 to 20.

One preferred polymeric sulfonate acid generator is represented by formula (I) wherein R_1 , R_2 , R_3 , R_4 , R_5 , and R_6 , are all hydrogen, SO_3^- group is in the para-positions to the $(CH-CH_2)$ repeating group n is about 8, and X^+ is 2-methoxy-4-(phenylamino)-

benzenediazonium. This compound is 2-methoxy-4-(phenylamino)-benzenediazonium polystyrene sulfonate (MSPSS), and its synthesis is shown in Example 1 below.

Another preferred polymeric sulfonate acid generator is represented by formula (II) wherein R_1 is a hydroxyl group; n is from about 4 to 20 and X^+ is 2-methoxy-4-

(phenylamino) benzene diazonium. This compound 2-methoxy-4-(phenylamino)-benzene diazonium sulfonated phenolic resin (MSFC-369), and its synthesis is shown in Example 2 below. The preferred novolac resin precursor for this second embodiment is FC-369 (available from 3M, St. Paul, Minn.). The exact identification of R_2 , R_3 , and R_4 and n are not disclosed by 3M, but it is believed the SO_3^- group is in both the para and meta position to the hydroxyl group (i.e., there is a mixture of these two isomers).

Preferable onium salt sulfonates can be obtained by reaction of the corresponding onium chloride, bromide, fluoride, iodide or bisulfate salt with sodium or potassium polymeric sulfonate in water or solvent mixture of water and an organic solvent such as an alcohol.

These compounds are added to radiation-sensitive patterning compositions in an amount of 0.01 to 50% by weight, preferably 0.1 to 25% by weight, and more preferably 0.5 to 20% by weight based on the total solid components of the patterning composition. When the amount added is less than 0.01% by weight, an image cannot be obtained, and, when the amount added is more than 50% by weight, a stain is produced in a nonimage formation portion at the time of printing, and thus neither is preferable.

(B) Cross-Linking Agents Cross-Linkable by an Acid

Cross-linking agents cross-linkable by an acid preferably used in the invention (hereinafter referred to as a cross-linking agent) are compounds having, in a molecule, at least two groups bonded to a benzene ring, such as hydroxymethyl, alkoxymethyl, epoxy, or vinyl ether. Examples include methylol melamine, resol resin, epoxidized novolac resin, and urea resin. Other examples include amino resins having at least 2 alkoxymethyl groups (e.g. alkoxymethylated melamine resin, alkoxymethylated glycoluril and alkoxymethylated benzoguanamine). Compounds disclosed in "Kakyozei Handbook (Cross-linking Agent Handbook)", by Shinzo Yamashita and Tosuke Kaneko, published by Taiseisha, Co., Ltd., are also preferable. In particular, phenol derivatives having, in a molecule, at least two groups bonded to a benzene ring such as a hydroxymethyl group and alkoxymethyl group provide good fastness in an image portion when an image is formed, and thus are preferable. Examples of phenol derivatives include resol resin. Preferred resole resins would be GP649D99 resole available from Georgia Pacific and

BKS-5928 resole resin available from Union Carbide Corporation.

However, these cross-linking agents are unstable with respect to heat, and thus they are not very favorable in terms of storability after the production of an image recording material. On the other hand, phenol derivatives having, in a molecule, at least two groups bonded to a benzene ring such as a hydroxymethyl group and alkoxymethyl group, and 3 to 5 benzene rings with a molecular weight of 1,200 or less have good storability, and thus are most preferably used in the invention.

As an alkoxymethyl group, those having 6 or fewer carbon atoms are preferable. Examples include methoxymethyl, ethoxymethyl, n-propoxymethyl, isopropoxymethyl, n-butoxymethyl, isobutoxymethyl, sec-butoxymethyl, and t-butoxymethyl. Furthermore, alkoxy groups having an alkoxy substituent or alkoxy substituents such as a 2-methoxyethoxy, and 2-methoxy-1-propyl are also preferable. Among these phenol derivatives, particularly preferable ones are illustrated in U.S. 5,965,319 (columns 31-38).

Phenol derivatives having a hydroxymethyl group can be obtained by the reaction of a corresponding phenol compound without a hydroxymethyl group and formaldehyde in the presence of a base catalyst. It is preferable that a reaction temperature be 60°C or less to prevent resinification or gelation of the phenol derivative. Specifically, the phenol derivatives having a hydroxymethyl group can be synthesized by methods disclosed in JP-A-6-282067 and 7-64285.

Phenol derivatives having an alkoxymethyl group can be obtained by the reaction of a corresponding phenol derivative having a hydroxymethyl group and alcohol in the presence of an acid catalyst. It is preferable that a reaction temperature be 100°C or less to prevent resinification or gelation of the phenol derivative. Specifically, the phenol derivatives having an alkoxymethyl can be synthesized by a method disclosed in EP-632,003 A1.

The phenol derivatives having a hydroxymethyl group or an alkoxymethyl group synthesized as mentioned above are preferable in terms of storability. The phenol derivatives having an alkoxymethyl group are particularly preferably in terms of storability.

One particularly preferred cross-linking agent is terephthalaldehyde.

The cross-linking agent is used in the amount of 5 to 70% by weight, and preferably, 10 to 65% by weight based on the total solids of the radiation-sensitive material. When the amount of the cross-linking agent is less than 5% by weight, the film strength of the image portion at the time of image recording deteriorates. On the other

hand, an amount more than 70% by weight is not preferable in terms of storability.

These cross-linking agents can be used alone or in a combination of two or more.

(C) Polymer Compounds Capable of Reacting with the Cross-Linking Agent

Any polymer capable of reacting with the cross-linking agent to prepare suitable
5 radiation-sensitive compositions may be employed in the invention. One preferred class
of these polymers are polymer compounds having an alkaline-soluble group in the
molecule. These polymer compounds having an alkaline-soluble group used in the
invention (hereinafter referred to as alkaline-soluble polymer compound) mean resins
having an alkaline-soluble group in a molecule, such as a novolac resin, acetone-
10 pyrogallol resin, polyhydroxystyrenes, hydroxystyrene-N-substituted maleimide
copolymer, hydroxystyrene-maleic anhydride copolymer, and polymer compound such as
an acrylic copolymer or a urethane type polymer having an alkaline-soluble group, whose
monomers include 1 mol % or more of a component unit having an acidic group such as
an acrylic acid. Examples of an alkaline-soluble group here include a carboxyl group,
15 phenolic hydroxyl group, sulfonic acid group, phosphonic acid group, imide group,
carbonate groups and sulfonamide groups.

Novolac resins are resins obtained by the condensation of phenols and aldehydes
under an acidic condition. Examples of preferable novolac resins include novolac resin
obtained from phenol and formaldehyde, novolac resin obtained from m-cresol and
20 formaldehyde, novolac resin obtained from o-cresol and formaldehyde, novolac resin
obtained from octylphenol and formaldehyde, novolac resin obtained from m-/p- mixed
cresol and formaldehyde, novolac resin obtained from a mixture of phenol/cresol (either of
m-, p-, o-, or m-/p-, m-/o-, o-/p- mixed) and formaldehyde, novolac resin obtained from
resorcinol and formaldehyde, and novolac resin obtained from phenol/resorcinol and
25 formaldehyde. It is preferable that these novolac resins have a weight-average molecular
weight of 800 to 200,000 and a number-average molecular weight of 400 to 60,000.

When a polymer at least one of whose monomers is hydroxystyrene such as poly-
p-hydroxystyrene, poly-m-hydroxystyrene, p-hydroxystyrene-N-substituted maleimide
copolymer, and p-hydroxystyrene-maleic anhydride copolymer is used, it is preferable that
30 the weight-average molecular weight be 2,000 to 500,000, and preferably 4,000 to
300,000.

Examples of acrylic copolymers having an alkaline-soluble group include
methacrylic acid-allylmethacrylate copolymer, methacrylic acid-benzylmethacrylate
copolymer, methacrylic acid-hydroxyethylmethacrylate copolymer, poly(hydroxyphenyl

methacrylamide), poly(hydroxyphenylcarbonyloxyethyl acrylate), and poly(2,4-dihydroxyphenyl carbonyloxyethyl acrylate). These acrylic resins are resins whose monomers include a component unit having, in a molecule, an acidic group such as carboxyl group and hydroxyphenyl group. Resins whose component units include 1 mol % or more of (meth)acrylic acid, hydroxystyrene, and hydroxyphenyl (meth)acrylamide based on the total component units and whose weight-average molecular weight is 2,000 to 500,000, preferably 4,000 to 300,000 is preferable.

Examples of urethane type polymers having an alkaline-soluble group include a resin obtained by the reaction of diphenylmethane diisocyanate, hexamethylene diisocyanate, tetraethylene glycol, and 2,2-bis(hydroxymethyl) propionic acid. It is preferable that the urethane-type polymer be a resin whose monomer include a component unit having an acidic group such as carboxylic acid and a hydroxyphenyl group in a molecule in an amount of 1 mol % or more.

Among these examples of alkaline soluble polymer compounds, novolac resins are preferable in terms of the durability of the form plate. On the other hand, polymers whose monomers include hydroxystyrene and acrylic copolymers having an alkaline-soluble group are preferable in terms of developing properties.

The amount of these alkaline soluble polymer compounds is 10 to 90% by weight, preferably 20 to 85% by weight, and more preferably 30 to 80% by weight based on the total solids of the radiation-sensitive patterning composition. If the amount of the alkaline soluble polymer compound is less than 10% by weight, the durability of the radiation-sensitive layer deteriorates. On the other hand, an amount more than 90% by weight is not preferable in terms of either sensitivity or durability. These alkaline soluble polymer compounds can be used alone or in a combination of two or more.

While not wishing to be bound by theory, it is believed that the crosslinking and binder resins are co-reactive resins. The designations of "crosslinking resins" and "binder resin" may therefore be used interchangeably and, in some cases, one resin may act as both a "crosslinking resin" and as a "binder resin."

(D) Infrared Absorbing Compounds

Infrared ray absorbing compounds used in the invention are a dye or pigment effectively absorbing an infrared ray having a wavelength of 760 nm to 1,200 nm. It is preferable that the dye or pigment have an absorption maximum between the wavelengths of 760 nm and 1,200 nm. Preferably, the IR dyes contain anions that do not form volatile acids in the presence of other strong acids.

Commercially available dyes or those disclosed in the literature (such as "Senryo Binran (Dye Handbook)" edited by Yuki Gosei Kagaku Kyokai (Organic Synthetic Chemistry Association), published in 1970, can be used. Examples include azo dyes, metal complex azo dyes, pyrazolone azo dyes, anthraquinone dyes, phthalocyanine dyes, carbonium dyes, quinoneimine dyes, methyne dyes, cyanine dyes, and metal thiolate complexes. Examples of preferable dyes include cyanine dyes disclosed in JP-A-58-125246, 59-84356, 59-202829, and 60-78787; methyne dyes disclosed in JP-A-58-173696, 58-181690, and 58-194595; naphthoquinone dyes disclosed in JP-A-58-112793, 58-224793, 59-48187, 59-73996, 60-52940, and 60-63744; squarylium dyes disclosed in JP-A-58-112792; and cyanine dyes disclosed in U.K. 434,875.

Furthermore, near infrared absorption sensitizing agents disclosed in U.S. 156,938 can be preferably used. Moreover, substituted aryl benzo(thio)pyrylium salts disclosed in U.S. 3,881,924; trimethyne thiapyrylium salts disclosed in JP-A-57-142645 (U.S. 4,327,169); pyrylium-containing compounds disclosed in JP-A-58-181051, 58-220143, 59-41363, 59-84248, 59-84249, 59-146063, and 146061; cyanine dyes disclosed in JP-A-No. 59-216146; pentamethyne thiopyrylium salts disclosed in U.S. 4,283,475; and pyrylium compounds disclosed in JP-5-13514 and 5-19702 can be preferably used as well. Other preferable dyes include the near infrared absorption dyes disclosed in U.S. 4,756,993, preferably those represented by formulas (I) and (II) of U.S. 4,756,993 therein.

Among these dyes, particularly preferable are cyanine dyes, squarylium dyes, pyrylium salts, and nickel thiolate complexes.

Pigments usable in the invention include commercially available pigments and those disclosed in the Color Index (C. I.) Manual, "Saishin Ganryo Binran (Modern Pigment Manual)" edited by Nippon Ganryo Gijutsu Kyokai (Japan Pigment Technology Association), published in 1977; "Ganryo Oyo Gijutsu (Modern Pigment Application Technology)" by CMC Press, published in 1986; and "Insatsu Ink Gijutsu (Printing Ink Technology)" by CMC Press, published in 1984. Examples of pigments include black pigments, yellow pigments, orange pigments, brown pigments, red pigments, purple pigments, blue pigments, green pigments, fluorescent pigments, metal powder pigments, and polymer bond pigments. Specifically, insoluble azo pigments, azo lake pigments, condensation azo pigments, chelate azo pigment, phthalocyanine pigments, anthraquinone pigments, perylene and perynone pigments, thioindigo pigments, Paris Blue pigment, Prussian Blue pigment, quinacridone pigments, dioxazine pigments, isoindolinone pigments, quinophthalone pigments, colored lake pigments, azine pigments, nitroso

pigments, nitro pigments, natural pigments, fluorescent pigments, inorganic pigments, and carbon black can be used. Among these examples, carbon black is preferable.

These pigments can be used without surface treatment, or can be used after being applied with surface treatment. Examples of surface treatment methods include a method of surface coating with a resin or a wax, a method of adhering a surfactant, and a method of bonding a reactive substance (such as a silane coupling agent, an epoxy compound, and polyisocyanate) with the pigment surface. The above-mentioned surface treatment methods are disclosed in "Kinzokusekken no Seishitsu to Oyo (Natures and Applications of Metal Soaps)" by Sachi Press; "Insatsu Ink Gijutsu (Printing Ink Technology)" by CMC Press; published in 1984; and "Saishin Ganryo Oyo Gijutsu (Modern Pigment Application Technology)" by CMC Press, published in 1986.

A pigment particle size of 0.01 μm to 10 μm is preferable, 0.05 μm to 1 μm is more preferable, and 0.1 μm to 1 μm is the most preferable. A pigment particle size smaller than 0.01 μm is not preferable in terms of the stability of the pigment dispersion in a photosensitive layer coating solution. On the other hand, a pigment particle size larger than 10 μm is not preferable in terms of the uniformity of the image recording layer.

As methods of dispersing a pigment, known dispersing methods employed in ink production or toner production can be used. Examples of dispersing machines include ultrasonic dispersing machines, sand mills, attritors, pearl mills, super mills, ball mills, impellers, dispersers, KD mills, colloid mills, dynatrons, triple roll mills, and pressure kneaders. Details thereof are described in "Saishin Ganryo Oyo Gijutsu (Modern Pigment Application Technology)" by CMC Press, published in 1986.

These dyes or pigments can be added in an amount of 0.01 to 50% by weight based on the total solids of the radiation-sensitive patterning material, preferably in an amount of 0.1 to 10% by weight, more preferably in an amount of 0.5 to 10% by weight in the case of a dye, and more preferably in an amount of 0.1 to 10% by weight in the case of a pigment. An amount of a pigment or dye less than 0.01% by weight causes low sensitivity. On the other hand, an amount more than 50% by weight produces stains in a nonimage portion at the time of printing.

These dyes or pigments can be added in a layer with other components or, when the image recording material comprises a plurality of layers, can be added in a layer which is different from a layer containing the other components.

While IR absorbers are generally required for most preferred applications, new developments with dynamic mirrors and UV lasers may allow for radiation-sensitive

compositions that do not require IR absorbers, but only need the above-noted first three components. Accordingly, one embodiment of the invention encompasses this alternative composition and its use with these new imaging techniques.

(E) Other Components

5 In the invention, the above-mentioned four components (A) to (D) are necessary, and various compounds can be added to the radiation-sensitive patterning material as needed.

For example, a dye having a large absorption in the visible light region can be used as the coloring agent. Preferably, these visible dyes and colorant agents contain anions that do not form volatile acids in the presence of other strong acids. Specifically,
10 examples include Oil Yellow #101, Oil Yellow #103, Oil Pink #312, Oil Green BG, Oil Blue BOS, Oil Blue #603, Oil Black BY, Oil Black BS, Oil Black T-505 (Orient Chemical Industry, Co., Ltd.), Victoria Pure Blue, Crystal Violet (CI42555), Methyl Violet (CI42535), Ethyl Violet, Rhodamine B (CI145170B), Malachite Green (CI42000),
15 Methylene Blue (CI52015), and dyes disclosed in JP-A- 62-293247. It is preferable to add these dyes for easily distinguishing the image portion and the nonimage portion after image formation. The amount to be added is 0.01 to 10% by weight based on the total solid component of the patterning composition.

In order to enable stable treatment regardless of the fluctuation in development
20 conditions, a nonionic surfactant disclosed in JP-62-251740 and 3-208514 and an ampholytic surfactant disclosed in JP-A-121044 and 4-13149 can be added to the patterning composition. Examples of nonionic surfactants include sorbitan tristearate, sorbitan monopalmitate, sorbitan triolate, mono glyceride stearate, and polyoxyethylene nonylphenyl ether. Examples of ampholytic surfactants include alkyl
25 di(aminoethyl)glycine, alkyl polyaminoethylglycine hydrochloride, 2-alkyl-n-carboxyethyl-N-hydroxyethyl imidazolinium betaine, and N-tetradecyl-N,N-substituted betaine (for example, Amorgen K, Dai-Ichi Kogyo Co., Ltd.). The amount of the above-mentioned nonionic surfactants and ampholytic surfactants is preferably 0.05 to 15% by weight, and more preferably 0.1 to 5% by weight in a radiation-sensitive patterning
30 material.

In order to provide flexibility to the film, and the like, a plasticizer can be added as needed to the image recording material. Examples include butylphthalyl, polyethylene glycol, tributyl citrate, diethyl phthalate, dibutyl phthalate, dihexyl phthalate, dioctyl phthalate, tricresyl phosphate, tributyl phosphate, trioctyl phosphate, tetrahydrofurfuryl

oleate, an oligomer and a polymer of acrylic acid or methacrylic acid.

In addition to these examples, the above-mentioned onium salts, haloalkylated s-triazines, epoxy compounds, vinyl ethers, phenol compounds having an alkoxy methyl group and phenol compounds having a hydroxymethyl group disclosed in JP-7-18120, can also be added.

The image recording material can be produced, in general, by dissolving the above-mentioned component in a solvent and applying the resultant solution to an appropriate support. Solvents used herein include, but are not limited to, ethylene dichloride, cyclohexanone, methyl ethyl ketone, methanol, ethanol, propanol, ethylene glycol monomethyl ether, 1-methoxy-2-propanol, 2-methoxy ethyl acetate, 1-methoxy-2-propyl acetate, dimethoxyethane, methyl lactate, ethyl lactate, N,N-dimethyl acetamide, N,N-dimethyl formamide, tetramethyl urea, N-methyl pyrrolidone, dimethyl sulfoxide, sulfolane, gamma.-butyl lactone, toluene, acetone and water.

These solvents are used alone or as a mixture. The concentration of the above-mentioned components (total solid components including additives) is preferably 1 to 50% by weight in the solution. The application amount (solid component) on the support obtained after applying and drying is determined according to the application purpose. However, as to the planographic printing plate, in general, 0.5 to 5.0 g/m² is preferable and 1 to 2.5 g/m² is more preferable. As a method of application, various methods can be used, such as bar coater application, rotation application, spray application, curtain application, dip application, air knife application, blade application, and roll application. As the application amount decreases, the apparent sensitivity increases, but the film characteristic of the image recording film decreases.

A surfactant for improving the applicability, such as a fluorine-containing surfactant disclosed in JP-A-62-170950 can be added to the image recording layer. An addition amount is preferably 0.01 to 1% by weight based on the total solid component of the radiation-sensitive patterning composition, and more preferably 0.05 to 0.5% by weight.

II. Lithographic Substrates

Examples of a support used in the invention include dimensionally stable plate-like substances such as paper, paper laminated with plastic (such as polyethylene, polypropylene, and polystyrene), metal plates (such as aluminum, zinc, and copper), plastic films (such as cellulose diacetate, cellulose triacetate, cellulose propionate, cellulose butyrate, cellulose acetate/butyrate, cellulose nitrate, polyethylene terephthalate,

polyethylene, polystyrene, polypropylene, polycarbonate, and polyvinyl acetal), and paper or plastic film laminated or deposited with the above-mentioned metals.

A polyester film or an aluminum plate is preferable as a support in the invention. In particular, an aluminum plate is preferable since it has good dimensional stability and can be provided at a relatively low cost. Examples of preferable aluminum plates include pure aluminum plates and alloy plates comprising aluminum as the main component and trace quantities of a different element. Furthermore, plastic films to which aluminum is laminated or deposited can also be used. Examples of different elements included in an aluminum alloy include silicon, iron, manganese, copper, magnesium, chrome, zinc, bismuth, nickel, and titanium. An amount of the different element in the alloy is preferably 10% by weight or less. In the invention, pure aluminum is particularly preferable. However, since production of a completely pure aluminum is difficult in terms of refining technology, one containing trace quantities of a different element can be used. The composition of an aluminum plate applied in the invention as mentioned above is not specifically defined, and a known aluminum plate can be also used. The thickness of an aluminum plate used in the invention is about 0.1 mm to 0.6 mm, preferably 0.15 mm to 0.4 mm, and more preferably 0.2 mm to 0.3 mm.

When an aluminum plate is used as the support, it is desirable to conduct a roughening treatment prior to the coating with a polymer first layer. Also, prior to roughening of the aluminum plate, a degreasing treatment with a surfactant, an organic solvent, or an aqueous alkaline solution is conducted for removing the rolling oil on the surface as needed.

The surface roughening treatment of an aluminum plate can be implemented using various methods, such as a mechanically roughening method, an electrochemically roughening method in which a plate surface is dissolved, and a chemically roughening method in which a plate surface is dissolved selectively. As a mechanical method, known methods such as a ball abrasion method, brush abrasion method, blast abrasion method, and buff abrasion method can be used. As an electrochemically roughening method, a method in which an alternating current or direct current is applied to a plate in an electrolytic solution containing a hydrochloric acid or nitric acid can be used. Further, a method combining both of the above-mentioned methods as disclosed in JP-A-54-63902 can be used.

An aluminum plate to which surface roughening treatment is applied may be subjected to an alkaline etching treatment or a neutralizing treatment, if necessary,

followed by an anodizing treatment so as to improve the water retention property and the abrasion resistance property of the surface, if desired. As an electrolyte used in the anodizing treatment of an aluminum plate, various electrolytes which form a porous oxide film can be used. In general, sulfuric acid, phosphoric acid, oxalic acid, chromic acid, or a mixture thereof can be used. The concentration of an electrolyte is suitably decided according to the type of electrolyte.

The treatment conditions of the anodization may not be specified since they significantly change depending on the type of electrolyte solution used. In general, conditions of an electrolyte solution concentration of 1 to 80% by weight, a solution temperature of 5 to 70°C, a current density of 5 to 60 A/dm², a voltage of 1 to 100 V, and an electrolysis duration of 10 seconds to 5 minutes are appropriate.

If the amount of film produced by anodization, durability of the plate may be insufficient, less than 1.0 g/m², and scratches may be easily produced in a non-image portion of the planographic printing plate and, thereby, so-called "scratch toning" in which ink adheres to such scratches in printing.

After the anodizing treatment, hydrophilic treatment is applied to the aluminum surface, if necessary. Examples of a hydrophilic treatment used in the invention include an alkaline metal silicate (such as an aqueous solution of sodium silicate) method as disclosed in U.S. 2,714,066, 3,181,461, 3,280,734, and 3,902,734. In this method, the support (aluminum plate) is treated by immersing or electrolysis with an aqueous solution of sodium silicate. Other examples include a method of treating with potassium fluoro-zirconate disclosed in JP-B-36-22063 and a method of treating with polyvinyl phosphonate disclosed in U.S. 3,276,868, 4,153,461, and 4,689,272.

III. Processes of Imaging

The patterning composition is coated onto the above-noted substrate by any known coating technique. Examples of such coating technology include rotation or spin coating, slot coating wire bar coating, dip coating, air knife coating, roll coating, blade coating, curtain coating and the like. The preferred method is slot coating.

The patterning composition is preferably dried to a suitable temperature to remove excess solvent. This drying may be carried out in a hot air drier or infrared ray dryer and the like, preferably at temperatures from about 40°C to about 150°C for 30 seconds to 10 minutes.

The thickness of the resulting layer, after drying, on the support can vary widely, but it is typically in the range from about 0.5 to about 3 microns, more preferably, from

about 1 to about 2 microns.

No other essential layers are provided on the substrate. In particular, there need be no protective or other type of layers over the patterning composition layer. Optional, but not preferred, antihalation layers may be disposed under the imaging layer, or on the backside of the support (such as when the support is a transparent polymeric film).

In the second step, the patterning composition layer is subjected to sufficient actinic radiation (e.g. 180 nm to 1200 nm) to imagewise expose that layer. The actinic radiation may be any radiation that will image this layer, including infrared (IR), ultraviolet and visible light. The sensitive material is preferably exposed to infrared radiation (IR) by scanning a laser beam modulated by an image signal. This IR imaging may be carried out by well-known methods. For example, the patterning composition layer may be imaged with a laser or an array of lasers emitting modulated near IR or IR radiation in a wavelength region that is absorbed by the absorber. IR radiation, especially IR radiation in the range of 750 to 1200 nm, preferably about 800 nm to about 1125 nm, is typically used for imaging thermally imageable elements. Imaging is conveniently carried out with a laser emitting at about 830 or at about 1056 nm. The IR exposure energy is preferably from about 30 to about 500 mJ/cm²; more preferably from about 30 to about 350 mJ/cm², and most preferably from about 50 to about 175 mJ/cm². Suitable commercially available imaging devices include imagesetters such as the Creo Trendsetter (CREO, British Columbia, Canada), the Gerber Crescent 42T (GERBER, Brussels, Belgium) and Platerite 8000 (SCREEN, Rolling Meadows, Illinois). While IR exposure is the preferred actinic radiation source, conventional UV light or visible light sources may also be used. These include carbon arc lamps, mercury vapor lamps, fluorescent lamps, tungsten lamps and photoflood lamps operating in the UV/visible light spectrum between 250 and 700 nm.

Alternatively, the patterning composition layer may be imaged using an apparatus containing a heated stylus or a thermal printing heat. A suitable commercially hot stylus imaging device is the GS 618-400 thermal plotter (OYO Instruments, Houston, Texas). When exposure is carried out with a thermal head, it is unnecessary that the element contains the IR absorber. However, elements that do can still be imaged with the thermal head.

After the imagewise radiation or exposure, the patterning composition may be optionally heated. This optional heating operation can be effected by radiation, convection, contact with heated surfaces, for example, with rollers, or by immersion in a heated bath comprising an inert liquid, for example, water. The temperature range will be

set around the fog point of the plate containing the patterning composition. The fog point is defined as the minimum amount of heat energy required to render a thermal plate non-processable. Preferably, the applied heat energy is $\pm 50^{\circ}\text{F}$ from the fog point, more preferably $\pm 30^{\circ}\text{F}$ from the fog point and most preferably $\pm 15^{\circ}\text{F}$ from the fog point. The duration of heating can vary widely, depending on the method chosen for the application of heat as well as the other steps in the process. If a heat-transferring medium is used, the heating time will preferably be from about 30 seconds to about 30 minutes, more preferably from about 1 minute to about 5 minutes.

The next step is developing the exposed patterned composition layer with an aqueous developing solution. The developing solution may be any liquid or solution that can penetrate and remove the unexposed regions without substantially affecting the complimentary exposed regions. While not being bound by any theory or explanation, it is believed that image discrimination is based on kinetic effect. The unexposed regions are removed more rapidly in the developer than the exposed regions. Development is carried for a long enough time to remove the unexposed regions in the developer, but not long enough to remove the exposed regions. The preferred time in the developer is from about 10 to 120 seconds. Hence, the unexposed regions are described as being "soluble" or "removable" in the developer because they are removed, and dissolved and/or dispersed, more rapidly in the developer than the exposed regions.

A conventional aqueous alkaline solution can be used as a developer or a replenisher for the image recording material. Examples include inorganic alkaline salts such as sodium silicate, potassium silicate, sodium tertiary phosphate, potassium tertiary phosphate, ammonium tertiary phosphate, sodium secondary phosphate, potassium secondary phosphate, ammonium secondary phosphate, sodium carbonate, potassium carbonate, ammonium carbonate, sodium hydrogencarbonate, potassium hydrogencarbonate, ammonium hydrogencarbonate, sodium borate, potassium borate, ammonium borate, sodium hydroxide, ammonium hydroxide, potassium hydroxide, and lithium hydroxide. Furthermore, also used are organic alkaline agents such as monomethyl amine, dimethyl amine, trimethyl amine, monoethyl amine, diethyl amine, triethyl amine, monoisopropyl amine, diisopropyl amine, triisopropyl amine, n-butyl amine, monoethanol amine, diethanol amine, triethanol amine, monoisopropanol amine, diisopropanol amine, ethylene imine, ethylene diamine, and pyridine.

These alkaline agents can be used alone or in a combination of two or more.

Furthermore, it is known that, when an automatic developing machine is used for developing, by adding to the developer an aqueous solution (replenisher) whose alkaline is stronger than that of the developer, a large amount of planographic printing plates can be developed without changing the developer in the developing tank for a long time. The replenishing method is also preferably applied in the invention.

Various types of surfactants and organic solvents can be added to a developer or a replenisher for promoting or curbing the developing property, improving the dispersion of developing scum or conformity of the printing plate image portion to ink as needed. Examples of preferable surfactants include anionic surfactants, cationic surfactants, nonionic surfactants, and ampholytic surfactants.

Furthermore, reducing agents such as a sodium salt or a potassium salt of an inorganic acid including hydroquinone, resorcinol, sulfurous acid, and hydrogen sulfurous acid, organic carboxylic acid, antifoaming agents, and water softeners can be added to a developer or a replenisher as needed.

Useful developers are aqueous solutions having a pH of about 7 or above. Preferred aqueous alkaline developers are those that have a pH between 8 and about 13.5, typically at least about 11, preferably at least about 12. Useful developers include commercially available developers such as PC9000, PC3000, PC955, PC592, GoldstarTM, GreenstarTM, ThermalProTM, PROTHERM®, MX1710, and 956 aqueous alkaline developers each available from Kodak Polychrome Graphics LLC. Developers are described for example in Yamasue, U.S. 4,259,434; Seino, U.S. 4,452,880; Miller, U.S. 5,851,735; Eckler, U.S. 5,998,102; Miro, EP-A-0732628; Toyama, GB-A-2,276,729; and Fiebag, U.S. 6,143,479.

Development is typically carried out in a processor equipped with an immersion type developing bath, a section for rinsing with water, a gumming section, a drying section and a conductivity measuring unit. Typically, the developer is applied to the imaged precursor by rubbing or wiping the element with an applicator containing the developer. Alternatively, the imaged precursor may be brushed with the developer or the developer may be applied to the precursor by spraying the element with sufficient force to remove the unexposed regions. In either instance, a printing plate is produced. Development may be carried out in a commercially available processor, such as a Mercury V Processor and (Kodak Polychrome Graphics) and a Quartz K85 Processor (Glunz and Jensen of Norfolk, UK). Preferably, the developer temperature is from about 10°C to about 50°C, more

preferably about 15°C to about 35°C. Following development, the printing plate is rinsed with water and dried. Drying may be conveniently carried out by IR heaters or with hot air. After drying, the printing plate may be treated with a gumming solution. A gumming solution comprises one or more water soluble polymers, for example polyvinylalcohol, polymethacrylic acid, polymethacrylamide, polyhydroxyethylmethacrylate, polyvinylmethacrylate, gelatin and polysaccharide such as dextrin, pullulan, cellulose, gum arabic and alginic acid. A preferred material is gum arabic.

While post-development heating or other operation is normally not necessary for this invention, such operations may be preferred for some applications.

The images obtained by the above described processing are suitable for many uses. For example, in the case of using a simple aluminum plate as the base, good prints are obtained by applying it to a printing machine after carrying out development. Further, a material prepared by providing a sensitive layer containing dyes on a transparent plastic film such as a polyester film can be used for correction of prints. In addition, it is possible to use photomasks, laser recording of output signals of computers and facsimile recording materials.

Moreover, the base of the developed sensitive material may be subjected to various processings according to the purpose. For example, in case of using a glass plate having a chromium vacuum deposition layer as the base, the chromium deposition layer is etched with a known etching solution containing ceric ion after the sensitive layer is developed to form an etching resist, and the resist layer is then removed, by which the base can be used as a hard mask. In case of using a silicon plate as the base, it is possible to make an etching resist of the silicon oxide layer or to use for a lift-off step. In case of using a copper foil plate for making a print circuit plate, it is possible to use as an etching resist or a plating resist after development.

The invention is further described in detail by means of the following Examples and Comparisons. All parts and percentages are by weight and all temperatures are degrees Celsius unless explicitly stated otherwise.

EXAMPLES

SYNTHESIS EXAMPLE 1

Synthesis of 2-methoxy-4-(phenylamino)-benzenediazonium polystyrene sulfonate (MSPSS) acid generator.

0.50 g of sodium polystyrene sulfonate (Scientific Polymer Products, Ontario, NY) in 50 ml of water was slowly mixed with 15 ml of 5% (wt%) 2-methoxy-4-

(phenylamino)-benzenediazonium bisulfate (Diverstec, Fort Collins, CO) aqueous solution while stirring. The mixture was stored in dark at 0-5°C for 5 hours. After decanting water, the resulting oil material was dried under nitrogen flow and the yield was 1.0 g. The product was then dissolved in 30 ml of γ -butyrolactone (BLO), and was stored in refrigerator for further use.

Proton NMR (in DMSO- d_6): δ 0.4-2.4 (4H, br), 4.0 (3H, s), 6.5-7.0 (4H, m, br), 7.2-7.8 (7H, m, br), 8.1 (1H, s), and 10.8 (1H, s).

SYNTHESIS EXAMPLE 2

Synthesis of 2-methoxy-4-(phenylamino)-benzenediazonium sulfonated phenolic resin (MSFC-369) acid generator.

10 g of sodium sulfonated phenolic resin FC-369 (3M, St. Paul, MN) in 150 ml of water was slowly mixed with 25 ml of 5% (wt%) 2-methoxy-4-(phenylamino)-benzenediazonium bisulfate (Diverstec, Fort Collins, CO) aqueous solution while stirring. The reaction mixture was stored in dark at 0-5°C for 5 hours. The yellow solid was collected by filtration and then dried by vacuum. The yield was 8.8 g.

Proton NMR in DMSO- d_6): δ 3.8 (2H, br), 4.0 (3H, s), 6.5-7.2 (5H, m), 7.2-8.2 (12H, m), 10.7 (1H, s) and 11.1 (1H, m).

EXAMPLE 3

Preparations of the lithographic plates

A coating solution was prepared by dissolving 5.6 g of 25% resole (GP649D99 resole resin from Georgia-Pacific, Atlanta, GA), 6.8 g of 34% N-13 novolac (Eastman Kodak, Rochester, NY), 23 g of MSPSS (3.5% in BLO) prepared above, 0.42 of Trump IR dye (2-[2-[2-chloro-3-[2-(1,3-dihydro-1,3,3-trimethyl-2H-benzeindol-2-ylidene)ethylidene]-1-cyclohexen-1-yl]ethenyl]-1,3,3-trimethyl-1H-benzeindolium 4-methylbenzenesulfonate) (Eastman Kodak, Rochester, NY), 0.06 g of D11 colorant dye (PCAS, Longjumeau, France), and 0.2 g of 10% Byk-307 (Byk-Chemie, Wallingford, CT) in 30 g of 1-methoxy-2-propanol and 25 g of BLO. An electrochemically grained and anodized aluminum substrate, post-treated with polyvinylphosphoric acid (PVPA), was coated with above solution with a dry coating weight of about 120 mg/ft². When properly dried at 190°F for about 2 minutes on a rotating drum, the resulting plate was placed on a CREO Trendsetter 3244x image setter (CreoScitex, Burnaby, British Columbia, Canada) and exposed to 830 nm IR laser at a drum speed of 165 rpm and a series of laser power from 3 to 14 W (ranged from 40 to 180 mJ/cm²). The minimum exposure energy to

achieve maximum processed density was about 100 mJ/cm^2 . The plate was preheated in a SPC Mini-HD Oven (Wisconsin Oven Corp., East Troy, WI) at 263°F for about 2 minutes and was subsequently developed through a Unigraph Quartz K85 processor (Glunz & Jensen, Norfolk, England) charged with ThermalProTM developer (Kodak Polychrome Graphics, Norwalk, CT) at 25°C . The developed plate was mounted on a Miehle sheet-fed press to produce about 20,000 good impressions using a black ink containing 1.5% of calcium carbonate

The plate can alternatively be imaged by UV radiation. An UV exposure was accomplished by flood exposing the plate prepared above on an Olec Light Integrator (OLEC Corporation, Irvine, CA) with 25 units, and a six to ten sensitivity was achieved based on a T-4 grayscale.

EXAMPLE 4

A coating solution was prepared by dissolving 6.8 g of 25% resole (GP649D99 resole resin, Georgia-Pacific), 8.4 g of 34% N-13 novolac (Eastman Kodak), 0.7 g of MSFC-369 prepared above, 0.5 of Trump IR dye (described above) (Eastman Kodak), 0.4 g of terephthalaldehyde (Aldrich), 0.1 g of D11 colorant dye (PCAS, Longjumeau, France), and 0.2 g of 10% Byk-307 (Byk Chemie) in 64 g of 1-methoxy-2-propanol and 20 g of BLO. An electrochemically grained and anodized aluminum substrate was coated with above solution with a dry coating weight of about 130 mg/ft^2 . The plates were imaged as described in Example 3. The minimum exposure energy to achieve maximum image density was about 120 mJ/cm^2 . The plate can alternatively be imaged by UV radiation.

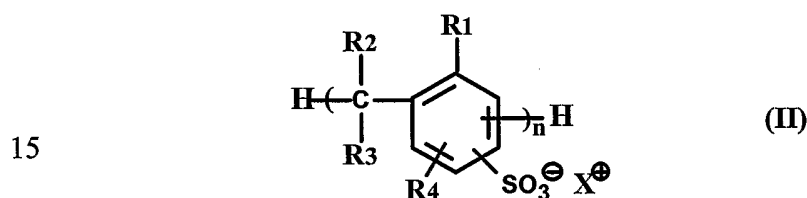
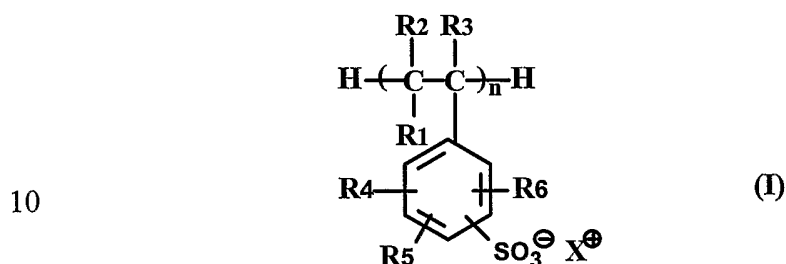
When Example 3 to 4 are conducted with UV imaging, the IR dye employed therein is non-critical.

WHAT IS CLAIMED IS:

1. A radiation-sensitive patterning composition comprising:

(1) at least one acid generating compound selected from compounds of formula

5 (I) and formula (II):



wherein:

R₁, R₂, R₃, R₄, R₅, and R₆, are independently selected from the group consisting of hydrogen, nitro, hydroxyl, carbonyl, halogen, cyano, unsubstituted and substituted alkyl groups, unsubstituted and substituted cycloalkyl groups; unsubstituted and substituted alkoxy groups, and unsubstituted and substituted aryl groups;

wherein:

X⁺ is an onium ion selected from the group consisting of diazonium, iodonium, sulfonium, phosphonium, bromonium, chloronium, oxysulfoxonium, oxysulfonium, sulfoxonium, selenium, tellurium and arsenium; and

n is an integer from 4 to 100;

(2) at least one cross-linking agent cross-linkable by an acid;

(3) at least one polymer compound capable of reacting with the cross-linking agent; and

(4) at least one infrared absorbing compound.

2. The radiation-sensitive patterning composition of claim 1 wherein R₁, R₂, R₃, R₄, R₅, and R₆ are independently selected from the group consisting of hydrogen, hydroxyl, and unsubstituted and substituted alkyl groups having 1 to 20 carbon atoms.

3. The radiation-sensitive patterning composition of claim 1 or claim 2 wherein X^+ is selected from the group consisting of diazonium, iodonium, and sulfonium.

4. The radiation-sensitive patterning group of claim 1 or claim 2 wherein the X^+ is 2-methoxy-4-(phenylamino)-benzenediazonium.

5. The radiation-sensitive patterning group of any of claims 1 to 4 wherein R_1 , R_2 , R_3 , R_4 , R_5 , and R_6 are each hydrogen and n is from 4 to 20.

6. The radiation-sensitive patterning composition of any of claims 1 to 5 wherein the polymer compound is a polymer compound having an alkaline-soluble group

7. The radiation-sensitive patterning composition of any of claims 1 to 6 wherein the cross-linking agent is a terephthalaldehyde.

8. The radiation-sensitive patterning composition of any of claims 1 to 7 wherein:

the acid generating compound comprises about 0.01% to about 50% by weight of the solid components of the radiation-sensitive composition.;

the cross-linking agent comprises about 5% to 70% by weight of the solid components of the radiation-sensitive composition;

the polymer compound comprises about 10% to about 90% by weight of the solid components of the radiation-sensitive composition; and

the infrared absorbing agent comprises about 0.01% to about 50% by weight of the solid components of the radiation-sensitive composition.

9. A radiation-sensitive imaging element comprising a lithographic substrate having a coating of the radiation-sensitive composition of any of claims 1 to 8 thereon.

10. A process of imaging a radiation-sensitive element comprising the steps of:

(1) providing the photosensitive imaging element of claim 9;

(2) imagewise exposing the radiation-sensitive imaging element; and

(3) removing unexposed areas of the photosensitive composition layer from the lithographic substrate.

INTERNATIONAL SEARCH REPORT

International Application No

PCT/US 03/17063

A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 G03F7/004 G03F7/038 B41C1/10

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 G03F B41C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

WPI Data, PAJ, EPO-Internal, INSPEC

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 5 965 319 A (F. KOBAYASHI) 12 October 1999 (1999-10-12) cited in the application column 10, line 36 - line 67 column 11, line 1 - line 15 claims	1-10
Y	US 5 945 250 A (T. AOAI ET AL.) 31 August 1999 (1999-08-31) cited in the application claims	1-10
A	US 4 661 429 A (M. MOLLAIRE ET AL.) 28 April 1987 (1987-04-28) claims 1,6	1-10
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☒ Further documents are listed in the continuation of box C.☒ Patent family members are listed in annex.

* Special categories of cited documents:

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O document referring to an oral disclosure, use, exhibition or other means

P document published prior to the international filing date but later than the priority date claimed

T later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

X document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

Y document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

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Name and mailing address of the ISA

European Patent Office, P.B. 5618 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,
Fax: (+31-70) 340-3016

Authorized officer

Dupart, J.-M.

INTERNATIONAL SEARCH REPORT

International Application No

PCT/US 03/17063

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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Information on patent family members

International Application No

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