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(54) Titre : FORMULATION DE PEINTURE DURCISSABLE ET PHOTOACTIVABLE AUX ULTRAVIOLETS ET
REVETEMENTS DURCIS CONNEXES

(54) Title: UV PHOTOACTIVATABLE CURABLE PAINT FORMULATIONS AND CURED COATINGS THEREOF

(57) **Abrégé/Abstract:**

A UV photoactivatable curable paint formation for providing a cured paint coating of a desired appearance on a substrate by UV irradiation, comprises a UV curable film-forming compound; a UV photoinitiator; a particulate UV reflective material in an effective rate of curing enhancing amount without affecting the resultant desired appearance of the cured paint coating.



ABSTRACT

5 A UV photoactivatable curable paint formation for providing a cured paint coating of a desired appearance on a substrate by UV irradiation, comprises a UV curable film-forming compound; a UV photoinitiator; a particulate UV reflective material in an effective rate of curing enhancing amount without affecting the resultant desired appearance of the cured paint coating.

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UV PHOTOACTIVATABLE CURABLE PAINT
FORMULATIONS AND CURED COATINGS THEREOF

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FIELD OF THE INVENTION

This invention relates to UV photoactivable curable paint formulations, process of producing cured coatings therefrom and said cured coatings. It relates particularly to the production of vehicle surfaces coated with said cured formulation by UV radiation.

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BACKGROUND TO THE INVENTION

UV photoactivatable curable paint formulations for providing cured paint coatings on a substrate by UV irradiation are known. These prior art formulations comprise UV curable film-forming compounds and a UV photoinitiator to initiate polymeric reaction of the film-forming compounds under the action of the UV radiation.

Such formulations may be pigment-free if a clear coat is desired or contain pigments, dyes and the like if a white, coloured, metallic or other effect appearance is desired. Metallic paints comprising particulate metals are, thus, known wherein the particulate metal is present to provide a desired resultant appearance.

It will be readily understood that it is generally desirable that suitable curing of a curable paint formulation be attained in a reasonable period of time. This is extremely desirable in a commercial environment, such as the surface coating of vehicle bodies and parts thereof on a manufacturing assembly line where the rate of vehicle throughput in a paint shop can have a significant operational cost to the overall manufacturing process.

PCT/EPO5/005517, published November 24, 2006, corresponding to US 2008/0032037A1, published February 7, 2008 – Frey, Thomas et al acknowledges that unlike their transparent counterparts, pigmented coating materials *per se* are difficult to cure by radiation, since the pigments they comprise absorb and reflect the radiation and hence only a small part of the irradiated energy does is actually able effectively to bring about curing. The use of radiation curing for colored and opaque coatings is therefore hindered by the interaction of the pigments used with the radiation, whose intensity is attenuated. Volume curing of the coating particularly at its underside, i.e., down to the substrate, can be reduced

as a result of the pigmentation to the point where the coating becomes unusable. Further, aforesaid US 2008/0032037 A1 notes that there has been no lack of attempts to extend radiation curing to pigmented coating materials. Such attempts have involved exposing the coating materials to radiation for a duration empirical data suggested would lead to volume
5 curing.

To address the aforesaid disadvantages, US 2008/0032037 A1 describes a method of allowing, on the one hand, the suitability or non-suitability of radiation curing to be predicted for a specified pigmentation of a coating and, on the other hand, allowing the variables for radiation curing to be determined in such a way that sufficient volume curing can be expected.
10 That object is achieved by a method of determining the conditions for radiation curing radiation-curable pigmented coating materials comprising at least one pigment P, at least one binder B and at least one photoinitiator I on a substrate, comprising the steps of determining, in effect, a plurality of defined parameters.

A promised advantage of the aforesaid method is that the scope of experimental test series can be substantially reduced, the utilization of the exposure units can be optimized, and off-specification batches due to inadequate radiation can be avoided.
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There is, however, always the need to enhance the rate of curing of a curable paint formulation irrespective of the nature of the curing process whether it be, for example, a chemical, thermal (baking), or radiation by UV, IR and/ or microwave process.
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SUMMARY OF THE INVENTION

The invention provides in one aspect a UV photoactivatable curable paint formation for providing a cured paint coating of a desired appearance on a substrate by UV irradiation, said formulation comprising a UV curable film-forming compound; a UV photoinitiator; a particulate UV reflective material in an effective rate of curing enhancing amount without affecting the resultant desired appearance of said cured paint coating.
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Most preferably the formulation comprises a pigment

The particulate UV reflective material is preferably a metal, such as, for example, aluminum or alloy thereof and preferably in the general form of a platelet or sphere.
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Preferred formulations comprise 0.1% to 1.0% W/W particulate material and most preferred formulations comprise 0.5% to 0.8% W/W.

In a further aspect, the invention provides a process of producing a cured paint coated substrate comprising (i) coating a substrate with a paint formation as hereinabove defined and (ii) irradiating said formulation with UV radiation to effect curing and produce said cured paint coated substrate.

5 In a further aspect, the invention provides a coated substrate having a cured coating produced by UV irradiation of a paint formulation as hereinabove defined.

The invention is of particular value in the manufacture of painted vehicle surfaces and parts, thereof. In addition to providing enhanced production rates in the painting of vehicles, the invention provides for reduced capital costs of painting equipment.

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DETAILED DESCRIPTION OF PREFERRED EMBODIMENTS

In the practice of the invention, a standard basic solvent paint formulation was prepared to which various amounts of particulate aluminum platelets were dispensed.

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Table 1 lists the ingredients and amounts thereof wherein the oligomer was an acrylated polyester-urethane (BOMAR SPECIALITIES); monomer was trimethyl acrylate (Petrochem); photoinitiator was bis (2,4,6-trimethylbenzoyl) phenyl phosphine oxide (IRGACURE 819® - CIBA/BASF);

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aluminum (Algon 500™ - Toyal America); filler was IRGANOX™ - IRGANOX;

pigment for (i) the black paint formulation was carbon black,

(ii) the white paint formulation was titanium dioxide,

and (iii) the silver paint formulation was titanium dioxide and aluminum

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powder.

dispersant was BYKP – 1045 (BYK);

light stabilizer (A) was 50% Tinuvin 400™ (CIBA) and (B) 50% Tinuvin 292 (CIBA); and

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solvent was methyl ethyl ketone / methyl isobutyl ketone / butyl acetate / ethyl acetate / xylene in the ratios 20/10/10/15/3.

Coatings of the test formulations were applied to a metal substrate to the film thickness (μ) given in Table 1. UV radiation was applied to the coatings by a FUSION F300

™ Focused-Beam Lamp positioned at a distance of 53mm from the coating surface for a 12 second exposure time.

Table 2 shows the resultant hardness and resin conversion values at the film surface and in the lower body of the film.

5 Each of the test samples had a solvent resistance (ASTM D5402-06) with double rubs of methyl isobutyl ketone in showing no staining.

Additional experiments with aluminum amounts of 0.1%, 0.2%, 0.8%, 1.0% and 2.0% W/W showed that the preferred aluminum amounts selected from 0.5 to 0.8% W/W provided significant advantageous curing rate enhancement without effecting undesirable or unwanted
10 appearance changes in the cured painted substrate.

TABLE 1

Raw Material	BASIC	BLACK		WHITE		SILVER	
		Wt. %	(g)	(w/w)	(g)	(w/w)	
Oligomer	15-45%	16.3	16.3%	15.3	15.3%	15.7	15.7%
Monomer	25-65%	53	53.0%	54.79	54.8%	54.59	54.6%
Photoiniator	2-10%	2.9	2.9%	3.25	3.3%	1.95	2.0%
Aluminum	0-25%	1.1	1.1%	0.8	0.8%	0	0.0%
Filler	0-5%	1.86	1.9%	1.86	1.9%	5.61	5.6%
Pigment	1-10%	3.25	3.3%	9.45	9.5%	6.3	6.3%
Dispersant	0-1%	0.5	0.5%	0.1	0.1%	0.3	0.3%
Light Stabilizer (A)	0.1-1%	0.47	0.5%	0.47	0.5%	0.47	0.5%
Light Stabilizer (B)	1-2%	1.18	1.2%	1.18	1.2%	1.18	1.2%
Solvent	5-30%	19.44	19.4%	12.8	12.8%	13.9	13.9%
Total		100		100		100	

TABLE 2

		FILM THICKNESS	HARDNESS BY PENCIL (ASTM D3363-05)	RESIN CONVERSION	
				Surface	Through
WHITE	NO Aluminum	25	H	66%	50%
		50	H	55%	48%
	With Aluminum	25	2H	88%	75%
		50	2H	81%	73%
BLACK	NO Aluminum	25	H	68%	57%
		50	H	65%	54%
	With Aluminum	25	2H	87%	82%
		50	2H	85%	80%
SILVER	NA	25	2H	98%	97%
		50	2H	98%	98%

5 Although this disclosure has described and illustrated certain preferred embodiments of the invention, it is to be understood that the invention is not restricted to those particular embodiments. Rather, the invention includes all embodiments which are functional or mechanical equivalence of the specific embodiments and features that have been described and illustrated.

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THE EMBODIMENTS OF THE INVENTION IN WHICH AN EXCLUSIVE PROPERTY
OR PRIVILEGE IS CLAIMED ARE DEFINED AS FOLLOWS:

1. A UV photoactivatable curable paint formulation for providing a cured paint
5 coating of a desired appearance on a substrate by UV irradiation, said formulation
comprising a UV curable film-forming compound; a UV photoinitiator; a
particulate UV reflective metal in an effective rate of curing enhancing amount
without affecting the resultant desired appearance of said cured paint coating.
2. A paint formulation as claimed in claim 1 comprising a pigment.
- 10 3. A paint formulation as claimed in either one of claims 1 or 2 wherein said metal
is aluminum or an alloy thereof.
4. A paint formulation as claimed in any one of claims 1 to 3 wherein said metal
particulate is in the general form of a platelet or sphere.
5. A paint formulation as claimed in any one of the claims 1 to 4 wherein said
15 substrate is a surface of a vehicle or part thereof.
6. A paint formulation as claimed in any one of claims 1 to 5 comprising 0.1% to
1.0% W/W particulate UV reflective metal.
7. A paint formulation as claimed in claim 6 comprising 0.5% to 0.8% W/W
particulate UV reflective metal.
- 20 8. A process of producing a cured paint coated substrate comprising (i) coating a
substrate with a paint formulation as defined in any one of claims 1 to 7 and (ii)
irradiating said formulation with UV radiation to effect curing and produce said
cured paint coated substrate.
9. A process as defined in claim 8, wherein the irradiating step occurs for about 5 to
25 about 25 seconds.
10. A process as defined in claim 9, wherein the irradiating step occurs for about 10
to about 20 seconds.
11. A coated substrate having a cured coating produced by UV irradiation of a paint
formulation as defined in any one of claims 1 to 7.
- 30 12. A coated substrate having a cured coating produced by UV irradiation of a paint
formulation when made by a process as defined in any one of claims 8 to 10.