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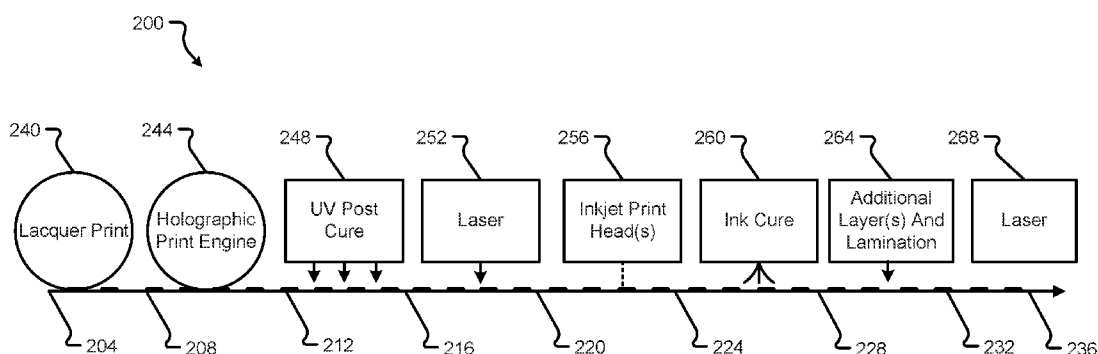


Fig. 2

(57) Abstract: A security feature, a document including a security feature, and a method of producing a document are provided. In one example a security document is disclosed to include a substrate having an imprinted lacquer applied to a first side of the substrate and a metal complex ink applied to the first side of the substrate thereby covering the imprinted lacquer applied to the first side of the substrate. The security document further includes a laser feature created in the metal complex ink.

LASER TREATMENT OF SECURE DOCUMENTS

FIELD

[0001] The present disclosure is generally directed to security features, security documents incorporating security features, and methods of manufacturing the same.

BACKGROUND

[0002] The use of identification documents and other credentials is pervasive. Credentials are used on a daily basis for a number of different purposes. Credentials, which may also be referred to as secure documents, are most commonly used to prove identity, to verify age, to access an asset (e.g., secure area, financial account, computing resource, etc.), to evidence driving privileges, to cash a check, and so on. Airplane passengers are required to show a credential during check in, and sometimes at security screening and prior to boarding their flight. We also live in an ever-evolving cashless society where credentials are used to make payments, access an automated teller machine (ATM), debit an account, or make a payment, etc. Many industries require that their employees carry photo identification credentials on the job and to access various locations on a job site.

[0003] While many different types of security features have been developed to enhance the security associated with credentials, optical variable or holographic security features have been among the most popular features developed in the last decades thanks to their difficulty to copy and the ease with which they can be verified. The diffractive effects of surface relief structures is known, however traditional methods of producing diffractive effects are inefficient in most cases.

SUMMARY

[0004] Embodiments of the present disclosure aim to overcome the shortcomings described above. In some embodiments, a credential manufacturing process can begin when a roll of material (e.g., a Polycarbonate (PC)) substrate is received having a cured micro replicated (imprinted) lacquer applied thereto. The imprinted liquid lacquer may be crosslinked using any type of known curing techniques (e.g., Ultraviolet (UV) light, Infrared (IR) light, heat, chemical, e-beam etc.). Thereafter, a metal complex ink is applied to the PC substrate having the micro replicated lacquer applied thereto. The metal complex ink can be applied with any type of known or yet to be developed inkjet print head, including standard commercial inkjet print heads. The metal complex is then quickly cured (e.g., within 1-10 seconds of application of the ink) such that the dried metal

complex has a mirror-like finish. Curing can be achieved by application of hot air and/or IR radiation with little solvent emission. The cured metal complex will have a thickness between 0.3 and 5 microns. At this point the PC substrate, which may be between 50-150 microns thick, has a thin metal structure cured on top of it.

[0005] The substrate having its thin metal structure can then be laminated with other PC structures into a card format. These additional layers may be printed or not, with or without chips, etc. Some of these layers may be laserable or otherwise be configured for personalization. In some embodiments, the metal complex is laserable (e.g., capable of being treated with laser energy). Treatment of the metal complex with laser energy may involve ablating (e.g., removing) at least some of the metal complex material from the rest of the material remaining in the thin metal complex structure. In other embodiments, treatment of the metal complex with laser energy may involve simply exposing the metal complex ink to laser energy such that a visible property of the metal complex ink changes. For instance, the metal complex ink may turn a different color, oxidize or have a different diffraction surface effect, or otherwise appear differently from other portions of the metal complex ink that have not been treated or had laser energy applied thereto.

[0006] The metal complex may be a metal complex ink having any type of metal complexes therein (e.g., silver, copper, gold, etc.) that is applied through inkjet printing heads in bands up to 65mm wide. The inkjet printing heads may have a resolution of 200dbi, 400dbi, 800dbi or any other suitable resolution that enables a smooth application of the chosen metal complex ink. As an alternative to metal complex inks, a nanoparticle ink may be used. Ideally, a metal complex ink should be chosen that works well with the selected substrate material. For example, it may be desirable to use a metal complex ink having a lower curing temperature than the PC substrate so that the ink can cure without disrupting the substrate. Selections of different substrate materials may also be useful. For instance, a higher softening temperature PC copolymer or PC copolymer / PC blend may be ideal, but other types of PC substrates may be used as well.

[0007] After the metal complex structure is cured on top of the PC substrate, additional types of PC layers may be applied to the substrate. These layers may have windows or other known types of features. The metal complex surface finish can vary (gloss, structure to matte) and can be different when viewed on opposite sides. The additional PC layers may be laminated to the PC substrate to form the desired layers of a secure document. At this point, the layers are still in a roll format.

[0008] One or more high-quality images may be laser-engraved into the outermost PC layer(s). This may correspond to a card personalization step. Engraving may occur before or after lamination. The rolls material may then be cut/singulated to create multiple documents (e.g., cards, passports, printed IDs, RFIDs, etc.).

[0009] For the purposes of this disclosure, credentials are broadly defined and may include, for example, credit cards, bank cards, phone cards, passports, driver's licenses, network access cards, employee badges, debit cards, security cards, visas, immigration documentation, national ID cards, citizenship cards, social security cards, security badges, certificates, identification cards or documents, voter registration cards, police ID cards, border crossing cards, legal instruments or documentation, security clearance badges and cards, gun permits, gift certificates or cards, labels or product packaging, membership cards or badges, etc. Also, the terms "document," "credential," "card," and "documentation" are used interchangeably throughout this document. Credentials are also sometimes interchangeably referred to as "security documents," "ID documents," "identification documents," "security credentials," "photo-IDs," and "photo ID documents".

[0010] The phrases “at least one”, “one or more”, and “and/or” are open-ended expressions that are both conjunctive and disjunctive in operation. For example, each of the expressions “at least one of A, B and C”, “at least one of A, B, or C”, “one or more of A, B, and C”, “one or more of A, B, or C” and “A, B, and/or C” means A alone, B alone, C alone, A and B together, A and C together, B and C together, or A, B and C together. When each one of A, B, and C in the above expressions refers to an element, such as X, Y, and Z, or class of elements, such as X_1 - X_n , Y_1 - Y_m , and Z_1 - Z_o , the phrase is intended to refer to a single element selected from X, Y, and Z, a combination of elements selected from the same class (e.g., X_1 and X_2) as well as a combination of elements selected from two or more classes (e.g., Y_1 and Z_o).

[0011] The term “a” or “an” entity refers to one or more of that entity. As such, the terms “a” (or “an”), “one or more” and “at least one” can be used interchangeably herein. It is also to be noted that the terms “comprising”, “including”, and “having” can be used interchangeably.

[0012] The terms “determine,” “calculate,” and “compute,” and variations thereof, as used herein, are used interchangeably and include any type of methodology, process, mathematical operation, or technique.

[0013] The term “means” as used herein shall be given its broadest possible interpretation in accordance with 35 U.S.C., Section 112, Paragraph 6. Accordingly, a claim incorporating the term “means” shall cover all structures, materials, or acts set forth herein, and all of the equivalents thereof. Further, the structures, materials or acts and the equivalents thereof shall include all those described in the summary of the invention, brief description of the drawings, detailed description, abstract, and claims themselves.

[0014] The preceding is a simplified summary of the disclosure to provide an understanding of some aspects of the disclosure. This summary is neither an extensive nor exhaustive overview of the disclosure and its various aspects, embodiments, and configurations. It is intended neither to identify key or critical elements of the disclosure nor to delineate the scope of the disclosure but to present selected concepts of the disclosure in a simplified form as an introduction to the more detailed description presented below. As will be appreciated, other aspects, embodiments, and configurations of the disclosure are possible utilizing, alone or in combination, one or more of the features set forth above or described in detail below.

BRIEF DESCRIPTION OF THE DRAWINGS

[0015] The accompanying drawings are incorporated into and form a part of the specification to illustrate several examples of the present disclosure. These drawings, together with the description, explain the principles of the disclosure. The drawings simply illustrate preferred and alternative examples of how the disclosure can be made and used and are not to be construed as limiting the disclosure to only the illustrated and described examples. Further features and advantages will become apparent from the following, more detailed, description of the various aspects, embodiments, and configurations of the disclosure, as illustrated by the drawings referenced below.

[0016] Fig. 1 is a flow diagram depicting a method of manufacturing a secure document in accordance with at least some embodiments of the present disclosure;

[0017] Fig. 2 is a diagram depicting components used to manufacture a secure document in accordance with at least some embodiments of the present disclosure;

[0018] Fig. 3A is a cross-sectional view of a substrate used during production of a secure document in accordance with at least some embodiments of the present disclosure;

[0019] Fig. 3B is a cross-sectional view of a first layered structure used to produce a secure document in accordance with at least some embodiments of the present disclosure;

[0020] Fig. 3C is a cross-sectional view of the first layered structure of Fig. 3B after having laser energy applied thereto in accordance with at least some embodiments of the present disclosure;

[0021] Fig. 3D is a cross-sectional view of a second layered structure used to produce a secure document in accordance with at least some embodiments of the present disclosure;

[0022] Fig. 3E is a cross-sectional view of an alternative format of the second layered structure depicted in Fig. 3D;

[0023] Fig. 3F is a cross-sectional view of an alternative format of the second layered structure depicted in Fig. 3D;

[0024] Fig. 3G is a cross-sectional view of a third layered structure used to produce a secure document in accordance with at least some embodiments of the present disclosure;

[0025] Fig. 3H is a cross-sectional view of an alternative format of the third layered structure depicted in Fig. 3G;

[0026] Fig. 3I is a cross-sectional view of an alternative format of the third layered structure depicted in Fig. 3G; and

[0027] Fig. 4 is a flow chart depicting a method of producing a secure document in accordance with at least some embodiments of the present disclosure.

DETAILED DESCRIPTION

[0028] COPYRIGHT AND LEGAL NOTICES

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[0029] According to one embodiment of the present disclosure, a method of manufacturing a secure document is provided, comprising:

- receiving a substrate having a micro replicated lacquer applied to a first side of the substrate;

- applying a metal complex ink to the first side of the substrate thereby covering the micro replicated lacquer applied to the first side of the substrate;

- curing the metal complex ink within a predetermined amount of time of applying the metal complex ink to the first side of the substrate; and

- applying laser energy to at least one of the metal complex ink and the substrate, thereby creating a laser-treated personalization feature on the substrate.

[0030] With reference now to Fig. 1, additional details of a method 100 for manufacturing a secure document will be described in accordance with at least some embodiments of the present disclosure. The method 100 begins with a design and origination process (step 104). In this process, various design details for a security feature and/or security document having a security feature are contemplated. The design of the security feature and/or document is then incorporated into a master plate (step 108). This master plate is used to produce one or more replicas (step 112) in the form of imprint plates (step 116). In some embodiments, where the security feature corresponds to a holographic feature, the imprint plates may correspond to holographic imprint plates that can be used to replicate a substrate during an imprinting process.

[0031] The method 100 continues when a substrate, such as a polycarbonate (PC) substrate, is received (step 128) and has one or more layers of lacquer applied thereto (step 120) in a printing process (step 124). In some embodiments, the lacquer is applied to the PC substrate for a liquid lacquer patch (step 132) and micro replication process imprints into the liquid lacquer and crosslinks (cures) the lacquer (step 136). A non-limiting example of such a process corresponds to the Holoprint® process, details of which are provided in EP 1150843 B1 and/or U.S. Patent Publication No. 2004/0166336 to Lindvold et al., the entire contents of which are hereby incorporated herein by reference. The resulting product is a PC substrate having a micro replicated cured lacquer on at least one side thereof.

[0032] The lacquer may then be post cured in a second curing process (step 140). The lacquer may be cured using heat, light, or a combination thereof. This product may then have a metal complex ink (e.g., a silver complex ink) applied thereto (step 148). In some embodiments, the metal complex ink is applied to the product using an inkjet print head (step 148). At this point, the metal complex ink overlies the micro replication lacquer, thereby creating one or more holographic features on the substrate (step 152). In some embodiments, the resulting product can be referred to as a Diffractive Optically Variable Image Device (DOVID) or an intermediary product of a security document. The metal complex may be cured (step 156) using heat, light, or a combination thereof. In some embodiments, the metal complex applied to the substrate is cured within a predetermined amount of time of the metal complex ink being applied to the substrate. As a non-limiting example, the substrate may have the metal complex ink printed thereon and the metal complex ink may be cured within no more than ten seconds of application. This relatively short amount of time between metal complex ink application and curing helps to create an

optically-appealing DOVID feature. Even more specifically, the DOVID feature may include a mirror-like finish that is interrupted only by the micro replicated lacquer. The combination of the micro replicated lacquer and metal complex ink applied thereto creates a DOVID feature on the substrate.

[0033] In at least some embodiments, prior to having the metal complex ink applied thereto, the substrate and the imprinted lacquer may have laser energy applied thereto (step 154). In some embodiments, the laser may alter an appearance of the lacquer and/or remove at least some material of the DOVID created within the lacquer, thereby resulting in a laser-treated holographic feature on the substrate.

[0034] After the metal complex ink has been applied and cured, the resulting product may be referred to as an applied DOVID (step 160). As mentioned above, this applied DOVID may have a laser-treated optical structural feature present underneath the metal layer. In some embodiments, the DOVID feature may only be provided on a portion of the substrate whereas other portions of the substrate do not have the DOVID feature applied thereto. An additional or optional laser engraving process may be performed on the applied DOVID (step 154). In this step, the cured metal may have laser energy applied thereto. This application of laser energy may result in a removal of at least some of the metal. In other embodiments, the laser energy may not be sufficient to remove the material of the metal, but the laser energy may be sufficient enough to change an appearance of the metal (e.g., by sintering or otherwise heating the metal to change the surface). In some embodiments, the application of the laser energy may change the metal into a metal oxide, which means that the metal may be transformed rather than removed via ablation. The application of additional laser energy may help to further enhance the security feature created by the DOVID feature and the metal complex ink layer.

[0035] One or more additional layers may then be provided on the applied DOVID (step 164). Alternatively or additionally, electronic components (e.g., an Integrated Circuit (IC) chip, an antenna, electronic traces, etc.) may be provided on the applied DOVID. These additional layers and/or electronic components may be laminated via application of heat and/or pressure. In some embodiments, the metal complex ink comprises a higher melting temperature and/or lower curing temperature than the other layers (e.g., the substrate and additional layers) so that the lamination step does not melt, reflow, or otherwise cause the metal complex ink to undesirably alter in any way. If the substrate was provided in a sheet or web-based format such that a plurality of cards are manufactured on a single sheet, the method 100 may further include punching or singulating individual documents from the

sheet or web. This results in the production of one or many secure documents, which may also be referred to as secure IDs (step 168). An additional, but optional, laser engraving step may then be performed (step 172). While shown as being performed after step 168, it should be appreciated that the optional laser engraving step may alternatively or additionally be performed immediately before or immediately after step 160.

[0036] With reference now to Fig. 2, additional details of the components 200 used to manufacture a secure document or a plurality of secure documents will be described in accordance with at least some embodiments of the present disclosure. In the depicted embodiment, a plurality of secure documents may be manufactured simultaneously from a sheet or web-based format of a substrate. In particular, embodiments of the present disclosure provide a method and system 200 for manufacturing a plurality of secure documents in-line, meaning that a single web-based substrate can be passed through a plurality of processes without the need for cutting the web-based substrate or otherwise manually moving a sheet of substrate from one machine to another.

[0037] As shown in Fig. 2, a roll of substrate 204 is fed to a lacquer printer 240. The lacquer printer 240 may apply a first layer of lacquer to the substrate 204. The lacquer applied by the lacquer printer 240 may further be imprinted with an imprint plate mounted on a cylinder or the like. In some embodiments, a flexographic print roll is used to simultaneously apply a layer of lacquer to the web-based substrate (which may correspond to a polycarbonate sheet of material) and pattern that lacquer into the desired shape (e.g. square, oval, star etc.). At this point the web-based substrate now has a layer of imprinted lacquer 208, which can be provided to a holographic print engine 244. In some embodiments, the holographic print engine 244 is used to pattern and simultaneously cure the lacquer. The output of the holographic print engine 244 may then pass through an additional cure process 248. In some embodiments, UV light and/or heat is used to further cure the imprinted lacquer and ensure that the patterns applied thereto by the holographic print engine 244 are totally cured and maintained.

[0038] The web-based substrate having the imprinted and cured lacquer 216 may then be optionally treated with a laser 252. This laser 252 may remove at least some portions of the lacquer applied by the holographic print engine 244. The substrate with the laser-treated holographic feature 220 is then passed under one or more inkjet print heads 256. The inkjet print heads 256, in some embodiments, may correspond to commercial inkjet printing heads configured to deliver a metal complex ink in bands up to 65mm wide and at a resolution of 200dbi, 400dbi, 800dbi or any other suitable resolution that enables a

smooth application of the chosen metal complex ink onto the web-based substrate. In some embodiments, the metal complex ink may be applied to have a thickness between 1 and 5 microns.

[0039] The selection of the type of metal complex ink applied by the inkjet print head(s) 256 can depend upon the type of substrate being used and the desired effects of a security feature that will result from the application of the metal complex ink. Non-limiting types of metal complex inks that may be used include silver complex inks, copper complex inks, gold complex inks, etc. Even more specifically, the metal complex ink may correspond to a homogenous liquid where the metal is present as a metal salt or metal complex.

Alternatively or additionally, the metal ink may have additional metal particles or flakes suspended therein and the sizes of such particles may be no larger than 10 nanometers and may be distributed substantially randomly throughout a liquid of the ink. In some embodiments, a plurality of inkjet print heads 256 are used to apply a metal complex ink (or different metal nanoparticle inks) to different areas of the substrate (e.g., areas where a security feature is desired and/or an area where the imprinted lacquer has already been applied).

[0040] The uncured metal complex ink(s) is applied to the substrate in a layer having a substantially uniform thickness. By applying the metal complex ink in a substantially uniform layer, the metal complex ink is allowed to conform to the imprinted lacquer, thereby creating a conformal layer of metal complex ink. It should be appreciated that the layer of metal complex ink may be completely conformal to the features created by the imprinted lacquer, partially conformal to the features created by the imprinted lacquer, or interrupted with features created by the imprinted lacquer. The application of the metal complex ink by the inkjet print heads corresponds to one of many possible application methods. Other methods which may be used to apply the metal complex ink include, without limitation, flexographic application methods, slot coating application methods, gravure application methods, etc. Indeed, any methods suitable to apply the metal complex ink to the web-based substrate can be used without departing from the scope of the present disclosure.

[0041] The substrate having the uncured metal complex ink 224 is quickly passed to an ink curing station 260. In the ink cure station 260, the metal complex ink 224 is exposed to environmental conditions that cause the metal complex ink to cure. In some embodiments, the ink cure station 260 is positioned substantially adjacent to the inkjet print head(s) 256 such that the metal complex ink is cure within a predetermined amount of time of

application to the substrate. More specifically, a quick curing of the metal complex ink is desirable to help achieve a mirror-like finish with the layer of metal complex ink and to help ensure that the layer at least substantially conforms to the imprinted lacquer. In some embodiments, the ink cure station 260 exposes the metal complex ink to UV light within 1-10 seconds and no more than 10 seconds of being applied to the substrate. In some embodiments, the metal complex ink may be cured using a combination of UV light and/or hot air drying heads that force hot and dry air onto the metal complex ink. This curing process substantially transforms the metal complex ink into a metal layer. For instance, a silver complex ink may be substantially transformed to a layer of silver having a substantially uniform thickness and a mirror-like finish. These features enable the cured metal layer to exhibit holographic properties and other security-related properties.

[0042] At this point the substrate having the cured metal complex ink 228 may then be passed to one or more additional processes 264 to ultimately result in the creation of one or many secure documents 232. In some embodiments, the substrate (in a web-based format) having the cured metal complex ink 228 is cut into sheets and those sheets are collated with other printed sheets, other electronic components (e.g., antennas, IC chips, etc.), protective overlay sheets, and the like. These additional sheets of material and electronic components may then be laminated together under application of heat and pressure.

[0043] The laminated sheets may then further be singulated or have individual secure documents cut therefrom. Thus, the production process can output a plurality of secure documents from a single sheet of material. In some embodiments, the individual secure documents 232 may be subjected to another laser 268. This laser 268 may be the same as or different from the laser 252. In some embodiments, this laser 268 is used to treat, alter, or ablate at least some material applied by the inkjet print head(s) 256. The resulting output from the laser 268 is one or more laser-engraved secure documents 236.

[0044] With reference now to Figs. 3A-I, the construction of a secure document or components thereof will be described in accordance with at least some embodiments of the present disclosure. With reference initially to Fig. 3A, a substrate 304 is shown to include a first side 308 and an opposing second side 312. Although the substrate 304 is shown to have first and second ends connecting the first and second sides 308, 312, it should be appreciated that the substrate 304 is provided in a web-based format, a roll, a sheet, or the like such that the distance between the ends of the substrate 304 is significantly smaller

than the length of the sides 308, 312. Said another way, the substrate 304 may be relatively thin even though Fig. 3A depicts the substrate 304 as having a significant thickness.

[0045] In some embodiments, the substrate 304 corresponds to a layer of polycarbonate or a PC copolymer. The substrate 304 may have a thickness between approximately 50 microns and 75 microns. The thickness of the substrate 304 may depend, at least in part, upon the desired final thickness of the security document to be made with the substrate 304.

[0046] Fig. 3B depicts the substrate 304 having an imprinted lacquer 316 applied thereto. More specifically, the imprinted lacquer 316 may be applied to the first side 308 of the substrate 304. Although not depicted, it should be appreciated that the imprinted lacquer 316 may alternatively or additionally be applied to the second side 312 of the substrate 304 without departing from the scope of the present disclosure. The imprinted lacquer 316 may have any number of possible formats or designs provided thereon. The depiction of the imprinted lacquer 316 as corresponding to a plurality of uniform ridges that are evenly spaced apart is for ease of discussion and clarity.

[0047] Fig. 3C depicts an embodiment of the substrate 304 and imprinted lacquer 316 after having been subjected to laser energy. In particular, a laser 252 may be used to incorporate one or more features into the holographic image created by the imprinted lacquer 316. Even more specifically, laser energy may be used to create one or more laser features 320 in the imprinted lacquer 316, in the first surface 308 of the substrate 304, or a combination thereof. As can be seen in Fig. 3C, the laser energy may remove at least some material of the imprinted lacquer 316 and/or substrate 304. In some embodiments, the laser energy may actually remove an entire row or ridge of the imprinted lacquer 316. This may also be referred to as a laser feature 320 even though no such feature is actually present in the form of an imprinted lacquer 316 ridge. As noted above, however, this laser engraving step may correspond to an optional step in the manufacture of the security document.

[0048] Figs. 3D-F depict various possible intermediate products that can be realized by applying a metal complex layer 324, 324', 324" to the first side 308 of the substrate 304 over the raised features created by the imprinted lacquer 316 and then treating the metal complex layer with laser energy, thereby creating one or more laser features 320 in the metal complex layer. In particular, Fig. 3D shows a first configuration where the metal complex ink 324 is applied in a relatively uniform thickness across the first side 308 of the substrate 304. It can be seen that the thickness of the metal complex ink 324 is less than a

thickness of a feature created by the imprinted lacquer 316. For instance, the metal complex ink 324 may be applied to have a thickness between 0.3 and 5 microns and the features created by the imprinted lacquer 316 may have a thickness between 2 and 10 microns. Thus, at least some side portions of the features created by the imprinted lacquer 316 may not be covered by the metal complex ink 324. Rather, the top surfaces of the features created by the imprinted lacquer 316 and the exposed portions of the first side 308 of the substrate 304 may be uniformly covered with the metal complex ink 324. On the other hand, at least some portions of the features created by the imprinted lacquer 316 (e.g., vertical walls, inclines, etc.) may not be covered with the metal complex ink 324.

[0049] Once the metal complex ink 324 is applied to the substrate 304 and cured, the laser 264 may be used to treat at least some portions of the cured metal complex ink 324. As shown in Fig. 3D, the laser feature(s) 320 may correspond to voids in the metal complex ink 324 where at least some material has been removed/ablated. Alternatively, or additionally, the laser feature(s) 320 may correspond to areas of the metal complex ink 324 that have been transformed and present at least one different visual characteristic than other portions of the metal complex ink 324 that have not been subjected to laser energy. As can be appreciated, these laser feature(s) 320 may be present on top of the features created by the imprinted lacquer 316 or they may be present between the imprinted lacquer 316.

[0050] Fig. 3E depicts an alternative configuration where the metal complex ink 324' is applied uniformly across the imprinted lacquer 316 and the first side 308 of the substrate 304. In this example, the entirety of the features created by the imprinted lacquer 316 is covered by the metal complex ink 324'. The thickness of the metal complex ink 324' may be similar to that depicted and described in connection with Fig. 3D; however, the metal complex ink 324' may be applied in a thick enough layer to maintain the layer thickness between the peaks and valleys of the features created by the imprinted lacquer 316. When cured appropriately, this particular configuration may help to create a holographic feature with the metal complex ink substantially conforming to the features created by the imprinted lacquer 316. The metal complex ink 324' may then be subjected to laser energy from the laser 264, thereby creating one or more laser features 320. Again, these laser features 320 may correspond to voids of material or areas of the metal complex ink 324' that have been transformed into a metal oxide. The laser features 320 may be visible from just the first side 308 of the substrate 304 or the laser features 320 may be visible from the

second side 312 of the substrate 304 if an appropriate window is provided in the substrate 304

[0051] Fig. 3F depicts another alternative configuration where the metal complex ink 324'' is conformally applied to the substrate 304 and imprinted lacquer 316, but is thicker in the valleys between the features created by the imprinted lacquer 316 than the peaks created by the imprinted lacquer 316. This particular configuration still presents the metal complex ink 324'' in substantial conformity with the imprinted lacquer 316 as shown in Fig. 3E. However, the metal complex ink 324'' in this configuration is not completely uniform in its thickness. The features created by the imprinted lacquer 316 still create the contours in the metal complex ink 324'' and will, therefore, contribute to the appearance of the security features resulting from the metal complex ink 324''. An advantage to this particular configuration is that the application of additional layers to the first side 308 of the substrate may be easier to accommodate as compared to other configurations where the imprinted features create a less smooth surface for lamination.

[0052] Again, one or more laser features 320 may be created in the metal complex ink 324''. This particular embodiment shows the laser features 320 substantially overlapping the imprinted lacquer 316 ridges/features, but it should be appreciated that one or more laser features 320 may also be provided in the troughs between the imprinted lacquer 316 ridges/features.

[0053] Although Figs. 3D-F only depict laser features 320 in metal complex layer, it should be appreciated that embodiments of the present disclosure also contemplate that laser features 320 may be provided in two or more of the substrate 304, the imprinted lacquer 316, and/or the metal complex layer. These features 320 may be created using two different laser application processes (as shown in Fig. 2) or a suitably strong laser may be used to ablate through the thickness of the metal complex layer and at least some of the imprinted lacquer 316. Thus, a single laser feature 320 may be present in the metal complex layer 324 as well as the imprinted lacquer 316. Such a laser feature 320 may be useful to prevent counterfeiting due to the laser feature 320 being applied at a single, but specific step, thereby creating a unique-looking feature.

[0054] Figs. 3G-I depict further possible intermediate products that can be realized with the intermediate products of Figs. D-F. In particular, Fig. 3G shows an intermediate product created by applying at least one additional layer 328 to the intermediate product of Fig. 3D. In some embodiments, the at least one additional layer 328 may correspond to an additional PC layer. Alternatively or additionally, other materials may be used for the

additional layer 328. For instance, clear or semi-transparent plastics such as PET, PVC, etc. may be used for the at least one additional layer 328. Fig. 3H shows an intermediate product against created with at least one additional layer 328 applied to the intermediate product of Fig. 3E. Fig. 3I shows an intermediate product created with at least one additional layer 328 applied to the intermediate product of Fig. 3F. It should be appreciated that more than one additional layer may be applied to the substrate 304 having the metal complex ink cured thereon. Additional laser engraving steps may be performed on the at least one additional layer 328. For instance, personalization of the document may be achieved by further laser engraving the top-most layer among the additional layers 328. This may be done in addition to the other laser engraving steps discussed herein.

[0055] It should be appreciated that the substrate 304 can be sandwiched between additional layer 328 and other additional layers. More than two additional layers may further be applied to the stack of layers. For instance, a third additional layer and fourth additional layer may also be provided to the stack of layers and all of these layers of materials may be laminated together to create a cohesive security document.

[0056] Electronic components may also be incorporated into the stack of layers. The electronic component(s) may correspond to one or more of an IC chip, an antenna, an electrical trace, etc. As is known in the art, the electronic component may be incorporated into the stack of layers using lamination techniques. Alternatively or additionally, one or more recesses or reliefs may be formed in an additional layer to accommodate the electronic component and to avoid an undesirable bump around the electronic component.

[0057] With reference now to Fig. 4, another method of manufacturing a secure document will be described in accordance with at least some embodiments of the present disclosure. The method begins when a PC substrate with an imprinted lacquer provided thereon is received (step 404). The imprinted lacquer may be cured on the substrate and may cover a portion or the entire area of the substrate.

[0058] The method continues with the application of one or many different types of metal complex inks to at least one side of the PC substrate (step 408). In some embodiments, a single metal complex ink is applied to the side of the PC substrate. In some embodiments, a plurality of different metal complex inks are applied to the side of the PC substrate. The metal complex inks are applied to the side of the substrate having the imprinted lacquer formed thereon. In some embodiments, a first of the plurality of metal complex inks may correspond to a silver complex ink whereas a second of the plurality of metal complex inks may correspond to a gold or copper complex ink.

Alternatively or additionally, both metal complex inks may correspond to a silver complex ink, but with different solvents or liquid formulations. For example, one of the metal complex inks may have an alcohol or ester solvent whereas another of the metal complex inks may have ketones or glycol ethers as a solvent. Furthermore, the different metal complex inks may be applied to the substrate and the imprinted lacquer with different inkjet print heads. Thus, the different metal complex inks may be applied side-by-side or adjacent to one another, thereby creating a difference in optical characteristics from one metal complex ink to the next metal complex ink. The metal complex inks may be applied with a small (e.g., less than 5 micron) gap provided there between. Alternatively, a small amount of overlap between the metal complex inks may be tolerated. The existence of gaps or the lack thereof may depend upon the resolution of the inkjet print heads and the viscosity of the metal complex ink.

[0059] Because the metal complex inks are applied at substantially the same time, it may be possible to cure all of the different metal complex inks with a common curing process (step 412). In particular, the method continues by exposing the substrate with the different metal complex inks applied thereto to a common curing process within a predetermined amount of time of the application of such metal complex inks. As a non-limiting example, the metal complex inks may be exposed to UV light and/or heated air within 1-10 seconds of being applied to the substrate. This relatively quick application of a curing process helps to create a mirror-like finish for the metal complex ink.

[0060] Thereafter, the metal complex ink(s) may then be subjected to laser energy (step 416). In this step, a single laser is used to create one or more laser features in each of the different metal complex materials. The laser may be used to create a single image that traverses each of the different metal complex materials. The laser may be strong enough to remove at least some material or the laser may be used to transform the metal complex layer(s) to a metal oxide or the like.

[0061] The method continues with the application of one or more additional layers to one or both sides of the substrate (step 420). The method may also include providing one or more electronic components to the tack of layers created by the PC substrate and the additional layers (step 424). The additional layers and/or electronic component(s) may then be laminated together with the application of heat and/or pressure to create a desired laminated stack for a secure document (step 428).

[0062] If the laminated stack is provided in a sheet or roll format, the method may further include singulating or cutting individual secure documents from the sheet or roll

(step 432). Additional personalization steps may then be performed in which the outermost layers of the secure document are either laser engraved or printed with colored ink(s).

[0063] While the flowcharts have been discussed and illustrated in relation to a particular sequence of events, it should be appreciated that changes, additions, and omissions to this sequence can occur without materially affecting the operation of the disclosed embodiments, configuration, and aspects.

What Is Claimed Is:

1. A method of manufacturing a secure document, comprising:
receiving a substrate having an imprinted lacquer applied to a first side of the substrate;
applying a metal complex ink to the first side of the substrate thereby covering the imprinted lacquer applied to the first side of the substrate;
curing the metal complex ink within a predetermined amount of time of applying the metal complex ink to the first side of the substrate; and
applying laser energy to at least one of the metal complex ink and the substrate, thereby creating a laser-treated holographic feature on the substrate.
2. The method of claim 1, further comprising:
applying a second layer to a second side of the substrate that opposes the first side of the substrate;
covering the metal complex ink with a third layer thereby sandwiching the substrate between the second layer and the third layer; and
laminating the substrate, second layer, and third layer.
3. The method of claim 2, wherein the metal complex ink comprises a lower curing temperature than the substrate, the second layer, and the third layer.
4. The method of claim 1, wherein the laser-treated holographic feature extends entirely through a thickness of the metal complex ink and at least partially extends into the imprinted lacquer..
5. The method of claim 1, wherein the laser-treated holographic feature corresponds to a portion of the metal complex ink that has been ablated.
6. The method of claim 1, wherein the laser energy applied to the metal complex ink causes the metal complex ink to transform into a metal oxide, thereby changing an appearance of the metal complex ink that is exposed to the laser energy as compared to other portions of the metal complex ink that are not exposed to the laser energy.
7. The method of claim 1, wherein the laser-treated holographic feature corresponds to a void created in the imprinted lacquer and wherein the metal complex ink is used to cover the void created in the imprinted lacquer.
8. The method of claim 1, further comprising:

applying a second metal complex ink to the first side of the substrate, wherein the second metal complex ink is applied at substantially the same time as the metal complex ink.

9. The method of claim 8, wherein the second metal complex ink comprises a different material than is provided in the metal complex ink and wherein both the metal complex ink and the second metal complex ink both have the laser energy applied thereto, thereby creating a single laser-treated holographic feature that traverses both the metal complex ink and the second metal complex ink.

10. The method of claim 9, further comprising:
curing the second metal complex ink at substantially the same time as the metal complex ink.

11. The method of claim 1, wherein the metal complex ink is cured by exposure to at least one of Ultraviolet (UV) light and Infrared (IR) light.

12. The method of claim 1, further comprising:
providing at least one electronic component over the substrate;
covering the at least one electronic component with an additional layer of polycarbonate; and
laminating the additional layer of the polycarbonate to the substrate thereby fixing a position of the at least one electronic component between the substrate and the additional layer of polycarbonate.

13. The method of claim 1, wherein the laser energy is applied to the metal complex ink after the metal complex ink has been cured.

14. A secure document, comprising:
a substrate having an imprinted lacquer applied to a first side of the substrate;
a metal complex ink applied to the first side of the substrate thereby covering the imprinted lacquer applied to the first side of the substrate, wherein the metal complex ink comprises a lower curing temperature than the substrate; and
a laser feature established in the metal complex ink.

15. The secure document of claim 14, wherein the metal complex ink is cured so as to exhibit a mirror-like finish and wherein the laser feature corresponds to at least one of a void in the metal complex ink and a portion of the metal complex ink that exhibits a different optical characteristic than other portions of the metal complex ink that have not had laser energy applied thereto.

16. The secure document of claim 15, wherein the metal complex ink comprises a silver nanoparticle ink and wherein the laser feature corresponds to a portion of the metal complex ink that has been oxidized.

17. The secure document of claim 14, further comprising:

a second metal complex ink applied adjacent to the metal complex ink.

18. The secure document of claim 17, wherein the laser feature extends through both the metal complex ink and the second metal complex ink.

19. A secure document, comprising:

a polycarbonate substrate;

an imprinted lacquer provided on at least one surface of the polycarbonate substrate; and

a security feature provided on the polycarbonate substrate, wherein the security feature at least partially conforms to the imprinted lacquer and comprises a first metal complex ink that has been at least one of ablated and oxidized with laser energy, thereby creating a laser feature in the first metal complex ink.

20. The secure document of claim 19, wherein the security feature further comprises a second metal complex ink positioned adjacent to the first metal complex ink and wherein the laser feature extends at least partially into the second metal complex ink.

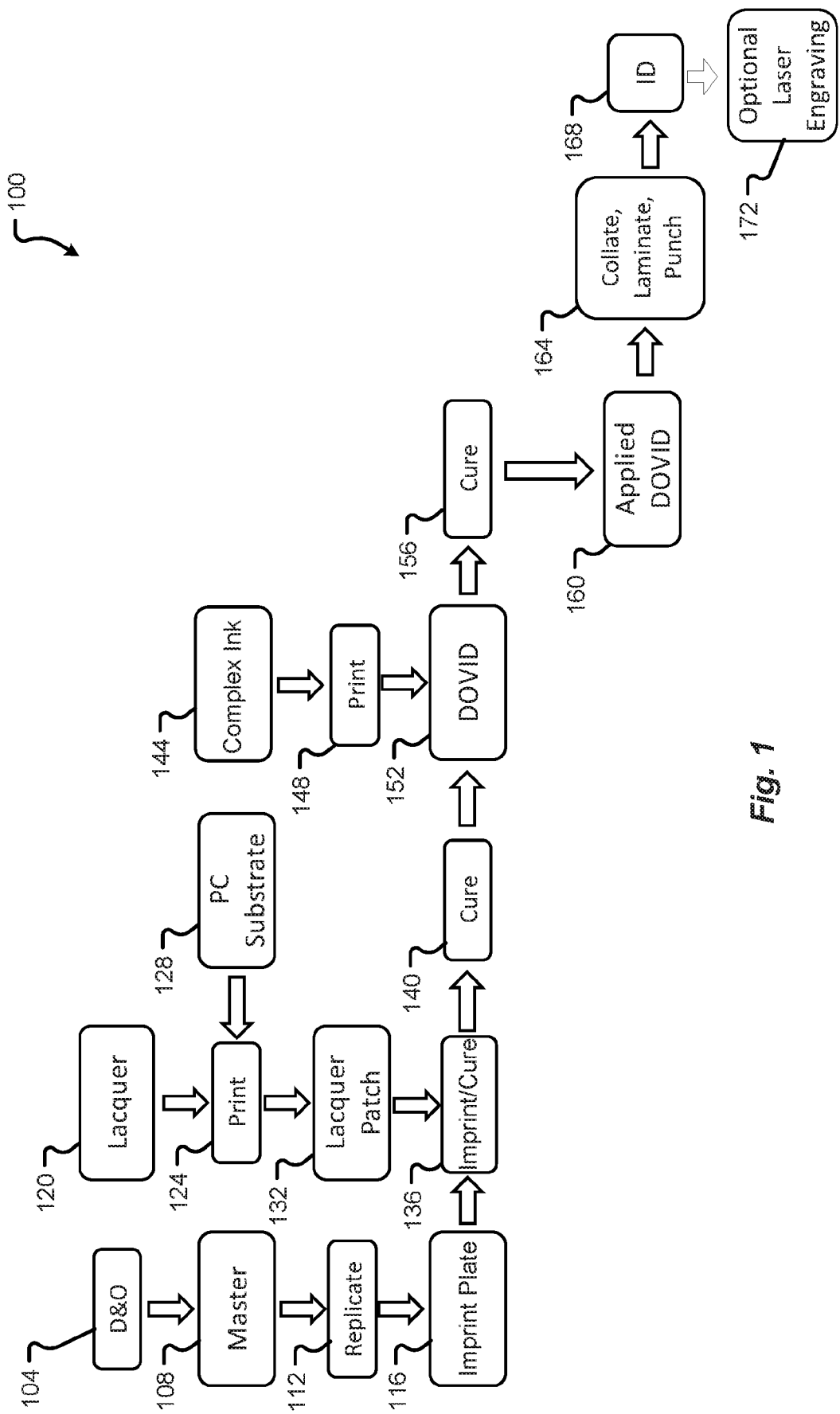


Fig. 1

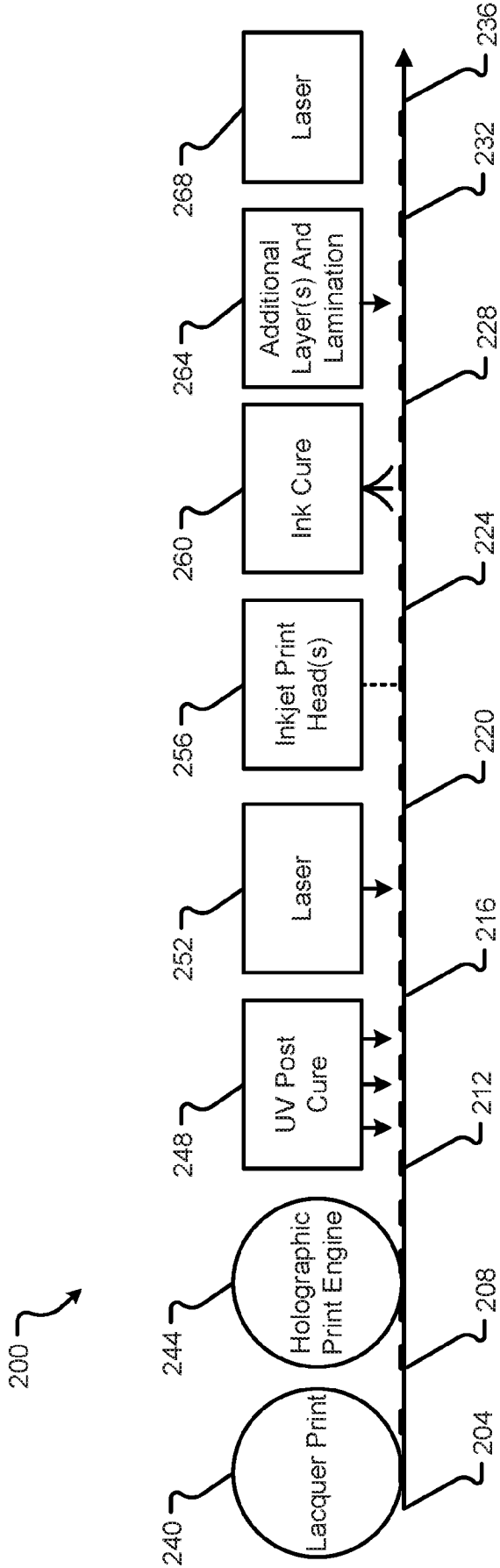


Fig. 2

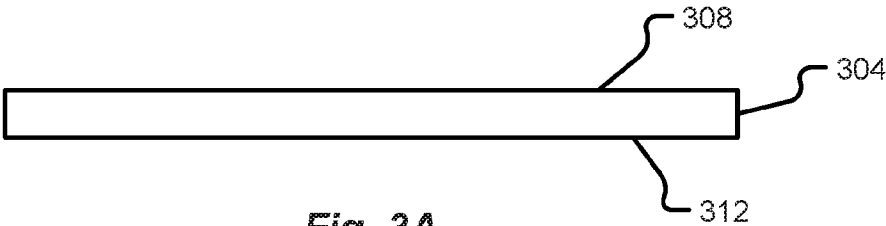


Fig. 3A

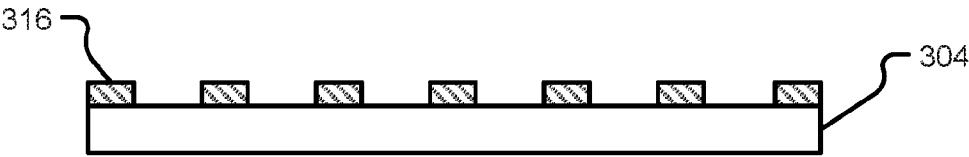


Fig. 3B

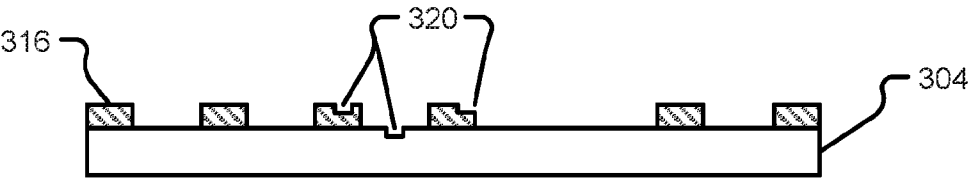


Fig. 3C

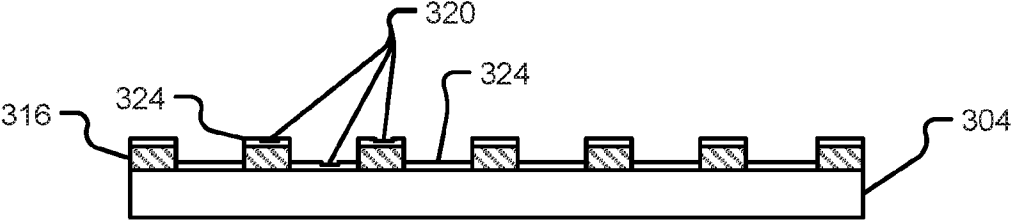


Fig. 3D

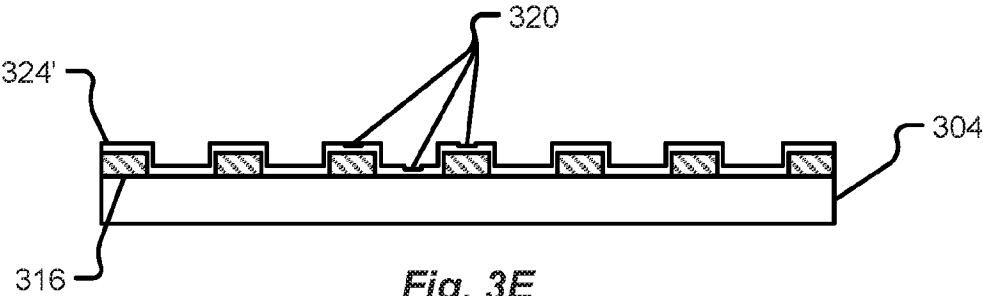


Fig. 3E

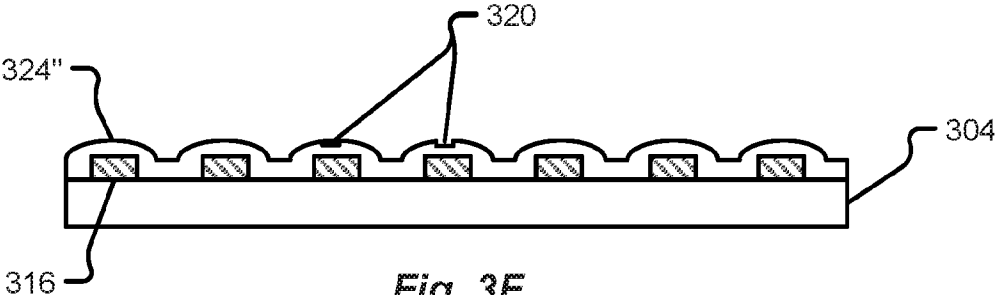


Fig. 3F

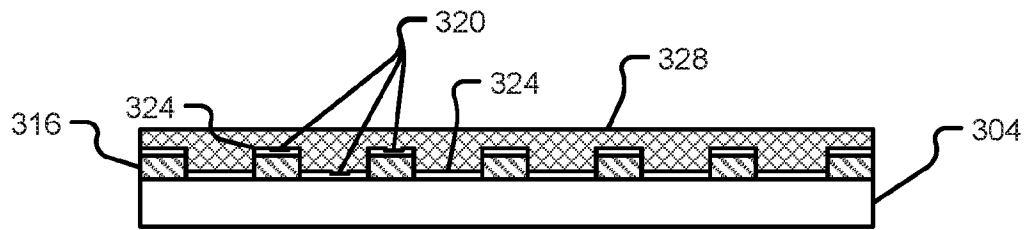


Fig. 3G

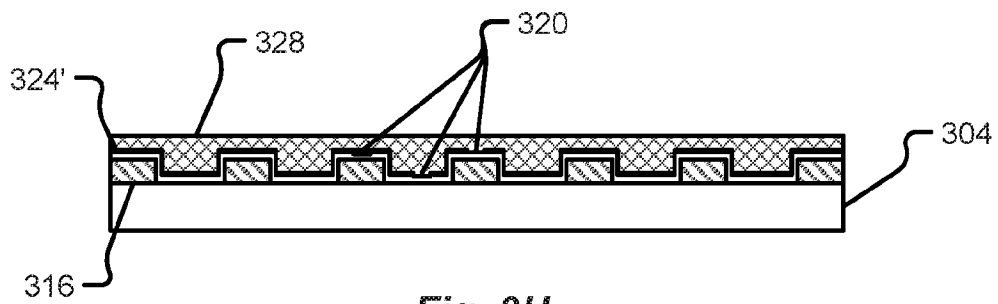


Fig. 3H

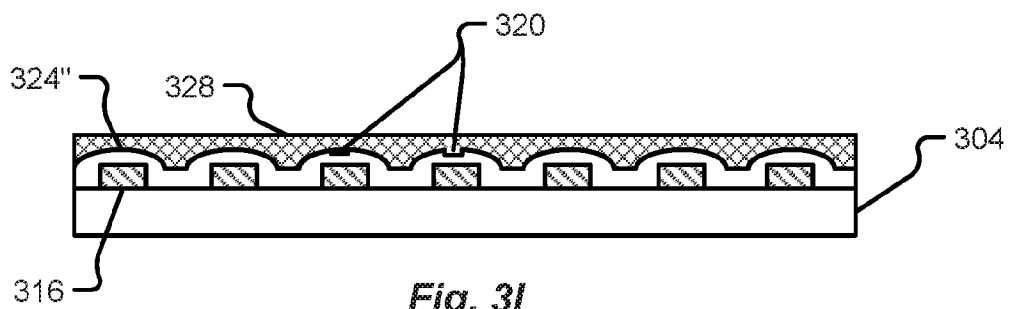
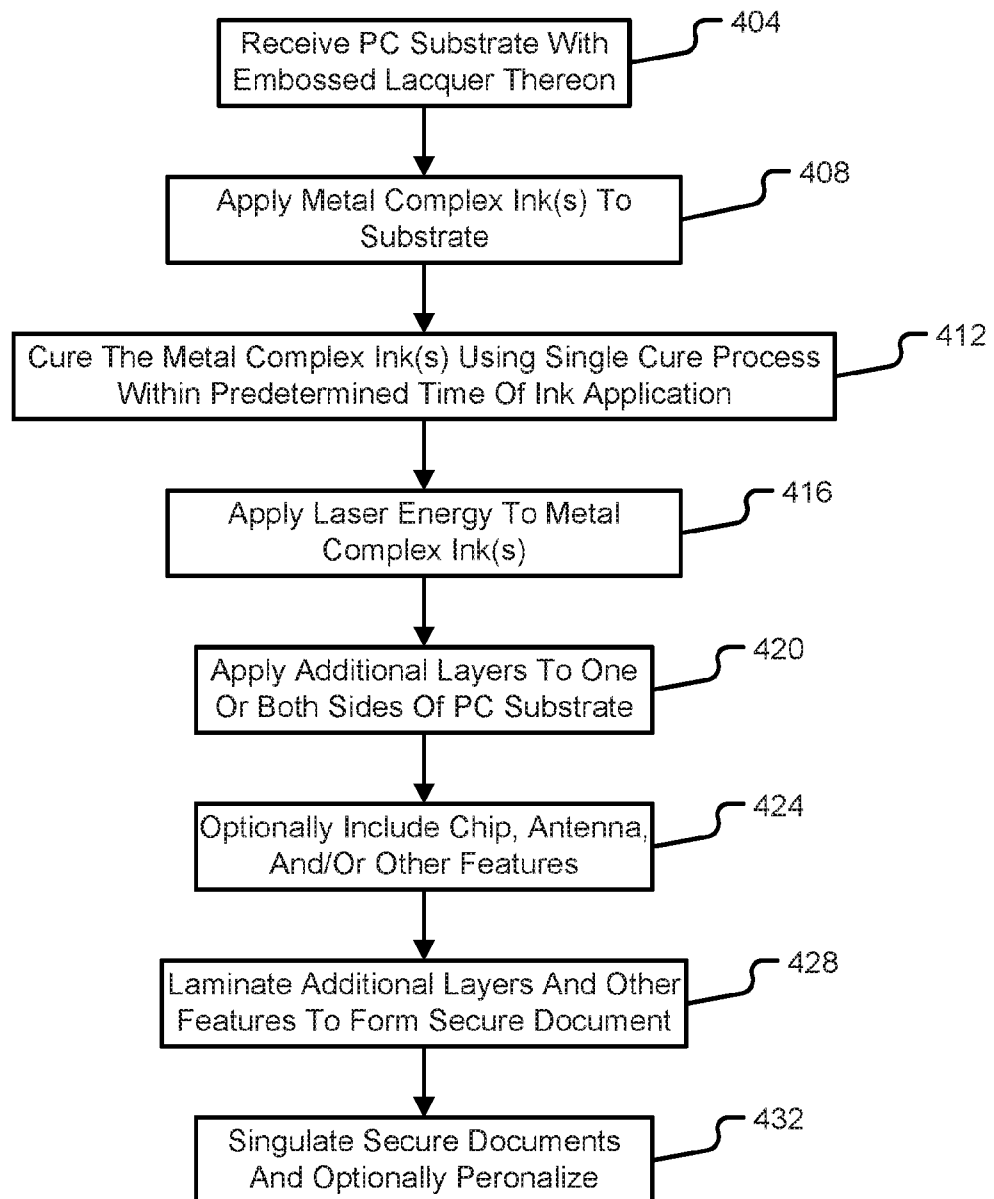


Fig. 3I

**Fig. 4**

INTERNATIONAL SEARCH REPORT

International application No
PCT/IB2018/001458

A. CLASSIFICATION OF SUBJECT MATTER
INV. B42D25/378 B42D25/373
ADD.

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)
B42D

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 practicable, search terms used)

EP0-Internal, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	WO 2012/176126 A1 (BASF SE [DE]; RICHERT MICHELLE [FR]; BOLLE THOMAS [DE]; FLEURY ROLAND) 27 December 2012 (2012-12-27) page 23, line 18 - page 24, line 31; figure 1	1-20
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A	----- WO 2013/186167 A2 (BASF SE [DE]; BASF SCHWEIZ AG [CH]) 19 December 2013 (2013-12-19) page 1, line 5 - page 4, line 15 page 20, line 41 - page 25, line 30; figure ----- -/--	1-20

☒ Further documents are listed in the continuation of Box C.

☒ See patent family 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

"&" document member of the same patent family

Date of the actual completion of the international search

11 March 2019

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Zacchini, Daniela

INTERNATIONAL SEARCH REPORT

International application No

PCT/IB2018/001458

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