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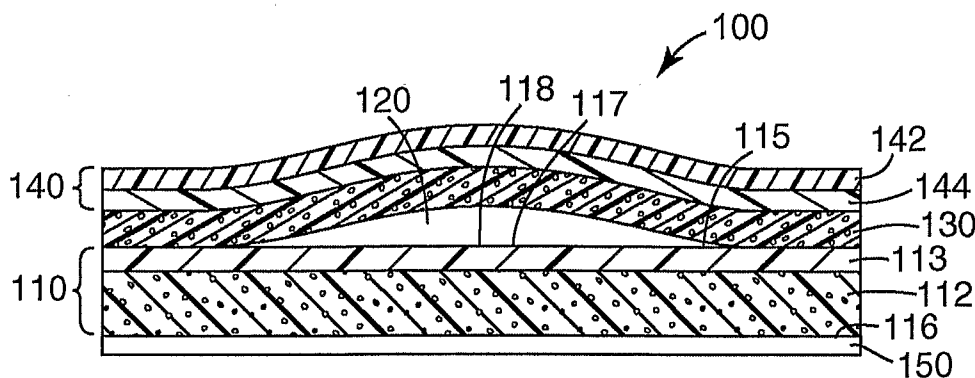
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(54) Title: CONFORMABLE ABRASIVE ARTICLES AND METHODS OF MAKING AND USING THE SAME



(57) Abstract: Conformable abrasive article comprising: a backing having a first major surface; a deformable material contacting a central portion of the first major surface; an elastic member affixed to the first major surface of the backing and together with the backing enclosing the deformable material; and an abrasive member affixed to the elastic member, wherein the abrasive member comprises abrasive particles and a binder; and methods of making and using the same.

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CONFORMABLE ABRASIVE ARTICLES AND METHODS OF MAKING AND USING THE SAME

5 BACKGROUND

In order to protect and preserve the aesthetic qualities of the finish on an automobile or other vehicle, it is generally known to provide a clear (non-pigmented or slightly pigmented) topcoat over a colored (pigmented) basecoat, so that the basecoat remains unaffected even during prolonged exposure to the environment or weathering.

10 Generally in the art, this is known as a basecoat/topcoat or basecoat/clearcoat finish. Typically, the basecoat is applied over a primer coat. During application of each of these coats, or during repair thereof, nibs, protrusions or other defects may occur which aesthetically detract from the appearance of the finish.

Removal of such defects (commonly referred to as "de-nibbing") is currently
15 accomplished by abrading methods that are typically slow and tedious, and may result in flat spots in the characteristic orange-peel appearance of areas of the clear coat that are adjacent to nibs that are removed. To overcome this change in appearance, a technician may be required to repair a full body panel, instead of repairing the individual defects.

More generally, the same issues of blending the surface appearance are also of at
20 least aesthetic importance in many other conventional abrading processes such as, for example, those processes involving coated abrasive products.

SUMMARY

In one aspect, the present invention provides a conformable abrasive article
25 comprising:

 a backing having a first major surface;

 a deformable material contacting a central portion of the first major surface, the deformable material having greatest thickness proximal to the center of the first major surface;

30 an elastic member affixed to the first major surface of the backing and together with the backing enclosing the deformable material; and

an abrasive member affixed to the elastic member, wherein the abrasive member comprises abrasive particles and a binder.

In another aspect, the present invention provides a method of making a conformable abrasive article comprising:

- 5 providing a backing having a first major surface;
 contacting a deformable material with a central portion of the first major surface of the backing, the deformable material having greatest thickness proximal to the center of the first major surface;
 affixing an elastic member to the first major surface of the backing, the elastic
10 member and the compressible backing enclosing the deformable material; and
 affixing an abrasive member to the elastic member, wherein the abrasive member comprises abrasive particles and a binder.

In another aspect, the present invention provides a method of making a conformable abrasive article comprising:

- 15 providing a backing having a first major surface;
 contacting a deformable material with a central portion of the first major surface of the backing, the deformable material having greatest thickness proximal to the center of the first major surface;
 affixing an elastic member to the first major surface of the backing, the elastic
20 member and the compressible backing enclosing the deformable material; and
 applying a curable composition comprising a polymerizable binder precursor and abrasive particles to the extensible tie layer; and
 at least partially curing the curable composition to provide an abrasive layer.

- In some embodiments, the backing comprises a flexible member having a
25 compressible foam layer affixed thereto, wherein the flexible member has a surface that comprises the second major surface of the backing, and wherein the compressible foam layer has a surface that comprises the first major surface of the backing.

- In some embodiments, the elastic member comprises a conformable elastomeric film affixed to an elastomeric foam, wherein the conformable elastomeric film is further
30 affixed to the first major surface of the backing.

Conformable abrasive articles according to the present invention are useful, for example, for abrading a workpiece. For example, the present invention provides a nib-

removal system that achieves the desired effect of nib removal with little or no perceptible damage to the appearance of the clear coat surface around the nib, and resulting in considerable savings in time, labor, and materials.

As used herein:

5 "compressible" means reducible in volume by at least 10 percent by applied mechanical force without substantial crushing or fusing;

"conformable" means capable of adjusting shape in response to an applied mechanical force;

10 "thickness" of the conformable abrasive article is determined as the distance from the second major surface of the backing to the outermost surface of the abrasive layer.

BRIEF DESCRIPTION OF THE DRAWING

Fig. 1 is a cross-sectional schematic view of an exemplary conformable abrasive article according to one embodiment of the present invention;

15 Fig. 2 is a cross-sectional schematic view of another exemplary conformable abrasive article according to one embodiment of the present invention;

Fig. 3 is a cross-sectional schematic view of another exemplary conformable abrasive article according to one embodiment of the present invention;

20 Fig. 4 is a cross-sectional schematic view of another exemplary conformable abrasive article according one embodiment of the present invention.

Figs. 5A-5C are enlarged schematic cross-sectional views of various embodiments of abrasive layers;

Fig. 6 is a perspective view of an exemplary conformable abrasive pad according to one embodiment of the present invention;

25 Fig. 7 is a perspective view of an exemplary conformable abrasive pad according to one embodiment of the present invention; and

Fig. 8 is a perspective view of an exemplary conformable abrasive belt according to one embodiment of the present invention.

30 DETAILED DESCRIPTION

Conformable abrasive articles according to the present invention have a backing having a first major surface; a deformable material contacting a central portion of the first

major surface, the deformable material having greatest thickness proximal to the center of the first major surface; an elastic member affixed to the first major surface of the backing. Together, the elastic member and the backing envelope the deformable material. An abrasive member is affixed to the elastic member such that the abrasive layer is at least outwardly disposed.

One exemplary embodiment of a conformable abrasive article is shown in Fig. 1. Referring now to Fig. 1, which is not drawn to scale, conformable abrasive article 100 comprises compressible backing 110 having first and second major surfaces 115, 116. Deformable material 120 contacts a central portion 117 of first major surface 115, and has its greatest thickness proximal to the center 118 of first major surface 115. Compressible backing 110 comprises foam 112 and optional polymeric film 113 affixed to foam 112. Elastic member 130 is affixed to first major surface 115 of compressible backing 110, and together with compressible backing 110, encloses deformable material 120. Abrasive member 140, which comprises abrasive layer 142 and optional flexible backing 144, is affixed to elastic member 130. Optional attachment system 150 is affixed to second major surface 116 of compressible backing 110.

Another exemplary embodiment, shown not to scale in Fig. 2 conformable abrasive article 200 comprises compressible backing 210 having first and second major surfaces 215, 216. Deformable material 220 contacts a central portion 217 of first major surface 215, and has its greatest thickness proximal to the center 218 of first major surface 215. Compressible backing 210 comprises foam 212 and optional polymeric film 213 affixed to foam 212. Elastic member 230 is affixed to first major surface 215 of compressible backing 210, and together with compressible backing 210, encloses deformable material 220. Abrasive member 240, which comprises abrasive layer 242 and optional flexible backing 244, is affixed to elastic member 230. Optional attachment system 250 is affixed to second major surface 216 of compressible backing 210. In this embodiment, each of the compressible backing 210, elastic member 230, the optional flexible backing 244, are curved and abrasive layer 242 is outwardly convex.

Another exemplary embodiment of a conformable abrasive article is shown in Fig. 3. Referring now to Fig. 3, which is not drawn to scale, conformable abrasive article 300 comprises compressible backing 310 having first and second major surfaces 315, 316. Deformable material 320 contacts a central portion 317 of first major surface 315, and has

its greatest thickness proximal to the center 318 of first major surface 315. Compressible backing 310 comprises foam 312 and optional polymeric film 313 affixed to foam 312. Elastic member 330 is affixed to optional first elastomeric film 361, which in turn is affixed to first major surface 315 of compressible backing 310, and together with compressible backing 310, encloses deformable material 320. Abrasive member 340, which comprises abrasive layer 342 and optional flexible backing 344, is affixed to optional second elastomeric film 363, which in turn is affixed to elastic member 330. Abrasive layer 342 comprises an array of shaped abrasive composite particles 348. Optional attachment system 350, optionally having loops 356, is affixed to second major surface 316 of compressible backing 310.

Another exemplary embodiment of a conformable abrasive article is shown in Fig. 4. Referring now to Fig. 4, which is not drawn to scale, conformable abrasive article 400 comprises compressible backing 410 having first and second major surfaces 415, 416. Deformable material 420 contacts central portion 417 of first major surface 415, and has central region 470 of substantially uniform thickness and a peripheral region 472 of decreasing thickness. Compressible backing 410 comprises foam 412 and optional polymeric film 413 affixed to foam 412. Elastic member 430 is affixed to optional first elastomeric film 461, which in turn is affixed to first major surface 415 of compressible backing 410, and together with compressible backing 410, encloses deformable material 420. Abrasive member 440 (not shown), which comprises abrasive layer 442 and optional flexible backing 444, is affixed to optional second elastomeric film 463, which in turn is affixed to elastic member 430. Abrasive layer 442 comprises an array of shaped abrasive composite particles 448. Optional attachment system 450 with threaded fastener 452, is affixed to second major surface 416 of compressible resilient backing 410. In this embodiment, compressible backing 410 is substantially planar, while elastic member 430, optional flexible backing 444, are curved, and abrasive layer 442 is outwardly convex.

Backing

The backing may comprise any rigid or resilient and/or compressible material(s). The degree of flexibility of the backing will typically vary with the intended use.

For example, in some embodiments, the backing may comprise a rigid plate or flange (for example, a molded polymeric or metal plate or flange). Optionally, the backing

in these embodiments may have an integral or affixed mechanical fastener, for example as described hereinbelow.

In some embodiments, the backing may comprise a compressible resilient nonwoven web, optionally in combination with one or more thin synthetic polymeric films affixed thereto.

Useful nonwoven webs include, for example, open fiber webs (for example, lofty open fiber webs) wherein the fibers are bonded together in their mutual contact points by a binder (for example, formed by drying and/or curing a binder precursor material). The nonwoven web may be made, for example, from an air-supported construction (for example, as described in U.S. Pat. No. 2,958,593 (Hoover et al.)), from a carded and cross-lapped construction, or a meltblown construction. Useful fibers include natural and synthetic fibers, and blends thereof. Useful synthetic fibers include, for example, those fibers made of polyester (for example, polyethylene-terephthalate), high or low resilience nylon (for example, hexamethylene-adipamide, polycaprolactam), polypropylene, acrylic (formed from acrylonitrile polymer), rayon, cellulose acetate, chloride copolymers of vinyl-acrylonitrile, and others. The appropriate natural fibers include those coming from cotton, wool, jute, and hemp.

Fiber diameters may be, for example, less than or equal to 1, 2, 4, 6, 10, 13, 17, 70, 110, 120 or 200 denier, although this is not a requirement. Fiber webs basis weights will depend upon the web thickness and the degree of openness.

Examples of suitable binder precursor materials include latexes (for example, acrylic latexes or polyurethane latexes), phenolic resins, aminoplast resins, polymer plastisols, and combinations thereof.

The non-woven web is typically formed and then coated with a binder precursor then submitted to a coating procedure in which a curable binder precursor is applied to the web, for example, by roll coating, dip coating, or spraying.

In some embodiments, the backing comprises at least one compressible foam layer, optionally in combination with one or more flexible members (for example, polymeric films) affixed thereto. In general, in these embodiments, any foam layer with at least one coatable major surface may be used. The foam layer may comprise any compressible foam material. In some embodiments, the compressible foam material is elastic. Useful foams include elastic foams such as, for example, chloroprene rubber foams,

ethylene/propylene rubber foams, butyl rubber foams, polybutadiene foams, polyisoprene foams, EPDM polymer foams, polyurethane foams, ethylene-vinyl acetate foams, neoprene foams, and styrene/butadiene copolymer foams. Useful foams also include thermoplastic foams such as, for example, polyethylene foams, polypropylene foams, polybutylene foams, polystyrene foams, polyamide foams, polyester foams, plasticized polyvinyl chloride (that is, pvc) foams. The foam layer may be of an open cell or closed cell variety, although typically, if the abrasive article is intended for use with liquids, an open cell foam having sufficient porosity to permit the entry of liquid is desirable. Particular examples of useful open cell foams are polyester polyurethane foams, commercially available from Illbruck, Inc., Minneapolis, Minnesota under the trade designations "R 200U", "R 400U", "R 600U" and "EF3-700C".

In those embodiments wherein the compressible backing comprises a foam layer, the thickness of the compressible foam layer is typically in a range of from 1 to 50 millimeters, however, other thickness may also be used. Typically, the bulk density of the compressible foam layer as determined by ASTM D-3574 is greater than 0.03 gram per cm^3 (2 lbs per ft^3), however lower density foam layers may also be used. In some embodiments, the foam layer has a bulk density of 0.03 to 0.10 grams per cm^3 (1.8 - 6 lbs per ft^3). While thinner or thicker and/or lighter or heavier foams may be useful, they may require special handling because they are somewhat more difficult to process on conventional coating equipment.

The compressible backing is typically in sheet form with substantially parallel major surfaces, but other surface-configurations with one or both major surfaces being planar or other than planar are also useful. For example, in those embodiments wherein the compressible backing comprises a foam layer, the second major surface may be planar to facilitate attachment and the first major surface, that is, the surface may be other than planar, such as an undulated or convoluted surface. Convoluted foams are disclosed in U.S. Pat. No. 5,007,128 and 5,396,737 (both to Englund et al.).

In those embodiments wherein the compressible backing comprises a foam layer, the foam layer may have an elongation in a range of from 85 to 150 % (that is, the stretched length of the foam minus the unstretched length of the foam all divided by the unstretched length of the foam and then multiplied by 100 equals 85 to 150%).

Deformable Material

The deformable material contacts a central portion of, and has its greatest thickness proximal to, the center of the first major surface of the backing. The deformable material may comprise gas (for example, air), liquid (for example, water, oil), foam (for example, as described hereinabove), semi-solid gel or paste, or a combination thereof. The deformable material may be enclosed within a polymeric bladder.

In some embodiments, the deformable material comprises an elastomer. For example, the deformable material may comprise, or even consist essentially of, at least one elastomeric gel or foamed elastomeric gel, typically comprising a highly plasticized elastomer. Examples of useful elastomeric gels include polyurethane elastomer gels, for example, as described in U.S. Pat. No. 6,908,979 (Arendoski); SEEPS elastomer gels, for example, as described in U.S. Pat. No. 5,994,450 and 6,797,765 (both to Pearce); styrene-butadiene-styrene/oil gels; and silicone elastomer gels, for example, as described in U.S. Pat. No. 6,013,711 (Lewis et al.).

For solid and gel materials, the elastic modulus (measured at 1 Hz and 25 °C) for the deformable material is between 1500 and 4.9×10^5 Pascals (Pa), for example, between 1750 and 1×10^5 Pa, although this is not a requirement. Examples of such deformable materials include styrene-butadiene-styrene/oil gels (for example, having an elastic modulus of 1992 Pa at 1 Hz and 25 °C), urethane foam (for example, having an elastic modulus of 3.02×10^5 Pa at 1 Hz and 25 °C or 4.31×10^5 Pa at 1 Hz and 25 °C); and elastomeric urethane rubber (for example, having modulus 4.89×10^5 Pa at 1 Hz and 25 °C).

The deformable material may be of any shape such as, for example, geometric shapes such as domes, curves, cones, truncated cones, ridges, polyhedrons, truncated polyhedrons, or other shapes (for example, yurt-shaped). The deformable material may also be ridged (for example, along the longest dimension of the first major surface of the compressible backing) as, for example, in the case of rectangular pads or belts.

The deformable material may contact from as little as 0.1, 5, 10, 20, 30, 40 or 50 percent up to 60, 70, 80, 90, or even 99.9 percent of the first major surface of the compressible backing. For example, the deformable material may contact at least one half of the major surface of the compressible backing.

Typically, the maximum thickness of the deformable material is selected based on factors such as, for example, the intended use and the overall size of the conformable abrasive article. In some embodiments, the maximum thickness of the deformable material is in a range of from 25 micrometers to 0.5 centimeter.

5

Elastic Member

The elastic member is a layer of material that provides a degree of flexibility and resiliency to the abrasive article, while enclosing the deformable material between itself and the compressible backing.

10

In some embodiments, the elastic member comprises an elastomeric film. The elastomeric film may be a uniform film, or it may be a composite film (for example, having multiple layers produced by coextrusion, heat lamination, or adhesive bonding). Examples of elastomers that may be used in the elastomeric film include polyolefin, polyester (for example, those available under the trade designation "HYTREL" from E.I. du Pont de Nemours & Co., Wilmington, Delaware), polyamide, styrene/butadiene copolymer (for example, those available under the trade designation "KRATON" from Kraton Polymers, Houston Texas), and polyurethane elastomers (for example, those polyurethane elastomers available under the trade designation "ESTANE 5701" and "ESTANE 5702"; chloroprene rubber, ethylene/propylene rubbers, polybutadiene rubber, polyisoprene rubber, natural or synthetic rubber, butyl rubber, silicone rubber, or EPDM rubber; and combinations thereof. Examples of useful elastomeric films include those described in U.S. Pat. Nos. 2,871,218 (Schollenberger); 3,645,835 (Hodgson); 4,595,001 (Potter et al.); 5,088,483 (Heinecke); 6,838,589 (Liedtke et al.); and RE33353 (Heinecke). Also useful are pressure sensitive adhesive coated polyurethane elastomer films, commercially available from 3M Company under the trade designation "TEGADERM".

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In some embodiments the elastic member comprises resilient foam. For example, the elastic member may comprise a composite of an elastomeric film affixed to elastomeric foam. Useful resilient elastomeric foams include, for example, chloroprene rubber foams, ethylene/propylene rubber foams, butyl rubber foams, polybutadiene foams, polyisoprene foams, EPDM polymer foams, polyurethane foams, ethylene-vinyl acetate foams, neoprene foams, and styrene/butadiene copolymer foams.

Affixing may be accomplished, for example, by an adhesive (for example, hot melt or pressure sensitive), by coextrusion, by heat laminating, or any other suitable method. In such embodiments, either of the elastomeric film or the elastomeric foam, for example, may be affixed to the first major surface of the backing.

5 The elastic member may contain additives such as, for example, stabilizers, fillers, pigments, processing aids, and the like.

 The elastic member may be affixed to the backing by any suitable means including, for example, hot melt adhesives, pressure sensitive adhesives, glues, and heat laminating or bonding. In some embodiments, affixing may be achieved using a pressure
10 sensitive transfer adhesive such as, for example, that marketed by 3M Company under the trade designation "HS300LSE".

 Typically, the thickness for the elastic layer is in a range from 0.01 millimeters to 3.5 millimeters, for example, in a range of from 0.02 to 3.2 millimeters, or in a range of from 0.02 to 1.7 millimeters, although other thicknesses may also be used.

15 Typically, the elastic modulus (measured at 1 Hz and 25 °C) of the elastic member is between 2.4×10^5 and 7×10^5 Pascals, for example, between 3×10^5 and 6×10^5 Pascals, or even between 4×10^5 and 5×10^5 Pascals, although this is not a requirement.

 Alternatively, or in addition to the optional tie layer the elastic member may be surface treated by corona, flame or acid or base priming.

20

Abrasive Member

 The abrasive member comprises an abrasive layer, optionally affixed to a flexible backing (that is, a coated abrasive article). The optional flexible backing may be elastic.

 In some embodiments, the abrasive layer comprises make and size layers and
25 abrasive particles as shown for example, in Fig. 5A. Referring now to Fig. 5A, abrasive layer 140a comprises make layer 506, abrasive particles 510, size layer 512, and optional supersize 514. Useful make, size, and optional supersize layers, flexible coated abrasive articles, and methods of making the same according to these embodiments include, for example, those described in U.S. Pat. Nos. 4,588,419 (Caul et al.); 4,734,104 (Broberg);
30 4,737,163 (Larkey); 4,751,138 (Tumey et al.); 5,078,753 (Broberg et al.); 5,203,884 (Buchanan et al.); 5,152,917 (Pieper et al.); 5,378,251 (Culler et al.); 5,366,523 (Rowenhorst et al.); 5,417,726 (Stout et al.); 5,436,063 (Follett et al.); 5,490,878 (Peterson

et al.); 5,496,386 (Broberg et al.); 5,609,706 (Benedict et al.); 5,520,711 (Helmin);
5,954,844 (Law et al.); 5,961,674 (Gagliardi et al.); 4,751,138 (Tumey et al.); 5,766,277
(DeVoe et al.); 6,059,850 (Lise et al.); 6,077,601 (DeVoe et al.); 6,228,133 (Thurber et
al.); and 5,975,988 (Christianson), and those marketed by 3M Company under the trade
5 designations "260L IMPERIAL FINISHING FILM".

In other embodiments, the abrasive layer comprises abrasive particles in a binder,
typically substantially uniformly distributed throughout the binder, as shown for example,
in Fig. 5B. Referring now to Fig. 5B, abrasive layer 140b comprises binder 536 and
abrasive particles 510. Details concerning materials and methods for making such
10 abrasive layers may be found, for example, in U.S. Pat. Nos. 4,927,431 (Buchanan et al.);
5,014,468 (Ravipati et al.); 5,378,251 (Culler et al.); 5,942,015 (Culler et al.); 6,261,682
(Law); and 6,277,160 (Stubbs et al.); and U.S. Pat. Appln. Publ. Nos. 2003/0207659 A1
(Annen et al.) and 2005/0020190 A1 (Schutz et al.).

In those embodiments wherein the abrasive member has no backing, a slurry of
15 abrasive particles in a binder precursor may be applied directly to the elastic member, and
then at least partially cured. Examples of useful flexible coated abrasive articles of this
embodiment include those described in U.S. Pat. No. 6,929,539 (Schutz et al.).

In some embodiments, the abrasive layer comprises a structured abrasive layer, for
example, as described in Fig. 5C. Referring now to Fig. 5C, structured abrasive layer
20 140c comprises precisely shaped abrasive composites 565. Precisely shaped abrasive
composites 565 comprise abrasive particles 510 dispersed throughout binder 536.

In the embodiments shown in Figs. 5A-5C, the abrasive layer may contact the
elastic member, or if present, the optional flexible backing.

Structured abrasive members, useful in practice of the present invention, generally
25 have an abrasive layer comprising a plurality of non-randomly shaped abrasive
composites, optionally supported on a flexible backing, and affixed to the elastic member.
As used herein, the term "abrasive composite" refers to a body that includes abrasive
particles and a binder. In some embodiments, shaped abrasive composites may be
arranged according to a predetermined pattern (for example, as an array).

30 In some embodiments, at least a portion of the shaped abrasive composites may
comprise "precisely shaped" abrasive composites. This means that the shape of the
abrasive composites is defined by relatively smooth surfaced sides that are bounded and

joined by well-defined edges having distinct edge lengths with distinct endpoints defined by the intersections of the various sides. The terms "bounded" and "boundary" refer to the exposed surfaces and edges of each composite that delimit and define the actual three-dimensional shape of each abrasive composite. These boundaries are readily visible and discernible when a cross-section of an abrasive article is viewed under a scanning electron microscope. These boundaries separate and distinguish one precisely shaped abrasive composite from another even if the composites abut each other along a common border at their bases. By comparison, in an abrasive composite that does not have a precise shape, the boundaries and edges are not well defined (for example, where the abrasive composite sags before completion of its curing). Typically, precisely shaped abrasive composites are arranged on the backing according to a predetermined pattern or array, although this is not a requirement.

Shaped abrasive composites may be arranged such that some of their work surfaces are recessed from the polishing surface of the abrasive layer.

Suitable optional flexible backings include flexible backings used in the abrasive art such as, for example, flexible polymeric films (including primed polymeric films and elastomeric polymeric films), elastomeric cloth, thin polymeric foam, and combinations thereof. Examples of suitable flexible polymeric films include polyester films, polypropylene films, polyethylene films, ionomer films (for example, those available under the trade designation "SURLYN" from E. I. du Pont de Nemours & Co., Wilmington, Delaware), vinyl films, polycarbonate films, and laminates thereof.

Structured abrasive members may be prepared by forming a slurry of abrasive particles and a solidifiable or polymerizable precursor of the abovementioned binder resin (that is, a binder precursor), contacting the slurry with a backing member (or directly with the elastic member), and solidifying and/or polymerizing the binder precursor (for example, by exposure electromagnetic radiation or thermal energy) in a manner such that the resulting structured abrasive article has a plurality of shaped abrasive composites affixed to the backing member.

Examples of energy sources include thermal energy and radiant energy (including electron beam, ultraviolet light, and visible light).

In some embodiments the slurry may be coated directly onto a production tool having precisely shaped cavities therein and brought into contact with the backing, or

coated on the backing and brought to contact with the production tool. In this embodiment, the slurry is typically then solidified or cured while it is present in the cavities of the production tool. U.S. Pat. No. 6,929,539 (Schutz et al.).

Precisely shaped abrasive composites may be of any three-dimensional shape that results in at least one of a raised feature or recess on the exposed surface of the abrasive layer. Useful shapes include, for example, cubic, prismatic, pyramidal (for example, square pyramidal or hexagonal pyramidal), truncated pyramidal, conical, frusto-conical, pup tent shaped, and ridge shaped. Combinations of differently shaped and/or sized abrasive composites may also be used. The abrasive layer of the structured abrasive may be continuous or discontinuous.

For fine finishing applications, the density of shaped abrasive composites in the abrasive layer is typically in a range of from at least 1,000, 10,000, or even at least 20,000 abrasive composites per square inch (for example, at least 150, 1,500, or even 7,800 abrasive composites per square centimeter) up to and including 50,000, 70,000, or even as many as 100,000 abrasive composites per square inch (up to and including 7,800, 11,000, or even as many as 15,000 abrasive composites per square centimeter), although greater or lesser densities of abrasive composites may also be used.

Further details concerning structured abrasive member having precisely shaped abrasive composites, and methods for their manufacture may be found, for example, in U.S. Pat. Nos. 5,152,917 (Pieper et al.); 5,304,223 (Pieper et al.); 5,435,816 (Spurgeon et al.); 5,672,097 (Hoopman); 5,681,217 (Hoopman et al.); 5,454,844 (Hibbard et al.); 5,549,962 (Holmes et al.); 5,700,302 (Stoetzel et al.); 5,851,247 (Stoetzel et al.); 5,910,471 (Christianson et al.); 5,913,716 (Mucci et al.); 5,958,794 (Bruxvoort et al.); 6,139,594 (Kincaid et al.); 6,923,840 (Schutz et al.); and U.S. Pat. Appln. Nos. 2003/0022604 (Annen et al.).

Structured abrasive members having precisely shaped abrasive composites that are useful for practicing the present invention are commercially available as films and/or discs, for example, as marketed under the trade designation "3M TRIZACT FINESSE-IT" by 3M Company, Saint Paul, Minnesota. Examples include "3M FINESSE-IT TRIZACT FILM, 466LA" available in grades A7, A5 and A3. Structured abrasive members having larger abrasive composite sizes may also be useful for practicing the present invention, for

example, those marketed under the trade designation "TRIZACT CF", available from 3M Company.

Structured abrasive members may also be prepared by coating a slurry comprising a polymerizable binder precursor, abrasive particles, and an optional silane coupling agent through a screen that is in contact with a backing. In this embodiment, the slurry is typically then further polymerized (for example, by exposure to an energy source) while it is present in the openings of the screen thereby forming a plurality of shaped abrasive composites generally corresponding in shape to the screen openings. Further details concerning this type of screen coated structured abrasive may be found, for example, in U.S. Pat. Nos. 4,927,431 (Buchanan et al.); 5,378,251 (Culler et al.); 5,942,015 (Culler et al.); 6,261,682 (Law); and 6,277,160 (Stubbs et al.).

In some embodiments, a slurry comprising a polymerizable binder precursor, abrasive particles, and an optional silane coupling agent may be deposited on a backing in a patterned manner (for example, by screen or gravure printing), partially polymerized to render at least the surface of the coated slurry plastic but non-flowing, a pattern embossed upon the partially polymerized slurry formulation, and subsequently further polymerized (for example, by exposure to an energy source) to form a plurality of shaped abrasive composites affixed to the backing. Such embossed structured abrasive articles prepared by this and related methods are described, for example, in U.S. Pat. Appl. Pub. No. 2001/0041511 (Lack et al.). Commercially available examples of such embossed structured abrasive articles are believed to include abrasive belts and discs available from Norton-St. Gobain Abrasives Company, Worcester, Massachusetts, under the trade designation "NORAX" such as for example, "NORAX U264 – X80", "NORAX U266 – X30", "NORAX U264 – X80", "NORAX U264 – X45", "NORAX U254 – X45, X30", "NORAX U264 – X16", "NORAX U336 – X5" and "NORAX U254 – AF06".

Structured abrasive layers may be prepared by coating a slurry comprising a polymerizable binder precursor, abrasive particles, and an optional silane coupling agent through a screen that is in contact with the elastic member, which may optionally have a tie layer or surface treatment thereon. In this embodiment, the slurry is typically then further polymerized (for example, by exposure to an energy source such as heat or electromagnetic radiation) while it is present in the openings of the screen thereby forming a plurality of shaped abrasive composites generally corresponding in shape to the screen

openings. Further details concerning this type of screen coated structured abrasive may be found, for example, in U.S. Pat. Nos. 4,927,431 (Buchanan et al.); 5,378,251 (Culler et al.); 5,942,015 (Culler et al.); 6,261,682 (Law); and 6,277,160 (Stubbs et al.); and in U.S. Publ. Pat. Appl. No. 2001/0041511 (Lack et al.).

5 Useful polymerizable binder precursors that may be cured to form the above-mentioned binders are well-known and include, for example, thermally curable resins and radiation curable resins, which may be cured, for example, thermally and/or by exposure to radiation energy. Exemplary polymerizable binder precursors include phenolic resins, aminoplast resins, urea-formaldehyde resins, melamine-formaldehyde resins, urethane
10 resins, polyacrylates (e. g., an aminoplast resin having pendant free-radically polymerizable unsaturated groups, urethane acrylates, acrylate isocyanurate, (poly)acrylate monomers, and acrylic resins), alkyd resins, epoxy resins (including bis-maleimide and fluorene-modified epoxy resins), isocyanurate resins, allyl resins, furan resins, cyanate esters, polyimides, and mixtures thereof. Polymerizable binder precursors may contain
15 one or more reactive diluents (for example, low viscosity monoacrylates) and/or adhesion promoting monomers (for example, acrylic acid or methacrylic acid).

If either ultraviolet radiation or visible radiation is to be used, the polymerizable binder precursor typically further comprise a photoinitiator.

20 Examples of photoinitiators that generate a free radical source include, but are not limited to, organic peroxides, azo compounds, quinones, benzophenones, nitroso compounds, acyl halides, hydrazones, mercapto compounds, pyrylium compounds, triacrylimidazoles, bisimidazoles, phosphene oxides, chloroalkyltriazines, benzoin ethers, benzil ketals, thioxanthenes, acetophenone derivatives, and combinations thereof

25 Cationic photoinitiators generate an acid source to initiate the polymerization of an epoxy resin. Cationic photoinitiators can include a salt having an onium cation and a halogen containing a complex anion of a metal or metalloid. Other cationic photoinitiators include a salt having an organometallic complex cation and a halogen containing complex anion of a metal or metalloid. These are further described in U.S. Pat. No. 4,751,138. Another example of a cationic photoinitiator is an organometallic salt and an onium salt
30 described in U.S. Pat. No. 4,985,340; European Patent Applications 306,161 and 306,162. Still other cationic photoinitiators include an ionic salt of an organometallic complex in

which the metal is selected from the elements of Periodic Group IVB, VB, VIB, VIIB and VIIIB.

The polymerizable binder precursor may also comprise resins that are curable by sources of energy other than radiation energy, such as condensation curable resins.

5 Examples of such condensation curable resins include phenolic resins, melamine-formaldehyde resins, and urea-formaldehyde resins.

10 The binder precursor and binder may include one or more optional additives selected from the group consisting of grinding aids, fillers, wetting agents, chemical blowing agents, surfactants, pigments, coupling agents, dyes, initiators, energy receptors, and mixtures thereof. The optional additives may also be selected from the group consisting of potassium fluoroborate, lithium stearate, glass bubbles, inflatable bubbles, glass beads, cryolite, polyurethane particles, polysiloxane gum, polymeric particles, solid waxes, liquid waxes and mixtures thereof.

15 Abrasive particles useful in the present invention can generally be divided into two classes: natural abrasives and manufactured abrasives. Examples of useful natural abrasives include: diamond, corundum, emery, garnet (off-red color), buhrstone, chert, quartz, garnet, emery, sandstone, chalcedony, flint, quartzite, silica, feldspar, natural crushed aluminum oxide, pumice and talc. Examples of manufactured abrasives include: boron carbide, cubic boron nitride, fused alumina, ceramic aluminum oxide, heat treated
20 aluminum oxide (both brown and dark grey), fused alumina zirconia, glass, glass ceramics, silicon carbide (preferably green, although small amounts of black may be tolerated), iron oxides, tantalum carbide, chromia, cerium oxide, tin oxide, titanium carbide, titanium diboride, synthetic diamond, manganese dioxide, zirconium oxide, sol gel alumina-based ceramics, silicon nitride, and agglomerates thereof. Examples of sol gel
25 abrasive particles can be found in U.S. Pat. Nos. 4,314,827 (Leitheiser et al.); 4,623,364 (Cottringer et al); 4,744,802 (Schwabel); 4,770,671 (Monroe et al.) and 4,881,951 (Wood et al.).

30 The size of an abrasive particle is typically specified to be the longest dimension of the abrasive particle. In most cases there will be a range distribution of particle sizes. The particle size distribution may be tightly controlled such that the resulting abrasive article provides a consistent surface finish on the workpiece being abraded, however, broad and/or polymodal particle size distributions may also be used.

The abrasive particle may also have a shape associated with it. Examples of such shapes include rods, triangles, pyramids, cones, solid spheres, hollow spheres and the like. Alternatively, the abrasive particle may be randomly shaped.

5 Abrasive particles can be coated with materials to provide the particles with desired characteristics. For example, materials applied to the surface of an abrasive particle have been shown to improve the adhesion between the abrasive particle and the polymer. Additionally, a material applied to the surface of an abrasive particle may improve the adhesion of the abrasive particles in the softened particulate curable binder material. Alternatively, surface coatings can alter and improve the cutting characteristics
10 of the resulting abrasive particle. Such surface coatings are described, for example, in U.S. Pat. Nos. 5,011,508 (Wald et al.); 3,041,156 (Rowse et al.); 5,009,675 (Kunz et al.); 4,997,461 (Markhoff-Matheny et al.); 5,213,591 (Celikkaya et al.); 5,085,671 (Martin et al.) and 5,042,991 (Kunz et al.).

15 In some embodiments, for example, those including shaped abrasive composites, the abrasive particles have a particle size ranging from 0.1 micrometer to 1500 micrometers, more typically ranging from 0.1 micrometer to 1300 micrometers. In some embodiments, the abrasive particles have a size within a range of from JIS grade 800 (14 micrometers at 50% midpoint) to JIS grade 4000 (3 micrometers at 50% midpoint) or even JIS grade 6000 (2 micrometers at 50% midpoint), inclusive.

20 Typically, the abrasive particles used in the present invention have a Moh's hardness of at least 8, more typically above 9; however, abrasive particles having a Moh's hardness of less than 8 may be used.

25 If the abrasive member has an optional flexible backing, it may be affixed to the elastic member by any suitable means including, for example, hot melt adhesives, pressure sensitive adhesives (for example, latex pressure sensitive adhesives or pressure sensitive adhesive transfer films), glue, heat lamination, or coextrusion.

Attachment System

Conformable abrasive articles according to the present invention may be secured to a support structure, commonly referred to as a backup pad. The conformable abrasive article may be secured by means of, for example, a pressure sensitive adhesive, hook and
5 loop attachment, or some other mechanical means.

Accordingly, conformable abrasive articles according to the present invention may further comprise an attachment system affixed to the second major surface of the backing. The attachment system is typically designed to secure the conformable abrasive article to a tool (optionally having a back up pad mounted thereto) such as, for example, a rotary
10 sander.

In one embodiment, the attachment system comprises a layer of pressure sensitive adhesive, typically made by applying a layer of pressure sensitive adhesive to the second major surface of the backing. Useful pressure sensitive adhesives for this layer include, for example, those derived from acrylic polymers and copolymers (for example, polybutyl
15 acrylate), vinyl ethers (for example, polyvinyl n-butyl ether); vinyl acetate adhesives; alkyd adhesives; rubber adhesives (for example, natural rubber, synthetic rubber, chlorinated rubber); and mixtures thereof. One preferred pressure sensitive adhesive is an isooctyl acrylate:acrylic acid copolymer. The pressure sensitive adhesive may be coated out of organic solvent, water or be coated as a hot melt adhesive.

20 In another embodiment, the attachment system comprises a quick connect mechanical fastener such as, for example, those described in U.S. Pat. Nos. 3,562,968 (Johnson et al.); 3,667,170 (Mackay, Jr.); 3,270,467; and 3,562,968 (Block et al.); and in commonly assigned U.S. Ser. No. 10/828,119 (Fritz et al.), filed April 20, 2004.

25 In yet another embodiment, the attachment system comprises a loop substrate. The purpose of the loop substrate is to provide a means that the conformable abrasive article can be securely engaged with hooks from a support pad. The loop substrate may be laminated to the coated abrasive backing by any conventional means. The loop substrate may be a chenille stitched loop, a stitchbonded loop substrate or a brushed loop substrate (for example, brushed nylon). Examples of typical loop backings are further described in
30 U.S. Pat. Nos. 4,609,581 and 5,254,194 (both to Ott). The loop substrate may also contain a sealing coat to seal the loop substrate and prevent subsequent coatings from penetrating into the loop substrate.

In yet another embodiment, the attachment system comprises an intermeshing attachment system. An example of such an attachment system may be found in U. S. Publ. Pat. Appln. No. 2003/0143938 (Braunschweig et al.).

Likewise, the back side of the abrasive article may contain a plurality of hooks; these hooks are typically in the form of sheet like substrate having a plurality of hooks protruding therefrom, for example, as described in 5,672,186 (Chesley et al.). These hooks will then provide the engagement between the coated abrasive article and a support pad that contains a loop fabric. This hook substrate may be laminated to the coated abrasive backing by any conventional means.

Method of Making

Conformable abrasive articles according to the present invention may generally be made by: providing a backing with first and second opposed major surfaces; and contacting a deformable material with a central portion of the first major surface of the backing such that the deformable material has greatest thickness proximal to the center of the first major surface; affixing an elastic member to the first major surface of the backing such that the backing and the backing envelope the deformable material; and affixing an abrasive member to the elastic member, wherein the abrasive member comprises abrasive particles in a binder. The surface of the elastic member may be surface treated to enhance adhesion as discussed hereinabove.

Affixing of the various components may be accomplished by any suitable means such as, for example, an adhesive (for example, hot melt or pressure sensitive), glue, mechanical fasteners, coextrusion, by heat and/or pressure laminating, or any other suitable method.

Useful adhesives include, for example, acrylic pressure sensitive adhesive, rubber-based pressure sensitive adhesives, waterborne lattices, solvent-based adhesives, and two-part resins (for example, epoxies, polyesters, or polyurethanes). Examples of suitable pressure sensitive adhesives include those derived from acrylate polymers (for example, polybutyl acrylate) polyacrylate esters), acrylate copolymers (for example, isooctyl acrylate/ acrylic acid), vinyl ethers (for example, polyvinyl n-butyl ether); alkyd adhesives; rubber adhesives (for example, natural rubbers, synthetic rubbers and

chlorinated rubbers); and mixtures thereof. An example of a pressure sensitive adhesive coating is described in U.S. Pat. No. 5,520,957 (Bange et al.).

Adhesives may be applied by any suitable means including, for example, roll coating, brushing, extrusion, spraying, bar coating, and knife coating.

5 The deformable material may be applied to the backing by any suitable means including, for example, manually, by mechanical device, and/or by extrusion.

When enclosing the deformable material with the elastic member, or optional elastomeric film, care should typically be taken to ensure a continuous seal with the backing.

10 The abrasive member is then affixed to the elastic member, for example, by affixing the flexible backing to the elastic member or coating a slurry comprising binder precursor and abrasive particles onto the elastic member and at least partially curing the binder precursor as described herein above.

15 Abrasive articles

Conformable abrasive articles according to the present invention may be manufactured to have any form. Specific examples include a circular abrasive pad (shown as 600 in Fig. 6), a rectangular abrasive pad (shown as 700 in Fig. 7), or an abrasive belt (shown as 800 in Fig. 8).

20 Conformable abrasive articles may be used, for example, by hand or in combination with a power tool such as for example, a rotary sander or belt sander.

Conformable abrasive articles according to the present invention are useful for abrading (including finishing) a workpiece by a method that includes: providing a conformable abrasive article according to the present invention; frictionally contacting at
25 least one abrasive particle with a workpiece; and moving at least one of the abrasive particle and the workpiece relative to the other to abrade at least a portion of the surface of the workpiece. For example, the abrasive article may oscillate at the abrading interface during use.

30 The workpiece can be any of a variety of types of material such as painted substrates (for example, having a clear coat, base (color) coat, primer or e-primer), coated substrates (for example, with polyurethane, lacquer, etc.), plastics (thermoplastic, thermosetting), reinforced plastics, metal, (carbon steel, brass, copper, mild steel, stainless

steel, titanium and the like) metal alloys, ceramics, glass, wood, wood-like materials, composites, stones (including gem stones), stone-like materials, and combinations thereof. The workpiece may be flat or may have a shape or contour associated with it. Examples of common workpieces that may be polished by the abrasive article of the invention
5 include metal or wooden furniture, painted or unpainted motor vehicle surfaces (car doors, hoods, trunks, etc.), plastic automotive components (headlamp covers, tail-lamp covers, other lamp covers, arm rests, instrument panels, bumpers, etc.), flooring (vinyl, stone, wood and wood-like materials), counter tops, and other plastic components.

During abrading processes it may be desirable to provide a liquid to the surface of
10 the workpiece and/or the abrasive layer. The liquid may comprise water and/or an organic compound, and additives such as defoamers, degreasers, liquids, soaps, corrosion inhibitors, and the like.

Without wishing to be bound by theory, it is believed that during abrading abrasive articles according to the present invention are typically compressed causing deformation
15 of the deformable material which then redistributes the compression force toward the periphery of the abrasive article, minimizing excessive downward force on the centermost region of the abrasive crown, and resulting in a smoother transition in the appearance of the abraded surface of a workpiece than would be typically observed using a corresponding conventional abrasive article that did not include a cushion of deformable
20 material as in the present invention.

Objects and advantages of this invention are further illustrated by the following non-limiting examples, but the particular materials and amounts thereof recited in these examples, as well as other conditions and, details, should not be construed to unduly limit this invention.

25 EXAMPLES

Unless otherwise noted, all parts, percentages, ratios, etc. in the examples and the rest of the specification are by weight, and all reagents used in the examples were obtained, or are available, from general chemical suppliers such as, for example, Sigma-
30 Aldrich Company, Saint Louis, Missouri, or may be synthesized by conventional methods.

The following abbreviations are used throughout the Examples:

- GC1: antioxidant commercially available under the trade designation "IRGANOX 1010" from Ciba Specialty Chemicals, Tarrytown, New York.
- 5 GC2: butadiene-styrene block copolymer commercially available under the trade designation "KRATON D1107" from Kraton Polymers, Houston, Texas.
- GC3: white mineral oil
- PM1: 2-phenoxyethyl acrylate monomer available under the trade designation "SR 339" from Sartomer Company, Exton, Pennsylvania.
- 10 PM2: trimethylolpropane triacrylate available under the trade designation "SR 351" from Sartomer Company.
- PM3: a polymeric dispersant available under the trade designation "SOLPLUS D520" from Noveon, Inc., Cleveland, Ohio.
- 15 PM4: gamma-methacryloxypropyltrimethoxy silane resin modifier available under the trade designation "SILQUEST A174" from Witco Corporation, Greenwich, Connecticut.
- PM5: ethyl 2,4,6-trimethylbenzoylphenylphosphinate photoinitiator available under the trade designation "LUCIRIN TPO-L" from BASF Corp., Charlotte, North Carolina.
- 20 PM6: silicon dioxide available under the trade designation "AEROSIL OX-50" from Degussa Corp., Dusseldorf, Germany.
- MNI: a grade JIS 1000 silicon carbide abrasive mineral, commercially available under the trade designation "GC1000" from Fujimi Corp., Elmhurst, Illinois.
- MN2: a grade JIS 2000 silicon carbide abrasive mineral, commercially available under the trade designation "GC2000" from Fujimi Corp.
- 25 MN3: a grade JIS 3000 silicon carbide abrasive mineral, commercially available under the trade designation "GC3000" from Fujimi Corp.
- MN4: a grade JIS 4000 silicon carbide abrasive mineral, commercially available under the trade designation "GC4000" from Fujimi Corp.
- 30 MN5: a grade JIS1500 silicon carbide abrasive mineral, commercially available under the trade designation "GC1500" from Fujimi Corp.

PREPARATION OF ABRASIVE SLURRIES AS1-AS5

A resin pre-mix was made by mixing for 30 minutes at 20 °C, 63.12 grams of PM1, 63.12 grams of PM2, 18.04 grams of PM3, 13.53 grams of PM4 and 13.55 grams of PM5. PM6 (22.54 grams) was then added and the mixing continued until homogeneous.

5 Abrasive slurries AS1-AS4 (as reported in Table 1, below) were made by combining 257 grams of the following minerals to 193 grams of the resin pre-mix, then combined for 5 minutes on a high speed shear mixer until homogeneous.

TABLE 1

ABRASIVE SLURRY	MINERAL
AS1	MN1
AS2	MN2
AS3	MN3
AS4	MN4
AS5	MN5

10 The temperature during the high speed mixing step was kept below 100 °F (37.8 °C). AS1 was applied via knife coating to a polypropylene production tool having a uniform pattern, as disclosed in U.S. Pat. No. 6,929,539 (Schutz et al.). The slurry coated polypropylene production tool was brought into contact with 3 mil ethylene-acrylic acid
15 primed polyester film such that the slurry contacted the polyester film. The production tool was then irradiated with an ultraviolet (UV) lamp, type "D" bulb, from Fusion Systems Inc., Gaithersburg, Maryland, at 600 Watts per inch (236 Watts per cm) while moving the web at 30 feet per minute (9.14 meters/minute), and a nip pressure of 90 pounds per square inch (620.5 kilopascals (kPa)) for a 10 inch (25.4 cm) wide web. The production
20 tool was removed from the resulting substantially cured shaped abrasive coating on the film laminated backing. Discs of 1.25 inch (3.2 cm) diameter and designated AD1, were then die cut from the resulting abrasive material. This process was then repeated to make abrasive discs AD2, AD3, AD4 and AD5 from abrasive slurries AS2, AS3, AS4 and AS5 respectively.

EXAMPLE 1

A gel composition was prepared by mixing in a glass jar at 20 °C until homogeneous, 1.2 parts by weight GC1, 12.4 parts by weight GC2 and 86.4 parts by weight GC3. The mixture was then heated with a heat gun to render it pourable. The heated gel was placed into a mold with a dome-shaped recess 1.27 cm in diameter and 1.2 mm deep at the center, and allowed to cool for 10 minutes to form a gel body. The gel body was then placed in the center of a 1.25-inch (3.2 cm) sanding pad, commercially available under the trade designation "FINESSE-IT ROLOC SANDING PAD, PART No. 02345" from 3M Company. The gel-filled body was secured to the sanding pad with a 2 inch by 2 inch (5.1 by 5.1 cm) piece of 0.8 mils (20.3 micrometers (μm)) of an adhesively coated elastomeric polyurethane transfer film, commercially available under the trade designation "TEGADERM", from 3M Company, with the excess film wrapped over the edge of the sanding pad. A 1.25-inch (3.2 cm) diameter by 31.25 mils (793.8 μm) thick piece of another elastomeric polyurethane film, commercially available under the trade designation "BUMPON PROTECTIVE PRODUCT 6200 SERIES ROLLSTOCK", from 3M Company, was applied over the TEGADERM film. The remaining exposed adhesive perimeter of the TEGADERM film was then covered with a strip of vinyl tape commercially available under the trade designation "VINYL TAPE, NO. 471" from 3M Company. Abrasive disc AD1 was then secured to the surface of the "BUMPON" film.

EXAMPLE 2

The process described above was repeated, except that abrasive disc AD1 was replaced with abrasive disc AD2.

EXAMPLE 3

The process described above was repeated, except that abrasive disc AD1 was replaced with abrasive disc AD3.

EXAMPLE 4

The process described above was repeated, except that abrasive disc AD1 was replaced with abrasive disc AD4.

EXAMPLE 5

A layer of transfer adhesive commercially available under the trade designation "HS300LSE" from 3M Company, was laminated to the non-adhesive, exposed face of the "TEGADERM" transfer film. AS5 was applied via knife coating to a polypropylene production tool having a uniform pattern, as disclosed in U.S. Pat. No. 6,929,539. The slurry coated polypropylene production tool was brought into contact with the elastomeric polyurethane transfer film such that the slurry contacted the exposed layer of the "HS300LSE" transfer adhesive. The production tool was then irradiated with an ultraviolet (UV) lamp, type "D" bulb, from Fusion Systems Inc., Gaithersburg, Maryland, at 600 Watts per inch (236 Watts per cm) while moving the web at 30 feet per minute (9.14 meters/minute), and a nip pressure of 90 pounds per square inch (620.5 kilopascals (kPa)) for a 10 inch (25.4 cm) wide web. The production tool was removed from the resulting substantially cured shaped abrasive coating on the elastomeric polyurethane film.

A 2 inch (5.1 cm) wide strip of the "471" vinyl tape was applied to both ends and both lengths of a sanding sponge, commercially available under the trade designation "SMALL AREA SANDING SPONGE, TYPE 907NA", from 3M Company. The tape was applied around the perimeter of the sanding sponge such that 1/8 inch (3.2 mm) of tape was exposed above one side of the sponge, thereby forming a mold. The gel composition described in Example 1 was prepared and poured into the mold and allowed to cool for 10 minutes.

The gel was pulled down and secured onto the sanding sponge with a 4-inch x 4-inch (10-cm by 10-cm) piece of the "TEGADERM" transfer film. The film was wrapped over the edges of the sanding pad. An area measuring 2.5 inches x 2.5 inches (6.4 cm by 6.4 cm) was created over this layer with 0.5-inch (1.27-cm) foam tape, commercially available under the trade designation "SOFT EDGE FOAM MASKING TAPE, PART NO. 06297." This created another cavity for additional gel. The aforementioned gel was prepared and poured into the mold and allowed to cool for 10 minutes, thereby creating a centered raised portion 6.4 cm x 6.4 cm x 0.3 cm high. The gel was pulled down and secured onto the sanding sponge with a 4-inch x 4-inch (10.2-cm by 10.2-cm) piece of "TEGADERM" transfer film. The film was then wrapped over the edges of the sanding pad. The release liner was removed from the abrasive-coated elastomeric polyurethane film described above, and the resulting abrasive-coated free film was pulled down and

secured on to the hand pad, such that the exposed adhesive contacted the hand pad and the abrasive coating was the exposed layer on the resulting abrasive hand pad.

EXAMPLE 6

5 A 2-inch (5.1-cm) wide strip of the "471" vinyl tape was applied around circumference of a 6 inches (15.2 cm) in diameter hand pad, commercially available under the trade designation "3M HOOKIT II SOFT HAND PAD, PART No. 05291." The tape was applied such that 1/8 inch (3.2 mm) of tape was exposed around the circumference, thereby forming a dam to create a volume into which gel can be poured. The gel
10 composition described in Example 1 was prepared and poured into the resulting mold and allowed to cool for 10 minutes. The abrasive-coated elastomeric polyurethane film of Example 5 was similarly applied to the gel face of the hand pad.

EXAMPLE 7

15 Foam masking tape, (1.27 cm in width, commercially available under the trade designation "SOFT EDGE FOAM MASKING TAPE" from 3M Company, was used to form a channel on a 1.27 cm wide x 45.7 cm long abrasive belt, commercially available under the trade designation available "237AA" from 3M Company. The belt was folded in half and held level on a silicone liner with the foam masking tape. The gel composition
20 described in Example 1 was prepared and poured into the resulting mold and allowed to cool for 10 minutes. This procedure was repeated until the entire outer surface of the belt contained an approximately 3-mm thick layer of gel. The abrasive-coated elastomeric polyurethane film of Example 5 was similarly applied to the gel face of the belt.

TESTING

25 Abrasive articles were tested for their ability to remove dirt nibs in automotive clearcoat without concomitant leveling of the surrounding orange peel. The sanding substrates were 18-inch by 24-inch (45.7-cm by 61-cm) clear coated black painted cold roll steel test panels, obtained from ACT Laboratories, Inc., Hillsdale, Michigan, as the
30 sanding substrate. The panels were then scuffed to ensure mechanical paint adhesion using "TRIZACT HOOKIT II BLENDING DISC, 443SA, GRADE P1000" commercially available from 3M Company, attached to a random orbit sander, model number "59025"

obtained from Dynabrade, Inc., Clarence, New York, operating at a line pressure of 40 pounds per square inch (258 kilopascals (kPa)). The panels were scuffed by sanding around the edges of the panel first, then sanding the entire panel with an up/down motion and then side-to-side motion. The panels had a matte finish when this step was complete.

5 The panels were wiped down with a dry paper towel to remove most of the wet swarf. The panels were then washed with general purpose adhesive cleaner (commercially available under the trade designation "3M General Purpose Adhesive Cleaner" from 3M Company), Part No. 051135-08984.

10 A clearcoat solution was prepared by mixing together 3 parts of resin (available under the trade designation "CHROMA CLEAR G2 4500S"), 1 part activator (available under the trade designation "62-4508S") and 1 part reducer (available under the trade designation "12375S"), all commercially available from E.I. du Pont de Nemours & Co., Wilmington, Delaware. The clearcoat was applied to the panel using a spray gun, model NR 95 from SATA Farbspritztechnik GmbH, Kornwestheim, Germany with 1.3-mm
15 spray nozzle operating at a line pressure of 40 pounds per square inch (258 kilopascals (kPa)). The clearcoat solution was sprayed onto each panel at a nominal thickness of 2 mils (50 micrometers). The panels were allowed to dry at room temperature in air for at least 24 hours 5 days before use.

Abrasive testing was done using a 3.2-cm random orbit sander, model number
20 "57502" obtained from Dynabrade, Inc., Clarence, New York, operating at a line pressure of 40 pounds per square inch (258 kilopascals (kPa)). Dirt nibs in the cured clearcoat were identified visually. The abrasive article was attached to the sander and tested by damp-sanding a given nib for between 2 and 6 seconds at a time, depending on the abrasive grade. The nib was sanded with the center of the abrasive article using the weight of the
25 tool to generate the down force. The sanded area was polished using a Dewalt Buffer model no. 849, commercially available from Dewalt Industrial Tool, Hampstead, Maryland, operating at 1400 rotations per minute (rpm). The buffing used a machine glaze (available under the trade designation "PERFECT-IT III TRIZACT MACHINE GLAZE", Part No. 05718), a backup pad (available under the trade designation (available
30 under the trade designation "PERFECT-IT BACK UP PAD", Part No. 05725) and a polishing pad (available under the trade designation "PERFECT-IT FOAM POLISHING PAD", Part No. 05930), all commercially available from 3M Company. The average

surface finish (R_z) in micrometers (μm) of each sanded spot was measured using a profilometer available under the trade designation "SURTRONIC 3+ PROFILOMETER" from Taylor Hobson, Inc., Leicester, England. R_z is the average of 5 individual measurements of the vertical distance between the highest point and the lowest point over the sample length of an individual profilometer measurement. Two finish measurements were made per sanded spot.

The abrasive articles of Examples 1 through 4 were tested by the procedure outlined above, and the results are reported in Table 2 (below).

TABLE 2

Sample	Nib Removed	Orange Peel Leveled	Average R_z (micrometers)	Sanding time to remove the nib (seconds)
Example 1	Yes	No	0.68	2
Example 2	Yes	No	0.43	4
Example 3	Yes	No	0.36	4
Example 4	Yes	No	0.33	5

Various modifications and alterations of this invention may be made by those skilled in the art without departing from the scope and spirit of this invention, and it should be understood that this invention is not to be unduly limited to the illustrative embodiments set forth herein.

What is claimed is:

1. A conformable abrasive article comprising:

a backing having a first major surface;

5 a deformable material contacting a central portion of the first major surface, the deformable material having greatest thickness proximal to the center of the first major surface;

an elastic member affixed to the first major surface of the backing and together with the backing enclosing the deformable material; and

10 an abrasive member affixed to the elastic member, wherein the abrasive member comprises abrasive particles and a binder.

2. A conformable abrasive article according to claim 1, wherein the backing is compressible.

3. A conformable abrasive article according to claim 1, wherein the backing is compressible and resilient.

4. A conformable abrasive article according to claim 1, wherein the conformable abrasive article is selected from the group consisting of a circular abrasive pad, a rectangular abrasive pad, and an abrasive belt.

5. A conformable abrasive article according to claim 1, wherein the abrasive member comprises a coated abrasive member having an abrasive layer affixed to a flexible backing member, the abrasive layer comprising the abrasive particles and make and size layers, and wherein at least the make layer comprises the binder.

6. A conformable abrasive article according to claim 1, wherein the abrasive member comprises a coated abrasive member having an abrasive layer affixed to a flexible backing member, and wherein the abrasive layer comprises the abrasive particles uniformly dispersed in the binder.

7. A conformable abrasive article according to claim 6, wherein the backing member is elastic.

8. A conformable abrasive article according to claim 6, wherein the abrasive member comprises an abrasive layer that contacts the elastic member.

9. A conformable abrasive article according to claim 6, wherein the elastic member comprises an elastomeric film affixed to an elastomeric foam, and wherein the elastomeric film is further affixed to the first major surface of the backing.

10. A method of abrading a workpiece, the method comprising:
providing a conformable abrasive article according to claim 6;
frictionally contacting at least one abrasive particle with a workpiece; and
moving at least one of the abrasive particle and the workpiece relative to the other to
abrade at least a portion of the surface of the workpiece.

11. A method according to claim 10, further comprising:
providing a liquid to the surface of the workpiece.

12. A conformable abrasive article according to claim 6, wherein the elastic member comprises a polyurethane elastomer.

13. A conformable abrasive article according to claim 1, wherein the abrasive member comprises a flexible backing member having an abrasive layer affixed thereto, wherein the abrasive layer comprises abrasive composite particles, the abrasive composite particles comprising the abrasive particles dispersed in the binder, and wherein the backing member is affixed to the elastic member.

14. A conformable abrasive article according to claim 13, wherein the abrasive composite particles comprise abrasive grits in a binder, and wherein the abrasive grits have a size within a range of from JIS grade 800 to JIS grade 6000, inclusive.

15. A conformable abrasive article according to claim 13, wherein the abrasive composite particles are precisely shaped.

16. A conformable abrasive article according to claim 1, wherein the backing comprises a flexible member having a compressible foam layer affixed thereto, wherein the flexible member has a surface that comprises a second major surface of the backing, and wherein the compressible foam layer has a surface that comprises the first major surface of the backing.

17. A conformable abrasive article according to claim 16, wherein the compressible foam layer is elastic.

18. A conformable abrasive article according to claim 16, wherein the flexible member comprises a polymeric film.

19. A method of abrading a workpiece, the method comprising:
providing a conformable abrasive article according to claim 16;
frictionally contacting at least one abrasive particle with a workpiece; and
moving at least one of the abrasive layer and the workpiece relative to the other to
abrade at least a portion of the surface of the workpiece.

20. A conformable abrasive article according to claim 1, wherein the elastic member comprises compressible resilient foam.

21. A conformable abrasive article according to claim 1, wherein the elastic member comprises an elastomeric film affixed to an elastomeric foam, and wherein the conformable elastomeric film is further affixed to the first major surface of the backing.

22. A conformable abrasive article according to claim 21, wherein the elastomeric film comprises a polyurethane elastomer.

23. A method of abrading a workpiece, the method comprising:
providing a conformable abrasive article according to claim 20;
frictionally contacting at least one abrasive particle with a workpiece; and
moving at least one of the abrasive particles and the workpiece relative to the other
5 to abrade at least a portion of the surface of the workpiece.

24. A conformable abrasive article according to claim 1, wherein the deformable
material comprises an elastomer.

10 25. A conformable abrasive article according to claim 1, wherein the deformable
material consists essentially of elastomeric gel.

26. A conformable abrasive article according to claim 1, wherein the deformable
material comprises gas.

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27. A conformable abrasive article according to claim 1, wherein the deformable
material is domed or ridged.

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28. A conformable abrasive article according to claim 1, wherein the abrasive member
is outwardly convex.

29. A conformable abrasive article according to claim 1, wherein the deformable
material has a central region of substantially uniform thickness and a peripheral region of
decreasing thickness.

25

30. A conformable abrasive article according to claim 1, wherein the deformable
material contacts at least one half of the first major surface.

30

31. A conformable abrasive article according to claim 1, further comprising an
attachment system affixed to a second major surface of the backing, wherein the first and
second major surfaces are opposed.

32. A conformable abrasive article according to claim 31, wherein the attachment system comprises hooks or loops.

33. A conformable abrasive article according to claim 1, wherein the abrasive member
5 comprises an abrasive layer that contacts the elastic member.

34. A conformable abrasive article according to claim 33, wherein the binder comprises a reaction product of a polymerizable binder precursor comprising at least one of acrylic acid or methacrylic acid.

10 35. A method of abrading a workpiece, the method comprising:
providing a conformable abrasive article according to claim 1;
frictionally contacting the abrasive layer with a workpiece; and
moving at least one of the abrasive layer and the surface of the workpiece relative
15 to the other to abrade at least a portion of the surface of the workpiece.

36. A method according to claim 35, wherein the workpiece comprises a painted substrate.

20 37. A method of making a conformable abrasive article comprising:
providing a backing having a first major surface;
contacting a deformable material with a central portion of the first major surface of the backing, the deformable material having greatest thickness proximal to the center of the first major surface;

25 affixing an elastic member to the first major surface of the backing, the elastic member and the compressible backing enclosing the deformable material; and
affixing an abrasive member to the elastic member, wherein the abrasive member comprises abrasive particles and a binder.

30 38. A method according to claim 37, wherein the backing is compressible.

39. A method according to claim 37, wherein the backing is compressible and resilient.

40. A method according to claim 37, wherein the backing comprises a flexible member having a compressible foam layer affixed thereto, wherein the flexible member has a surface that comprises a second major surface of the backing, and wherein the compressible foam layer has a surface that comprises the first major surface of the backing.

41. A method according to claim 37, wherein affixing an elastic member to the first major surface of the backing and enclosing the deformable material comprises:
affixing a conformable elastomeric film to the first major surface of the backing;
and
affixing an elastomeric foam to the conformable elastomeric film.

42. A method according to claim 37, wherein the conformable elastomeric film comprises an elastomeric polyurethane.

43. A method according to claim 37, wherein affixing an abrasive member to the elastic member comprises:
providing a structured abrasive member comprising a backing and an abrasive layer; and
affixing the backing to the elastic member.

44. A method according to claim 37, wherein the abrasive member comprises a coated abrasive member having an abrasive layer affixed to a flexible backing member, the abrasive layer comprising the abrasive particles and make and size layers, and wherein at least the make layer comprises the binder.

45. A method according to claim 37, wherein the abrasive member comprises a coated abrasive member having an abrasive layer affixed to a flexible backing member, and wherein the abrasive layer comprises the abrasive particles uniformly dispersed in the binder.

46. A method according to claim 45, wherein the backing member is elastic.

47. A method according to claim 37, wherein the abrasive member comprises an abrasive layer that contacts the elastic member.

5

48. A method according to claim 37, wherein the abrasive member comprises a structured abrasive member.

49. A method of making a conformable abrasive article comprising:

10

providing a backing having a first major surface;

contacting a deformable material with a central portion of the first major surface of the backing, the deformable material having greatest thickness proximal to the center of the first major surface;

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affixing an elastic member to the first major surface of the backing, the elastic member and the compressible backing enclosing the deformable material; and

applying a curable composition comprising a polymerizable binder precursor and abrasive particles to the extensible tie layer; and
at least partially curing the curable composition to provide an abrasive layer.

20

50. A method according to claim 49, further comprising:

imparting a textured surface to the curable composition with a production tool; and

separating the production tool from the at least partially cured curable composition to produce a plurality of shaped abrasive composites.

25

51. A method according to claim 49, wherein the polymerizable binder precursor comprises at least one of acrylic acid or methacrylic acid.

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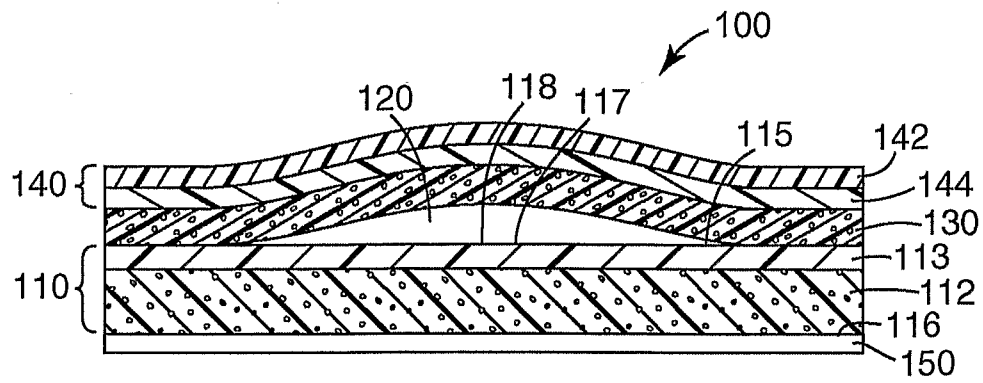


Fig. 1

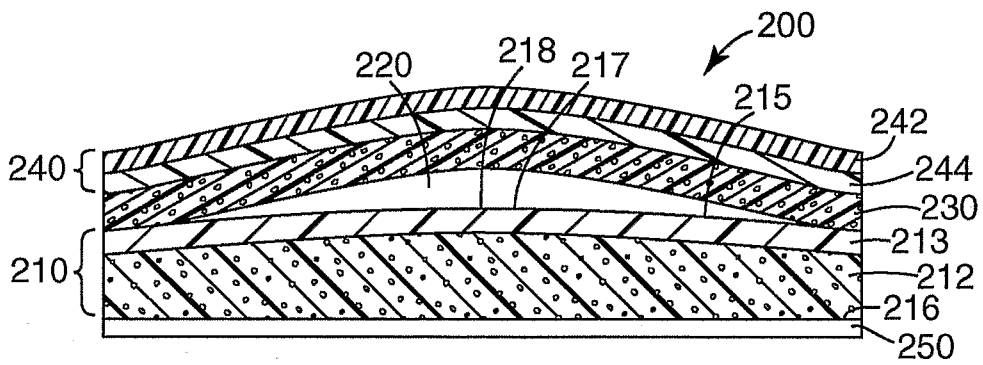


Fig. 2

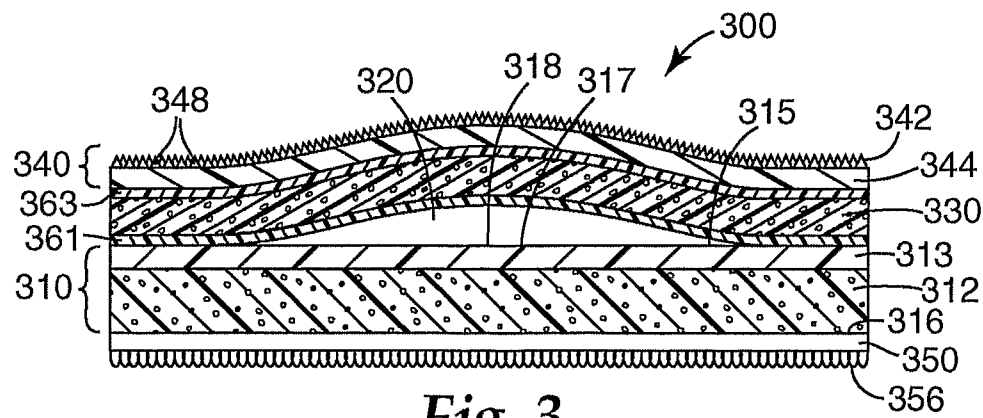


Fig. 3

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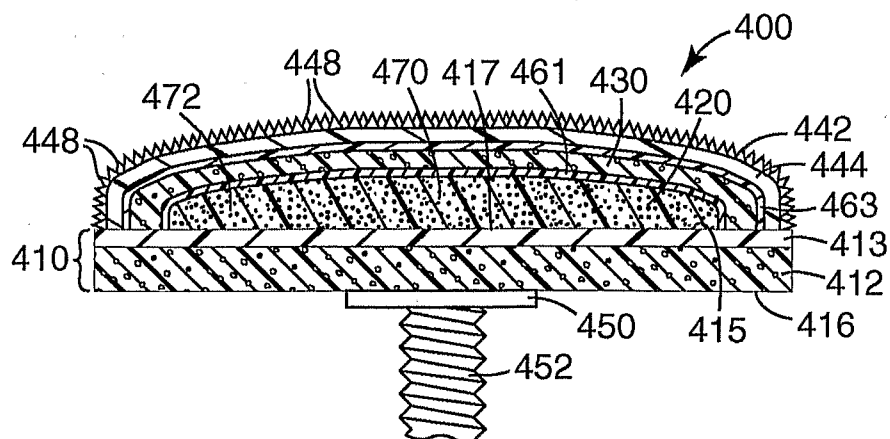


Fig. 4

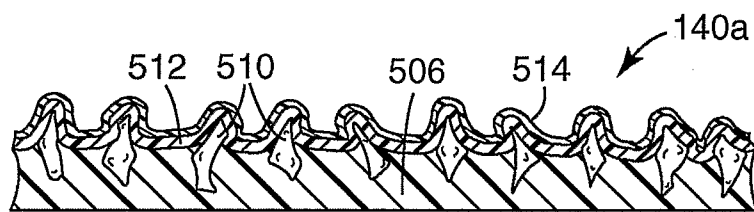


Fig. 5A

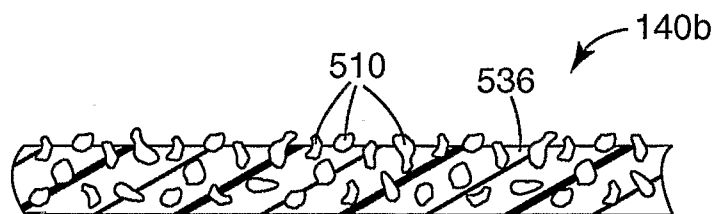


Fig. 5B

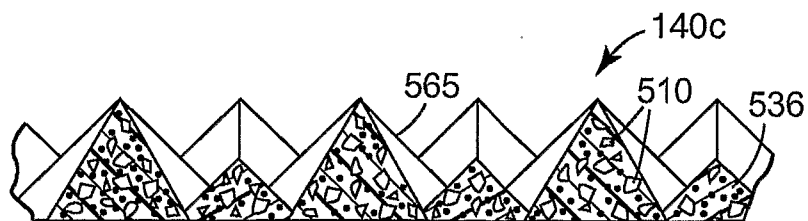


Fig. 5C

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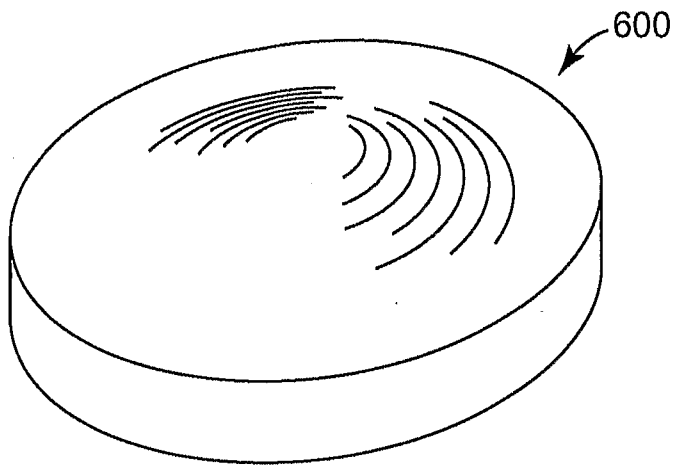


Fig. 6

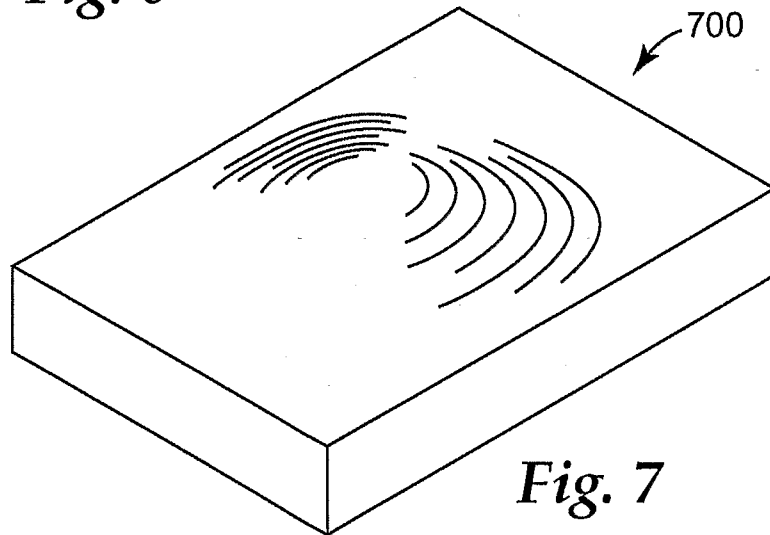


Fig. 7

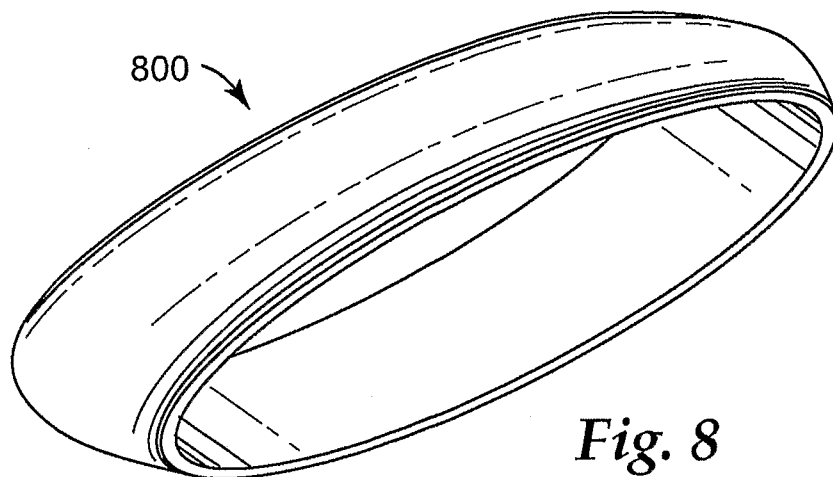


Fig. 8

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US2006/036835**A. CLASSIFICATION OF SUBJECT MATTER*****B24D 13/00(2006.01)i, B24D 11/02(2006.01)i, B24D 11/00(2006.01)i***

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 8 A61F 13/00, B23F 21/03, B24D 13/00, 11/00

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

Korean Patents and applications for inventions since 1975

Korean Utility models and applications for Utility models since 1975

Japanese Utility models and applications for Utility models 1975

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

eKIPASS (KIPO internal) & keywords : abrasive, backing, elastic member, and particle

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 6,632,129 B2 (DOUGLAS P. GOETZ) 14 October 2003 see the abstract, column 4, line 64 to column 6, line 67, and Figures 1, 3, 4c.	1-5, 20, 24-29, 33, 37-39, 42, 43, 47-49
Y	US 6,838,589 B2 (WAYNE L. LIEDTKE et. al.) 04 January 2005 see the abstract, column 4, line 1 to column 5, line 55, and Figure 4.	1-5, 20, 24-29, 33, 37-39, 42, 43, 47-49
A	US 5,692,950 A (DENISE R. RUTBERFORD et. al.) 02 December 1997 see the abstract, column 3, line 42 to column 7, line 36, and Figure 1.	1-51



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents:

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"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

14 FEBRUARY 2007 (14.02.2007)

Date of mailing of the international search report

14 FEBRUARY 2007 (14.02.2007)

Name and mailing address of the ISA/KR

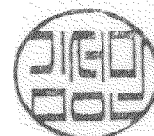
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Republic of Korea

Facsimile No. 82-42-472-7140

Authorized officer

KIM Seung Min

Telephone No. 82-42-481-8442



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