



(19) **United States**
(12) **Patent Application Publication** (10) **Pub. No.: US 2003/0021893 A1**
Usami et al. (43) **Pub. Date: Jan. 30, 2003**

(54) **METHOD FOR PRODUCING OPTICAL INFORMATION RECORDING MEDIUM**

Publication Classification

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(51) **Int. Cl.⁷** **B29D 11/00**
(52) **U.S. Cl.** **427/162**

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(21) Appl. No.: **10/167,406**

(22) Filed: **Jun. 13, 2002**

(30) **Foreign Application Priority Data**

Jun. 15, 2001 (JP) 2001-182062

(57) **ABSTRACT**

A method for producing an optical information recording medium includes the steps of: coating a solution for forming a dye recording layer onto a surface of a rotating disc-shaped resin substrate; and discharging a cleaning solution from a nozzle onto a peripheral edge to remove the dye recording layer from the peripheral edge, wherein discharge of the cleaning solution is initiated 1.0 to 300 seconds after completion of the coating, and the nozzle is disposed on a plane that extends in a normal line direction of the substrate and includes a straight line representing a discharge direction of the cleaning solution, so that an angle defined by the discharge direction and the normal line is 0 to 60°.

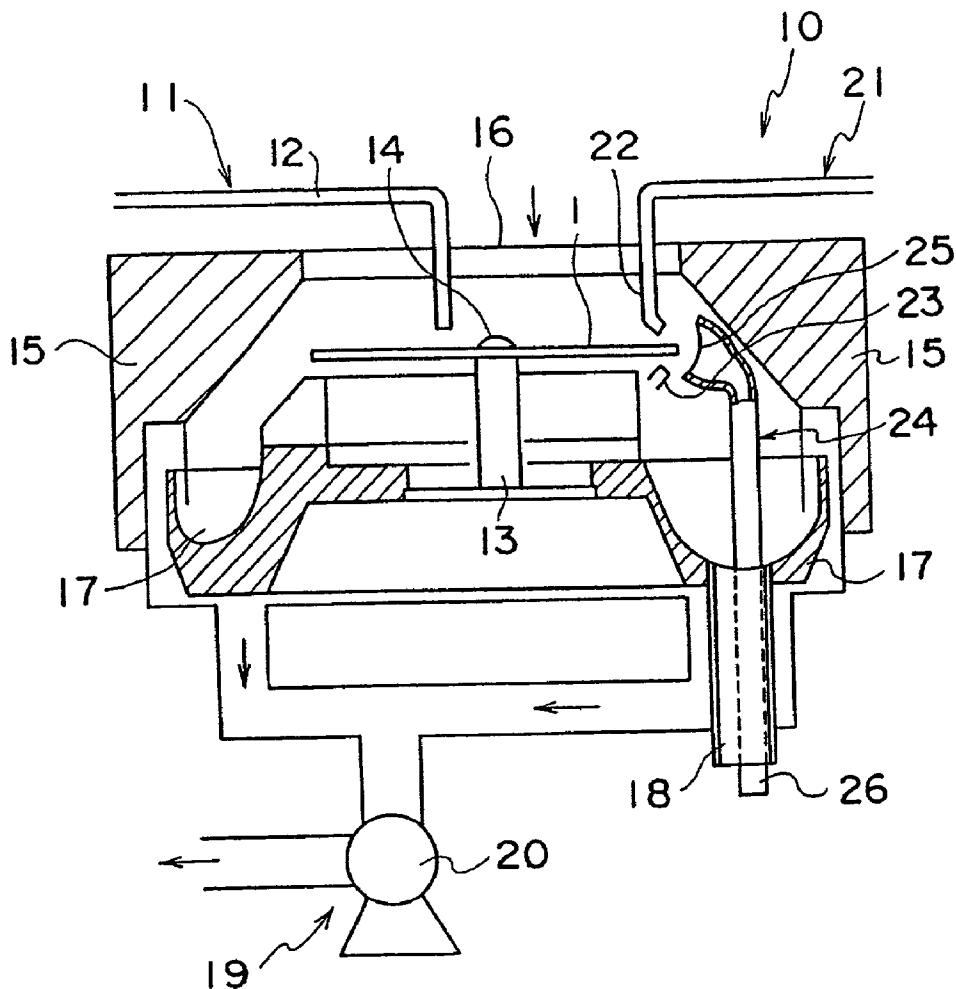


FIG. 1

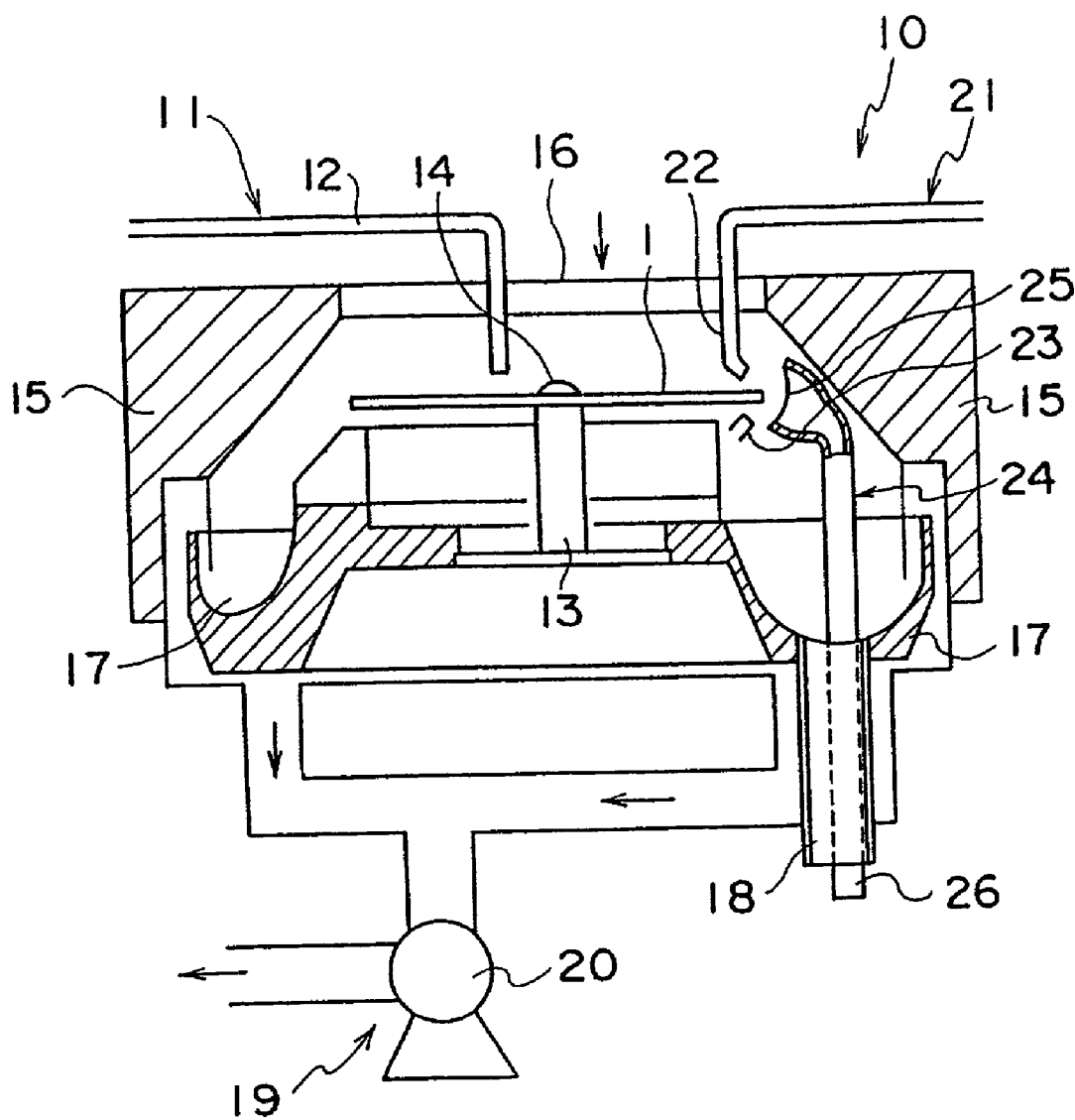


FIG. 2

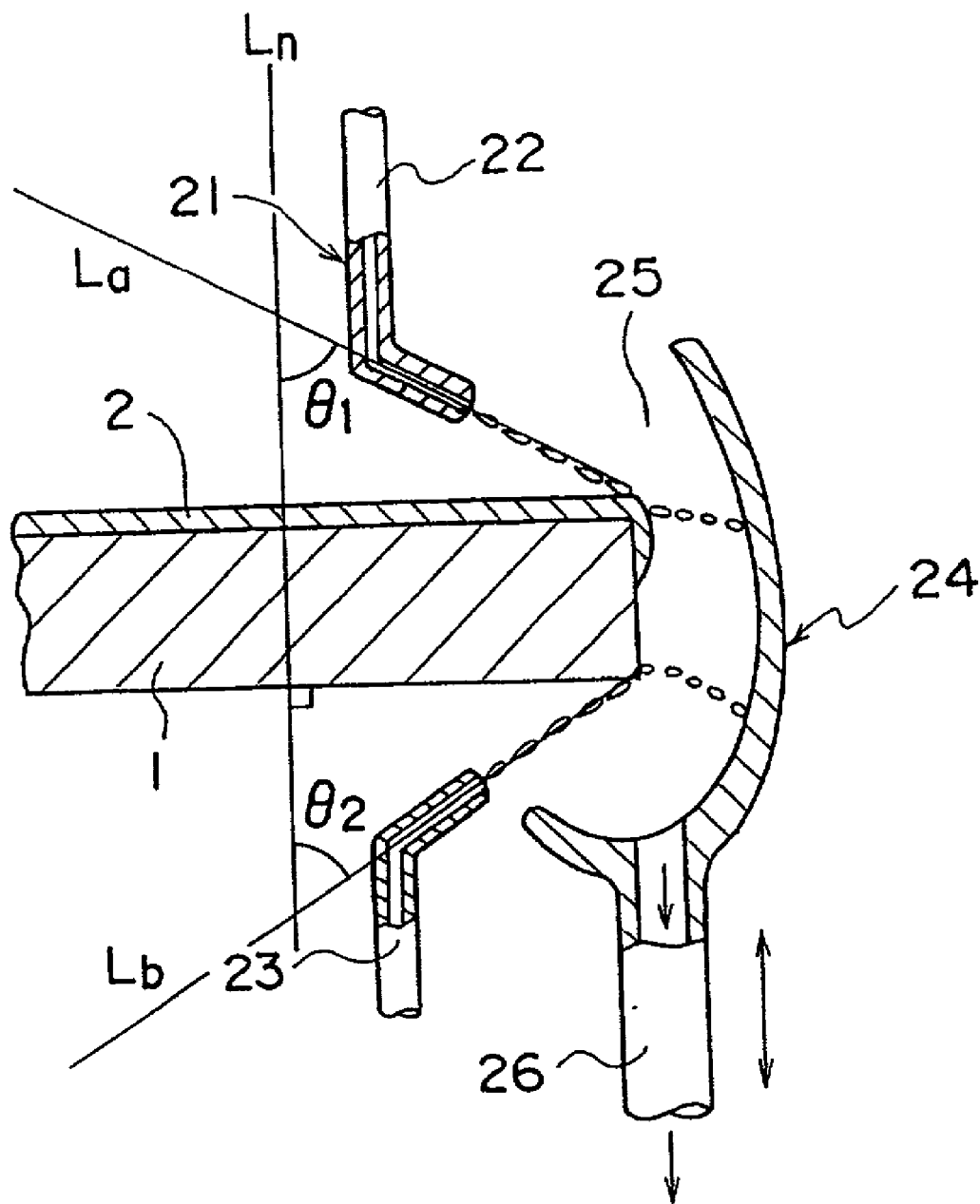


FIG. 3

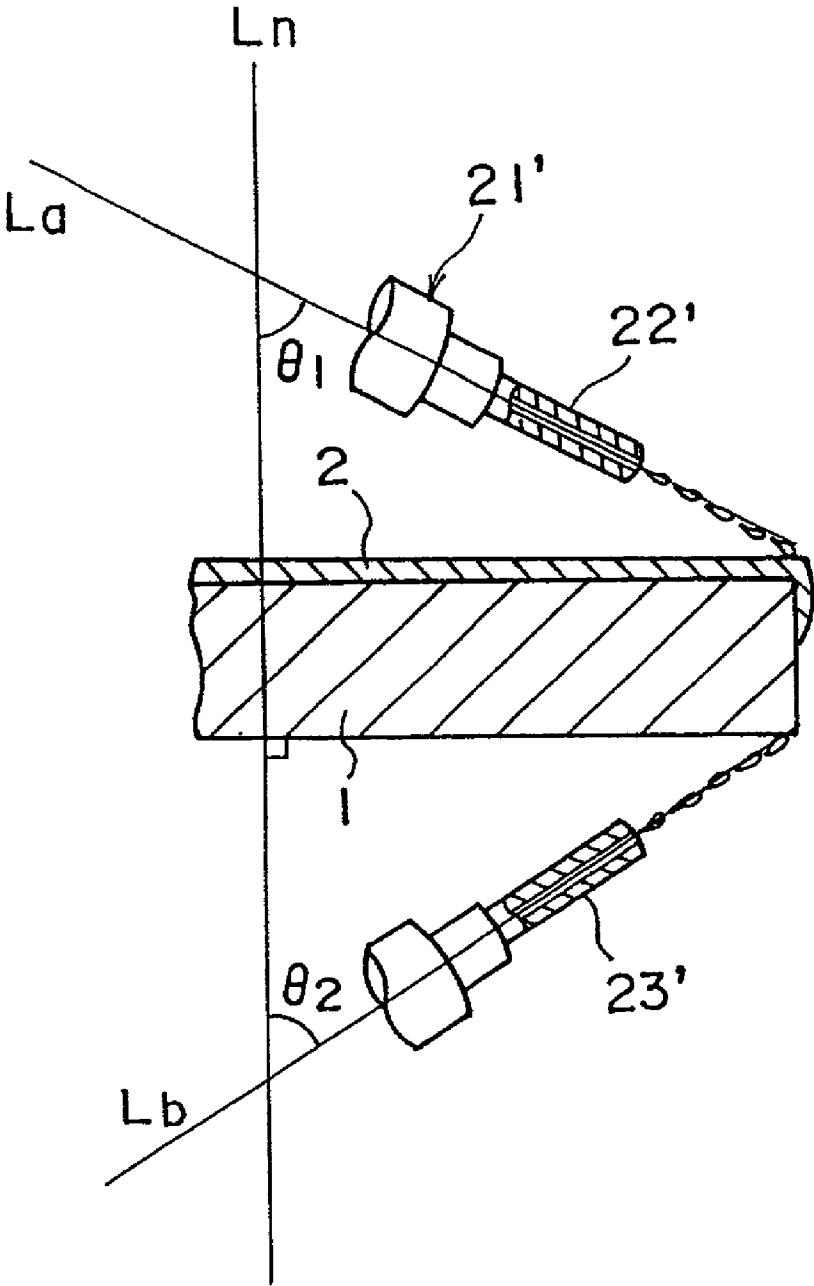


FIG. 4

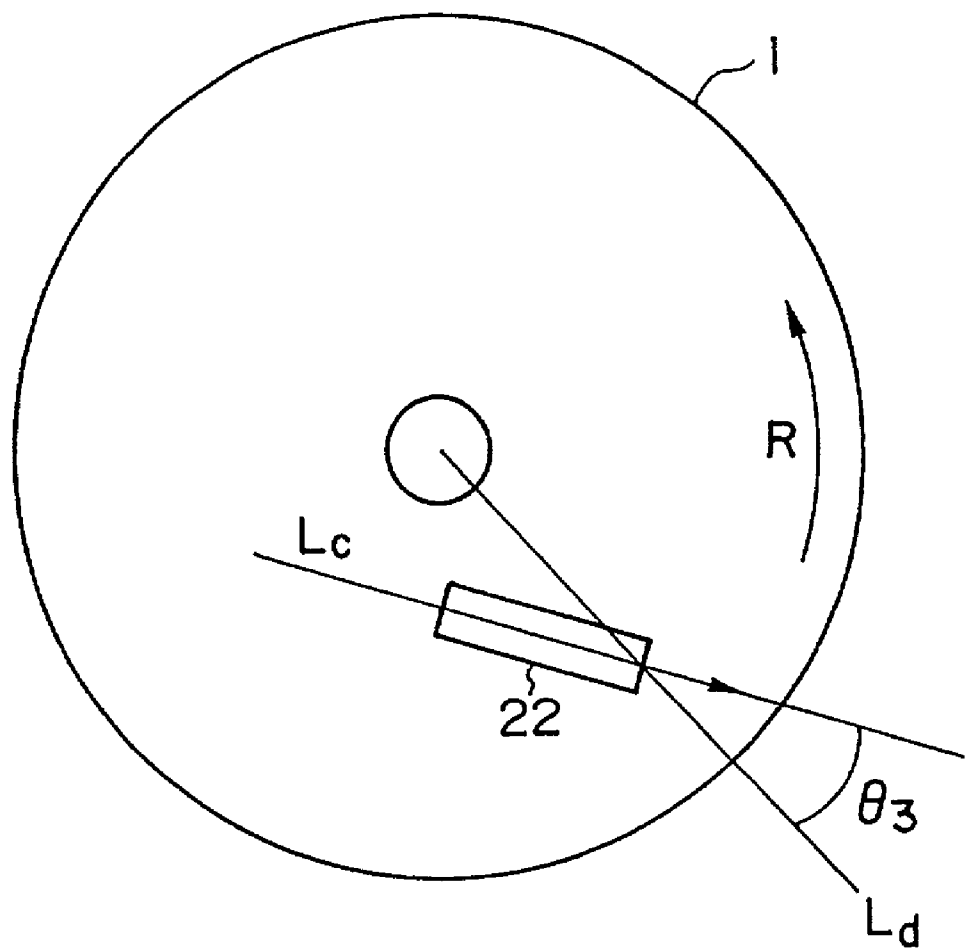


FIG. 5A

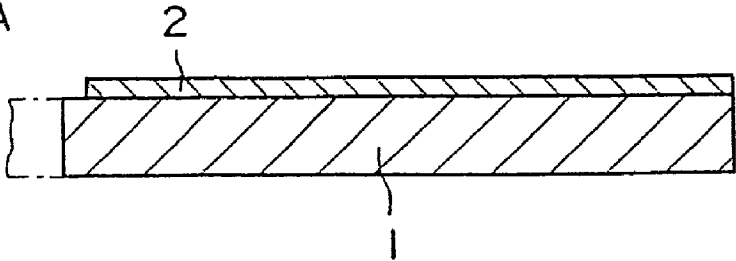


FIG. 5B

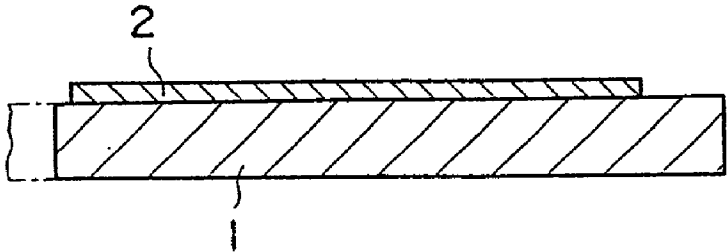


FIG. 5C

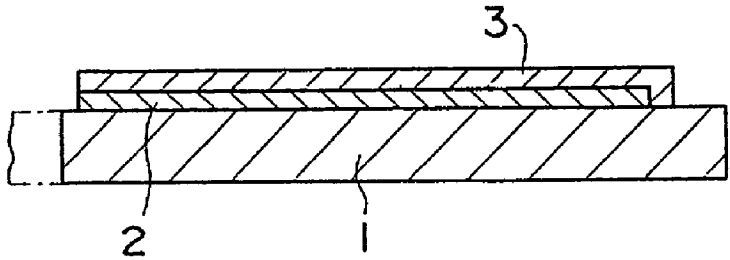


FIG. 5D

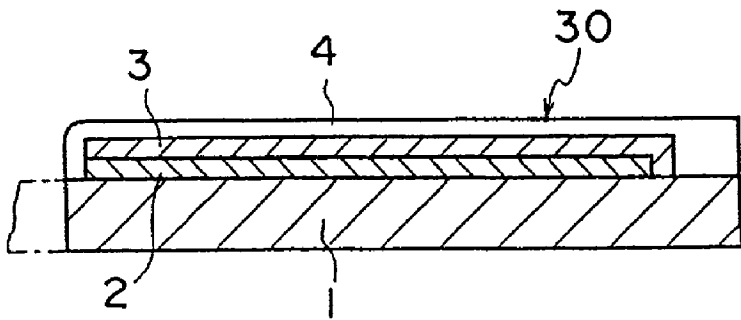


FIG. 7

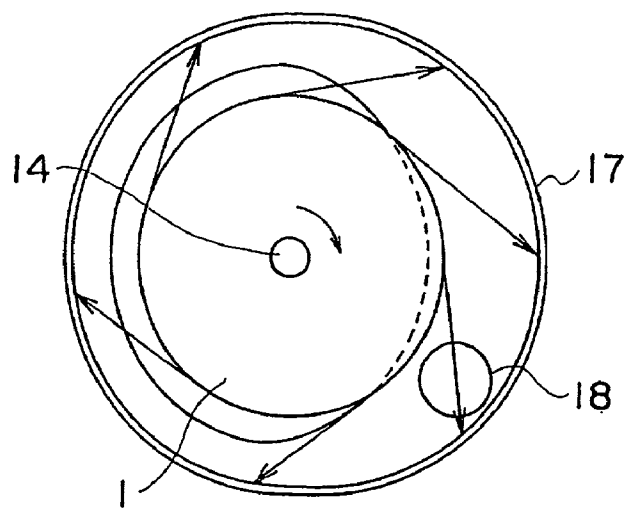


FIG. 8

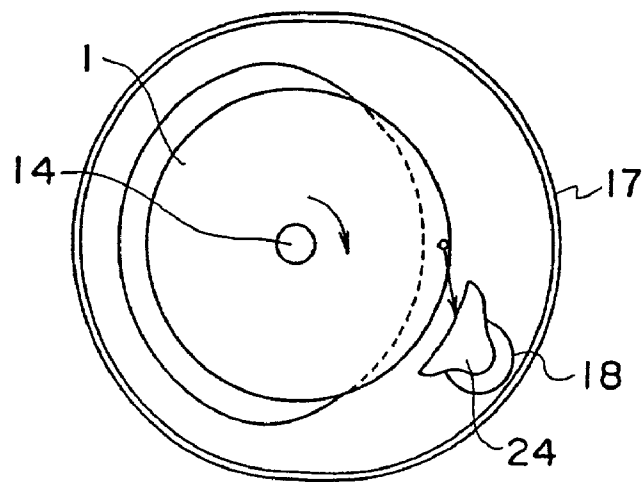


FIG. 9

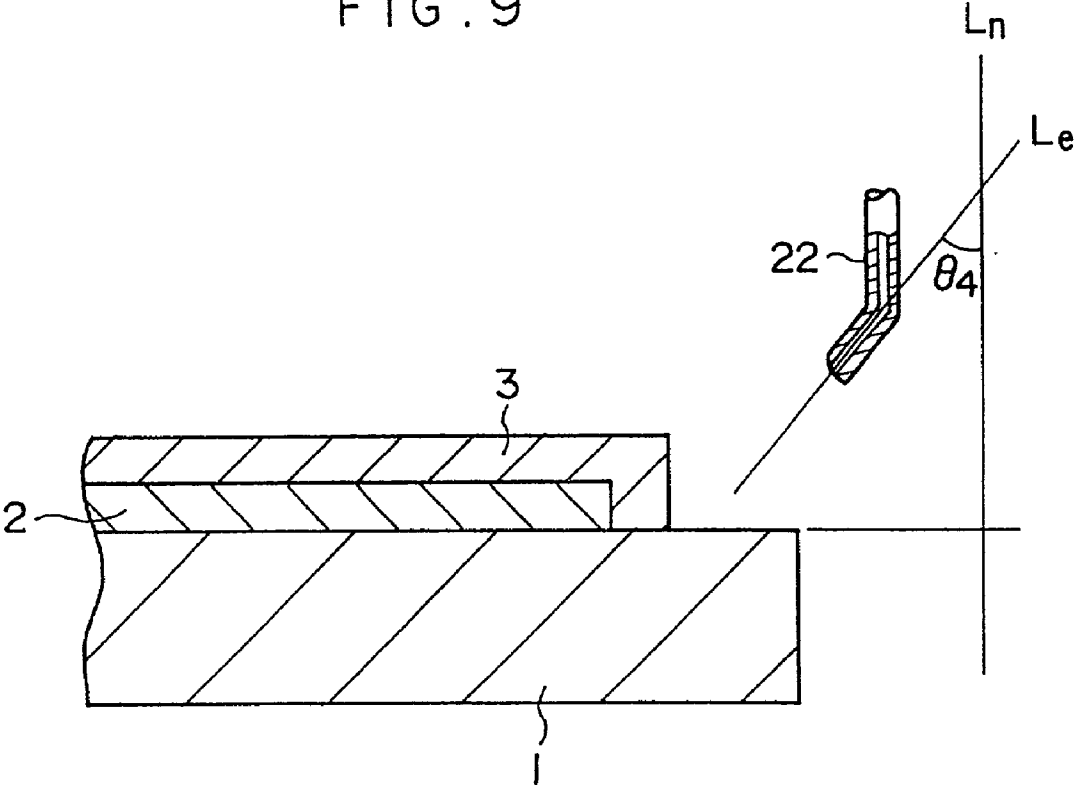


FIG. 10

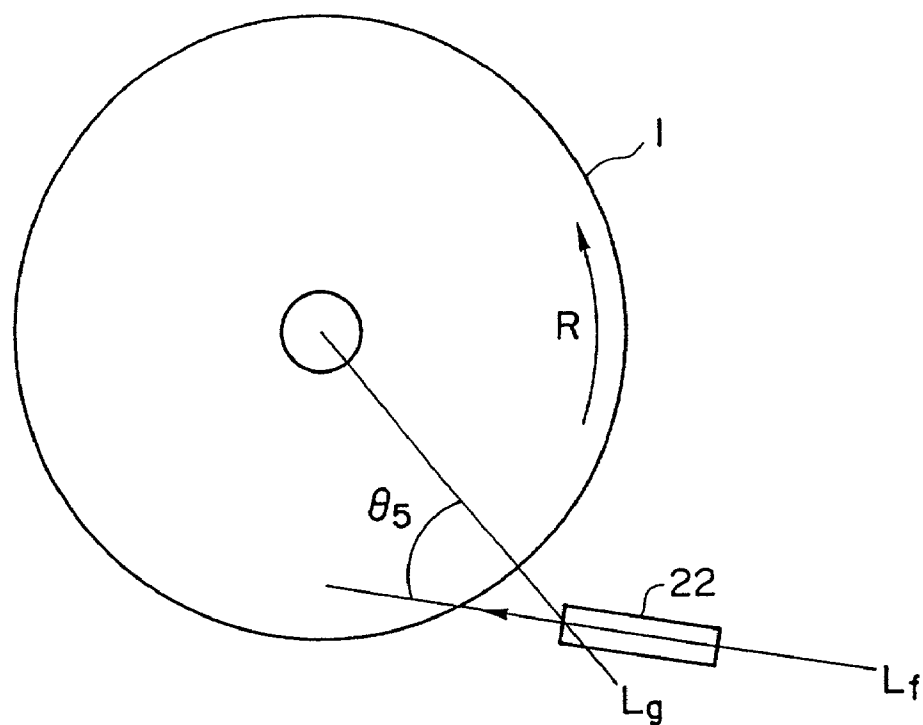


FIG. 11A

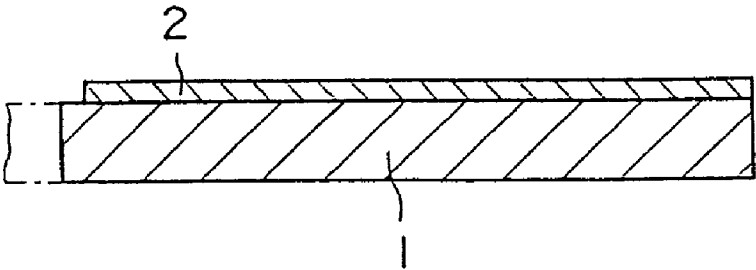


FIG. 11B

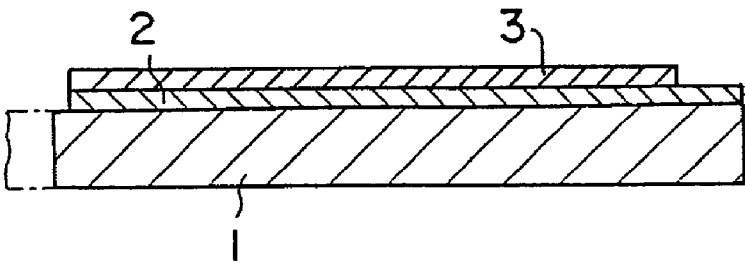


FIG. 11C

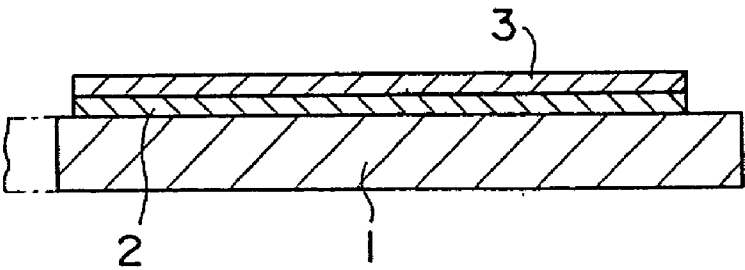
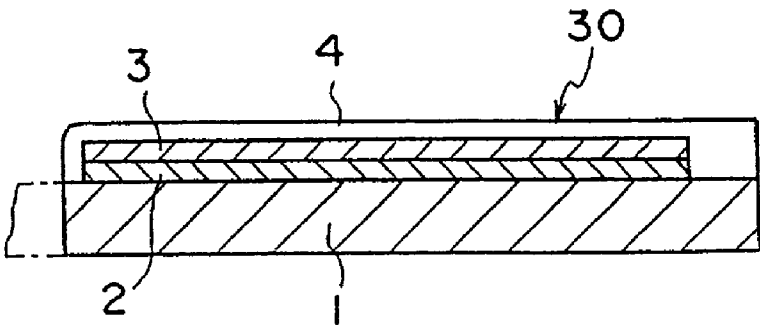


FIG. 11D



METHOD FOR PRODUCING OPTICAL INFORMATION RECORDING MEDIUM

BACKGROUND OF THE INVENTION

[0001] 1. Field of the Invention

[0002] The present invention relates to a method for producing an optical information recording medium, and more particularly, to a method for producing an optical information recording medium that includes a disc-shaped resin substrate having a peripheral edge disposed with an non-recording region.

[0003] 2. Description of the Related Art

[0004] A CD-R is a writable, optical information recording medium (optical disc) on which information can be written only once by irradiation with laser light, and is widely known. CD-Rs are advantageous in that, in comparison with conventional CDs in which information is recorded by forming pits on a substrate by injection molding, a small number of CDs can be manufactured rapidly and at a reasonable cost. Moreover, the demand for CD-Rs has been escalating recently with the spread of personal computers.

[0005] CD-Rs typically comprise a transparent disc substrate having successively disposed thereon a recording layer formed of an organic dye, a metallic (e.g., gold) reflective layer, and a resin protective layer. Information is recorded on the optical disc by irradiating the optical disc with a laser in the near infrared region (ordinarily laser light having a wavelength in the vicinity of 780 nm). Specifically, the portion of the dye recording layer that is irradiated absorbs the light, whereby temperature increases at the irradiated portion. The local increase in temperature deforms the recording layer (e.g., to form pits) at the irradiated portion, whereby information is recorded. The recorded information is ordinarily reproduced by irradiating the optical disc with a laser having the same wavelength as that of the laser used to record the information, and by detecting a difference in reflectance between the region of the recording layer that has been thermally deformed (recorded portion) and the region of the recording layer that has not been deformed (unrecorded portion).

[0006] Recently, writable digital versatile discs (DVD-Rs) have also been put to practical use as media having a larger recording capacity than CD-Rs. DVD-Rs typically comprise two transparent disc substrates that each have successively disposed thereon a recording layer formed of an organic dye, a reflective layer, and a resin protective layer, with the discs being adhered together so that the recording layers face inward, or comprise the transparent disc substrate and a protective substrate having the same disc shape as the disc substrate that are adhered together. In each transparent disc substrate, there is formed a guide groove (pre-groove) for tracking laser light irradiated during recording. The pre-groove has a width (0.74 to 0.8 μm) that is equal to or less than half the width of the pre-groove of a CD-R.

[0007] The outer peripheral edge of a CD-R or DVD-R is a non-recording region where no dye recording layer is disposed. The purpose of the non-recording region is to improve the outer appearance of the disc by covering the dye recording layer with the reflective layer, and to enhance adhesion by directly adhering the protective layer to the substrate. The dye recording layer is formed by spin-coating

a dye solution onto the surface of the substrate and drying the dye solution. However, although it is possible to initiate spin coating so that the spin coater begins coating from a somewhat limited position at the inner periphery of the substrate, it is difficult to control the range of coating towards the outer periphery. For this reason, the dye recording layer is generally first disposed on the entire surface of the substrate, and then cleaning solution is jetted onto the dye recording layer at the outer peripheral edge to remove the dye recording layer from the outer peripheral edge and create the non-recording region.

[0008] There are generally two ways that the non-recording region is formed in this manner during the process of producing the optical disc. One is by washing/removing the dye recording layer immediately after it has been formed, and the other is by washing/removing the dye recording layer after both it and the reflective layer have been formed. Below, the former may be called "earlier washing" and the latter may be called "later washing".

[0009] In the case of earlier washing, there are problems in that droplets of the cleaning solution may be scattered onto portions of the recording layer that are not to be removed, whereby those portions are dissolved and recording errors occur at those portions during recording or playback.

[0010] In the case of later washing (i.e., when the dye recording layer is formed by spin-coating the dye solution onto the surface of the substrate and allowing the dye solution to dry, and washing is conducted after the reflective layer is formed only on the recording region of the dye recording layer), the non-recording region is formed by washing only the portion of the recording layer disposed at the outer peripheral edge, where the reflective layer is not formed. However, practical problems arise in that the shape of the edge of the recording layer may become irregular depending upon washing conditions. In addition, because time lapses after coating the dye recording layer, there is the problem that it takes time wash the recording layer.

[0011] It is possible to prevent the cleaning solution from being scattered and adhering to the dye recording layer by preforming the non-recording region by spin-coating the dye solution onto the surface of the substrate except for the outer peripheral edge and allowing the dye solution to dry to thereby form the dye recording layer, and then washing after the reflective layer has been formed on the dye recording layer. However, because it is difficult to control the range of coating towards the outer periphery of the substrate, the dye recording layer intrudes into the area where the substrate and the reflective layer should ordinarily be closely adhered together, which reduces adhesion between the substrate and the reflective layer. When adhesion is reduced in this manner, water or oxygen may intrude from outside into the dye recording layer, whereby storage stability of the recording medium is reduced.

SUMMARY OF THE INVENTION

[0012] The present invention was devised in view of the preceding problems in the prior art. It is an object of the invention to provide a method for producing an optical information recording medium in which cleaning solution is prevented from being scattered and adhering to a dye recording layer when the dye recording layer is removed

from an outer periphery of the medium by washing, to thereby efficiently form a non-recording region and produce an optical information recording medium that has excellent storage stability and excellent recording and playback characteristics.

[0013] This object is achieved by the following means.

[0014] According to a first aspect of the invention, there is provided a method for producing an optical information recording medium, comprising at least the steps of: coating a solution for forming a dye recording layer onto a surface of a rotating disc-shaped resin substrate; and discharging a cleaning solution from a nozzle onto a peripheral edge to remove the dye recording layer from the peripheral edge, wherein discharge of the cleaning solution is initiated 1.0 to 300 seconds after completion of the coating, and the nozzle is disposed on a plane that extends in a normal line direction of the substrate and includes a straight line representing a discharge direction of the cleaning solution, so that an angle defined by the discharge direction and the normal line is 0 to 60°.

[0015] According to a second aspect of the invention, there is provided a method for producing an optical information recording medium, comprising at least the steps of: coating a solution for forming a dye recording layer onto a surface of a rotating disc-shaped resin substrate; coating a reflective layer on the formed dye recording layer; and discharging a cleaning solution from a nozzle onto a peripheral edge to remove the dye recording layer from the peripheral edge, wherein discharge of the cleaning solution is started 1.0 to 300 seconds after completion of the coating of the reflective layer, and the nozzle is disposed on a plane that extends in a normal line direction of the substrate and includes a straight line representing a discharge direction of the cleaning solution, so that an angle defined by the discharge direction and the normal line is 0 to 60°.

BRIEF DESCRIPTION OF THE DRAWINGS

[0016] FIG. 1 is a schematic sectional view illustrating a spin coater used in embodiments of the present invention.

[0017] FIG. 2 is an enlarged sectional view of a washing device and a waste recovery device used in the embodiments.

[0018] FIG. 3 is an enlarged sectional view illustrating a washing device that is different from the washing device illustrated in FIG. 2.

[0019] FIG. 4 is a plan view for illustrating a position at which a nozzle is disposed relative to a substrate.

[0020] FIGS. 5A to 5D are sectional views illustrating steps in a process for producing an optical disc in accordance with a first embodiment of the invention.

[0021] FIG. 6 is a sectional view illustrating the structure of a general CD-R disc.

[0022] FIG. 7 is a plan view illustrating the manner in which coating solution is spun off.

[0023] FIG. 8 is a plan view illustrating the manner in which coating solution is spun off.

[0024] FIG. 9 is a sectional view illustrating a position at which the nozzle is disposed when washing a non-recording region.

[0025] FIG. 10 is a plan view illustrating a position at which the nozzle is disposed when washing the non-recording region.

[0026] FIGS. 11A to 11D are sectional views illustrating steps in a process for producing an optical disc in accordance with a second embodiment of the invention.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

[0027] Hereinafter, embodiments of a method for producing an optical information recording medium according to the present invention will be explained in detail with reference to the drawings.

[0028] FIG. 1 is a sectional view of a spin coater 10 used in the method of the invention. As illustrated in FIG. 1, the spin coater 10 comprises an applicator 11, a spinner head 13, a wall 15 for preventing scatter, an exhaust device 19, a washing device 21, and a waste recovery device 24. The spin coater 10 illustrated in FIG. 1 can coat a dye recording layer and remove the dye recording layer from an outer peripheral edge of a disc resin substrate 1.

[0029] The applicator 11 comprises a nozzle 12 that includes a pressure tank (not illustrated) and a valve (not illustrated) for controlling discharge amount. The nozzle 12 drops a predetermined amount of coating solution onto a surface of the substrate 1. The applicator 11 is moved by means of a handling mechanism (not illustrated) from a standby position to a predetermined position above the substrate 1. The spinner head 13 is disposed below the applicator 11, includes a detachable fixing member 14 for keeping the substrate 1 horizontal, and is rotated by a drive motor (not illustrated). The substrate 1 is rotated by the spinner head 13 so that coating solution dropping onto the substrate 1 from the nozzle 12 is horizontally flown across the surface of the substrate 1 toward the outer periphery of the substrate 1 to form a coating film. Excess coating solution is spun away from and runs off of the outer peripheral edge of the substrate. Once the coating solution film has dried, a coating film is formed on the surface of the substrate 1. The wall 15 prevents excess coating solution (waste solution) spinning off from the outer peripheral edge of the substrate 1 from being scattered around the substrate 1. The wall 15 is disposed around the spinner head 13, with an opening 16 being formed above the spinner head 13.

[0030] Waste solution collects in a pan 17 disposed beneath the wall 15 and is recovered through a drain 18. The exhaust device 19 allows air to circulate in from the opening 16, over the surface of the substrate 1, and then to below the spinner head 13. The exhaust device 19 includes a valve (not illustrated) for adjusting exhaust amount and a fan 20. By adjusting the amount of exhaust (speed of exhaust), drying conditions for the coating film can be changed.

[0031] The washing device 21 comprises two nozzles 22 and 23 that include a pressure tank (not illustrated) and a valve (not illustrated) for adjusting discharge amount. The two nozzles 22 and 23 jet cleaning solution at a predetermined pressure onto the outer peripheral edge of the dye recording layer on the substrate 1, and can discharge the cleaning solution independently. Washing can therefore be performed using either one or both of the nozzles 22 and 23. Similar to the applicator 11, the washing device 21 is moved

by a handling mechanism (not illustrated) from a standby position to a predetermined position during washing, and can alter the direction in which the cleaning solution is discharged.

[0032] The washing device **21** will now be described in detail with reference to FIGS. 2 to 4. FIG. 2 is an enlarged sectional view illustrating the washing device **21** and the waste recovery device **24**. FIG. 3 is an enlarged sectional view illustrating a washing device **21'** that is different from the washing device illustrated in FIG. 2. FIG. 4 is a schematic plan view illustrating a position at which the nozzle **22** is disposed. FIGS. 2 and 3 are each views seen from the side of a plane extending in a normal line direction of the substrate **1** (i.e., orthogonal to the substrate **1**) and including a straight line representing the direction in which the cleaning solution is discharged from the nozzles **22** and **23**.

[0033] As illustrated in FIG. 2, the nozzles **22** and **23** are bent so that the cleaning solution is obliquely jetted onto the substrate **1**. However, the configuration of the nozzles **22** and **23** is not limited to the configuration shown in FIG. 2 as long as the conditions below concerning the discharge direction of the cleaning solution are met.

[0034] For preventing the cleaning solution from splattering, as illustrated in FIG. 2, the nozzles **22** and **23** are disposed so that angles θ_1 , θ_2 , which are defined by the intersection between a normal line L_n of the substrate **1** and directions L_a and L_b in which the cleaning solution is discharged from the nozzles **22** and **23**, are each 0 to 60°, and preferably 10 to 45°. The angle at which the nozzles **22** and **23** are bent is adjusted to meet this condition.

[0035] Although the nozzles **22** and **23** illustrated in FIG. 2 are bent, they may have, for example, a straight configuration such as nozzles **22'** and **23'** in FIG. 3. In order to discharge the cleaning solution within the angle range described below, the nozzles **22'** and **23'** are connected to the spin coater **10** via a valve (not illustrated) having an angle-adjusting function or a member (not illustrated) having an angle-adjusting function.

[0036] As illustrated in FIG. 3, the nozzles **22'**, **23'** are disposed so that angles θ_1 , θ_2 , which are defined by the intersection between the normal line L_n of the substrate **1** and directions L_a and L_b in which the cleaning solution is discharged from the nozzles **22'** and **23'**, are each 0 to 60°, and preferably 10 to 45°. The angle at which the nozzles **22'** and **23'** are disposed is adjusted to meet this condition.

[0037] Although the bent nozzles **22** and **23** and the straight nozzles **22'** and **23'** discharge the cleaning solution in the above-described angle range, they are at least disposed so that the discharge direction of the cleaning solution is directed away from the center of the substrate **1**. In addition, the range of the angles θ_1 and θ_2 is defined on the plane extending in a normal line direction of the substrate **1** and including the straight line representing the direction in which the cleaning solution is discharged.

[0038] As illustrated in FIG. 4, the nozzle **22** (and **23** or **22'** and **23'**) is, when seen from above, additionally disposed so that an angle θ_3 , which is defined by the intersection between a straight line L_d connecting the center of the substrate **1** with a mouth of the nozzle **22** and a cleaning

solution discharge direction L_c facing in the direction of rotation R , is preferably 0 to 60°, and more preferably 10 to 45°.

[0039] In addition, the distance between the mouth of the nozzle **22** (or **23**, **22'**, **23'**) and the substrate **1** is preferably 0.3 to 5.0 mm, more preferably 0.5 to 3.0 mm, and even more preferably 0.7 to 2.0 mm. The diameter of the nozzle is preferably 0.1 to 0.8 mm, and more preferably 0.2 to 0.6 mm, in order to stably discharge the cleaning solution.

[0040] Although description has been given of the washing device **21**, which is disposed with an upper nozzle (**22**) and a lower nozzle (**23**), the washing device **21** may be one disposed with only one nozzle. In this case, the washing device **21** preferably includes a handling mechanism to move the one nozzle so that the coating solution is discharged from both above and below the outer peripheral edge of the substrate **1** (the coating film). The washing device **21** may also be disposed with many nozzles. However, because increasing the number of nozzles results in an increase in the amount of cleaning solution used and may cause more splattering of the cleaning solution, the number of nozzles is preferably 1 to 4, and more preferably 1 or 2. Also, since the method of the invention includes two washing steps, the diameter of the nozzle and the number of nozzles may be changed for each step.

[0041] In order to recover the post-wash liquid (containing the cleaning solution and the dye-containing components removed by that cleaning solution), the waste recovery device **24** includes a drain **26** having an opening **25** that faces the direction in which the liquid is scattered. As seen in FIGS. 1 and 2, the waste recovery device **24** is independently disposed so that the drain **26** is accommodated within the drain **18**. Accordingly, the post-wash liquid (waste liquid) is gathered into the opening **25** and is recovered through the drain **26** separately from the waste coating solution. It is preferable to dispose the waste recovery device **24** with a mechanism for vertically moving the waste recovery device **24**. By moving the waste recovery device **24** to a lower standby position when the dye recording layer is being formed, the waste coating solution (e.g., the scattered dye-containing coating solution) can be recovered without being obstructed by the waste recovery device **24**.

[0042] Method for Producing Optical Disc (1)

[0043] Description will now be given of a first embodiment of the method of the invention applied to the spin coater **10** (FIG. 1) disposed with the washing device **21** and waste recovery device **24**. FIGS. 5A to 5D illustrate steps in the method, which in this embodiment is for forming the non-recorded region by earlier washing.

[0044] FIG. 6 illustrates an optical disc (CD-R) **30** comprising the disc-shaped transparent resin substrate **1** having successively disposed thereon a dye recording layer **2**, a reflective layer **3**, and a protective layer **4**. Because this type of optical disc is common, the method will be described using the optical disc **30** as an example. However, the method can also be applied to a DVD-R.

[0045] Examples of material usable for the substrate **1** include polycarbonate, acrylic resins such as polymethyl methacrylate, vinyl chloride resins such as polyvinyl chloride and vinyl chloride copolymer, epoxy resins, amorphous polyolefins, and polyester. These materials may be concur-

rently used as desired. The material used is preferably transparent. In particular, polycarbonate is preferable in view of resistance to moisture, dimensional stability, and cost.

[0046] The substrate **1** includes a guide groove for tracking or a pre-groove representing information such as address signals. The pre-groove is preferably formed directly in the substrate when the resin material is injection molded or extrusion molded, and preferably has a depth 0.01 to 0.3 μm and a half width of 0.2 to 0.9 μm .

[0047] On the surface of the substrate **1** at the side at which the dye recording layer **2** is disposed, an undercoat layer may be provided for the purpose of improving flatness and adhesive force, and preventing deterioration of the dye recording layer **2**. Examples of suitable material for the undercoat layer include macromolecular materials such as polymethyl methacrylate, acrylic acid/methacrylic acid copolymer, styrene/maleic anhydride copolymer, polyvinyl alcohol, N-methylol acrylamide, styrene/vinyltoluene copolymer, chlorosulfonated polyethylene, nitrocellulose, polyvinyl chloride, chlorinated polyolefin, polyester, polyimide, vinyl acetate/vinyl chloride copolymer, ethylene/vinyl acetate copolymer, polyethylene, polypropylene, polycarbonate, and a surface modifier such as a silane coupling agent. The undercoat layer can be formed by dissolving or dispersing the material into a suitable solvent to prepare a coating solution, and thereafter coating the coating solution onto the surface of the substrate by spin-coating, dip-coating, or extrusion-coating. The thickness of the undercoat layer is generally 0.005 to 20 μm , and preferably 0.01 to 10 μm .

[0048] As illustrated in **FIG. 5A**, the dye recording layer **2** is disposed on the substrate **1** using the spin coater **10** according to the invention. When the dye recording layer **2** is formed, the washing device **21** and the waste recovery device **24** have been moved to standby positions by handling mechanisms (not illustrated) so that they do not become obstacles. The substrate **1** is mounted on, for example, the spinner head **13** illustrated in **FIG. 1**, and horizontally held in place by the fixing member **14**. Next, coating solution supplied from the pressure tank (not illustrated) is adjusted to a predetermined amount by the valve (not illustrated) and dropped onto the inner periphery of the substrate **1** through the nozzle **12**. Here, the coating solution is a dye solution in which a dye has been dissolved in a suitable solvent. The concentration of the dye in the coating solution is generally 0.01 to 15 mass %, preferably 0.1 to 10 mass %, more preferably 0.5 to 5 mass %, and most preferably 0.5 to 3 mass %.

[0049] The spinner head **13** is drivingly rotated by the drive motor at high speed, whereby coating solution falling onto the substrate is spun across the surface of the substrate **1** and towards the outer periphery of the substrate **1** to form a coating film. Excess coating solution is spun off of the substrate **1** by centrifugal force, scattered around the substrate **1**, collides against the wall **15**, is collected in the pan **17**, and is thereafter recovered through the drain **18**. **FIG. 7** is a typical view illustrating excess coating solution (indicated by the arrows), which has reached the outer periphery of the substrate **1**, being omnidirectionally spun off of the substrate **1** by centrifugal force, scattering around the substrate **1**, and colliding against the wall. The coating film is

dried by the exhaust device **19** during and after the process of forming the coating film. The thickness of the coating film (the dye recording layer) is generally 20 to 500 nm, and preferably 50 to 300 nm.

[0050] The dye used in the dye recording layer is not particularly limited. Examples thereof include cyanine dyes, phthalocyanine dyes, imidazo-quinoxaline dyes, pyrylium/thiopyrylium dyes, azulonium dyes, squalirium dyes, metallic complex salt dyes such as Ni or Cr, naphthoquinone dyes, anthraquinone dyes, indophenol dyes, indoaniline dyes, triphenylmethane dyes, merocyanin dyes, oxonol dyes, aluminum/diimmonium dyes, and nitroso-compounds. Of these dyes, cyanine dyes, phthalocyanine dyes, azulonium dyes, squalirium dyes, oxonol dyes, and imidazo-quinoxaline dyes are preferable.

[0051] Examples of the solvent for the coating solution for forming the dye recording layer include: esters such as butyl acetate or cellosolve acetate; ketones such as methyl ethyl ketone, cyclohexanone or methyl isobutyl ketone; chlorinated hydrocarbons such as dichloromethane, 1,2-dichloroethane or chloroform; amides such as dimethyl formamide; hydrocarbon such as cyclohexane; ethers such as tetrahydrofuran, ethylether, or dioxane; alcohols such as ethanol, n-propanol, isopropanol, n-butanol, or diacetone alcohol; fluorine-containing solvents such as 2,2,3,3-tetrafluoropropanol; glycol ethers such as ethylene glycol monomethyl ether, ethylene glycol monoethyl ether, or propylene glycol monomethyl ether. These may be used singly or in combination of two or more, in consideration of the solubility of the dye. The solvent is preferably a fluorine-containing solvent such as 2,2,3,3-tetrafluoropropanol. Other additives may be included as needed in the coating solution, such as anti-fading agents, binding agents, antioxidants, UV absorbers, plasticizers, and lubricants.

[0052] Examples of the anti-fading agent include nitroso compounds, metal complexes, diimmonium salts, and aminium salts, which are described in Japanese Patent Application Laid-Open (JP-A) Nos. 2-300288, 3-224793, and 4-146189.

[0053] Examples of the binding agent include: natural organic high polymers, such as gelatin, cellulose derivatives, dextran, rosin, and rubber; and synthetic organic high polymers, such as hydrocarbon resins, such as polyethylene, propylene, polystyrene and polyisobutylene, vinyl resins, such as polyvinyl chloride, polyvinylidene chloride, and a polyvinyl chloride/polyvinyl acetate copolymer, acrylic resins, such as polymethyl acrylate and polymethyl methacrylate, and also polyvinyl alcohol, chlorinated polyethylene, epoxy resins, butyral resins, rubber derivatives, and initial condensation products of thermosetting resins like phenol/formaldehyde resins. When a binding agent is used, the amount thereof is generally 0.2 to 20 parts by mass, preferably 0.5 to 10 parts by mass, and more preferably 1 to 5 parts by mass, based upon 100 parts by mass of the dye.

[0054] Next, as illustrated in **FIG. 5B**, cleaning solution is jetted from the nozzle **22** onto the outer peripheral edge of the formed dye recording layer **2**, whereby the dye recording layer **2** is washed/removed from the outer peripheral edge (earlier washing). The handling mechanisms (not illustrated) move the washing device **21** and the waste recovery device **24** to predetermined positions, such as those illustrated in **FIG. 1**. Thus, ends of the nozzles **22** and **23** are directed

towards the outer periphery so that the discharge direction of the cleaning solution and the normal line of the substrate **1** define the prescribed angle illustrated in **FIG. 2**. This operation is performed before the dye recording layer **2** has finished drying, so that washing is initiated within a predetermined period of time after the dye recording layer **2** has finished drying. While the spinner head **13** is being rotated, the cleaning solution (discharge amount and discharge pressure having been adjusted by the pressure tank and the valve) is obliquely discharged onto the outer peripheral edge of the dye recording layer **2** through the two nozzles **22** and **23**, so that splashed cleaning solution does not adhere to the dye recording layer **2**.

[0055] **FIG. 8** shows a state in which jetted cleaning solution (indicated by an arrow) is scattered by centrifugal force from the substrate **1** towards the waste recovery device **24**. The cleaning solution is jetted onto a predetermined position of the outer periphery of the dye recording layer **2**. Because the rotational frequency of the spinner head **13** during washing is generally set to be large, the solution (waste liquid) is, as illustrated in **FIG. 8**, scattered in a roughly constant direction. By disposing the waste recovery device **24** to face that direction, the cleaning solution (waste liquid) containing the dye can be recovered by the waste recovery device **24**.

[0056] As mentioned previously, when the outer peripheral edge of the dye recording layer **2** is washed/removed, the surface and the reverse surface of the substrate **1** may be simultaneously washed by simultaneously operating the two nozzles **22** and **23**. Alternatively, it is also possible to first wash only the reverse surface (including part of the side surface of the substrate **1**) after forming the dye recording layer **2** and then, after forming the reflective layer **3**, wash the outer peripheral edge of the surface of the dye recording layer **2** of the substrate **1**.

[0057] Although there are no particular limitations on the cleaning solution (solvent) used for washing, examples thereof include diacetone alcohol, dibutyl ether, and 2,2,3,3-tetrafluoro-1-propanol. Diacetone alcohol is particularly preferable. These solvents are particularly effective when washing a cyanine dye recording layer. These solvents also have an advantage in that they scarcely damage the substrate even if the disc washed with these solvents is stored for a long period of time.

[0058] In order to enhance washing efficiency, washing is preferably conducted within 1.0 to 300 seconds, and more preferably within 3 to 100 seconds, after the coating layer serving as the dye recording layer **2** is formed. When washing is initiated earlier than 1.0 seconds, the shape of the edge of the dye recording layer **2** is compromised due to insufficient drying of the dye recording layer **2**. When washing is initiated later than 300 seconds, it becomes difficult to remove the dye recording layer **2** and may result in an inability to completely remove the dye recording layer **2** from the outer periphery of the substrate **1**.

[0059] Discharge time of the cleaning solution is preferably 0.1 to 1.5 seconds, more preferably 0.2 to 1.2 seconds, and even more preferably 0.3 to 1.0 seconds. The amount of cleaning solution discharged is preferably 0.2 to 3.0 ml, more preferably 0.4 to 2.0 ml, and even more preferably 0.6 to 1.5 ml. The pressure at which the cleaning solution is discharged is preferably 0.3 to 3.0 kg/cm², more preferably

0.5 to 2.0 kg/cm², and even more preferably 0.7 to 1.7 kg/cm², to prevent the cleaning solution from being splattered.

[0060] Discharge pressure can be adjusted in accordance with the diameter of the nozzle, and the product of the nozzle diameter and discharge pressure is preferably 0.2 to 2.4 mm·kg/cm², more preferably 0.3 to 1.0 mm·kg/cm², and even more preferably 0.4 to 0.6 mm·kg/cm².

[0061] The rotational frequency of the spinner head **13** at the time discharge of the cleaning solution begins is set to be 1000 to 10000 rpm, so that the cleaning solution is not splashed onto the area of the dye recording layer **2** that is not to be removed. Preferably, the rotational frequency is 2000 to 8000 rpm, and more preferably 3000 to 6000 rpm. The rotational frequency of the spinner head **13** at the time the cleaning solution is being spun off of the substrate is preferably 3000 to 10000 rpm, more preferably 4000 to 8000 rpm, and even more preferably 5000 to 7000 rpm.

[0062] Next, as illustrated in **FIG. 5C**, the reflective layer **3** is disposed on the dye recording layer **2** to enhance reflectance, particularly when information recorded on the disc **30** is reproduced. The material forming the reflective layer **3** comprises a substance having a high reflectance with respect to laser light. Examples thereof include metals such as Mg, Se, Y, Ti, Zr, Hf, V, Nb, Ta, Cr, Mo, W, Mn, Re, Fe, Co, Ni, Ru, Rh, Pd, Ir, Pt, Cu, Ag, Au, Zn, Cd, Al, Ga, In, Si, Ge, Te, Pb, Po, Sn, and Bi, metalloids, and stainless steel. Preferable examples include Cr, Ni, Pt, Cu, Ag, Au, Al, and stainless steel. These materials may be used singly or in combination of two or more. Alternatively, they may be used in the form of alloys. Au, Ag, or alloys thereof are especially preferable. The reflective layer **3** can be formed by, for example, depositing, sputtering, or ion-plating the light reflective material on the recording layer **2**. The thickness of the reflection film is generally 10 to 800 nm, preferably 20 to 500 nm, and even more preferably 50 to 300 nm.

[0063] After the reflective layer **3** has been formed, washing may be performed by jetting the cleaning solution from the nozzles **22** and **23** of the washing device **21** onto the outer peripheral edge (non-recording region) where the substrate has been exposed by removal of the dye recording layer **2**. Washing the non-recording region can be performed in substantially the same manner as washing/removing the outer peripheral edge of the dye recording layer **2**.

[0064] As illustrated in **FIG. 2**, when washing/removing the outer peripheral edge of the dye recording layer **2**, ends of the nozzles **22** and **23** are directed towards the outer periphery from the center of the substrate **1**. However, when washing the non-recording region, it is preferable for the mouth of the nozzle **22** (and **23**) to be disposed to the outer side of the substrate **1** and facing the inner periphery, as illustrated in **FIG. 9**. By disposing the nozzle **22** in this manner, it is possible to reliably wash the substrate **1** up to the boundary between the substrate **1** and the reflective layer **3**. It should be noted that the configuration of the nozzle **22** is not limited as long as the conditions below concerning the discharge direction of the cleaning solution are satisfied, even when washing the non-recording region. Washing may even be performed using the straight nozzle **22'** illustrated in **FIG. 3**.

[0065] **FIGS. 9 and 10** illustrate the position at which the nozzle **22** is disposed when washing the non-recording

region as respectively seen in an enlarged sectional view and a schematic planar view. The view in **FIG. 9** is seen from the side of a plane that extends in the normal line direction of the substrate **1** and includes the straight line representing the direction in which the cleaning solution is discharged from the nozzle **22**. Although **FIG. 9** only illustrates the position at which the nozzle **22** is disposed, the nozzle **23** may be disposed at a position similar to the one illustrated in **FIG. 2** to thereby wash the reverse surface of the substrate.

[0066] As illustrated in **FIG. 9**, when the non-recording region is washed, the nozzle **22** is preferably disposed so that an angle θ_4 defined by the intersection between a discharge direction L_c of the cleaning solution and the normal line L_n of the substrate **1** is 0 to 60°, and more preferably 10 to 45°. The angle at which the nozzle **22** (and **23**) is bent is adjusted to meet this condition. When the straight nozzle **22'** is used, the angle at which that nozzle **22'** is disposed is adjusted to meet the same condition.

[0067] The range of the angle θ_4 is defined on the plane that extends in the normal line direction of the substrate **1** and includes the straight line representing the discharge direction of the cleaning solution.

[0068] As illustrated in **FIG. 10**, when the substrate **1** is seen in planar view, the nozzle **22** (and **23**) is disposed so that an angle θ_5 , which is defined by the intersection between a discharge direction L_r (which is opposite to the direction of rotation R) of the cleaning solution and a straight line L_g connecting the center of the substrate **1** and the mouth of the nozzle **22**, is preferably 0 to 60°, and more preferably 10 to 45°.

[0069] The distance from the mouth of the nozzle **22** to the substrate **1** is preferably 0.3 to 5.0 mm, more preferably 0.5 to 3.0 mm, and even more preferably 0.7 to 2.0 mm. The diameter of the nozzle **22** is preferably 0.1 to 0.8 mm, and more preferably 0.2 to 0.6 mm, in order to stably discharge the cleaning solution.

[0070] The rotational frequency of the spinner head **13** at the time discharge of the cleaning solution is initiated is 3000 rpm or less in order to reliably wash the dye recording layer **2** adhering to the outer peripheral edge. Additionally, it is preferable for the rotational frequency to become 50% or less than the rotational frequency of the spinner head **13** when discharge is initiated for washing/removing the outer peripheral edge of the dye recording layer **2**.

[0071] As illustrated in **FIG. 5D**, the protective layer **4** is disposed on the reflective layer **3** to physically and chemically protect the dye recording layer **2**. The protective layer **4** can also be disposed on the side of the substrate **1** where the dye recording layer **2** is not disposed, in order to improve resistance to damage and moisture. Examples of material usable for the protective layer **4** include inorganic substances such as SiO , SiO_2 , MgF_2 , SnO_2 , and Si_3N_4 , and also organic substances such as thermoplastic resins, thermosetting resins and UV-curable resins.

[0072] The protective layer **4** can be formed by, for example, laminating a film obtained by extruding plastic material onto the reflective layer **3** and/or the substrate **1**, with an adhesive therebetween. The protective layer **4** may also be disposed by vacuum deposition, sputtering, or coating. When the protective layer **4** comprises a thermoplastic resin or thermosetting resin, the protective layer **4** can be

formed by dissolving the thermoplastic or thermosetting resin into a suitable solvent to prepare a coating solution, and thereafter coating the solution and allowing it to dry. When the protective layer **4** comprises a UV-curable resin, the protective layer **4** can be formed by using the UV-curable resin as it is or by dissolving it into a suitable solvent to prepare a coating solution, and thereafter coating the solution and curing the same by irradiating the solution with UV light. Additives such as anti-static agents, antioxidants, and UV absorbents may be added to the solution as needed. The protective layer **4** generally has a thickness of 0.1 to 100 μm .

[0073] It should also be noted that the spin coater **10** of the invention can be used to form the undercoat and protective layers in the same manner as the dye recording layer.

[0074] Method for Producing Optical Disc (2)

[0075] A second embodiment of the method of the invention, in which the non-recording region is formed by later washing, will now be described with reference to **FIGS. 11A** to **11D**.

[0076] As illustrated in **FIG. 11A**, the dye recording layer **2** is first formed on the substrate **1** using the spin coater **10**. Then, as illustrated in **FIG. 11B**, the reflective layer **3** is sputtered or ion-plated only on the recording region of the dye recording layer **2** (i.e., excluding the non-recording region).

[0077] Thereafter, as illustrated in **FIG. 11C**, the outer peripheral edge (the non-recording region) of the dye recording layer **2** is washed/removed (later washing) with the washing device **21** of **FIG. 2** having the nozzles **22** and **23**. Unless otherwise indicated, the later washing is performed in the same manner as the earlier washing described above, with the washing device **21** and in accordance with the conditions described below.

[0078] The two nozzles **22** and **23** used in the later washing are each bent, as in the earlier washing, so that the cleaning solution is obliquely jetted onto the substrate **1**. However, as long as the nozzle **22** satisfies the conditions below concerning the method by which the cleaning solution is discharged, the shape thereof is not limited. The straight nozzles **22'** and **23'** can also be used.

[0079] Because the nozzles **22** and **23** (or the straight nozzles **22'** and **23'**) used in the later washing are disposed in the same manner as they are in the earlier washing, description will be given of a case where the nozzles **22** and **23** are used.

[0080] As illustrated in **FIG. 2**, the nozzles **22** and **23** are preferably disposed so that the angles θ_1 and θ_2 defined by the intersection between the discharge directions L_a and L_b and the normal line direction L_n of the substrate **1** are each 0 to 60°, and preferably 10 to 45°. When the straight nozzles **22'** and **23'** are used, the angles at which they are disposed are adjusted in accordance with the angle conditions.

[0081] Although the nozzles **22** and **23** discharge the cleaning solution within the angle range described above, they are at least disposed so that they are not oriented towards the center of the substrate **1**. Also, the ranges of angles θ_1 and θ_2 are defined on the plane that extends in the normal line direction of the substrate **1** and includes the straight line representing the discharge direction of the cleaning solution.

[0082] As illustrated in FIG. 4, the nozzle 22 (and 23) is preferably disposed so that, when seen in planar view, the angle θ_3 defined by the intersection between the discharge direction L_c of the cleaning solution (facing the direction of rotation R) and the straight line L_d connecting the center of the substrate and the mouth of the nozzle is 0 to 60°, and more preferably 10 to 45°.

[0083] The distance from the mouth of the nozzle 22 (and 23) to the substrate 1 is preferably 0.3 to 5.0 mm, more preferably 0.5 to 3.0 mm, and even more preferably 0.7 to 2.0 mm. The diameter of the nozzle 22 is 0.1 to 0.8 mm, and more preferably 0.2 to 0.6 mm, in order to stably discharge the cleaning solution.

[0084] By using the nozzles 22 and 23 (or the straight nozzles 22' and 23') satisfying these conditions, as illustrated in FIG. 11C, the dye recording layer 2 can be removed from the non-recording region.

[0085] In order to enhance washing efficiency, washing is preferably conducted within 1.0 to 300 seconds, and more preferably within 3 to 100 seconds, after the reflective layer 3 is formed. When washing is initiated earlier than 1.0 seconds, the shape of the edge of the dye recording layer 2 is compromised due to insufficient drying of the dye recording layer, and may lead to edge peeling. When washing is initiated later than 300 seconds, it becomes difficult to remove the dye recording layer 2 by washing due to the dye recording layer 2 being overdried, and may result in an inability to completely remove the dye recording layer 2 from the outer periphery of the substrate 1 by washing.

[0086] Discharge time of the cleaning solution is preferably 0.1 to 1.5 seconds, more preferably 0.2 to 1.2 seconds, and even more preferably 0.3 to 1.0 seconds. The amount of cleaning solution discharged is preferably 0.2 to 3.0 ml, more preferably 0.4 to 2.0 ml, and even more preferably 0.6 to 1.5 ml. The pressure at which the cleaning solution is discharged is preferably 0.3 to 3.0 kg/cm², more preferably 0.5 to 2.0 kg/cm², and even more preferably 0.7 to 1.7 kg/cm², to remove the dried dye recording layer 2.

[0087] Discharge pressure can be adjusted in accordance with the diameter of the nozzle, and the product of the nozzle diameter and discharge pressure is preferably 0.2 to 2.4 mm·kg/cm², more preferably 0.3 to 1.0 mm·kg/cm², and even more preferably 0.4 to 0.6 mm·kg/cm².

[0088] The rotational frequency of the spinner head 13 at the time discharge of the cleaning solution begins is set to be 1000 to 10000 rpm, so that the cleaning solution is not splashed onto the area of the dye recording layer that is not to be removed. Preferably, the rotational frequency is 2000 to 8000 rpm, and more preferably 3000 to 6000 rpm. The rotational frequency of the spinner head 13 at the time the cleaning solution is being spun off of the substrate is preferably 3000 to 10000 rpm, more preferably 4000 to 8000 rpm, and even more preferably 5000 to 7000 rpm.

[0089] Thereafter, as illustrated in FIG. 11D, the protective layer 4 is disposed on the reflective layer 3 to physically and chemically protect the dye recording layer.

[0090] According to the methods of the invention, the direction in which the cleaning solution is discharged and other washing conditions are specified in washing/removing the dye recording layer from the outer peripheral edge of the

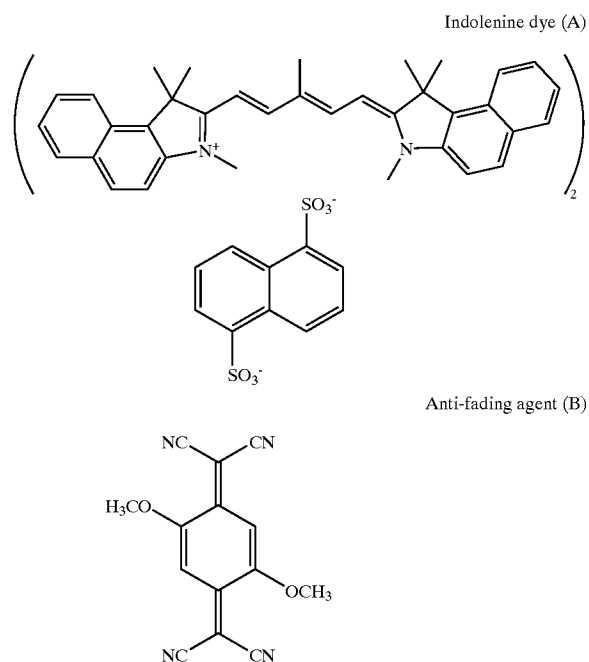
substrate. Therefore, the non-recording region of the optical disc is completely washed and the shape of the edge is excellent. As a result, an optical disc produced according to the methods of the invention has excellent storage stability and excellent recording and playback characteristics.

EXAMPLES

[0091] The present invention will now be described in further detail by way of examples. However, the invention is not limited to these examples.

Example 1

[0092] A polycarbonate substrate (diameter: 120 mm; thickness: 1.2 mm; made by Teijin Limited; trade name: Panlite AD 5503) having formed in its surface a spiral pre-groove (track pitch: 1.6 μ m; pre-groove width: 0.4 μ m; pre-groove depth: 0.16 μ m) was obtained by injection molding. 2.65 g of an indolenine dye (A), 0.265 g of an anti-fading agent (B), and 0.133 g of a bonding agent (made by Morton Limited, trade name: CA-139) were dissolved in 100 ml of 2,2,3,3-tetrafluoropropanol using an ultrasonic vibrator (1800 W) over 10 hours, whereby a coating solution for forming a dye recording layer was prepared.



[0093] The coating solution was spin-coated on the entire surface having the pre-groove of the polycarbonate substrate, with rotational frequency being varied from 300 rpm to 4000 rpm, and dried to thereby form the dye recording layer (pre-groove interior thickness: approximately 200 nm). The conditions under which the dye recording layer was formed were as follows. Atmospheric temperature and humidity were 23° C. and 50% RH, the temperatures of the coating solution and the substrate were 23° C., and exhaust wind speed was 0.1 m/sec.

[0094] Thereafter, using the nozzle 22 of the washing device 21 illustrated in FIG. 2, the outer peripheral edge of

the dye recording layer was washed/removed to thereby form a non-recording region. The washing conditions were as shown in Table 1, and diacetone propanol was used as the cleaning solution.

Comparative Examples 1 to 4

[0099] Optical information recording media (CD-Rs) of Comparative Examples 1 to 4 were produced in the same

TABLE 1

	Example 1	Comparative Example 1	Comparative Example 2	Comparative Example 3	Comparative Example 4	Example 2	Example 3
$\Theta_1(^{\circ})$	10	10	10	-30	70	10	10
$\Theta_3(^{\circ})$	0	0	0	0	0	-30	70
Number of nozzles	1	1	1	1	1	1	1
Discharge pressure (kg/cm ²)	1	1	1	1	1	1	1
Nozzle diameter (mm)	0.3	0.3	0.3	0.3	0.3	0.3	0.3
Discharge time (s)	0.5	0.5	0.5	0.5	0.5	0.5	0.5
Rotational frequency during discharge (rpm)	6000	6000	6000	6000	6000	6000	6000
Rotation time during discharge (s)	0.8	0.8	0.8	0.8	0.8	0.8	0.8
Rotational frequency during spin off (rpm)	6000	6000	6000	6000	6000	6000	6000
Rotation time during spin off (s)	0.5	0.5	0.5	0.5	0.5	0.5	0.5
Discharge amount (ml)	0.9	0.9	0.9	0.9	0.9	0.9	0.9
Lapse of time after forming recording layer (s)	30	500	0.1	30	30	30	30

[0095] Next, a reflective layer having a thickness of 150 nm was formed by sputtering Ag onto the dye recording layer. A UV-curable resin (trade name: SD-318; made by Dainippon Ink and Chemicals, Inc.) was spin-coated on the reflective layer while rotational frequency was varied from 50 rpm to 5000 rpm. Ultraviolet rays were then irradiated from a high pressure mercury lamp to thereby cure the UV-curable resin and form a protective layer having a thickness of 8 μ m.

[0096] A CD-R optical information recording medium (disc) comprising the substrate having disposed thereon the dye recording layer, the light reflective layer, and the protective layer was thereby produced (CD-R of Example 1). The non-recording region of the obtained CD-R was completely washed and the configuration of the edge portion was excellent. Also, a test for storability was conducted by storing the CD-R at 80° C. and in 85% humidity for 100 hours. Recording and playback characteristics of the CD-R were evaluated before and after the test for storability using a machine for evaluation "OMT2000" (made by Pulsteck Limited). The CD-R had excellent storage stability and excellent recording/playback characteristics.

Examples 2 and 3

[0097] Optical information recording media (CD-Rs) of Examples 2 and 3 were produced in the manner as in Example 1, except that washing conditions were changed as shown in Table 1.

[0098] The non-recording region of the CD-R of Example 2 was completely washed, and the shape of the edge was excellent. Slight splattering of the cleaning solution was observed, but not to the extent that would present a practical problem. The non-recording region of the CD-R of Example 3 was completely washed, and the shape of the edge was slightly compromised but not to the extent that would present a practical problem.

manner as in Example 1, except that washing conditions were changed as shown in Table 1.

[0100] The non-recording regions of the CD-Rs of Comparative Examples 1 and 4 could not be sufficiently washed, and it was visually confirmed that dye remained in the non-recording region. It was also confirmed that the shape of the edge of the CD-R of Comparative Example 2 was compromised. With respect to the CD-R of Comparative Example 3, splattering could not be sufficiently prevented and, although evaluation was conducted in the same manner as in Example 1, recording errors occurred at the outer periphery.

Example 4

[0101] A polycarbonate substrate (diameter: 120 mm; thickness: 1.2 mm; made by Teijin Limited; trade name: Panlite AD 5503) having formed in its surface a spiral pre-groove (track pitch: 1.6 μ m; pre-groove width: 0.4 μ m; pre-groove depth: 0.16 μ m) was obtained by injection molding. 2.65 g of the indolenine dye (A) shown above, 0.265 g of the anti-fading agent (B) shown above, and 0.133 g of a binding agent (made by Morton Limited; trade name: CA-139) were dissolved in 100 ml of 2,2,3,3-tetrafluoropropanol using an ultrasonic vibrator (1800 W) over 10 hours, to thereby prepare a coating solution for forming a recording layer.

[0102] The coating solution was spin-coated on the entire surface having the pre-groove of the polycarbonate substrate, with rotational frequency being varied from 300 rpm to 4000 rpm, and dried to thereby form the dye recording layer (pre-groove interior thickness: approximately 200 nm). The conditions under which the dye recording layer was formed were as follows. Atmospheric temperature and humidity were 23° C. and 50% RH, the temperatures of the coating solution and the substrate were 23° C., and exhaust wind speed was 0.1 m/sec.

[0103] Next, a reflective layer having a thickness of 150 nm was formed by sputtering Ag onto the recording region of the dye recording layer (and not the non-recording region).

[0104] Thereafter, using the nozzle 22 of the washing device 21 illustrated in FIG. 2, the outer peripheral edge of the dye recording layer was washed/removed to thereby form a non-recording region. The washing conditions were as shown in Table 2, and diacetone propanol was used as the cleaning solution.

Comparative Examples 5 to 8

[0109] Optical information recording media (CD-Rs) of Comparative Examples 5 to 8 were produced in the same manner as in Example 4, except that washing conditions were changed as shown in Table 2.

[0110] The non-recording regions of the CD-Rs of Comparative Examples 5, 8 and 9 could not be sufficiently washed, and it was visually confirmed that dye remained in

TABLE 2

	Example 4	Comparative Example 5	Comparative Example 6	Comparative Example 7	Comparative Example 8	Example 5	Example 6
$\Theta_1(^{\circ})$	40	40	40	-30	70	40	40
$\Theta_3(^{\circ})$	0	0	0	0	0	-30	70
Number of nozzles	1	1	1	1	1	1	1
Discharge pressure (kg/cm ²)	1.5	1.5	1.5	1.5	1.5	1.5	1.5
Nozzle diameter (mm)	0.4	0.4	0.4	0.4	0.4	0.4	0.4
Discharge time (s)	0.9	0.9	0.9	0.9	0.9	0.9	0.9
Rotational frequency during discharge (rpm)	450	450	450	450	450	450	450
Rotation time during discharging (s)	0.1	0.1	0.1	0.1	0.1	0.1	0.1
Rotational frequency during spin off (rpm)	5900	5900	5900	5900	5900	5900	5900
Rotation time for spin off (s)	1	1	1	1	1	1	1
Discharge amount (ml)	0.8	0.8	0.8	0.8	0.8	0.8	0.8
Lapse of time after forming reflective layer (s)	10	500	0.15	10	10	10	10

[0105] Next, a UV-curable resin (trade name: SD-318; made by Dainippon Ink and Chemicals, Inc.) was spin-coated on the reflective layer while rotational frequency was varied from 50 rpm to 5000 rpm. Ultraviolet rays were then irradiated from a high pressure mercury lamp to thereby cure the UV-curable resin and form a protective layer having a thickness of 8 μm.

[0106] A CD-R optical information recording medium (disc) comprising the substrate having disposed thereon the dye recording layer, the light reflective layer, and the protective layer was thereby produced (CD-R of Example 4). The non-recording region of the obtained CD-R was completely washed and the configuration of the edge portion was excellent. Also, a test for storability was conducted by storing the CD-R at 80° C. and in 85% humidity for 100 hours. Recording and playback characteristics of the CD-R were evaluated before and after the test for storability using a machine for evaluation “OMT2000” (made by Pulsteck Limited). The CD-R had excellent storage stability and excellent recording/playback.

Examples 5 and 6

[0107] Optical information recording media (CD-Rs) of Examples 5 and 6 were produced in the same manner as in Example 4, except that washing conditions were changed as shown in Table 2.

[0108] The non-recording regions of the CD-Rs of Examples 5 and 6 were completely washed, and the shapes of their edges were compromised, although not to the extent that would present a practical problem.

the non-recording regions. With respect to the CD-R of Comparative Example 6, it was confirmed that the shape of its edge was compromised.

What is claimed is:

1. A method for producing an optical information recording medium, comprising at least the steps of:

coating a solution for forming a dye recording layer onto a surface of a rotating disc-shaped resin substrate; and

discharging a cleaning solution from a nozzle onto a peripheral edge to remove the dye recording layer from the peripheral edge,

wherein

discharge of the cleaning solution is initiated 1.0 to 300 seconds after completion of the coating, and

the nozzle is disposed on a plane that extends in a normal line direction of the substrate and includes a straight line representing a discharge direction of the cleaning solution, so that an angle defined by the discharge direction and the normal line is 0 to 60°.

2. The method of claim 1, wherein, in removing the dye recording layer, when the substrate is viewed from above, a virtual line that extends from a discharge mouth of the nozzle in the discharge direction is located on a rotation direction side of a straight line connecting a center of the substrate and the discharge mouth of the nozzle, with an angle defined between the straight line and the virtual line being 0 to 60°.

3. The method of claim 1, wherein the angle defined by the discharge direction and the normal line is 10 to 45°.

4. The method of claim 1, wherein the distance from a discharge mouth of the nozzle to the substrate is 0.3 to 5.0 mm.

5. The method of claim 1, wherein discharge time of the cleaning solution is 0.1 to 1.5 seconds.

6. The method of claim 1, wherein the amount of the cleaning solution discharged is 0.2 to 3.0 ml.

7. The method of claim 1, wherein discharge pressure of the cleaning solution is 0.3 to 3.0 kg/cm².

8. The method of claim 1, wherein the cleaning solution is discharged by two nozzles that are respectively disposed at opposing positions above and below the substrate.

9. The method of claim 1, wherein discharge of the cleaning solution is initiated within 3 to 100 seconds after completion of the coating.

10. The method of claim 2, wherein the angle defined by the straight line and the virtual line is 10 to 45°.

11. A method for producing an optical information recording medium, comprising at least the steps of:

coating a solution for forming a dye recording layer onto a surface of a rotating disc-shaped resin substrate;

coating a reflective layer on the formed dye recording layer; and

discharging a cleaning solution from a nozzle onto a peripheral edge to remove the dye recording layer from the peripheral edge,

wherein

discharge of the cleaning solution is started 1.0 to 300 seconds after completion of the coating of the reflective layer, and

the nozzle is disposed on a plane that extends in a normal line direction of the substrate and includes a straight line representing a discharge direction of the cleaning solution, so that an angle defined by the discharge direction and the normal line is 0 to 60°.

12. The method of claim 11, wherein, in removing the dye recording layer, when the substrate is viewed from above, a virtual line that extends from a discharge mouth of the nozzle in the discharge direction is located on a rotation direction side of a straight line connecting a center of the substrate and the discharge mouth of the nozzle, with an angle defined by the straight line and the virtual line being 0 to 60°.

13. The method of claim 11, wherein the angle defined by the discharge direction and the normal line is 10 to 45°.

14. The method of claim 11, wherein the distance from a discharge mouth of the nozzle to the substrate is 0.3 to 5.0 mm.

15. The method of claim 11, wherein discharge time of the cleaning solution is 0.1 to 1.5 seconds.

16. The method of claim 11, wherein the amount of the cleaning solution discharged is 0.2 to 3.0 ml.

17. The method of claim 11, wherein discharge pressure of the cleaning solution is 0.3 to 3.0 kg/cm².

18. The method of claim 11, wherein the cleaning solution is discharged by two nozzles that are respectively disposed at opposing positions above and below the substrate.

19. The method of claim 11, wherein discharge of the cleaning solution is initiated within 3 to 100 seconds after completion of the coating of the reflective layer.

20. The method of claim 12, wherein the angle defined by the straight line and the virtual line is 10 to 45°.

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