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**Composite of coated, shaped metal material and cloth containing chemical fibers,
and method for manufacturing same**

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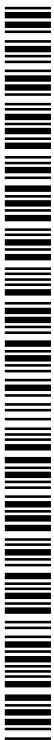
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(54) Title: COMPOSITE OF COATED, SHAPED METAL MATERIAL AND CLOTH CONTAINING CHEMICAL FIBERS, AND METHOD FOR MANUFACTURING SAME

(54) 発明の名称: 塗装金属素形材と化学繊維を含む布とが接合された複合体およびその製造方法

(57) Abstract: Provided is a composite having a coated, shaped metal material, and cloth which includes chemical fibers and which is joined to the surface of the coated, shaped metal material. This coated, shaped metal material has a shaped metal material, and a coating film that includes a polycarbonate unit-containing polyurethane resin formed on the surface of the coated, shaped metal material. The proportion of the mass of polycarbonate units to the total mass of resin in the coating film is 15-80 mass%. The thickness of the coating film is 0.2 μm or thicker.

(57) 要約: 複合体は、塗装金属素形材と、塗装金属素形材の表面に接合された、化学繊維を含む布と、を有する。塗装金属素形材は、金属素形材と、金属素形材の表面に形成されたポリカーボネートユニット含有ポリウレタン樹脂を含む塗膜とを有する。塗膜中の樹脂合計質量に対するポリカーボネートユニットの質量の割合は、15～80質量%である。塗膜の膜厚は、0.2 μm以上である。

DESCRIPTION

Title of Invention

COMPOSITE OF COATED, SHAPED METAL MATERIAL AND CLOTH
CONTAINING CHEMICAL FIBERS, AND METHOD FOR MANUFACTURING SAME

5 Technical Field

[0001] The present invention relates to a composite in which a coated shaped metal material and cloth containing a chemical fiber are joined to each other, and also to a method for manufacturing the composite.

Background Art

10 [0002] Metal sheets, press-molded products thereof, or so-called "shaped metal materials" molded by casting, forging, cutting, powder metallurgy, or the like are used in various industrial products such as automobiles. Shaped metal materials subjected to a surface treatment such as coating, blasting or polishing are sometimes used for providing good design. For example, used are a composite formed by lining cloth such as felt, a
15 woven fabric or a nonwoven fabric, which contains a chemical fiber, on the surface of a shaped metal material. Typically employed methods for lining cloth on the surface of a shaped metal material use a double sided tape or an adhesive to bond the cloth to the surface (see, e.g., PTL 1).

[0003] A composite described in PTL 1 has a melamine resin decorative layer including a
20 chemical fiber base material (e.g., cloth), an adhesive layer and a metal layer laminated in this order. The melamine resin decorative layer and the metal layer are bonded together with the adhesive layer composed of an adhesive.

Citation List

Patent Literature

[0004]

PTL 1

Japanese Patent Application Laid-Open No. 2014-208453

Summary of Invention

5 Technical Problem

[0005] Bonding of cloth to the surface of a shaped metal material using a double sided tape or an adhesive as described in PTL 1 has a disadvantage in that the thickness and weight of the composite increase by those of the double sided tape or adhesive. Further, since a step of attaching the double sided tape or applying the adhesive is necessary, and an
10 aging time is required in some cases until the adhesive strength stabilizes, the manufacturing time is prolonged and the manufacturing cost is increased. Using double sided tapes and adhesives raises another disadvantage of increasing the cost for materials.

[0006] The first object of the present invention is to provide a composite in which a shaped metal material and cloth containing a chemical fiber are joined to each other with
15 excellent adhesion, without using a double sided tape or an adhesive. The second object of the present invention is to provide a method for manufacturing the composite.

Solution to Problem

[0007] The present inventors have found that the above disadvantages can be overcome by forming a predetermined coating on the surface of a shaped metal material, and
20 completed the present invention with further extensive studies.

[0008] The present invention relates to the following composite.

[1] A composite including: a coated shaped metal material which includes a shaped metal material and a coating formed on a surface of the shaped metal material; and cloth which contains a chemical fiber and is joined to a surface of the coated shaped metal material, in
25 which the coating contains a polyurethane resin containing a polycarbonate unit, a mass

ratio of the polycarbonate unit to mass of a total resin in the coating is 15 to 80 mass%, and a film thickness of the coating is 0.2 μm or more.

[2] The composite according to [1], in which the chemical fiber is a polyurethane fiber, a nylon fiber, a polyester fiber, an acrylic fiber, a polyvinyl alcohol fiber, a polyolefin fiber, a polyvinyl chloride fiber or a combination thereof.

[3] The composite according to [1] or [2], in which the cloth is a woven fabric, a knitted fabric, lace, felt, a nonwoven fabric or a combination thereof.

[0009] Further, the present invention relates to the following method for manufacturing a composite.

[4] A method for manufacturing a composite including a coated shaped metal material and cloth containing a chemical fiber, the coated shaped metal material including a shaped metal material and a coating formed on a surface of the shaped metal material, the method including: providing the coated shaped metal material; heating the coated shaped metal material; and joining the cloth containing a chemical fiber by compression to a surface of the coated shaped metal material that is heated, in which the coating contains a polyurethane resin containing a polycarbonate unit, a mass ratio of the polycarbonate unit to mass of a total resin in the coating is 15 to 80 mass%, and a film thickness of the coating is 0.2 μm or more.

Advantageous Effects of Invention

[0010] The present invention can provide a composite in which a coated shaped metal material and cloth containing a chemical fiber are joined with excellent adhesion to each other, without using a double sided tape or an adhesive. The composite according to the present invention can be manufactured easily at low cost.

Description of Embodiments

[0011] 1. Composite

Hereinafter, an embodiment of the present invention will be described. The composite according to the present embodiment includes a coated shaped metal material, and cloth which contains a chemical fiber and is joined to the surface of the coated shaped metal material. Hereinafter, each component will be described.

5 [0012] [Coated Shaped Metal Material]

A coated shaped metal material includes a shaped metal material, and a coating formed on the surface of the shaped metal material. The coated shaped metal material may also include a chemical conversion film formed between the shaped metal material and the coating. Hereinafter, each component of the coated shaped metal material will be
10 described.

[0013] (1) Shaped Metal Material

Types of shaped metal materials serving as base materials to be coated are not particularly limited. Examples of the shaped metal materials include: metal sheets such as cold-rolled steel sheets, zinc-coated steel sheets, Zn-Al alloy-coated steel sheets, Zn-Al-Mg
15 alloy-coated steel sheets, Zn-Al-Mg-Si alloy-coated steel sheets, aluminum-coated steel sheets, stainless steel sheets (including austenitic, martensitic, ferritic, and ferrite-martensite duplex-phase stainless steel sheets), aluminum sheets, aluminum alloy sheets, and copper sheets; pressed products of metal sheets; and various metallic members shaped by processing methods such as casting (e.g., aluminum die-casting and zinc
20 die-casting), forging, cutting, and powder metallurgy. The shaped metal material may be subjected to a conventional coating pretreatment such as degreasing or pickling, as necessary.

[0014] (2) Chemical Conversion Film

As described above, the coated shaped metal material may also include a chemical
25 conversion film formed between the shaped metal material and a coating. The chemical conversion film is formed on the surface of the shaped metal material, and can improve the

adhesion of the coating to the shaped metal material and the corrosion resistance of the shaped metal material. The chemical conversion film may be formed, within the shaped metal material surface, at least on a region (joint surface) to be joined to below-described cloth, but is usually formed on the entire surface of the shaped metal material.

5 [0015] Types of chemical conversion treatment for forming the chemical conversion film are not particularly limited. Examples of the chemical conversion treatment include chromate conversion treatment, chromium-free conversion treatment, and phosphating treatment. The coverage of the chemical conversion film formed by the chemical conversion treatment is not particularly limited as long as the coverage falls within a range
10 effective for improving the adhesion of the coating and the corrosion resistance. For example, the coverage of the chromate film can be adjusted so that the coverage in terms of the total amount of Cr becomes 5 to 100 mg/m². The coverage of the chromium-free film can be adjusted so that the coverage of a Ti-Mo composite film falls within a range of 10 to 500 mg/m² or the coverage of a fluoro acid film falls within a range of 3 to 100 mg/m² in
15 terms of the amount of fluorine or in terms of the total amount of metal elements. The coverage of the phosphate film can be adjusted to 0.1 to 5 g/m².

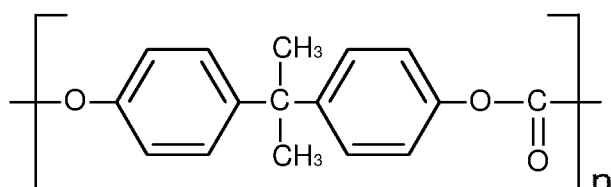
[0016] (3) Coating

The coating contains a polyurethane resin containing a polycarbonate unit, and improves the adhesion of cloth to the shaped metal material. As described below, the
20 coating may further contain a polycarbonate unit-free resin as an optional component. The coating, as with the chemical conversion film, may only be formed on the joint surface within the shaped metal material surface, but is usually formed on the entire surface of the shaped metal material (or the chemical conversion film).

[0017] The polyurethane resin containing a polycarbonate unit has a polycarbonate unit
25 in the molecular chain thereof. The "polycarbonate unit" refers to a structure shown below in the molecular chain of the polyurethane resin. The polyurethane resin

containing a polycarbonate unit has a skeleton (such as a benzene ring) and functional group similar to those of a chemical fiber contained in below-described cloth. This allows the polyurethane resin containing a polycarbonate unit to become compatible with the chemical fiber contained in cloth to strongly bond thereto when the cloth is bonded by thermocompression to the coated shaped metal material. Therefore, the adhesion of cloth to the coating can be improved by adding the polyurethane resin containing a polycarbonate unit to the coating.

[0018] [Formula 1]



The polyurethane resin containing a polycarbonate unit can be prepared, for example, by steps described below. An organic polyisocyanate is reacted with a polycarbonate polyol and a polyol having a tertiary amino group or a carboxyl group to form a urethane prepolymer. Polyols other than the polycarbonate polyol compound, for example, polyester polyol and polyether polyol, may be used in combination to an extent that does not compromise the objects of the present invention.

[0020] A cationic polyurethane resin containing a polycarbonate unit can be formed by neutralizing the tertiary amino group of the produced urethane prepolymer with an acid, or quaternizing the same with a quaternizing agent, followed by chain elongation using water.

[0021] Alternatively, an anionic polyurethane resin containing a polycarbonate unit can be formed by neutralizing the carboxyl group of the produced urethane prepolymer with a basic compound such as triethylamine, trimethylamine, diethanolmonomethylamine, diethylethanolamine, caustic soda, or caustic potassium to converse the prepolymer to a carboxylate.

[0022] The polycarbonate polyol can be obtained by reacting a carbonate compound with a diol compound. Examples of the carbonate compounds include dimethyl carbonate, diethyl carbonate, ethylene carbonate, and propylene carbonate. Examples of the diol compounds include ethylene glycol, diethylene glycol, propylene glycol, dipropylene glycol, neopentyl glycol, methylpentanediol, dimethylbutanediol, butyl ethyl propanediol, diethylene glycol, triethylene glycol, tetraethylene glycol, 1,4-butanediol, 1,4-cyclohexanediol, and 1,6-hexanediol. The polycarbonate polyol may be obtained by chain elongation using an isocyanate compound.

[0023] Types of organic polyisocyanates are not particularly limited. Examples of the organic polyisocyanates include 2,4-tolylene diisocyanate, 2,6-tolylene diisocyanate, m-phenylene diisocyanate, p-phenylene diisocyanate, 4,4'-diphenylmethane diisocyanate, 2,4'-diphenylmethane diisocyanate, 2,2'-diphenylmethane diisocyanate, 3,3'-dimethyl-4,4'-biphenylene diisocyanate, 3,3'-dichloro-4,4'-biphenylene diisocyanate, 1,5-naphthalene diisocyanate, 1,5-tetrahydronaphthalene diisocyanate, tetramethylene diisocyanate, 1,6-hexamethylene diisocyanate, dodecamethylene diisocyanate, trimethylhexamethylene diisocyanate, 1,3-cyclohexylene diisocyanate, 1,4-cyclohexylene diisocyanate, xylylene diisocyanate, tetramethylxylylene diisocyanate, hydrogenated xylylene diisocyanate, lysine diisocyanate, isophorone diisocyanate, and 4,4'-dicyclohexylmethane diisocyanate. These organic polyisocyanates may be used individually or in combination.

[0024] The coating may further contain a polycarbonate unit-free resin as an optional component. The polycarbonate unit-free resin further improves the adhesion of the coating to the shaped metal material. Types of polycarbonate unit-free resins are not particularly limited as long as the resin contains no polycarbonate unit in the molecular chain thereof. A polycarbonate unit-free resin containing a polar group is preferred for improving the adhesion of the coating to the shaped metal material. Examples of the

polycarbonate unit-free resins include epoxy resins, polyolefin resins, phenol resins, acrylic resins, polyester resins, and polycarbonate unit-free polyurethane resins. These resins may be used individually or in combination.

[0025] Examples of the epoxy resins include bisphenol A epoxy resins, bisphenol F epoxy resins, and bisphenol AD epoxy resins. Examples of the polyolefin resins include polyethylene resins and polypropylene resins. Examples of the phenol resins include novolac resins and resol resins.

[0026] The polycarbonate unit-free polyurethane resin can be obtained from copolymerization of a diol and a diisocyanate. Examples of the diols include bisphenol A, 1,6-hexanediol and 1,5-pentanediol, which are not a polycarbonate diol. Examples of the diisocyanates include aromatic diisocyanates, aliphatic diisocyanates, and alicyclic diisocyanates.

[0027] The mass ratio of the polycarbonate unit to the mass of the total resin is 15 to 80 mass%. When the mass ratio of the polycarbonate unit is less than 15 mass%, the adhesion of the cloth to the coating may become unsatisfactory. On the other hand, when the mass ratio of the polycarbonate unit is more than 80 mass%, the adhesion of the coating to the shaped metal material may become unsatisfactory. The mass ratio of the polycarbonate unit to the mass of the total resin can be determined by nuclear magnetic resonance spectroscopy (NMR analysis) using a sample of the coating dissolved in chloroform.

[0028] Preferably, the coating further contains an oxide, a hydroxide or a fluoride of a metal (valve metal) selected from the group consisting of Ti, Zr, V, Mo, and W, or a combination thereof. Dispersing any of these metal compounds in a chemical conversion film can further improve the corrosion resistance of the shaped metal material. Particularly, the fluorides of these metals can also be expected to suppress the corrosion of a film defect area by virtue of their self-repairing effects.

[0029] The coating may further contain a soluble metal phosphate or complex phosphate, or poorly soluble metal phosphate or complex phosphate. The soluble metal phosphate or complex phosphate further improves the corrosion resistance of the shaped metal material by complementing the self-repairing effects of the metal fluoride(s) described above. The
5 poorly soluble metal phosphate or complex phosphate disperses in the coating and improves film strength. The soluble metal phosphate or complex phosphate, or poorly soluble metal phosphate or complex phosphate is, for example, a salt of Al, Ti, Zr, Hf, Zn or the like.

[0030] The film thickness of the coating is not particularly limited as long as the film
10 thickness is 0.2 μm or more. When the film thickness of the coating is less than 0.2 μm , the adhesion of the cloth to the shaped metal material may not be satisfactorily improved. On the other hand, the upper limit of the film thickness of the coating is not particularly limited, and preferably about 20 μm . When the film thickness exceeds 20 μm , the coating cannot be expected to improve the adhesion any more.

15 [0031] The coating may further contain, in addition to the above described resins, an etching agent, an inorganic compound, a lubricant, a color pigment, a dye and/or the like.

[0032] An etching agent improves the adhesion of the coating to the shaped metal material by activating the surface of the shaped metal material. Examples of the etching agents include hydrofluoric acid, ammonium fluoride, hydrogen fluorozirconate and
20 hydrogen fluorotitanate.

[0033] An inorganic compound improves water resistance by densifying the coating. Examples of the inorganic compounds include sols of inorganic oxides such as silica, alumina, and zirconia, and phosphates such as sodium phosphate, calcium phosphate, manganese phosphate, and magnesium phosphate.

25 [0034] Examples of the lubricants include organic lubricants such as fluorine-based lubricants, polyethylene-based lubricants and styrene-based lubricants, and inorganic

lubricants such as molybdenum disulfide and talc.

[0035] Further, a predetermined color tone may be imparted to the coating by adding, e.g., an inorganic pigment, an organic pigment or an organic dye.

[0036] [Cloth]

5 The cloth contains a chemical fiber, and is joined to the surface of the coated shaped metal material.

[0037] Types of cloth and chemical fibers contained therein are not particularly limited, and appropriately selected in accordance with a desired design. Examples of the cloth include woven fabrics, knitted fabrics, lace, felt, nonwoven fabrics and combinations
10 thereof. Examples of the chemical fibers contained in the cloth include polyurethane fibers, nylon fibers, polyester fibers, acrylic fibers, polyvinyl alcohol fibers, polyolefin fibers, polyvinyl chloride fibers and combinations thereof. The chemical fiber preferably has a polycarbonate unit (specifically, a benzene ring), and more preferably is, for example, a polyurethane fiber or a polyester fiber.

15 [0038] The cloth may further contain a natural fiber, such as cotton, hemp, silk or paper, or inorganic fiber, such as a ceramic fiber or a metal fiber.

[0039] 2. Method for Manufacturing Composite

The method for manufacturing a composite will now be described. The method for manufacturing a composite according to the present embodiment includes: 1) a first step of
20 providing a coated shaped metal material; 2) a second step of heating the coated shaped metal material; and 3) a third step of joining cloth containing a chemical fiber by compression to the surface of the coated shaped metal material that is heated. Hereinafter, each step will be described.

[0040] 1) First Step

25 In the first step, a coated shaped metal material is provided. For example, the coated shaped metal material is manufactured by the below procedure. The coated shaped

metal material may be processed into a desired shape by pressing or the like.

[0041] A shaped metal material serving as a base material to be coated is provided. In a case where a chemical conversion film is formed, chemical conversion treatment is performed prior to formation of a coating. In a case where a chemical conversion film is not formed, the coating is directly formed.

[0042] In the case of forming a chemical conversion film on the surface of the shaped metal material, the chemical conversion film can be formed by applying a chemical conversion treatment solution to the surface of the shaped metal material followed by drying. A method for applying the chemical conversion treatment liquid is not particularly limited and can be appropriately selected from conventional methods. Examples of the methods for applying a chemical conversion treatment liquid include roll coating method, curtain flow method, spin coating method, spraying method, and dip-drawing method. The drying condition of the chemical conversion treatment liquid may be appropriately set in accordance with the composition of the chemical conversion treatment liquid, or the like. A uniform chemical conversion film can be formed on the surface of the shaped metal material by placing the shaped metal material having a chemical conversion treatment liquid applied thereon into a drying oven without washing with water, followed by heating the same at a peak plate temperature in a range of 80 to 250°C.

[0043] The coating can be formed by applying and baking a coating material which contains the above described polyurethane resin containing a polycarbonate unit on the surface of the shaped metal material (or the chemical conversion film). A method for applying the coating material is not particularly limited and can be appropriately selected from conventional methods. Examples of the methods for applying the coating material include roll coating method, curtain flow method, spin coating method, spraying method, and dip-drawing method. The baking condition of the coating material may be

appropriately set in accordance with the composition of the coating material, or the like. A uniform coating can be formed on the surface of the shaped metal material (or the chemical conversion film) by placing the shaped metal material having the coating material applied thereon into a drying oven, followed by drying the same at a peak plate
5 temperature in a range of 110 to 200°C with a hot-air dryer.

[0044] 2) Second Step

In the second step, the coated shaped metal material provided in the first step is heated to a temperature suitable for thermocompression bonding with cloth. The heating temperature of the coated shaped metal material is not particularly limited as long as the
10 cloth can be bonded by thermocompression to the surface of the coated shaped metal material. The temperature may be appropriately set in accordance with the composition of the coating, the type of chemical fiber contained in the cloth, and/or the like. A heating method is not particularly limited and can be appropriately selected from conventional methods. Examples of the heating methods include heater heating, electromagnetic
15 induction heating, ultrasonic heating and infrared heating. For example, the coated shaped metal material is heated on a hot plate.

[0045] 3) Third Step

In the third step, cloth containing a chemical fiber is joined by compression to the surface of the coated shaped metal material heated in the second step. Specifically, the
20 cloth containing the chemical fiber is brought in contact with the surface of the coated shaped metal material that is heated, and pressure is applied to allow the cloth to adhere to the surface. The strength and period of the pressure are not particularly limited as long as the cloth can be bonded by thermocompression to the surface of the coated shaped metal material. The strength and period may be appropriately set in accordance with the
25 composition of the coating, the type of chemical fiber contained in the cloth, and/or the like. Examples of methods for applying pressure include applying pressure by human power,

applying pressure mechanically using a vice, applying pressure using various rolls, and applying pressure by spraying air, nitrogen gas or the like. The cloth's own weight can be utilized if it is sufficient for adhesion of the cloth to the surface of the coated shaped metal material.

5 [0046] The cloth containing a chemical fiber can be joined with excellent adhesion to the surface of the coated shaped metal material by the above procedure. Accordingly, the composite according to the present embodiment can be manufactured.

[0047] As described above, the composite according to the present embodiment can be manufactured by bonding cloth containing a chemical fiber by thermocompression to the
10 surface of the coated shaped metal material according to the present embodiment. The coated shaped metal material according to the present embodiment has a predetermined coating formed thereon, which has excellent adhesion to both the shaped metal material and the cloth. Therefore, the composite according to the present embodiment has excellent adhesion to both the shaped metal material and the cloth.

15 [0048] Hereinafter, the present invention will be described in detail with reference to examples; however, the present invention is not intended to be limited by these examples.

Examples

[0049] In the present example, composites each including a coated shaped metal material and cloth containing a chemical fiber were prepared, and adhesion between the coated
20 shaped metal material and the cloth was examined.

[0050] 1. Preparation of Coated Shaped Metal Material

(1) Shaped Metal Material

A stainless steel sheet and a molten Zn-Al-Mg alloy-coated steel sheet both in the shape of a plate were provided as base materials to be coated for coated shaped metal
25 materials.

[0051] I. Stainless Steel Sheet

SUS430 with 2D-finish having a sheet thickness of 0.8 mm was provided as a stainless steel sheet.

[0052] II. Molten Zn-Al-Mg Alloy-coated Steel Sheet

5 A molten Zn-6mass% Al-3mass% Mg alloy-coated steel sheet having a coating coverage of 45 g/m² on one side was provided as a molten Zn-Al-Mg alloy-coated steel sheet. The steel substrate used was a cold-rolled steel sheet (SPCC) having a sheet thickness of 0.8 mm.

[0053] (2) Preparation of Coating Material

10 A polycarbonate unit-containing resin, a polycarbonate unit-free resin, and various additives were added to water to prepare each coating material having 20% of nonvolatile component in such a manner that the mass ratio of the polycarbonate (PC) unit to the mass of the total resin became a predetermined ratio shown in Table 1 (see Table 1). When more than one polycarbonate unit-free resin is used, each polycarbonate unit-free resin was
15 added in the same amount. To each coating material were added 0.5 mass% of ammonium fluoride (Morita Chemical Industries Co., Ltd.) as an etching agent, and 2 mass% of colloidal silica (Nissan Chemical Industries, Ltd.) and 0.5 mass% of phosphoric acid (Kishida Chemical Co., Ltd.) as inorganic compounds.

[0054] A. Polycarbonate Unit-Containing Resin

20 Regarding polycarbonate unit-containing resins shown in Table 1, SF-420 (DKS Co. Ltd.) was used as a polyurethane resin containing 50 mass% of a polycarbonate unit. SF-470 (DKS Co. Ltd.) was used as a polyurethane resin containing 70 mass% of a polycarbonate unit. HUX-386 (ADEKA Corporation) was used as a polyurethane resin containing 80 mass% of a polycarbonate unit. A product under test provided by a resin
25 manufacturer was used as a polyurethane resin containing 90 mass% of a polycarbonate unit.

[0055] A resin composition composed of 100 mass% of a polycarbonate unit was prepared by the following method. A polycarbonate sheet (TAKIRON Co., Ltd.) having a sheet thickness of 2.0 mm was cut into approximately 5-mm squares to obtain polycarbonate pieces. To 200 g of methylene chloride, 30 g of the polycarbonate pieces thus cut was added, and the mixture was stirred for 3 hours under heating to a solution temperature of 40°C to dissolve the polycarbonate pieces in methylene chloride. A resin composition composed of 100 mass% of a polycarbonate unit was prepared by the above steps.

[0056] B. Polycarbonate Unit-Free Resin

Regarding polycarbonate unit-free resins shown in Table 1, HUX-232 (ADEKA Corporation) or SF-170 (DKS Co. Ltd.) was used as a polycarbonate unit-free polyurethane resin. ADEKA Resin EM-0461N (ADEKA Corporation) or SUPER ESTER E-650 (Arakawa Chemical Industries, Ltd.) was used as an epoxy resin. HARDLEN NZ-1005 (Toyobo Co., Ltd.) was used as a polyolefin resin.

[0057] (3) Formation of Coating

Each base material to be coated was dipped for 1 minute to degrease the surface thereof in an aqueous alkali solution for degreasing (pH=12) having a solution temperature of 60°C. Subsequently, each coating material was applied to the degreased surface of the base material to be coated using a roll coater, and dried with a hot-air dryer at a peak plate temperature of 150°C to form a coating having the film thickness shown in Table 1.

[0058] [Table 1]

Coated Shaped Metal Material No.	PC Unit (mass%)	PC Unit-containing Resin	PC Unit-free Resin	Film Thickness of Coating (μm)	Base Material to be Coated
1	15	B	a, b	3.2	II
2	30	C	b	0.2	II
3	30	C	b	2.2	II
4	30	D	a	2.5	I
5	50	D	a, d	1.1	II
6	70	C	a	0.5	II
7	80	C	-	1.4	I
8	80	D	b	1.8	II
9	80	D	d	0.1	II
10	0	-	a	2.3	I
11	0	-	b, c	1.6	II
12	5	A	a	1.1	II
13	14	B	a, e	3.5	II
14	85	D	b	2.4	I
15	100	E	-	0.8	II

- PC Unit-containing Polyurethane Resin

A: Polyurethane Resin Containing 50 mass% of PC Unit (SF-420)

B: Polyurethane Resin Containing 70 mass% of PC Unit (SF-470)

5 C: Polyurethane Resin Containing 80 mass% of PC Unit (HUX-386)

D: Polyurethane Resin Containing 90 mass% of PC Unit

E: Polyurethane Resin Containing 100 mass% of PC Unit

- PC unit-free Resin

a: PC unit-free polyurethane resin (HUX-232)

10 b: PC unit-free polyurethane resin (SF-170)

c: Epoxy Resin (ADEKA Resin EM-0461N)

d: Epoxy Resin (SUPER ESTER E-650)

e: Polyolefin Resin (HARDLEN NZ-1005)

- Base Material to be Coated

15 I: SUS430

II: Molten Zn-Al-Mg Alloy-coated Steel Sheet

[0059] 2. Preparation of Composite

A warp knitted fabric composed of a polyurethane fiber and a nylon fiber (Hi-Tension; Asahi Kasei Corp.) was provided as cloth containing a chemical fiber. The cloth was cut into a piece having a size of 20 mm in width and 100 mm in length.

5 [0060] A coated shaped metal material cut to a size of 50 mm×50 mm was placed on a hot plate heated to 230°C. The piece of cloth was then placed on the surface of the coated shaped metal material that is heated so that the cloth was brought in contact, at an end region thereof having a size of 20 mm×20 mm, with the coated shaped metal material. Subsequently, pressure is applied at the region, where the coated shaped metal material and
10 the cloth overlap, for 10 seconds by putting a 2kg-weight thereon. Finally, cooling to room temperature while the load was continued to be applied to the cloth was performed to obtain a composite of the coated shaped metal material and the cloth.

[0061] 3. Evaluation of Adhesion

A 90° peeling test using a uniaxial tensile tester was performed, in which the cloth
15 was peeled off at a speed of 300 mm/min and in a direction always at a right angle to the plate surface of the coated shaped metal material. The maximum strength (peel strength) at which the cloth was peeled off by the 90° peeling test was measured. In this instance, the broken portion was observed to see whether the peeling occurred between the shaped metal material and the coating, or between the coating and the cloth. The composite was
20 evaluated as "Poor" when the peel strength was less than 5N, as "Fair" when the peel strength was 5N or more and less than 10N, as "Good" when the peel strength was 10N or more and less than 15N, and as "Excellent" when the peel strength was 15N or more, or only the cloth was broken. A composite having a peel strength of less than 10N (Fair) was found disqualified due to its inability to withstand practical use. Table 2 shows the
25 measuring results of the peel strength for the evaluated composites.

[0062] [Table 2]

Category	Coated Shaped Metal Material No.	PC Unit (mass%)	Film Thickness of Coating (μm)	Peel Strength (N)	Position of Peeling
Ex. 1	1	15	3.2	11.2 (Good)	Breakage of Cloth Interface between Coating and Cloth
Ex. 2	2	30	0.2	10.4 (Good)	Breakage of Cloth Interface between Coating and Cloth
Ex. 3	3	30	2.2	14.1 (Good)	Breakage of Cloth Interface between Coating and Cloth
Ex. 4	4	30	2.5	12.5 (Good)	Breakage of Cloth Interface between Coating and Cloth
Ex. 5	5	50	1.1	16.2 (Excellent)	Breakage of Cloth Interface between Coating and Cloth
Ex. 6	6	70	0.5	11.7 (Good)	Breakage of Cloth Interface between Coating and Cloth
Ex. 7	7	80	1.4	18.6 (Excellent)	Breakage of Cloth Interface between Coating and Cloth
Ex. 8	8	80	1.8	- (Excellent)	Breakage of Cloth
Ex. 9	2	30	0.2	11.1 (Good)	Breakage of Cloth Interface between Coating and Cloth
Ex. 10	5	50	1.1	12.8 (Good)	Breakage of Cloth Interface between Coating and Cloth
Ex. 11	8	80	1.8	- (Excellent)	Breakage of Cloth
Comp. Ex. 1	9	80	0.1	5.5 (Fair)	Not Confirmable
Comp. Ex. 2	10	0	2.3	0.0 (Poor)	Interface between Coating and Cloth
Comp. Ex. 3	11	0	1.6	0.0 (Poor)	Interface between Coating and Cloth
Comp. Ex. 4	12	5	1.1	3.0 (Poor)	Interface between Coating and Cloth
Comp. Ex. 5	13	14	3.5	6.9 (Fair)	Interface between Coating and Cloth
Comp. Ex. 6	14	85	2.4	6.1 (Fair)	Interface between Shaped Metal Material and Coating
Comp. Ex. 7	15	100	0.8	0.0 (Poor)	Interface between Shaped Metal Material and Coating

[0063] The composite of Comparative Example 1 had unsatisfactory adhesion between the coated shaped metal material and the cloth due to an unduly small film thickness of the coating. In addition, the position of peeling was not confirmable due to the unduly thin coating. The composite of each of Comparative Examples 2 to 5 had unsatisfactory adhesion between the coating and the cloth due to the too low mass ratio of the polycarbonate unit to the mass of the total resin in the coating. The composite of each of Comparative Examples 6 and 7 had unsatisfactory adhesion between the shaped metal material and the coating due to the too high mass ratio of the polycarbonate unit to the mass of the total resin in the coating.

[0064] Regarding the composite of each of Examples 1 to 11, the film thickness of the coating is 0.2 μm or more, and the mass ratio of the polycarbonate unit to the mass of the total resin in the coating is in a predetermined range (15 to 80 mass%), and thus adhesion between the coated shaped metal material and the cloth was excellent. The position of peeling was a breakage of the cloth, or a mixture of breakages of the cloth and at the interface between the coating and the cloth.

[0065] This application claims priority based on Japanese Patent Application No. 2015-020261, filed on February 4, 2015 the entire contents of which including the specification and abstract are incorporated herein by reference.

Industrial Applicability

[0066] The composite of the present invention has excellent adhesion between a coated shaped metal material and cloth containing a chemical fiber, and therefore, is suitably used for, e.g., interior materials of automobiles, various interior panels in architecture, or wall materials.

[0067] Mere reference to background art herein should not be construed as an admission

that such art constitutes common general knowledge in relation to the invention.

[0068] Throughout this specification, including the claims, where the context permits, the term “comprise” and variants thereof such as “comprises” or “comprising” are to be interpreted as including the stated integer or integers without necessarily excluding any other integers.

[The specification continues on page 20]

CLAIMS

1. A composite comprising:
 - a coated shaped metal material which includes a shaped metal material and a coating
 - 5 formed on a surface of the shaped metal material; and
 - cloth which contains a chemical fiber and is joined to a surface of the coating of the coated shaped metal material,
 - wherein, the coating contains a polyurethane resin containing a polycarbonate unit,
 - a mass ratio of the polycarbonate unit to mass of a total resin in the coating is 15 to
 - 10 80 mass%,
 - a film thickness of the coating is 0.2 μm or more, and
 - the chemical fiber is a polyurethane fiber, a polyvinyl alcohol fiber, a polyvinyl chloride fiber or a combination thereof.
- 15 2. The composite according to claim 1, wherein the cloth is a woven fabric, a knitted fabric, lace, felt, a nonwoven fabric or a combination thereof.
3. A method for manufacturing a composite including a coated shaped metal material and cloth containing a chemical fiber, the coated shaped metal material including a shaped
- 20 metal material and a coating formed on a surface of the shaped metal material, the method comprising:
 - providing the coated shaped metal material;
 - heating the coated shaped metal material; and
 - joining the cloth containing a chemical fiber by compression to a surface of the
 - 25 coating of the coated shaped metal material that is heated,
 - wherein, the coating contains a polyurethane resin containing a polycarbonate unit,

a mass ratio of the polycarbonate unit to mass of a total resin in the coating is 15 to 80 mass%,

a film thickness of the coating is 0.2 μm or more, and

the chemical fiber is a polyurethane fiber, a polyvinyl alcohol fiber, a polyvinyl
5 chloride fiber or a combination thereof.