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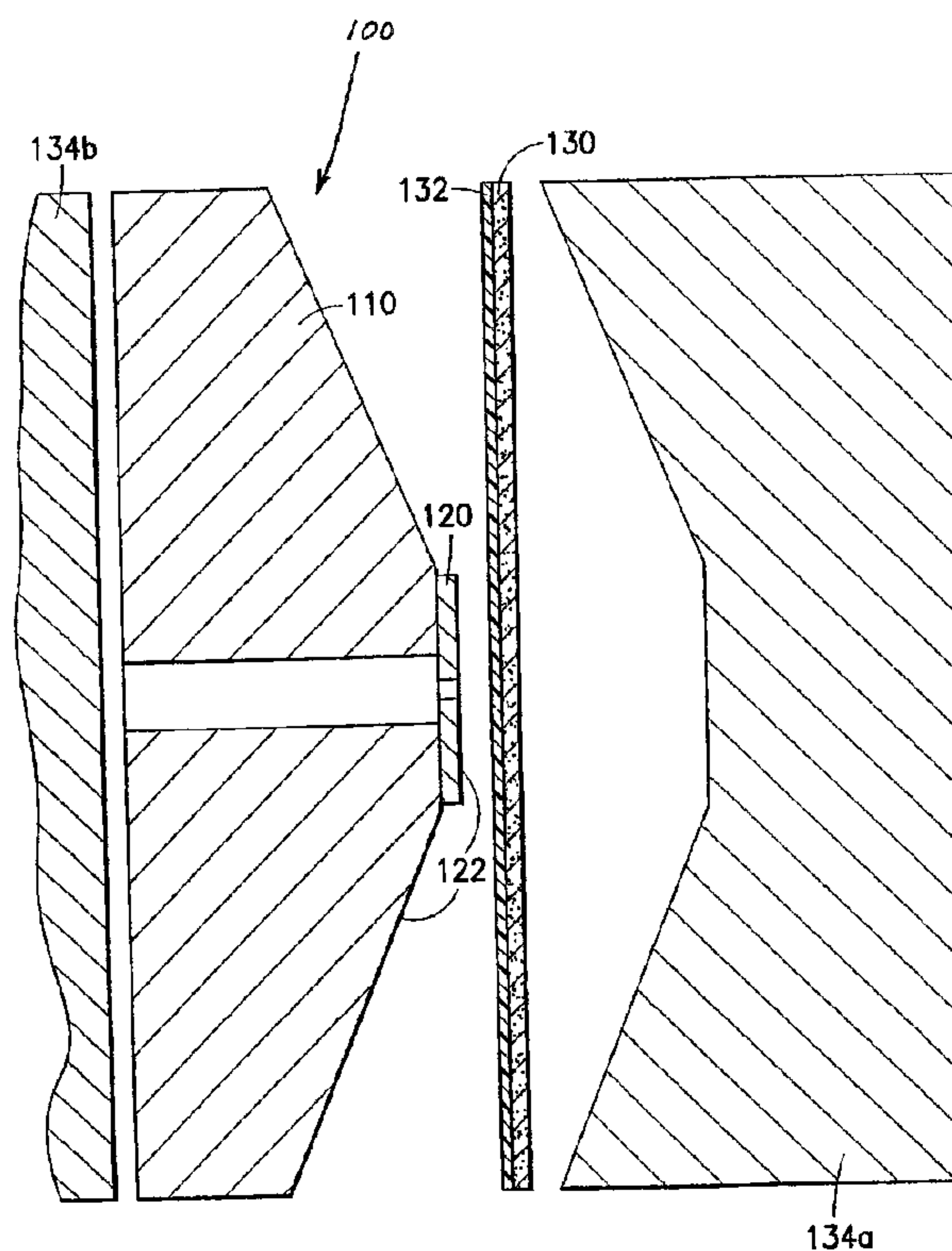
(72) Inventeurs/Inventors:
MYHILL, GREGORY A., US;
MILLER, NORMA, US

(73) Propriétaire/Owner:
ILLINOIS TOOL WORKS INC., US

(74) Agent: FINLAYSON & SINGLEHURST

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(54) Title: METHOD FOR COATING AN ORIFICE PLATE



(57) Abrégé/Abstract:

A method for coating an orifice plate and an orifice plate having a non-wetting coating thereon is provided. To form the plate, material having non-wetting characteristics can be provided as a surface of a transfer block. The non-wetting material is preferably Teflon™ (PTFE) and the transfer block is preferably a relatively soft material, which preferably has good heat transfer properties, such as aluminum. The surface of the transfer block comprising the non-wetting material can be pressed against the orifice plate, preferably under heating conditions. In one embodiment of the invention, the non-wetting surface is pressed against a secondary transfer block to coat the secondary transfer block with the non-wetting material and the coated surface of this second block is pressed against the orifice plate, preferably under heating conditions.

ABSTRACT OF THE DISCLOSURE

A method for coating an orifice plate and an orifice plate having a non-wetting coating thereon is provided. To form the plate, material having non-wetting characteristics can be provided as a surface of a transfer block. The non-wetting material is preferably TeflonTM (PTFE) and the transfer block is preferably a relatively soft material, which preferably has good heat transfer properties, such as aluminum. The surface of the transfer block comprising the non-wetting material can be pressed against the orifice plate, preferably under heating conditions. In one embodiment of the invention, the non-wetting surface is pressed against a secondary transfer block to coat the secondary transfer block with the non-wetting material and the coated surface of this second block is pressed against the orifice plate, preferably under heating conditions.

METHOD FOR COATING AN ORIFICE PLATE

BACKGROUND OF INVENTION

[001] The invention relates generally to orifice plates for fluid jet printers and more particularly, to a method for depositing a non-wetting coating on the surface of the orifice plate without clogging the fluid jetting orifices.

[002] Fluid jet printers produce images on a substrate by ejecting fluid drops onto the substrate in order to generate characters or images. Certain fluid jet printers are of the “continuous” type, where drops of fluid, such as ink, are continuously jetted through an orifice of a print head in a charged state. The charged droplets are then electrostatically directed onto the printing substrate when printing is desired and into a gutter when printing is not desired.

[003] Another type of a fluid jet printer is an “on demand” type printer. Drops of fluid, such as ink, are selectively jetted through an orifice of a print head when printing is desired and not jetted when no printing is desired.

[004] An ink storage chamber is commonly connected to the print head via an ink flow passageway, to provide a constant flow of ink to the printer head. Ink jet heads generally employ capillary action between the ink and passageways in the ink jet head to position ink at the proper location in the head for proper jetting and drop formation. High pressure outside the print head can undesirably overcome the capillary action and force ink back into the head. Low pressure outside the print head can undesirable draw ink out of the head. ↗

[005] Ink is generally ejected through an orifice formed through an orifice plate. Buildup of material at the orifice can affect surface tension interactions, drop formation and

disrupt proper operation. Ink buildup at the orifice surface can also attract dust, paper fibers and other debris and lead to clogging of the orifice. Ink present at the surface of the orifice can also lead to smearing and require increased distance between the orifice and the printing substrate, which leads a decrease in print quality. Thus, it is desirable for the surface of the orifice plate to be non-wetting with respect to the fluid jetted through the orifice.

[006] It is also advantageous for the inside of the ink passageways to be wetting. If the inside is wetting, ink will tend to coat all of the internal surfaces, proceed to a proper position in the print head and help air to exit from the ink passageways within the print head. If there is air inside the print head or the ink does not travel to the proper location, the jets might not operate properly.

[007] Various commonly known non-wetting coating methods have proved inadequate. The holes in the orifice plate are generally small, commonly about 0.002 inches in diameter. This makes them very difficult to mask off during a coating operation. Thus, some methods that involve coating the surface of the orifice plate will inadvertently coat the inside of the orifices, leading to either clogging or improper wetting properties within the fluid passageway. Some non-wetting coating materials tend to be removed from the surface of the orifice plate either through contact with ink or when the orifice plate is cleaned with various cleaning solvents used to clean dried ink from the orifice plate.

[008] Accordingly, it is desirable to provide an improved method of coating an orifice plate, to provide a non-wetting surface on the outside of the plate, while not clogging the orifices or coating the inner passageways within the orifices with the non-wetting material.

SUMMARY OF THE INVENTION

[009] Generally speaking, in accordance with the invention, a method for coating an orifice plate and an orifice plate having a non-wetting coating thereon is provided. To form the

plate material having non-wetting characteristics can be provided as a surface of a transfer block. The non-wetting material is referably Teflon (*PTFE). In one embodiment of the invention, the transfer block is a relatively soft material, which preferably has good heat transfer properties, such as aluminum. In one embodiment of the invention, the transfer block is made of the non-wetting material or has a thick layer of the non-wetting material on at least one surface. In another embodiment of the invention, a thin layer of the non-wetting material is disposed on the surface of a transfer block. In still another embodiment of the invention, the non-wetting material is disposed on the surface of a conformable material, such as a heat resistant elastomer, such as silicone. The surface of the transfer block comprising the non-wetting material can be pressed against the orifice plate, preferably under heating conditions. In one embodiment of the invention, the non-wetting surface is pressed against a secondary transfer block to coat the secondary transfer block with the non-wetting material and the coated surface of this second block is pressed against the orifice plate, preferably under heating conditions. Additional transfers can be made in order to achieve a coated surface having the appropriate thickness and other characteristics to be transferred to the surface of the orifice plate, substantially to the edge of the orifice, but substantially not being deposited on the inner surface of the orifice plate defining the orifice. In this manner, proper printing operation can be achieved, but ink and other debris can be kept off the surface of the orifice plate.

[0010] The temperature at which transfer is effected depends on the thermal properties and heat resistance of the material to be transferred. If Teflon is to be transferred, temperatures over 400° F, more preferably over 500° F and most preferably in the 550° F – 650° F range are used. Care should be taken so as not to heat the orifice plate and/or material to be transferred, to such an extent that the non-wetting material begins to degrade. The heat and pressure should be

(*PTFE - polytetrafluoroethene)

sufficient to transfer the non-wetting material onto the surface of the orifice plate without clogging the orifices or adversely affecting the operation of the print head.

[0011] Accordingly, the invention seeks to provide an improved method for providing a non-wetting coating on an orifice plate for a fluid jet printer.

[0012] Another aspect of the invention seeks to provide an improved orifice plate for a fluid jetting print head, having a non-wetting coating on the outside surface thereof.

BRIEF DESCRIPTION OF THE DRAWINGS

[0013] For a fuller understanding of the invention, reference is made to the following drawings, which are not necessary drawn to scale, in which:

[0014] FIG. 1 is a cross sectional view of a changer plate/orifice plate (CP/OP);

[0015] FIG. 2 is a cross sectional view of the CP/OP of FIG. 1 in relation to a coated silicone pad, prior to the pad being pressed against the CP/OP with a pressure plate, in accordance with an embodiment of the inventions;

[0016] FIGS. 3(a), 3(b) and 3(c) are a top view, an end view and a side view, respectively, of a CP/OP in accordance with an embodiment of the invention;

[0017] FIG. 4 is a schematic view of a device for applying a non-wetting coating to a CP/OP; and

[0018] FIGS. 5(a), 5(b) and 5(c) are schematic views of the steps for applying a non-wetting coating to a CP/OP in accordance with an embodiment of the invention.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

[0019] Orifice plates in accordance with the invention have a non-wetting surface that will help permit ink and other fluid substances and debris to roll off the surface of the plate and will help prevent accumulation problems.

[0020] According to the present invention, material having non-wetting characteristics is transferred by heat or pressure and preferably both, to the exterior surface of the orifice plate, preferably without clogging the orifice plate or negatively affecting the jetting performance of the orifice plate.

[0021] In a preferred embodiment of the invention, a Teflon (PTFE) solid film lubricant, such as one that contains no resins, such as Tiolon X20, sold by Tiodize Company of Huntington Beach, California, is coated, such as by spray coating, onto a transfer surface of a transfer block. Other known Teflon based non-wetting materials such as EnduraTM, from Endura Coating Co.; A-20, E-20, 1000-S20, FEP Green, PTFE and X-40 from Tiodize; Cammie 2000TM from AE Yale; 21845 from Ladd Research; MS122-22, MS 122DF, MS-143DF, MS-122V MS-122VM, MS-143V, MS-136W, MS-145W, U0316A2, U0316B2, MS-123, MS-125, MS-322 and MS-324 from Miller-Stephenson; and 633T2 from Oaao Bock can also be used. Various non-Teflon based non-wetting lubricant type materials include DylunTM, from ART; NyebarTM, DiamonexTM, NiLADTM, TIDLNTM, Kiss-CoteTM, Titanium oxide; Fluocad Fluorochemical Coating FC-722TM, from 3M; PermacoteTM from Dupont; Plasma Tech 1633TM from Plasma Tech, Inc.; and silicone sprays. These materials should be selected after consideration of the material to be jetted and the substrate onto which jetting will occur. Thus, if the jetted fluid is aqueous based, the non-wetting material should be hydrophobic. If the substrate will be covered with oils or adhesives the material can be selected to be non-wetting to those substances.

[0022] The coated surface of the transfer block can be pressed against the surface of the orifice plate (or the orifice plate and chamber plate "CP/OP"), which will be the exterior of the print head, with an effective amount of force and/or heat to transfer an effective amount of the non-wetting coating material to the exterior surface of the CP/OP to significantly improve the

non-wetting properties of the surface with respect to fluids, particularly aqueous based fluids and most particularly, inks. Transfers in accordance with the invention can also substantially prevent non-wetting material from becoming deposited on the inner surfaces of the plate that define the orifices.

[0023] It is advantageous to heat the transfer block, the orifice plate surface, or both, prior to performing the transfer process. The amount of heat will vary with the substance to be transferred. Heating should be to an effectively high temperature to ensure a thin transfer coat, but not high enough to degrade the material or to cause running, which could clog the orifices. When the non-wetting material is Teflon, the heating should be over 400 F, preferably over 500 F, most preferably in the range of 550°F-650°F.

[0024] The temperature and the duration of the heating step should be controlled so as not to result in degradation of the non-wetting material. The duration of heating can vary, based on the characteristics of the oven and the heat sink characteristics of the orifice plate and contact and transfer surfaces. The temperature and/or duration of heating may also be optimized to result in the desired non-wetting coating.

[0025] Acceptable transfer surfaces include metal, wood, plastic, silicone, viton or any other surface that is sufficient to achieve such contact with the orifice plate so as to effectively and substantially uniformly transfer the non-wetting material to the surface of the plate and not the orifices. The transfer surface is coated with the non-wetting material and should release the non-wetting coating material sufficiently under heat and pressure. In one embodiment of the invention, the transfer block is polished aluminum. In another, it is stainless steel or more preferably stainless steel having a layer of a conformable material that has been coated with the non-wetting material. Alternatively, the transfer block itself may be formed from the non-

wetting material, for example, a Teflon transfer block may be used, such that the first coating step is unnecessary.

[0026] The resulting orifice plate should have a thin coating of non-wetting material, such as Teflon thereon, which can be resistant to various typical cleaning operations and exhibit excellent non-wetting properties over acceptable durations of time. The thickness of the Teflon (or other non-wetting material) coating on the transfer surface should be adjusted, based on the characteristics of the orifice plate, including the size of the orifice holes, the type of Teflon transferred and other designed criteria. It has also been found that a coated transfer surface can be used to acceptably transfer an appropriate Teflon coating to 2, 3 and often more than 3 orifice plates before it needs to be recoated. Final coating thickness depends on the particular application. About 5μ is suitable for many applications. Other applications may be better suited to a 1-10 μ coating.

[0027] Orifice plates in accordance with preferred embodiments of the invention can have 72 - 140 orifices per inch. Each orifice advantageously has an inner diameter of about 0.0013 to 0.024 inches and a pitch of about 0.004 to 0.015 inches. Preferred orifices have a diameter of 0.002 inches.

[0028] Referring to the figures, FIG. 1 shows a chamber plate ("CP") and orifice plate ("OP") (the "CP/OP") 100 comprising a chamber plate 110 having a chamber plate hole 111 therethrough and an orifice plate 120 having an orifice 121 therethrough, mounted on a front surface 111a of chamber plate 110. A non-wetting coating 122 is disposed over orifice plate 120 and chamber plate 110. A CP/OP structure 100' with flat surfaces, having a chamber plate 110' with a chamber plate hole 111' therethrough and an orifice plate 120' having an orifice 121'

the, though, mounted on a front surface 111' of chamber plate 110' and a non-wetting coating 122' over orifice plate 120' is shown in FIGS. 3(a), 3(b), and 3(c).

[0029] If the surface of chamber plate 110 and orifice plate 120 to be coated by the non-wetting material has a complicated configuration (e.g., is non-planar, as shown in FIG.

2), an elastomer sheet, such as a silicon pad 130, may be applied to a pressure plate 134a and a non-wetting material (e.g., Teflon) coating applied, such as by spray coating. Non-wetting material 132 can be transferred to the desired surfaces of CP/OP 100 by applying pressure with one or more pressure plates such as plate 134a having a profile that matches the profile of CP/OP 100, to ensure sufficient contact between coated silicon pad 130, CP/OP 100 and pressure plate 134a to transfer an effective coating 132 from silicon pad 130 to CP/OP 100. A rear pressure plate 134b can be used to protect the rear of CP/OP 100.

[0030] A method of coating an orifice plate 530 of a CP/OP 540 is shown with reference to FIGS. 5(a) to 5(c). A Teflon coating 515 is sprayed onto a first transfer block 510 to form a Teflon coating layer 515a. It has been found that the resulting layer 515a is often too thick and can clog orifice holes when the surface of block 510 having coating 515a thereon is pressed against an orifice plate. Thus, it can be first pressed against a second transfer block 520 and heated for an effective amount of time in an oven 550 to form a layer of Teflon 515b on second transfer block 520. At this point, yet another transfer to another transfer block can be effected, or as shown in FIG. 5(c), layer 515b on block 520 can be pressed against orifice plate 530 of CP/OP 540, under heating conditions in oven 550 to deposit the non-wetting coating on orifice plate 530.

[0031] A press 400 for pressing a transfer block onto the orifice plate of a CP/OP is shown in greater detail in FIG. 4. Press 400 includes a fixed jaw 410 and a movable jaw 420.

Turning a knob 430 can advance movable jaw 420 towards fixed jaw 410 to press a front surface of a CP/OP 440 against a coated surface 451 of an aluminum transfer block 450. A backing block 460 which should be made of a relatively soft material such as aluminum can be used to protect the back of CP/OP 440. The entire assembly can then be placed into an oven. Other heating methods, such as induction heating or placing heating elements in press 400 can be employed. Also, the orientation with respect to moving jaw 420 can be reversed.

[0032] It will thus be seen that the aspects set forth above, among those made apparent from the preceding description, are efficiently attained and, since certain changes may be made in carrying out the above method and in the articles set forth without departing from the spirit and scope of the invention, it is intended that all matter contained in the above description and shown in the accompanying drawings shall be interpreted as illustrative and not in a limiting sense.

[0033] It is also to be understood that the following claims are intended to cover all of the generic and specific features of the invention herein described and all statements of the scope of the invention which, as a matter of language, might be said to fall therebetween.

The embodiments of the invention in which an exclusive property or privilege is claimed are defined as follows:

1. A method for coating an orifice plate with a material that is non-wetting to a selected material, comprising:

providing said orifice plate having at least one orifice therethrough, and having a front surface;

providing a first surface formed of non-wetting material;

pressing the first surface against a transfer surface and transferring a first coating of non-wetting material to the transfer surface; and

pressing the coated transfer surface against the front surface of the plate to coat the plate, substantially up to the edge of said at least one orifice, but not onto the portion of the plate defining said at least one orifice, with a second coating of the non-wetting material from the coated transfer surface.

2. The method of claim 1, wherein the transfer of the first coating is performed under heating conditions effective to transfer a coat of non-wetting material.

3. The method of claim 1, wherein the transfer of the second coating is performed under heating conditions effective to transfer a coat of non-wetting material.

4. The method of claim 2, wherein the transfer of the second coating is performed under heating conditions effective to transfer a coat of non-wetting material.

5. The method of claim 1, wherein the first surface is formed by spraying a composition comprising the non-wetting material onto a face of a first transfer block.

6. The method of claim 1, wherein the transfer surface comprises a resilient conformable material.
7. The method of claim 1, wherein the orifice plate is sized and configured to act as the orifice plate for an ink jet print head.
8. The method of claim 7, wherein the at least one orifice is less than 0.024 inches in diameter.
9. The method of claim 1, wherein the non-wetting material is non-wetting to aqueous materials.
10. The method of claim 1, wherein the non-wetting material comprises PTFE.
11. The method of claim 1, wherein the non-wetting material at the first surface of non-wetting material is a Teflon lubricant substantially free of resins.
12. The method of claim 3, wherein the heating is to over 400°F.
13. The method of claim 3, wherein the heating is in the range of 500°F to 650°F.
14. The method of claim 1, wherein the transfer surface has a shape corresponding to the shape of the front surface.
15. A method of coating an orifice plate constructed to be used with an ink jet print head comprising:
 - coating a first transfer surface of a first transfer plate with PTFE;
 - pressing said coated first transfer surface against a second transfer surface under an effective amount of heat and pressure to deposit a uniform second layer of PTFE on the second transfer surface and optionally repeating said depositing procedure on additional transfer surfaces;

pressing said deposited layer against the orifice plate of the ink jet print head having orifices with an effective amount of heat and pressure to transfer a coating of PTFE to the surface of the orifice plate, but not into inner surfaces of the plate defining the orifices.

16. The method of claim 15, wherein the surface of the orifice plate is heated to a temperature of over 400°F. when pressed against the deposited layer.

17. A method for coating an orifice plate, comprising:

providing said plate having at least one orifice therethrough, and having a front surface;

providing a first surface comprising a PTFE lubricant substantially free of resins;

pressing the first surface against the front surface of the plate while heating the first surface and front surface to a temperature in the range of 500°F. to 650°F. to coat the plate substantially up to the edge of the at least one orifice, but not onto the portion of the plate defining the at least one orifice, with a coating of the PTFE lubricant.

18. The method of claim 17, wherein such transfer is to a plate having a plurality of orifices spaced at 72-140 orifices per inch, and having a diameter of less than 0.024 inches.

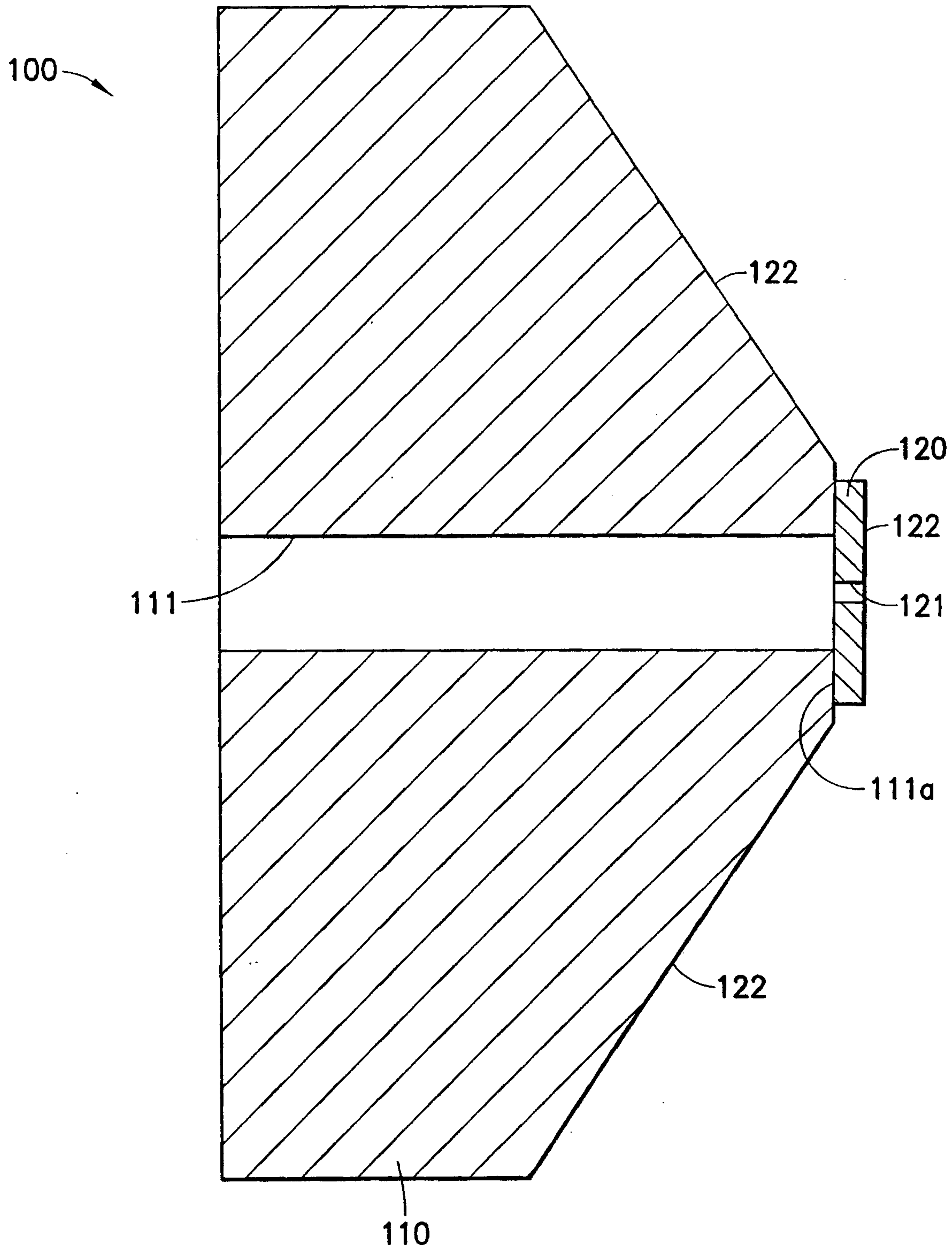


FIG. 1

Fenlayson & Singlehurst
PATENT AGENTS

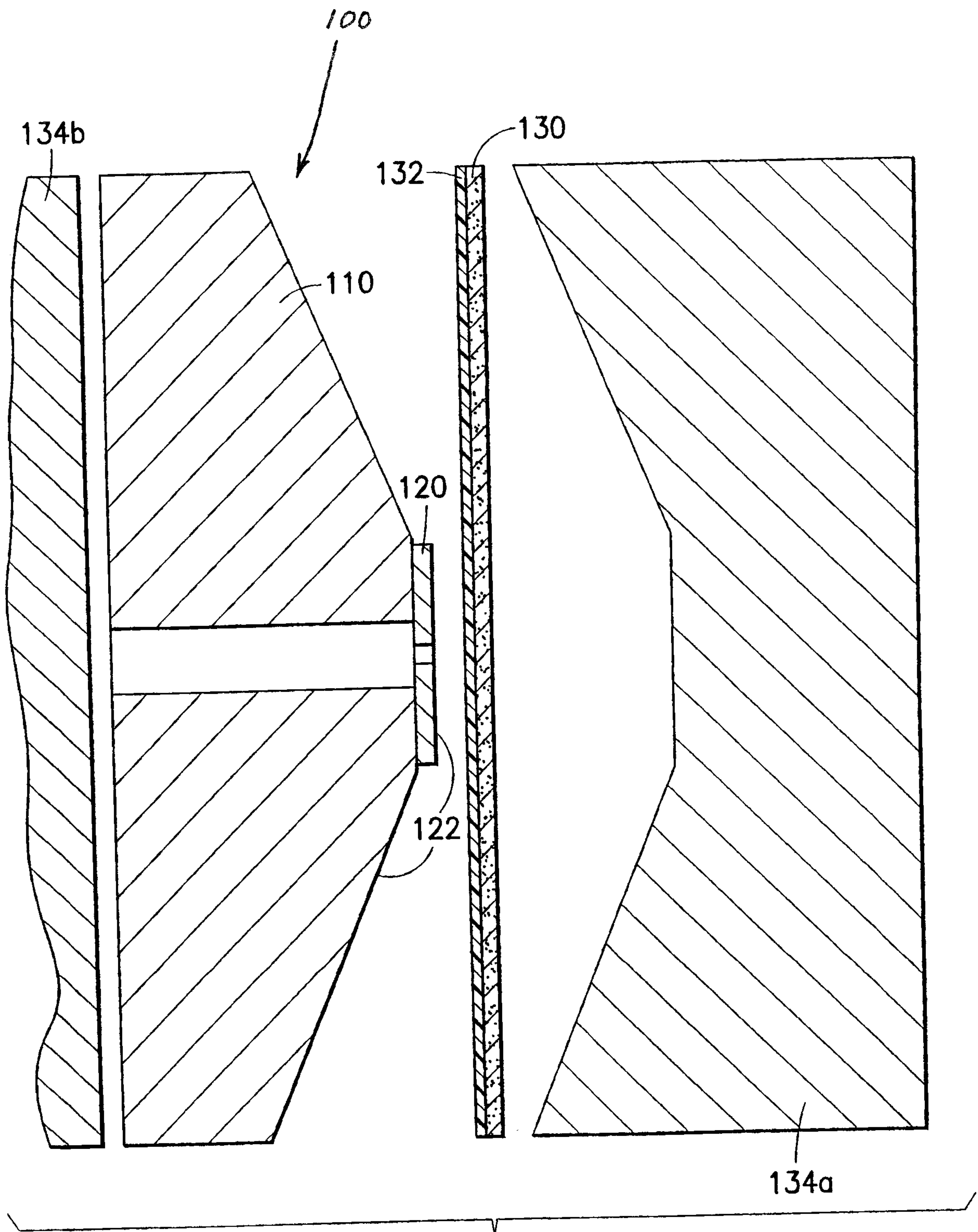


FIG. 2

Finlayson & Co., P.C.
PATENT AGENTS

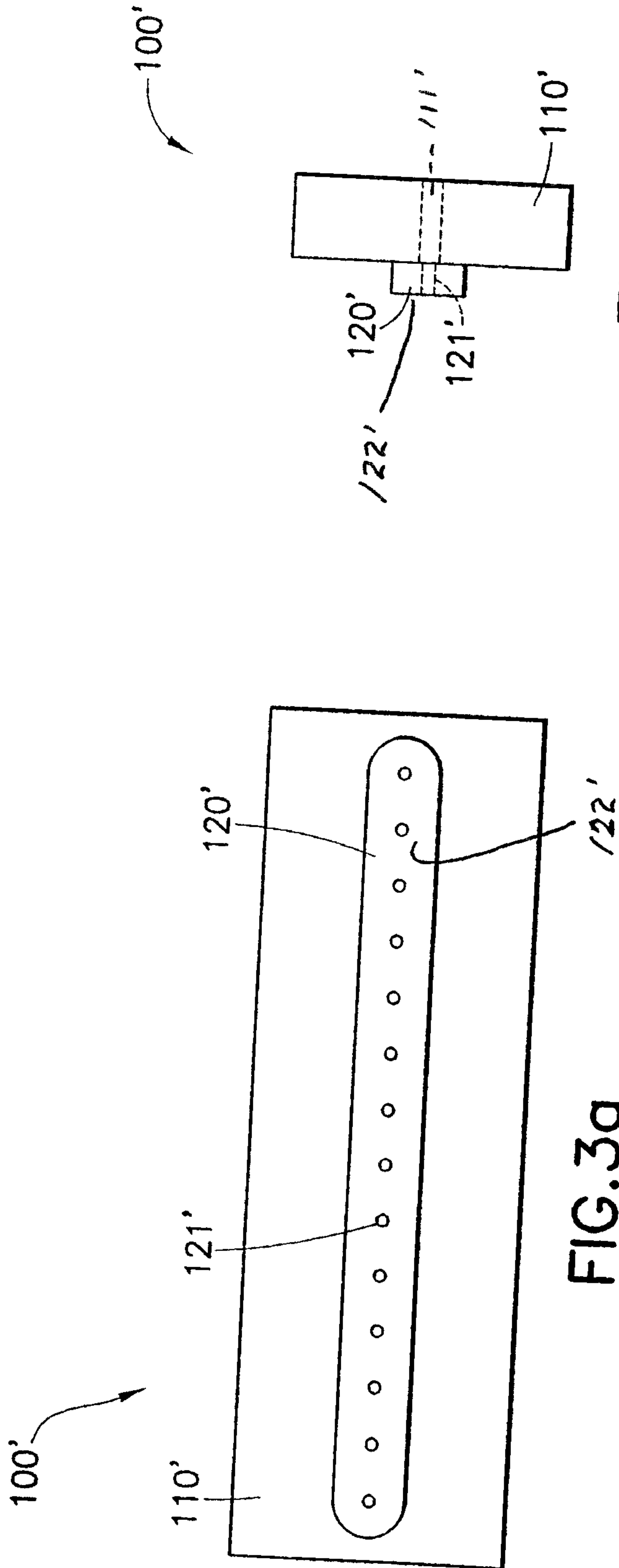


FIG. 3b

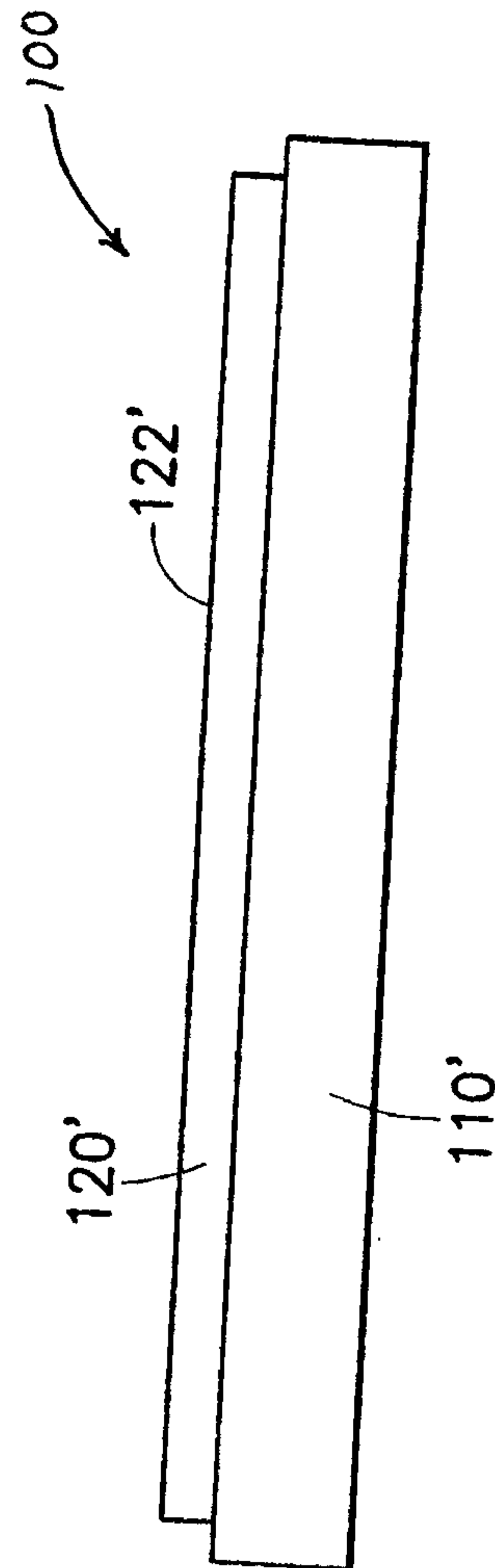


FIG. 3c

Dislayer & Singlet

PATENT AGENTS

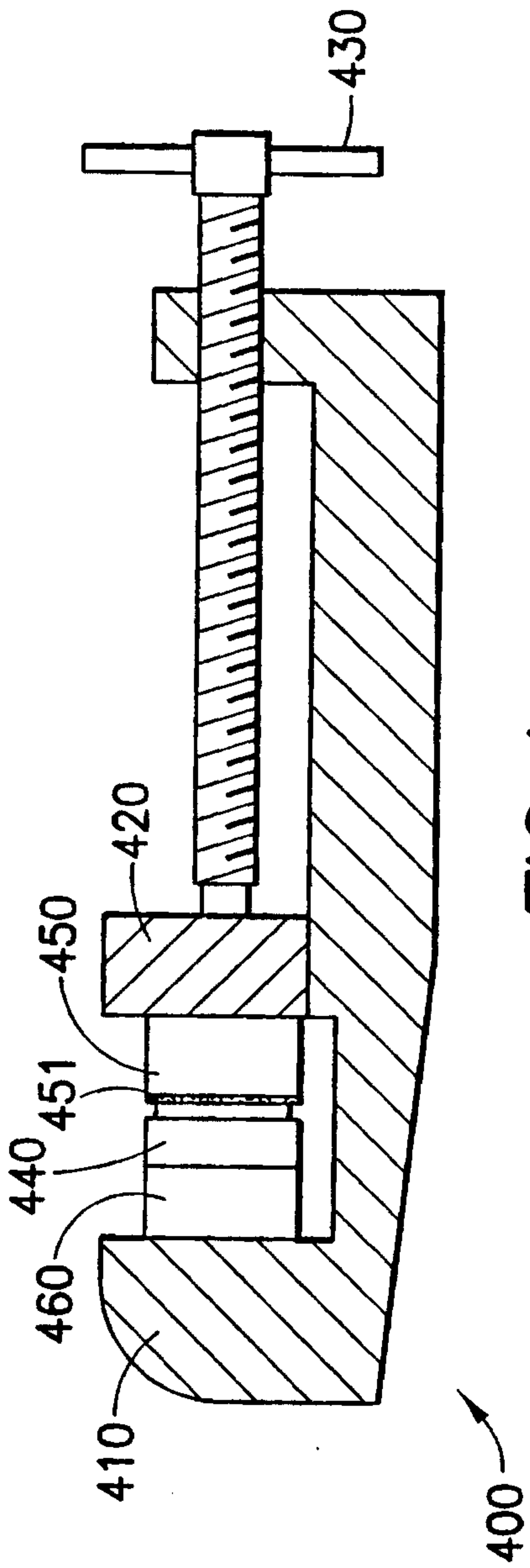


FIG. 4

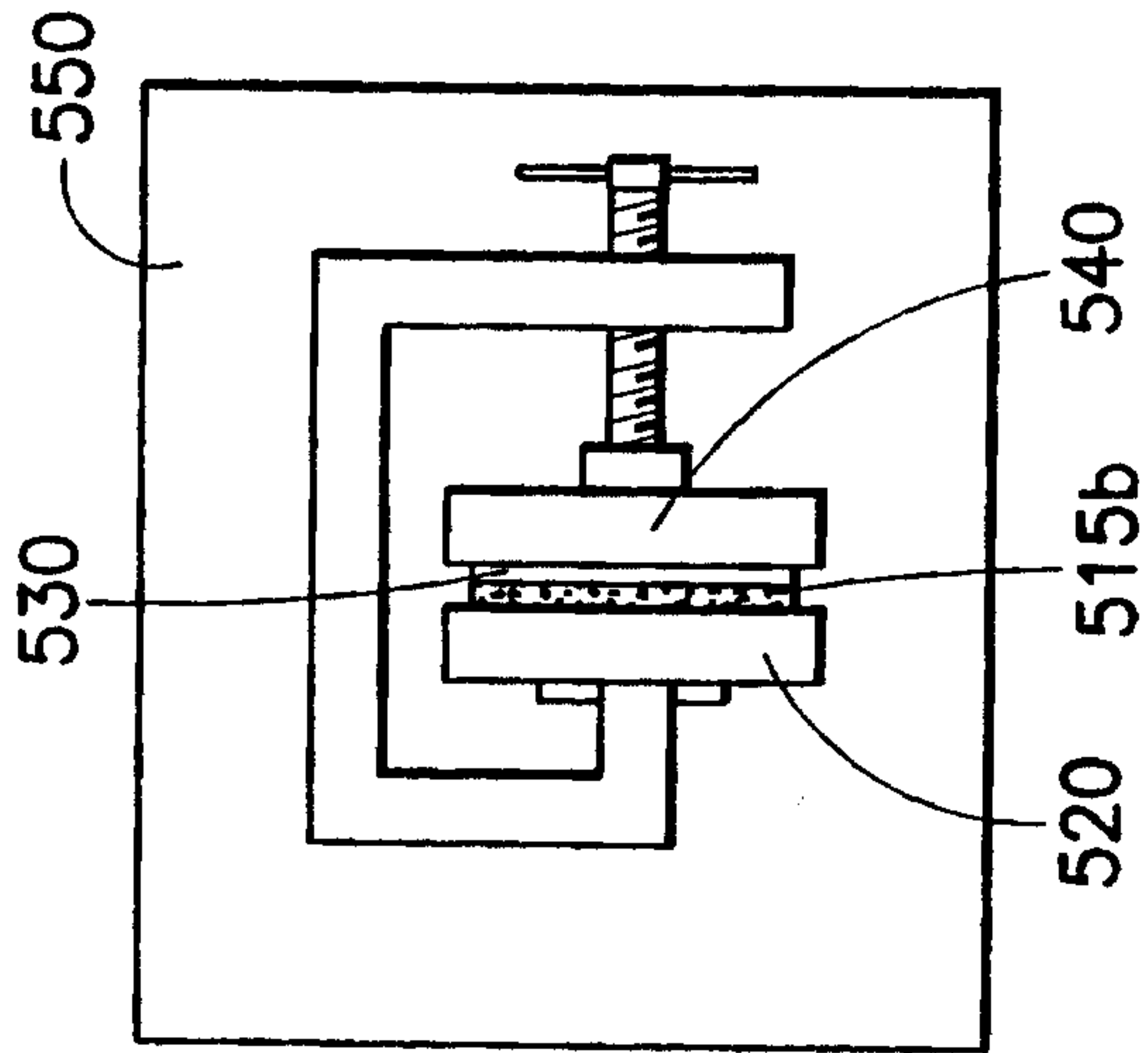


FIG. 5c

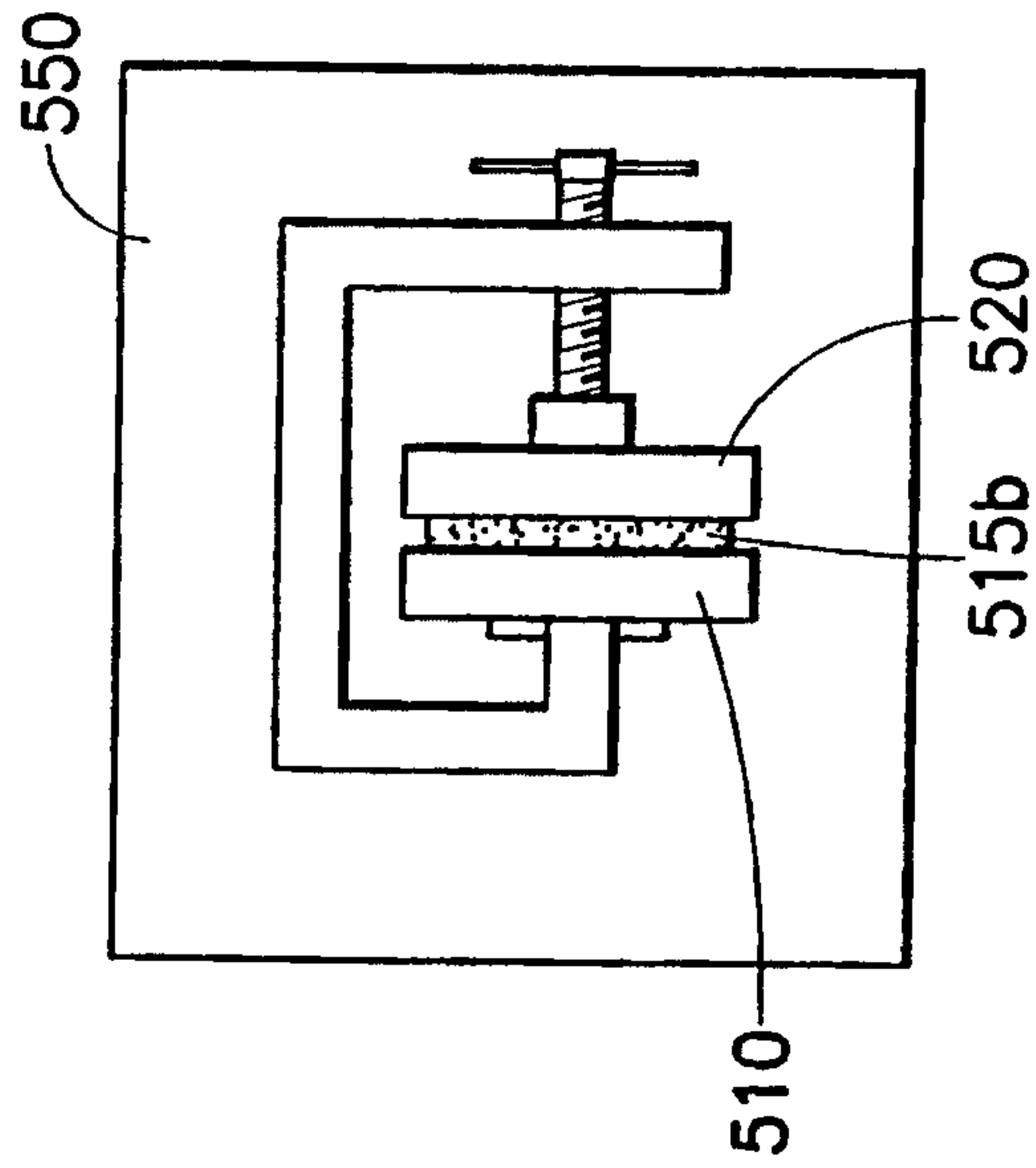


FIG. 5b

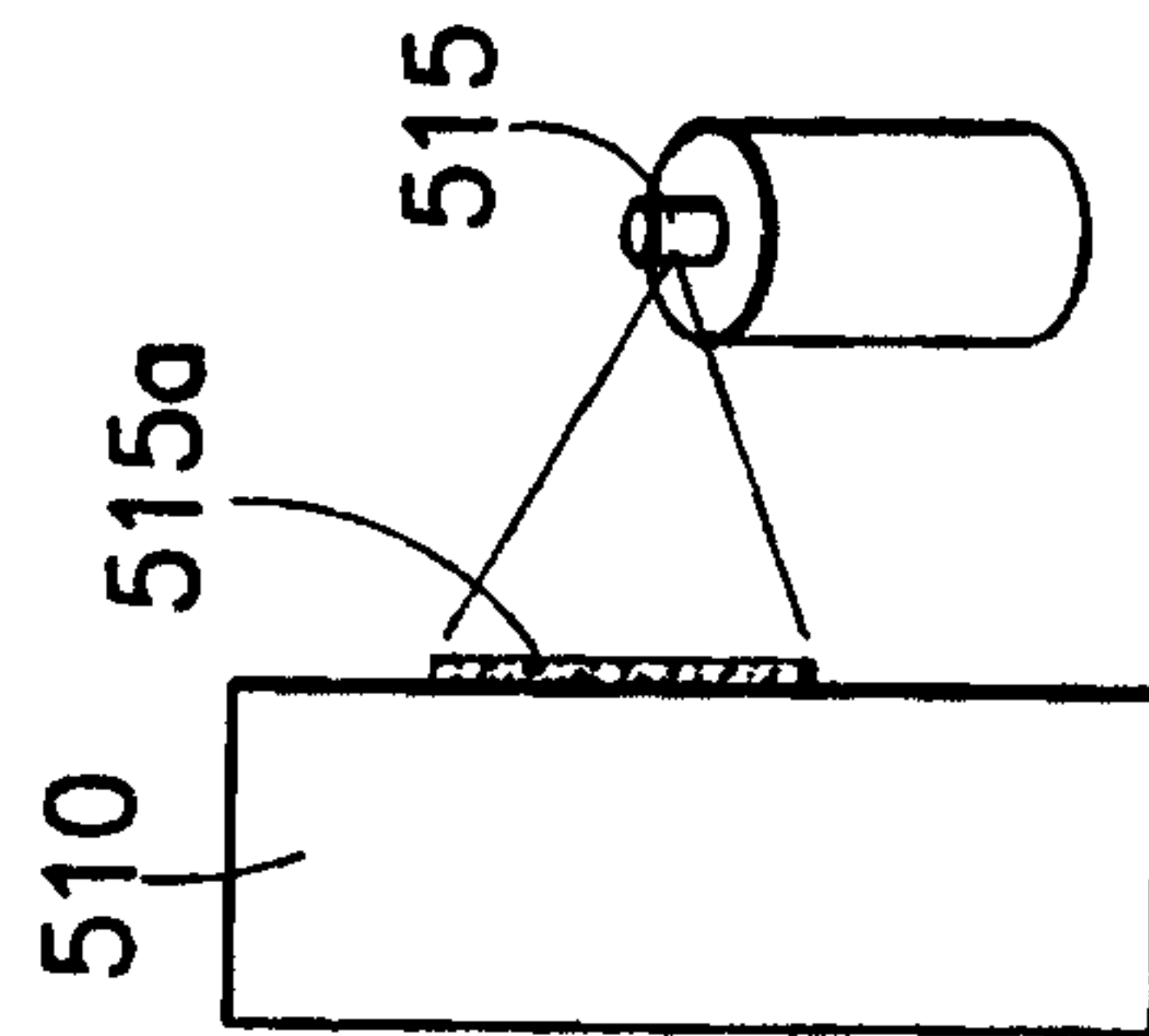


FIG. 5a

