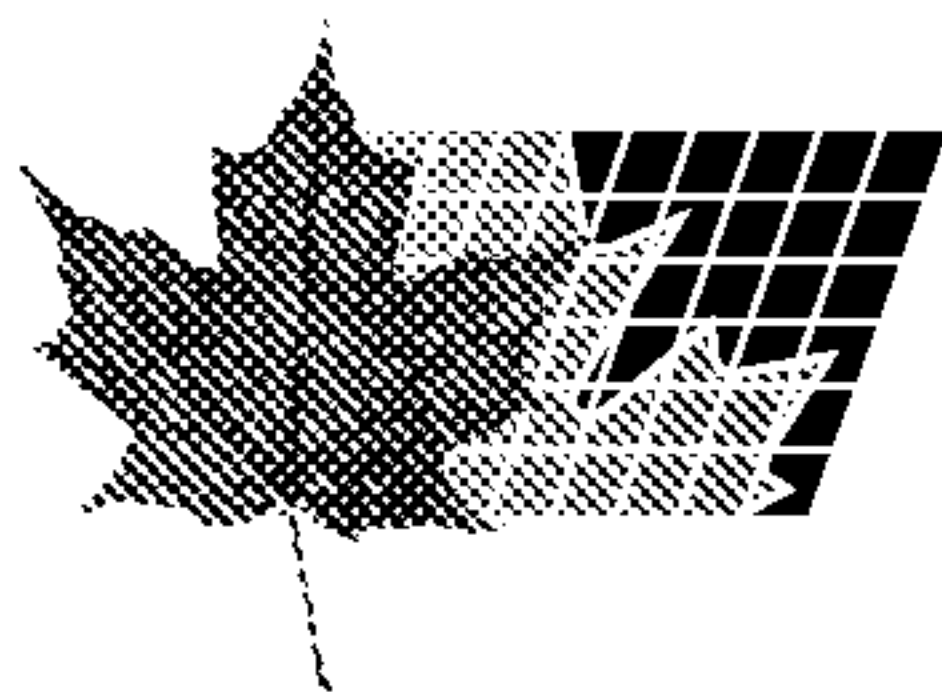




(11) (21) (C) **2,100,201**
(22) 1993/07/09
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(45) 2000/09/19

(72) Tochiara, Shinichi, JP

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(51) Int.Cl.⁵ C09D 11/00, B41J 2/01

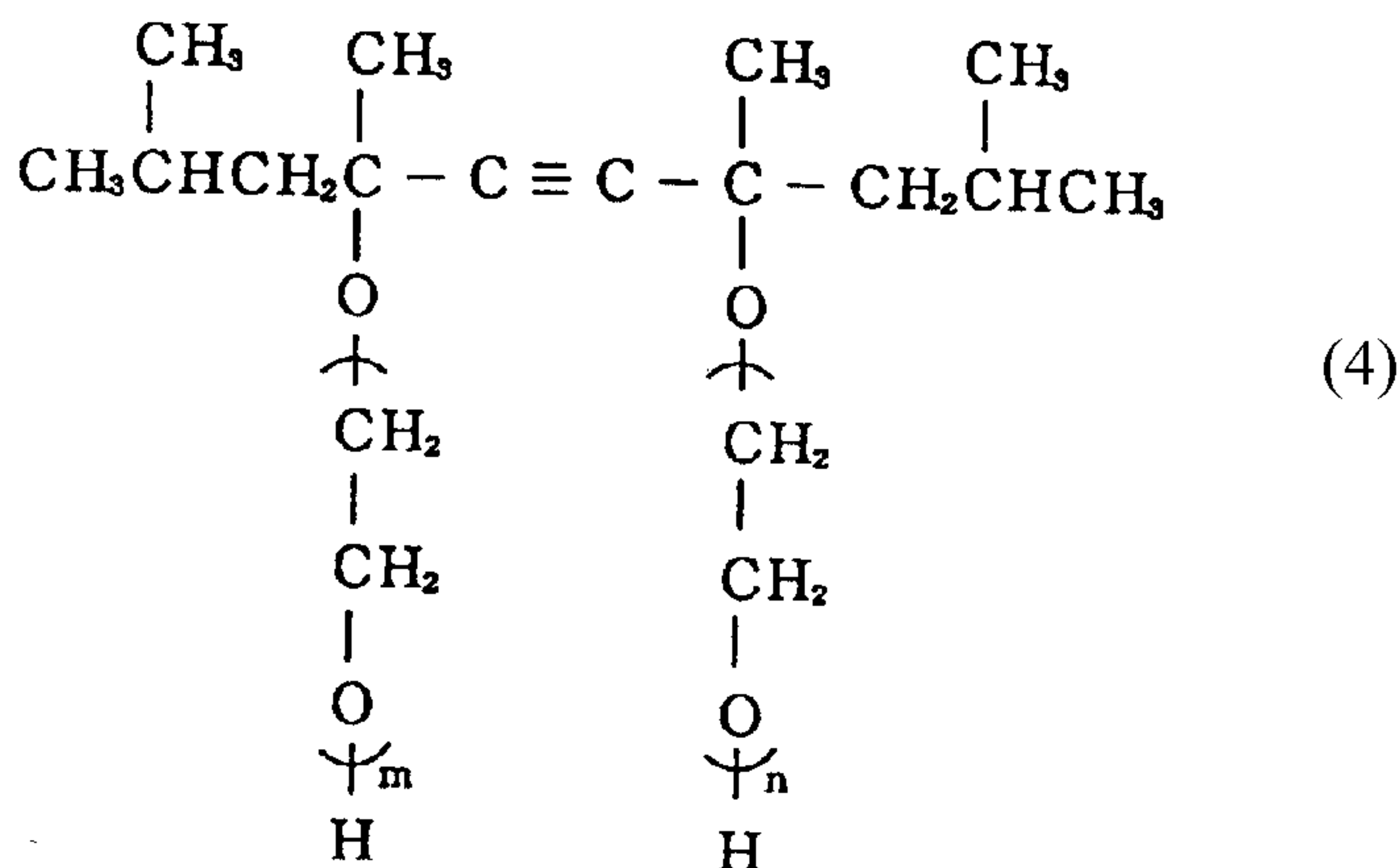
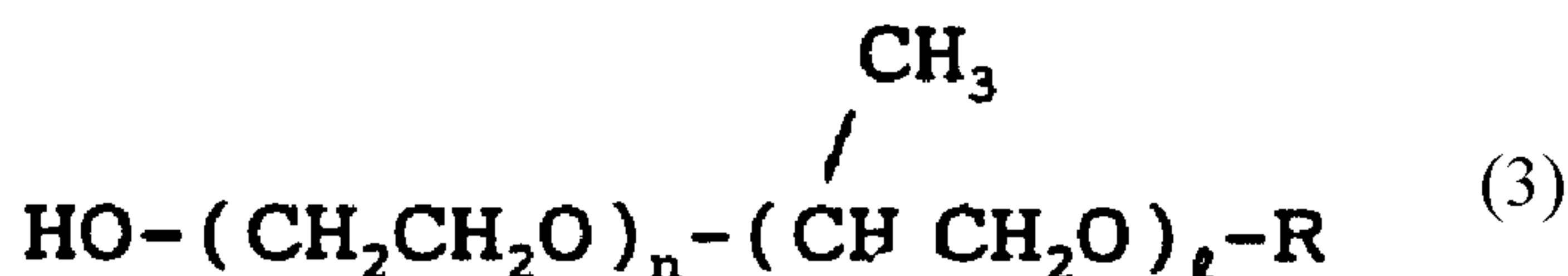
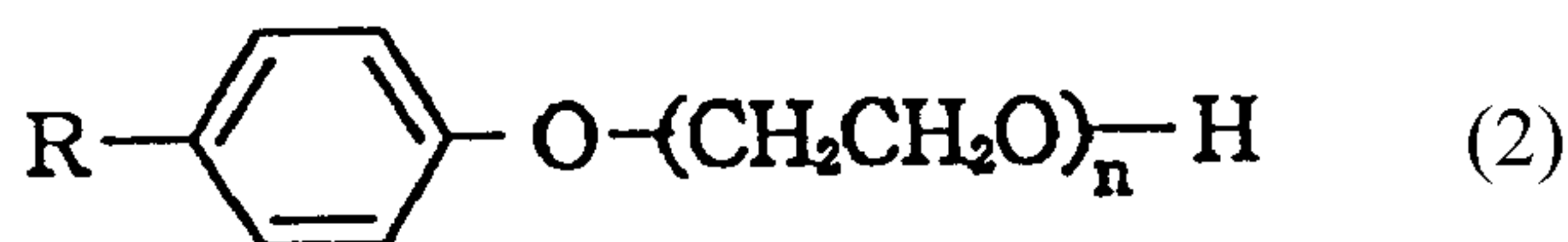
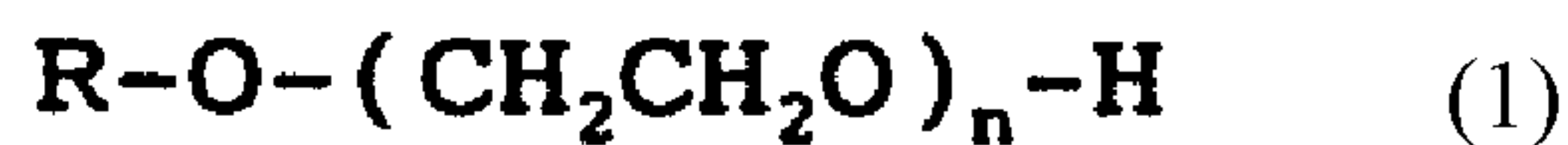
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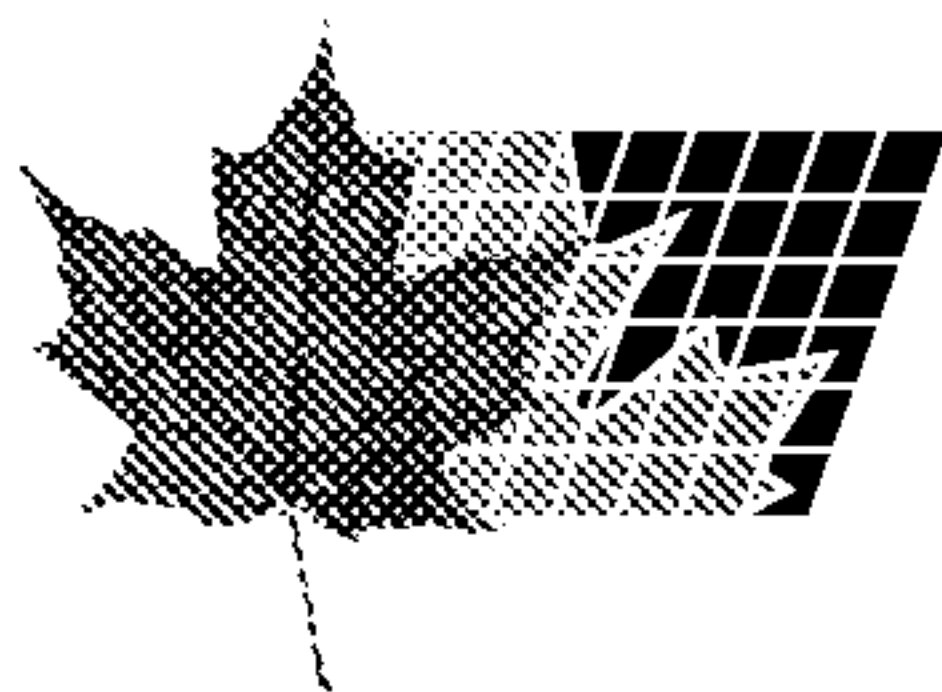
(30) 1992/07/10 (4-183993) JP

(30) 1993/03/17 (5-081164) JP

(54) **ENCRE, METHODE D'INSCRIPTION PAR JET D'ENCRE ET
APPAREIL D'INSCRIPTION PAR JET D'ENCRE**

(54) **INK, INK-JET RECORDING METHOD, AND INK-JET
RECORDING APPARATUS**





(11) (21) (C) **2,100,201**
(22) 1993/07/09
(43) 1994/01/11
(45) 2000/09/19

(57) Provided is an ink for ink-jet recording, comprising a dye, water, and the components (a), (b), and (c) below: (a) at least one surfactant selected from the group consisting of higher alcohol-ethylene oxide adducts represented by General Formula [1], alkylphenol-ethylene oxide adducts represented by General Formula [2], ethylene oxide-propylene oxide copolymers represented by General Formula [3], and acetylene glycol-ethylene oxide adducts represented by General Formula [4], at a content of from 0.1 to 20 % by weight; (see formula 1) where R is alkyl, and n is an integer; (see formula 2) where R is alkyl, and n is an integer; (see formula 3) where R is alkyl or hydrogen, and n and ℓ are respectively an integer; (see formula 4) where m and n are respectively an integer; (b) thiodiglycol; and (c) urea or an derivative thereof.

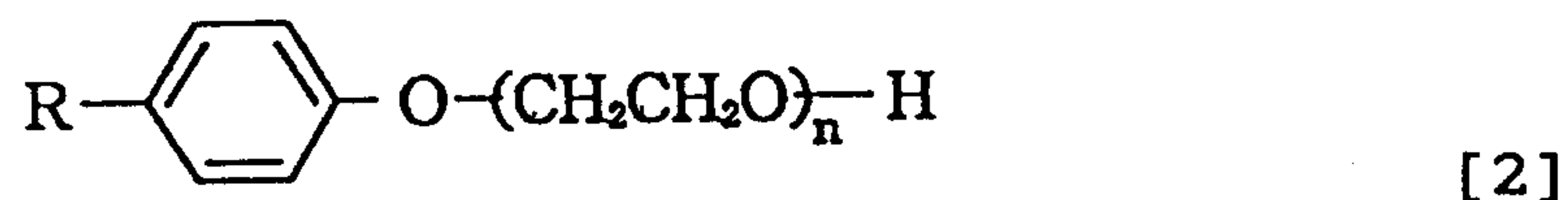
ABSTRACT OF THE DISCLOSURE

Provided is an ink for ink-jet recording, comprising a dye, water, and the components (a), (b), and (c) below:

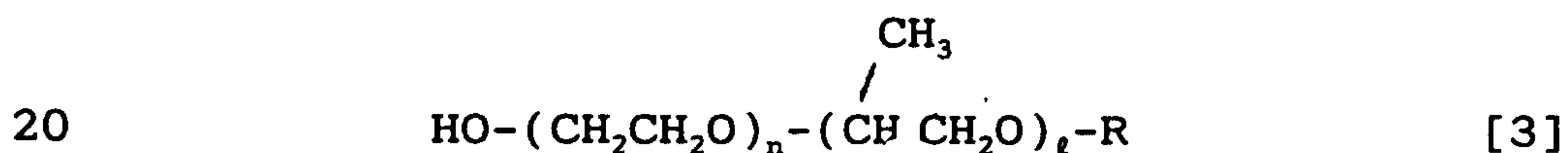
- 5 (a) at least one surfactant selected from the group consisting of higher alcohol-ethylene oxide adducts represented by General Formula [1], alkylphenol-ethylene oxide adducts represented by General Formula [2], ethylene oxide-propylene oxide copolymers
10 represented by General Formula [3], and acetylene glycol-ethylene oxide adducts represented by General Formula [4], at a content of from 0.1 to 20 % by weight;



- 15 where R is alkyl, and n is an integer;



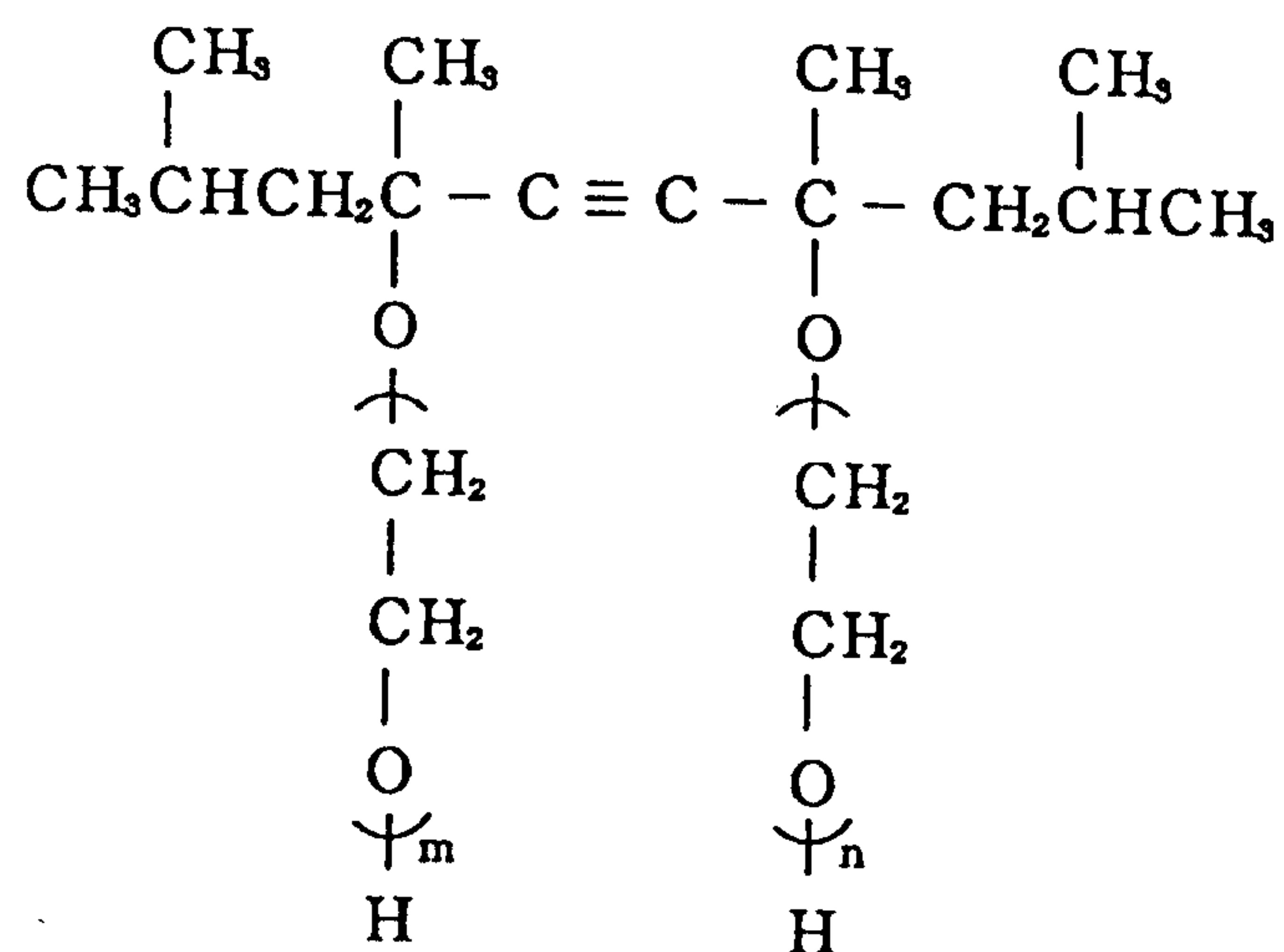
where R is alkyl, and n is an integer;



where R is alkyl or hydrogen, and n and l are respectively an integer;

2100201

5



[4]

10

where m and n are respectively an integer;

(b) thiodiglycol; and

(c) urea or an derivative thereof.

INK, INK-JET RECORDING METHOD, AND
INK-JET RECORDING APPARATUS

BACKGROUND OF THE INVENTION

5 Field of the invention

The present invention relates to an ink which provides excellent color recording on plain paper such as wood-free paper, medium-quality paper, bond paper, and paper for copying. The present invention also
10 relates to an ink-jet recording method, and an ink-jet recording apparatus employing the above ink.

Related Background Art

Personal computers including desk-top types, lap-top types, and book types have come to employ a
15 color display unit in recent years. Software is also directing to color representation. Consequently, printers are changing from monicolor types to color types.

Among recording methods employed by such
20 printers, ink-jet recording is attracting attention. In the ink-jet recording, ink droplets are ejected and are attached to a recording medium such as paper sheets, converted paper sheets, plastic films, and cloths without contact of a recording head with the
25 recording medium. The ink-jet recording method is advantageous in that noise is not produced because of non-contact of the recording head with the recording

medium, and high speed printing and color recording is practicable.

In the ink-jet recording method, it is required that (1) ink does not cause running of ink at the
5 recorded portion on the recording medium, (2) ink is sufficiently stable during storage, and (3) the safety is high. In color ink-jet recording, it is further required that (4) mixing (or bleeding) of different colors of inks caused by unfixed ink droplets does not
10 occur on contact of different color inks on a recording medium, (5) a solid color portion is uniform in color, and (6) failure of ink ejection does not occur after interruption of ink ejection (first-ejection difficulty), since limited colors of inks are more
15 frequently used in color printing unlike monicolor printing.

However, conventional inks per se are not usable as inks for color recording because they cause serious bleeding and do not give high-quality images.
20 Presumably, the bleeding is caused by the fact that the ink is dotted before the previously dotted different color of ink has been sufficiently fixed. Coat paper, which has high ink-absorbing ability, is used for color recording in order to prevent the bleeding. Further,
25 for printing on plain paper such as paper for copying and bond paper, a printing method reflecting upon the fixing time of ink is proposed in which ink is dotted

after the previously dotted ink droplet has been fixed.
In such a printing method, speed of paper feed have to
be slowed down disadvantageously, thereby the printing
time becomes longer irrespectively of the ink-dotting
5 method. Therefore, high speed printing which is
characteristic of ink-jet recording cannot be practised
with such a printing method.

To shorten the fixing time, Japanese Patent
Application Laid-Open No. 55-29546 discloses a method
10 in which a surfactant is incorporated into ink in a
larger amount than usual and thereby the ink seems to
become dry instantaneously owing to the increased
penetration power of ink afforded by the surfactant.
However, the simple addition of a surfactant in a
15 larger amount as above cannot prevent mixing of
different colors of inks at the border of colors even
though it improves the ink fixation. Moreover, it
augments penetration of ink toward the back face of the
paper, which lowers color density on the paper face, or
20 causes nonuniform dyeing of a fiber layer on the paper
surface, resulting in irregularity of color density in
solid printing area and deterioration of image quality.

Furthermore, feathering and ink fixation on a
plain paper are improved by use of strongly alkaline
25 ink (see Japanese Patent Application Laid-Open No. 56-
57862, etc.), or by use of a specific kind of ink (see
Japanese Patent Application Laid-Open No. 56-5871,

etc.). These inks, however, do not always prevent bleeding satisfactorily, and even in the case where the bleeding is relatively slight, the feathering is conspicuous (not satisfying the aforementioned requirement (1) of the prior art) or ejection failure is liable to occur (not satisfying the aforementioned requirement (6) of the prior art). As above, no color ink has been obtained which satisfies all the above requirements and gives high quality of an image with high speed on plain paper.

SUMMARY OF THE INVENTION

The present invention intends to provide an ink for ink-jet recording which is capable of forming a color image of high quality at high and uniform color density on a usual recording medium such as plain paper without feathering or ink-bleeding, and especially without mixing of different colors of inks at the color border.

The present invention also intends to provide an ink-jet recording method, and an ink-jet recording apparatus employing the above ink.

According to a first aspect of the present invention, there is provided an ink for ink-jet recording which contains a dye and water, and further comprises the components (a), (b), and (c) below:
(a) at least one surfactant selected from the group consisting of higher alcohol-ethylene oxide adducts

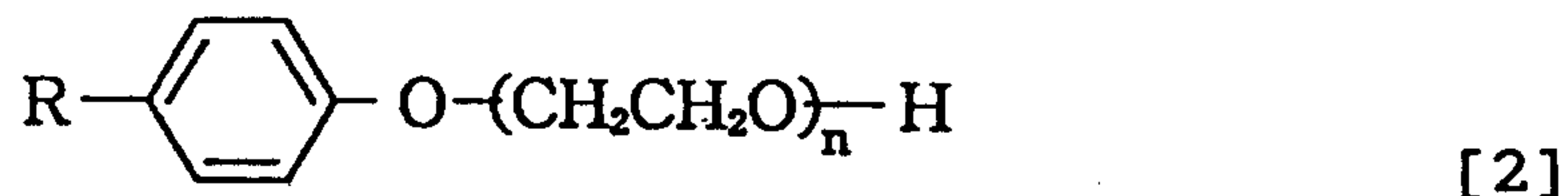
- 5 -

represented by General Formula [1], alkylphenol-
ethylene oxide adducts represented by General Formula
[2], ethylene oxide-propylene oxide copolymers
represented by General Formula [3], and acetylene
5 glycol-ethylene oxide adducts represented by General
Formula [4], at a content of from 0.1 to 20 % by weight
based on the total weight of the ink;



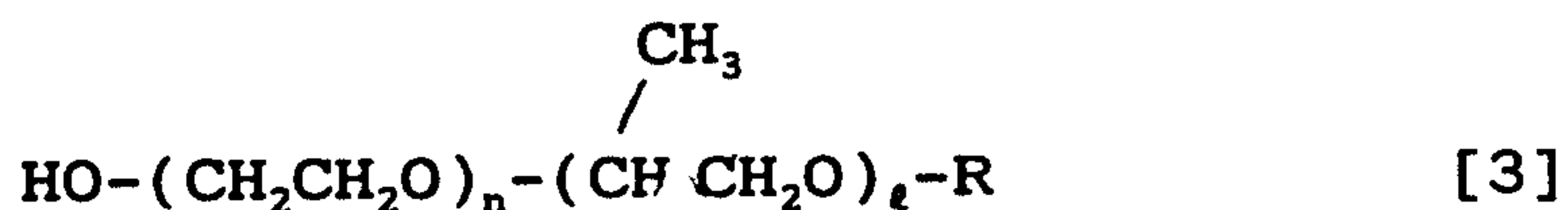
where R is alkyl, and n is an integer;

10



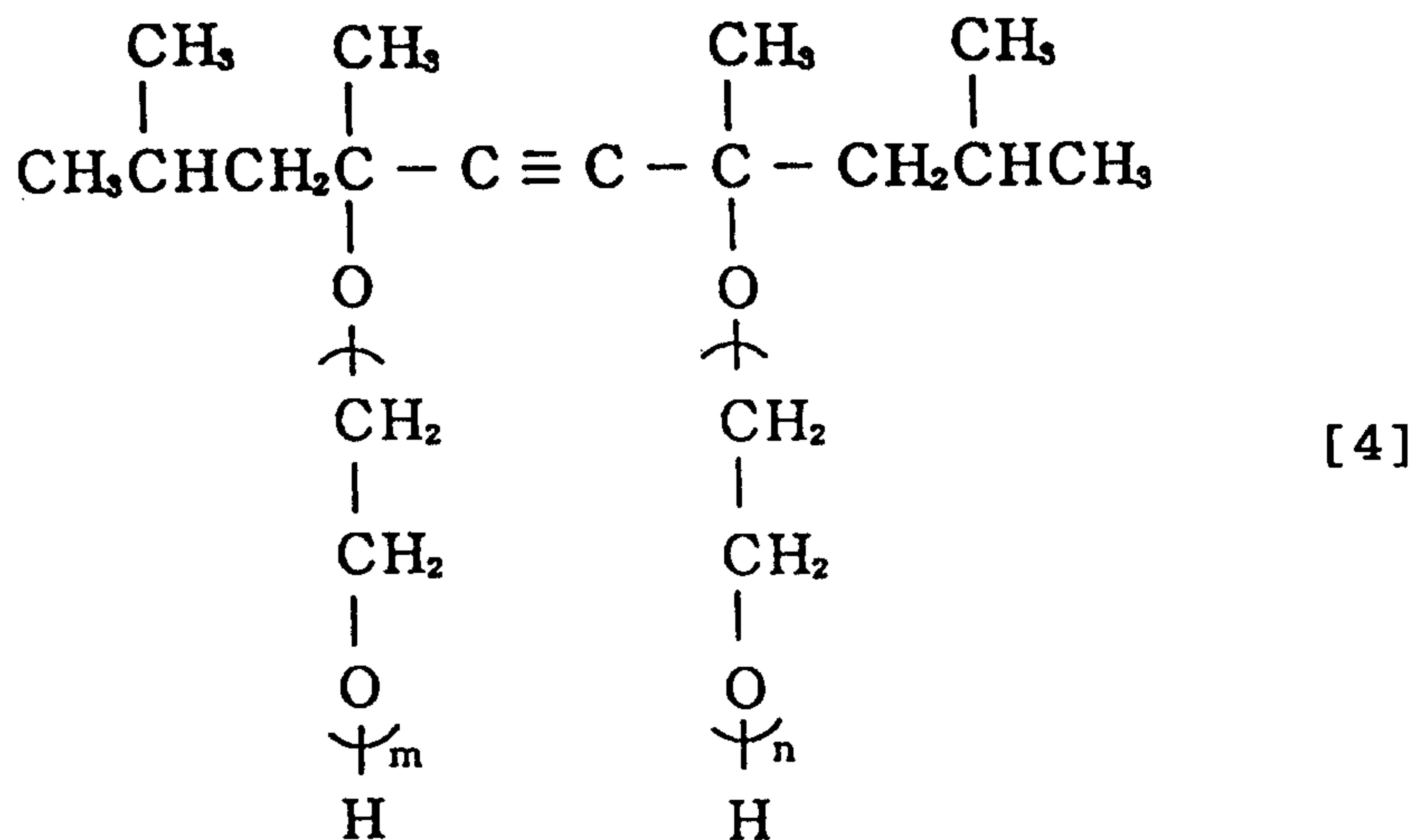
where R is alkyl, and n is an integer;

15



where R is alkyl or hydrogen, and n and l are
respectively an integer;

20



25

where m and n are respectively an integer;

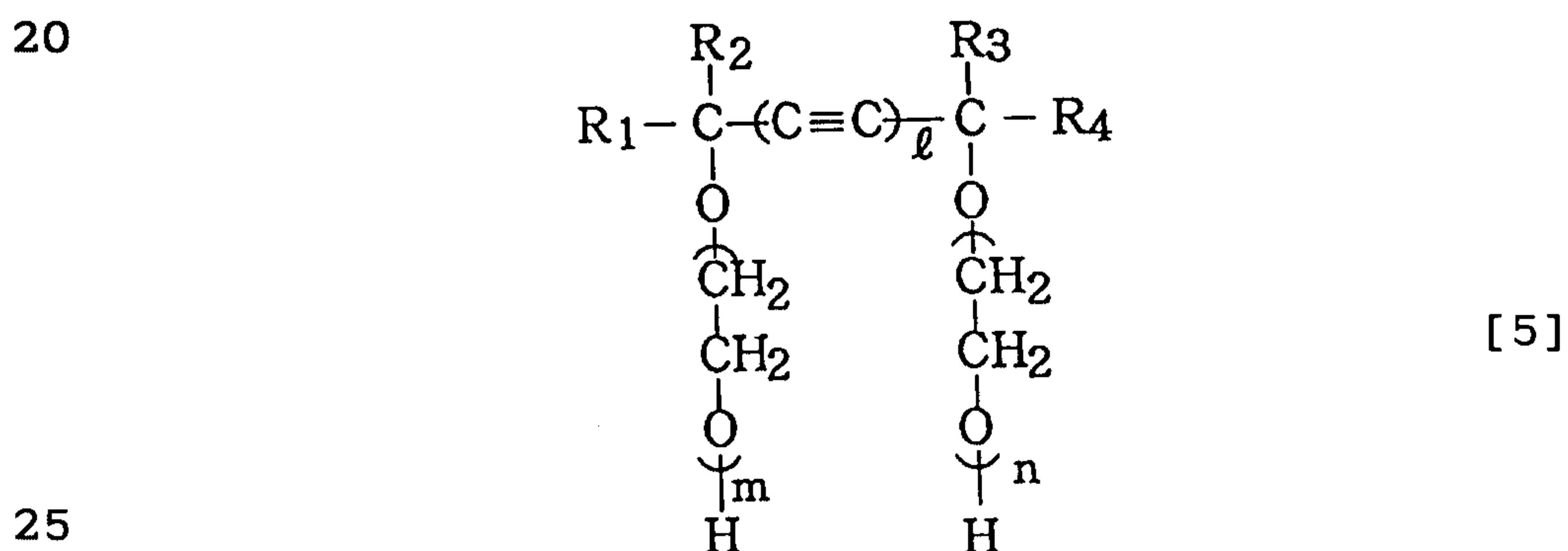
(b) thiodiglycol; and

(c) urea or an derivative thereof.

According to a second aspect of the present invention, there is provided an ink-jet recording method which conducts recording on a recording medium with droplets of ink, which comprises dye, water, and the aforementioned components (a), (b), and (c).

According to a third aspect another aspect of the present invention, there is provided a color ink-jet recording method which conducts recording by ejecting droplets of inks of two or more colors to adjacent or superposed positions on a recording medium, using the ink comprising a dye, water and the aforementioned components (a), (b), and (c).

According to a fourth aspect of the present invention, there is provided an ink which comprises a dye, a water-soluble organic solvent, water, and a compound of the formula;



where R_1 , R_2 , R_3 , and R_4 are respectively hydrogen, an

-7-

alkyl or alkenyl group of 1 to 4 carbon atoms, or a substituted or unsubstituted phenyl group at a content of from 0.1 to 20% by weight based on the total weight of the ink; and $m+n$ is ranging from 0 to 50; and ℓ is a
5 number of 2 or more.

According to a fifth aspect of the present invention, there is provided an ink-jet recording method which conducts recording with droplets of ink on a recording medium, using the ink comprising a dye, water-
10 soluble organic solvent, water, and a compound represented by General Formula [5] above.

According to a sixth aspect of the present invention, there is provided a color ink-jet recording method which conducts recording by ejecting droplets of
15 ink of two or more colors to adjacent or superposed positions on a recording medium, using the ink comprising a dye, water and the aforementioned compound represented by General Formula [5] above.

According to a seventh aspect of the present invention, there is provided a recording unit comprising
20 an ink container portion for holding ink and a head for ejecting the ink as ink droplets, in which the ink is the one specified in the above first or fourth aspect of the present invention.

25 According to a eighth aspect of the present invention, there is provided an ink cartridge comprising an ink container portion for holding ink, in which the ink is the one specified in the above first or fourth aspect of the present invention.

-8-

According to ninth aspect of the present invention, there is provided an ink-jet recording apparatus comprising the recording unit of the seventh aspect of the present invention, wherein the ink of the above first
5 or fourth aspect of the present invention is employed.

According to a tenth aspect of the present invention, there is provided a ink-jet recording apparatus, comprising an ink cartridge of the eighth aspect of the present invention, and a recording head.

10 According to an eleventh aspect of the present invention, there is provided a color ink-jet recording method in which droplets of two or more color inks are ejected in accordance of pulse signal to adjacent or superposed positions on a recording medium, and in which
15 the ink comprises a nonionic surfactant in an amount of from 1.0 to 20.0 % by weight based on the total weight of the ink, the ink ejected for one pulse is in an amount of from 10 to 70 p , and the feathering rate (A) defined by Equation [I] is in the range of from 2.5 to 3.5:

20
$$A = B/C \quad [I]$$

where B is a diameter (μm) of a dot formed on plain paper, and C is a diameter (μm) of the ejected ink droplet.

According to a twelfth aspect of the present
25 invention, there is provided color ink-jet recording apparatus which conducts recording by ejecting droplets

of two or more color inks onto adjacent or superposed positions on a recording medium, said apparatus comprises a recording means for conducting recording mode, by use of an ink containing a nonionic surfactant in an amount of from 1.0 to 20.0 % by weight, by
5 ejecting the ink for one pulse in an amount of from 10 to 70 pℓ to form ink dots at the feathering rate (A) defined by Equation [I] is in the range of from 2.5 to 3.5:

10
$$A = B/C \quad [I]$$

where B is a diameter (μm) of a dot formed on plain paper, and C is a diameter (μm) of the ejected ink droplet.

BRIEF DESCRIPTION OF THE DRAWINGS

15 Fig. 1 shows an example of the pattern of dotting of different color inks.

Fig. 2 shows another example of the pattern of dotting of different color inks.

20 Fig. 3 is a longitudinal cross-sectional view of a head portion of an ink-jet recording apparatus of the present invention.

Fig. 4 is a transverse cross-sectional view of a head portion of an ink-jet recording apparatus of the present invention.

25 Fig. 5 is a perspective view of a head portion of an ink-jet recording apparatus of the present invention.

Fig. 6 is a perspective view of an ink-jet recording apparatus of the present invention.

Fig. 7 is a longitudinal sectional view of an ink cartridge of the present invention.

5 Fig. 8 is a perspective view of a recording unit of the present invention.

Fig. 9 is a perspective view of a recording portion in which a plurality of recording heads are arranged and which was used in an example of the
10 present invention.

Fig. 10 is a perspective view of another recording head used in the present invention.

DESCRIPTION OF THE PREFERRED EMBODIMENT

The inventors of the present invention have
15 studied comprehensively a method of color image formation which does not causes bleeding of ink and gives a uniform color image without irregularity of colors. As the result, it has been found as a first invention that an ink containing the components (a),
20 (b), and (c) below is extremely effective:
(a) at least one surfactant selected from the group consisting of higher alcohol-ethylene oxide adducts represented by General Formula [1], alkylphenol-ethylene oxide adducts represented by General Formula
25 [2], ethylene oxide-propylene oxide copolymers represented by General Formula [3], and acetylene glycol-ethylene oxide adducts represented by General

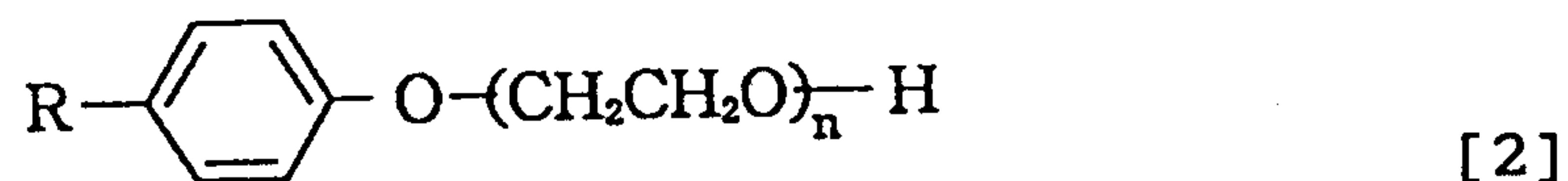
- 11 -

Formula [4], at a content of from 0.1 to 20 % by weight;

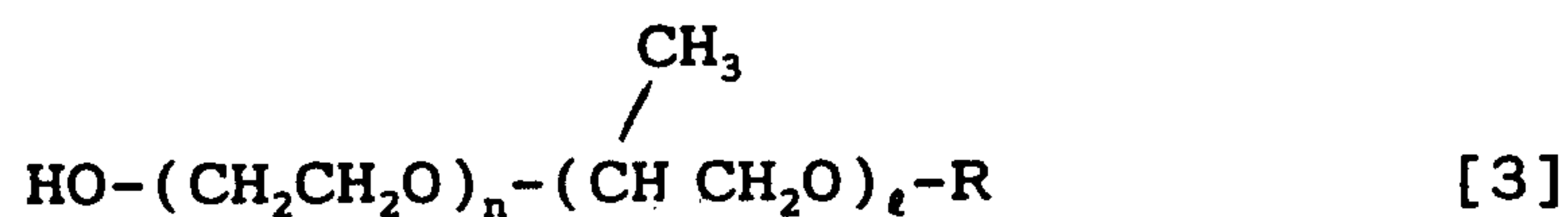


where R is alkyl, and n is an integer;

5



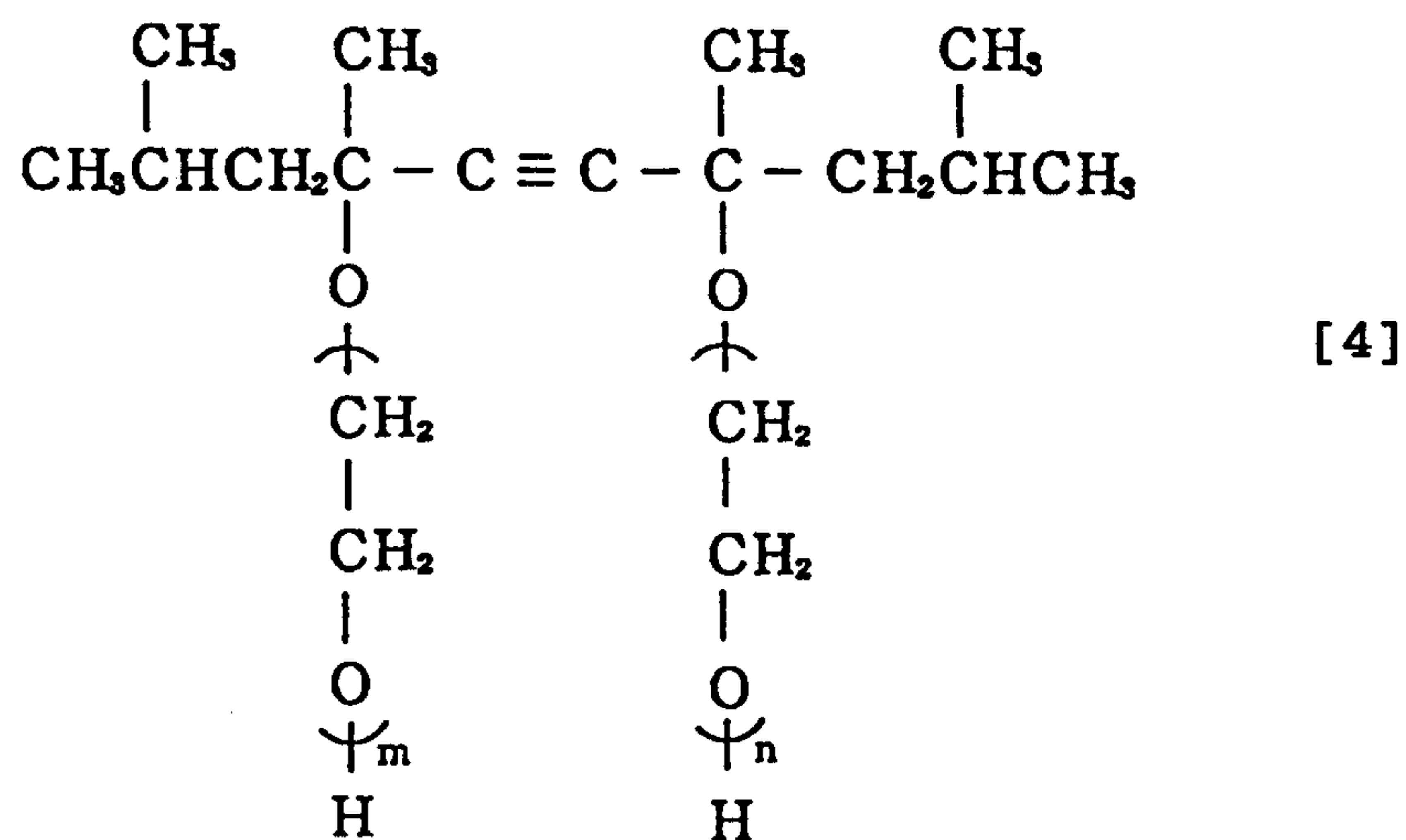
where R is alkyl, and n is an integer;



10

where R is alkyl or hydrogen, and n and l are respectively an integer;

15



20

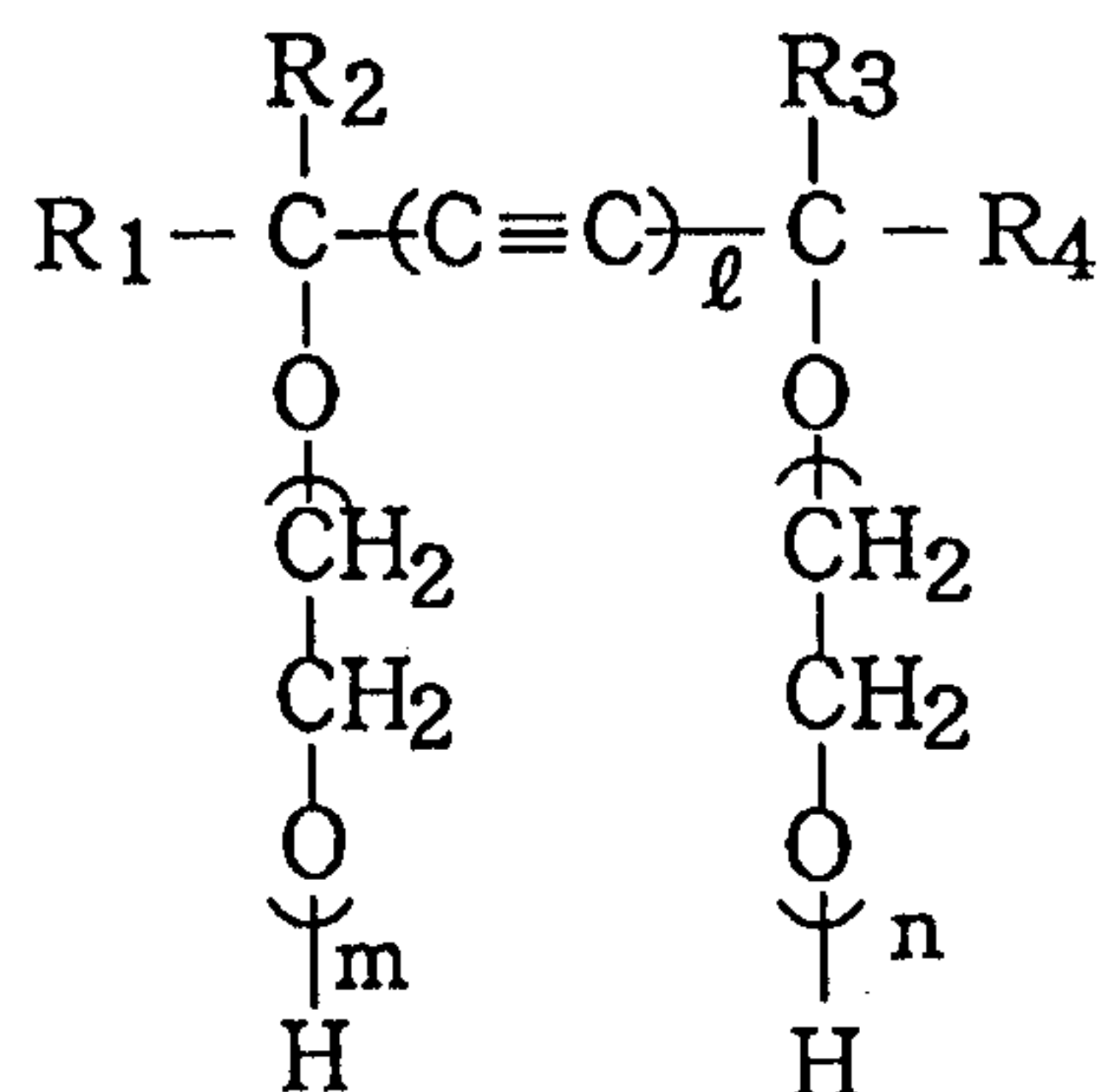
where m and n are respectively an integer;

(b) thiodiglycol; and

(c) urea or an derivative thereof.

25

As the further result of the study, it has been found as a second invention that an ink comprising the compound represented by General Formula (5) below is extremely effective:



[5]

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where R_1 , R_2 , R_3 , and R_4 are respectively hydrogen, an alkyl or alkenyl group of 1 to 4 carbon atoms, or a substituted or unsubstituted phenyl group; and $m+n$ is ranging from 0 to 50; and ℓ is a number of 2 or more.

The inks of the first invention and the second invention are effective for formation of uniform images without bleeding or color irregularity presumably from the reasons below.

The most important factor which affects prevention of ink bleeding and uniformity of color of recorded images is considered to be the wettability of a recording medium by the ink, or a wetting power of the ink on the recording medium. Among the recording media, plain paper especially has fibers exposed on the recording surface, and the fiber density on the surface is not uniform. At the portion where the fiber density is high, the ink fixation is slow, whereby ink bleeds or color of an image becomes irregular. The ink which has a sufficient wetting power is considered to be fixed uniformly irrespectively of the paper fiber

density, and to be free from bleeding and color
irregularity. Further, the ink which has excellent
wetting power is considered to form precisely circular
dots with uniformity of color, thereby providing images
5 of higher quality.

The first invention of the present invention
will be described in detail.

The wetting power of the ink relates closely to
the interaction between the ink and the recording
10 material at the interface. Addition of a surfactant
generally decreases the interfacial tension between the
ink and the recording medium, and improves the wetting
power of the ink. In particular, the nonionic
surfactant having ethylene oxide chain as the component
15 (a) of the first invention, when incorporated in the
ink, the hydrophilic ethylene oxide portion of the
surfactant presumably orients toward the recording
medium to give a specific uniform wettability. On the
contrary, an ionic surfactant, which has a hydrophilic
20 portion which has less affinity with the recording
medium than the nonionic surfactant, does not exhibit
such effect.

The ethylene oxide addition type nonionic
surfactant in the present first invention is preferably
25 added in an amount of from 0.1 to 20 %, more preferably
from 0.1 to 5 % by weight based on the weight of the
ink. The wetting power is not sufficient at the amount

of the surfactant of less than 0.1 % by weight, while, addition of the surfactant in an amount exceeding 20 % by weight does not improve more the wetting property and is disadvantageous in production cost and ink
5 reliability.

The addition number of the ethylene oxide unit, the hydrophilic portion, in the ethylene oxide addition type nonionic surfactant in the present first invention is preferably in the range of from 4 to 20, more
10 preferably from 4 to 10 in terms of "n" or "n+m" in consideration of the affinity of the ethylene oxide moiety with the recording medium and orientation thereon. At the value of "n" or "n+m" of less than 4, the solubility of the surfactant is not sufficient to
15 achieve the effect of the present invention, while at the value of more than 20, the excessive ethylene oxide is not necessarily effective and leads to slightly unstable ink ejection.

The medium for the aforementioned ethylene
20 oxide addition type nonionic surfactant is described below.

Generally, the ethylene oxide addition type nonionic surfactant is inconvenient for stabilization of ink ejection because of its relatively high
25 viscosity in consideration of ejection stabilization. Therefore, an additional water-soluble organic solvent is studied to improve the ink ejection without

impairing the effects of the present invention.
Consequently, thiodiglycol has been found to be
satisfactory. The failure of ink ejection is caused
generally by rise of viscosity resulting from
5 vaporization of water at the nozzle. The use of
thiodiglycol is considered to reduce more the rise of
the viscosity than other solvents, thereby improving
the ejection property. However, single use of
thiodiglycol is not sufficiently effective yet for
10 ejection stabilization. After comprehensive study, it
has been found that combined use of thiodiglycol and
urea or a derivative of urea improves greatly the ink
ejection property. Presumably, the interaction between
the thiodiglycol and urea or a urea derivative
15 suppresses the rise of the viscosity specifically, and
the dissolution of a dye is improved. The thiodiglycol
and a urea derivative-thiourea derivative are used
respectively in an amount of from 1 to 30 % by weight.

The amount of water used in the present first
20 invention is preferably in the range of from 50 to 85
%, more preferably from 55 to 75 % by weight. If the
amount of water is less than 50 %, the viscosity of the
ink is relatively high, and the ejection stability
tends to be relatively lower, even when thiodiglycol or
25 urea or derivative thereof is used concurrently. If
the amount of water is more than 85 %, the ethylene
oxide portion, which is the hydrophilic portion of the

ethylene oxide addition type nonionic surfactant, is relatively free, resulting in less orientation thereof and less uniformity.

5 The water-soluble organic solvents constituting the ink of the present first invention include polyalkylene glycols such as polyethylene glycol, and polypropylene glycol; alkylene glycols having 2 to 6 carbon atoms such as ethylene glycol, propylene glycol, butylene glycol, triethylene glycol, hexylene glycol, 10 and diethylene glycol; glycerin; 1,2,6-hexanetriol; lower alkyl ether of polyhydric alcohols such as ethylene glycol methyl ether, diethylene glycol methyl (or ethyl) ether, and triethylene glycol monomethyl (or ethyl) ether; alcohols such as methyl alcohol, ethyl 15 alcohol, n-propyl alcohol, isopropyl alcohol, n-butyl alcohol, sec-butyl alcohol, t-butyl alcohol, isobutyl alcohol, benzyl alcohol, and cyclohexanol; amides such as dimethylformamide, and dimethylacetamide; ketones and ketone alcohols such as acetone, and diacetone 20 alcohol; ethers such as tetrahydrofuran, and dioxane; and nitrogen-containing heterocyclic ketones such as N-methyl-2-pyrrolidone, 2-pyrrolidone, 1,3-dimethyl-2-imidazolidinone.

25 The water-soluble organic solvent may be incorporated in such an amount that the ink-bleeding is not caused and the ejection property is not impaired. Among the above solvents, preferred are ethylene

glycol, triethylene glycol, hexylene glycol, diethylene glycol, glycerin, ethyl alcohol, isopropyl alcohol, cyclohexanol, and so forth. The solvent preferably is contained in an amount of from 1 to 15 % by weight based on the total weight of the ink.

The dyes employed in the present invention include direct dyes, acid dyes, reactive dyes, disperse dyes, vat dyes, and the like. The content of the dye is decided depending on the kinds of the liquid medium components and the required properties of the ink, and is generally in the range of from 0.5 to 15 %, preferably from 1 to 7 % by weight based on the total weight of the ink.

The main constituents of the ink of the present first invention are described above. Other additives may be incorporated provided that the objects of the invention are achievable. The additive includes viscosity-adjusting agents such as polyvinyl alcohol, celluloses, and water-soluble resins; pH-controlling agents such as diethanolamine, triethanolamine, and buffer solutions; fungicides; and so forth. To the ink of electrically chargeable type used for ink-jet recording in which the ink droplets are charged, a resistivity-adjusting agent is added such as lithium chloride, ammonium chloride, and sodium chloride.

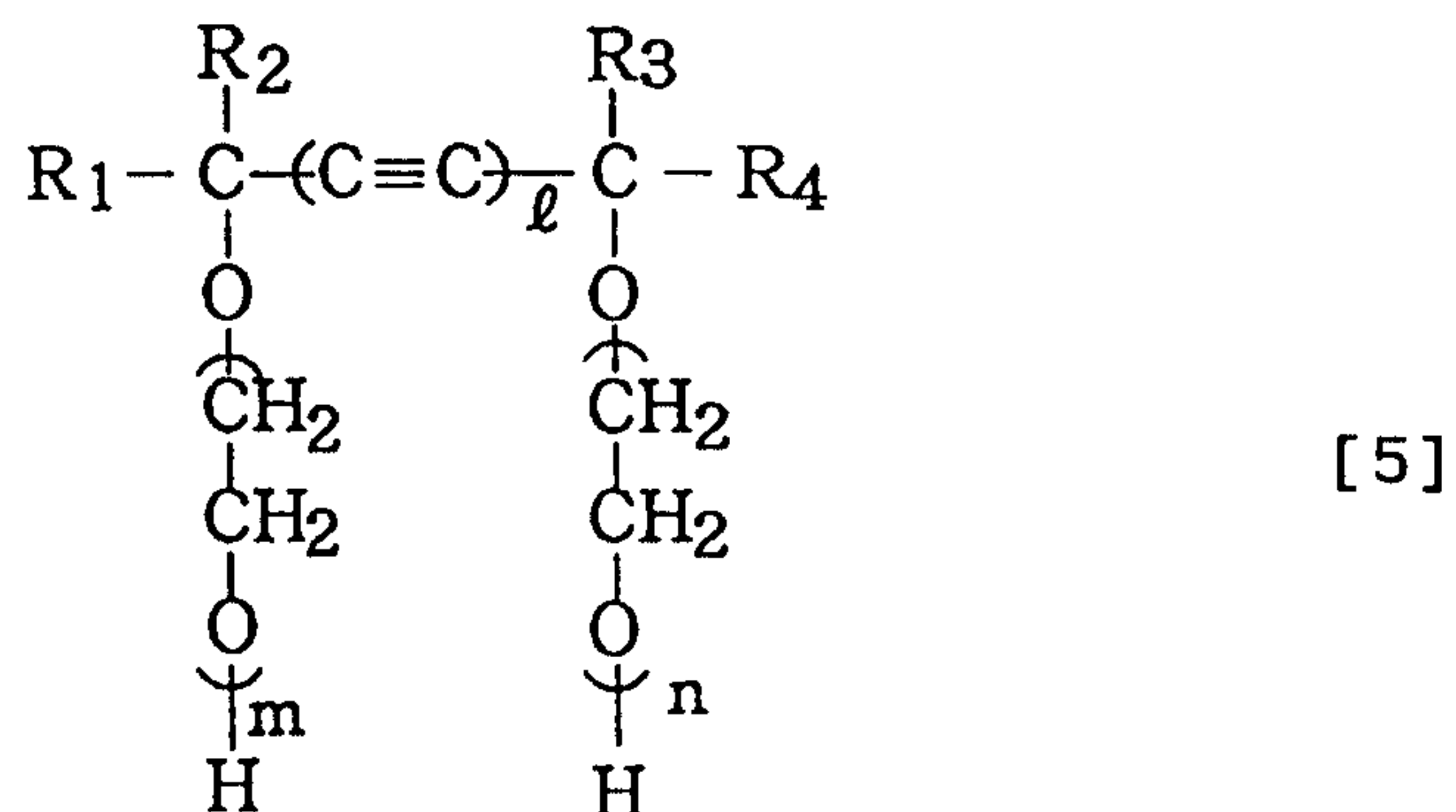
The second invention will be described in detail.

Generally, inks which contain a compound having one triple bond in the molecule give uniform color. However, the ink of the present second invention provides much more excellent uniformity of color than
5 the above ink containing a compound having one triple bond.

Presumably, the compound which is represented by General Formula [5] having two or more triple bonds and contained in the ink of the present second
10 invention has high electron density in the molecule and has rigid hydrophobic portion (triple bond-containing portion), causing little a free change in structure in comparison with the compound having one triple bond, whereby the compound of General Formula [5] orients
15 regularly to the surface of the ink, and interacts effectively with the recording medium at the interface to exhibit high wettability.

The ink of the present second invention contains the compound of General Formula [5] below in
20 an amount of preferably from 0.001 to 20 %, more preferably from 0.001 to 5 % by weight based on the total weight of the ink, and the number of $m+n$ in the formula is in the range of from 0 to 50.

5

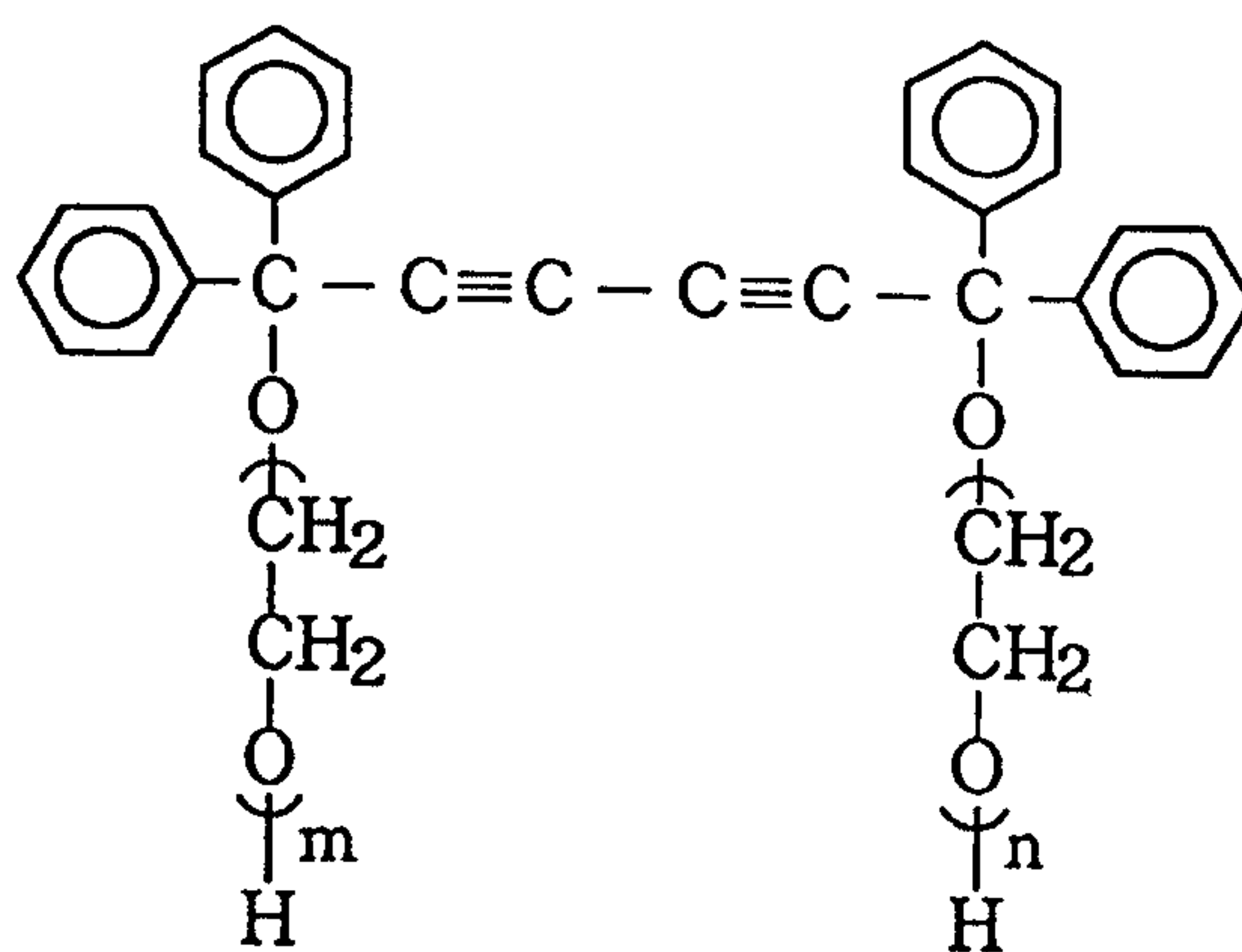


10

Specific examples of the compound of General Formula [5] are shown below without limiting the compound thereto in any way.

No.1

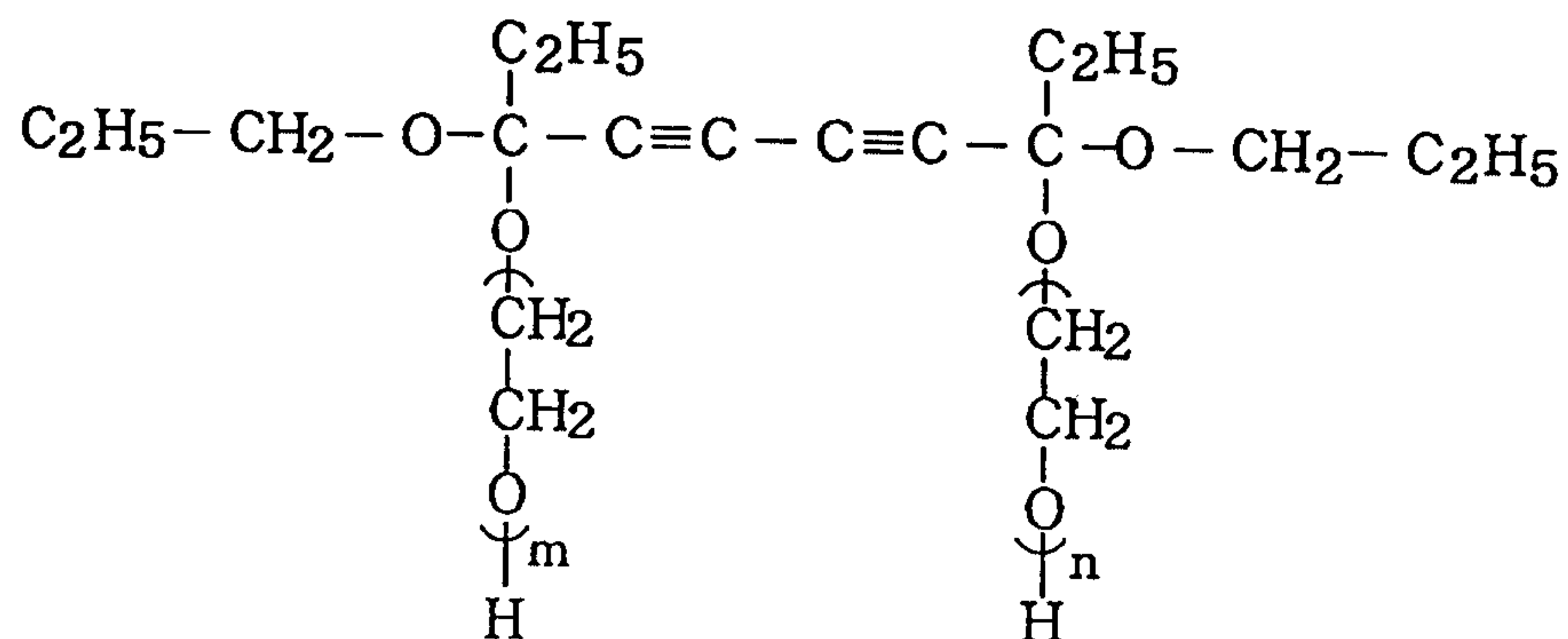
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No.2

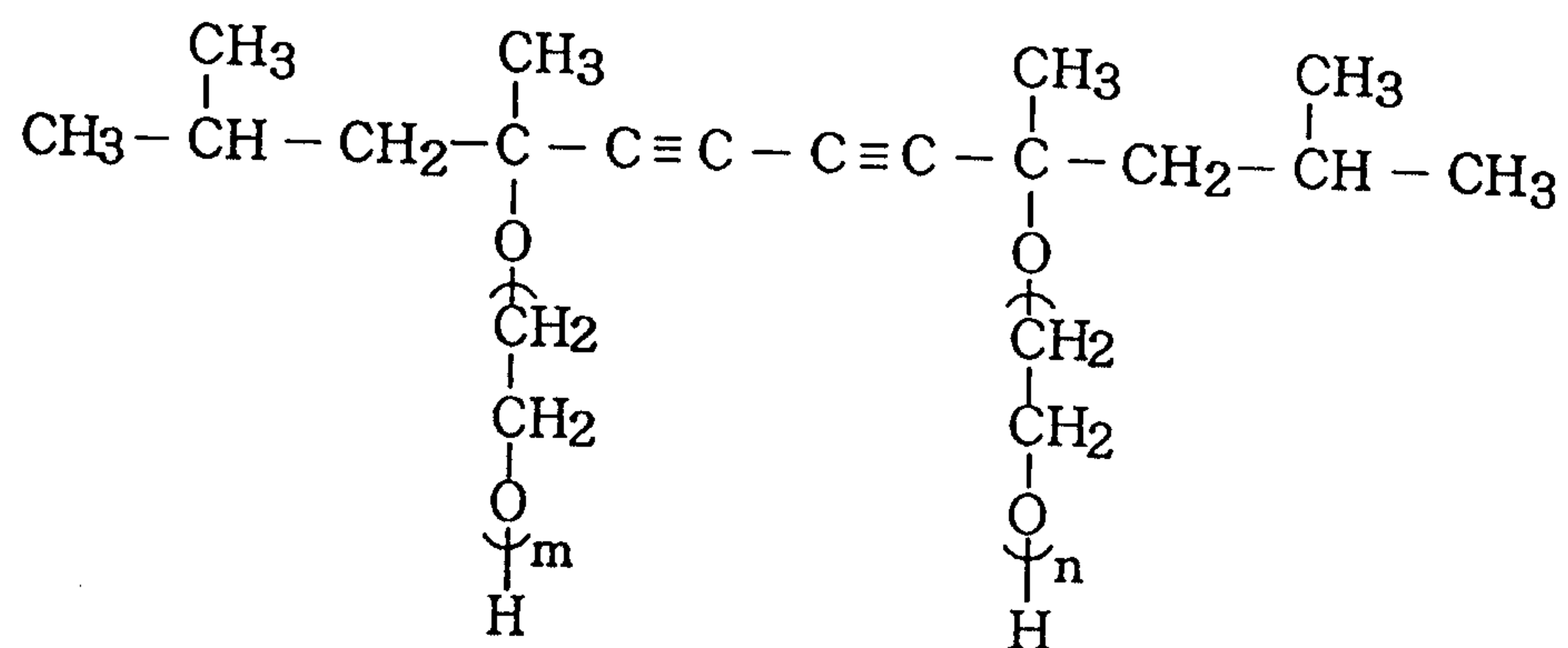
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No.3

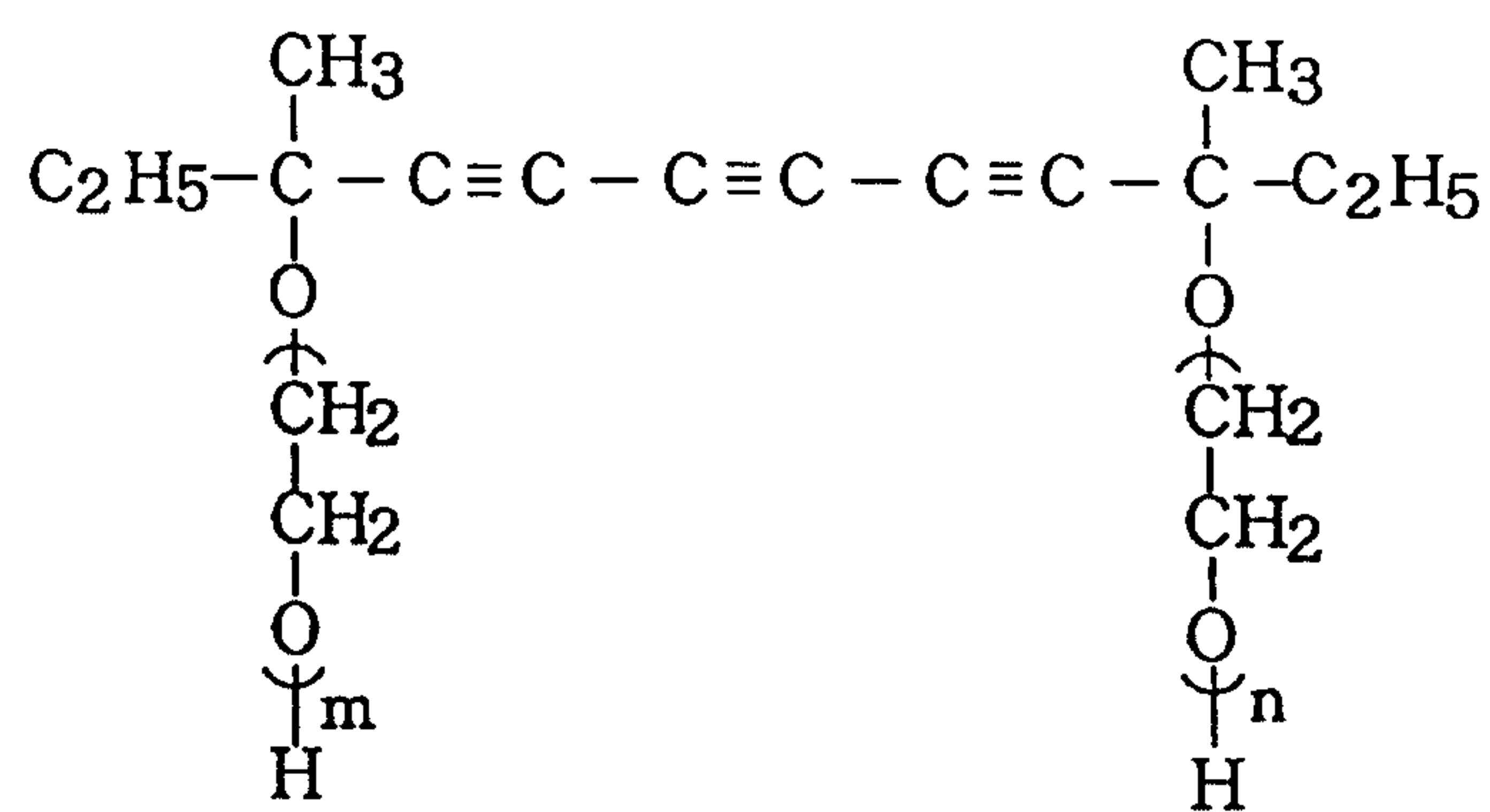
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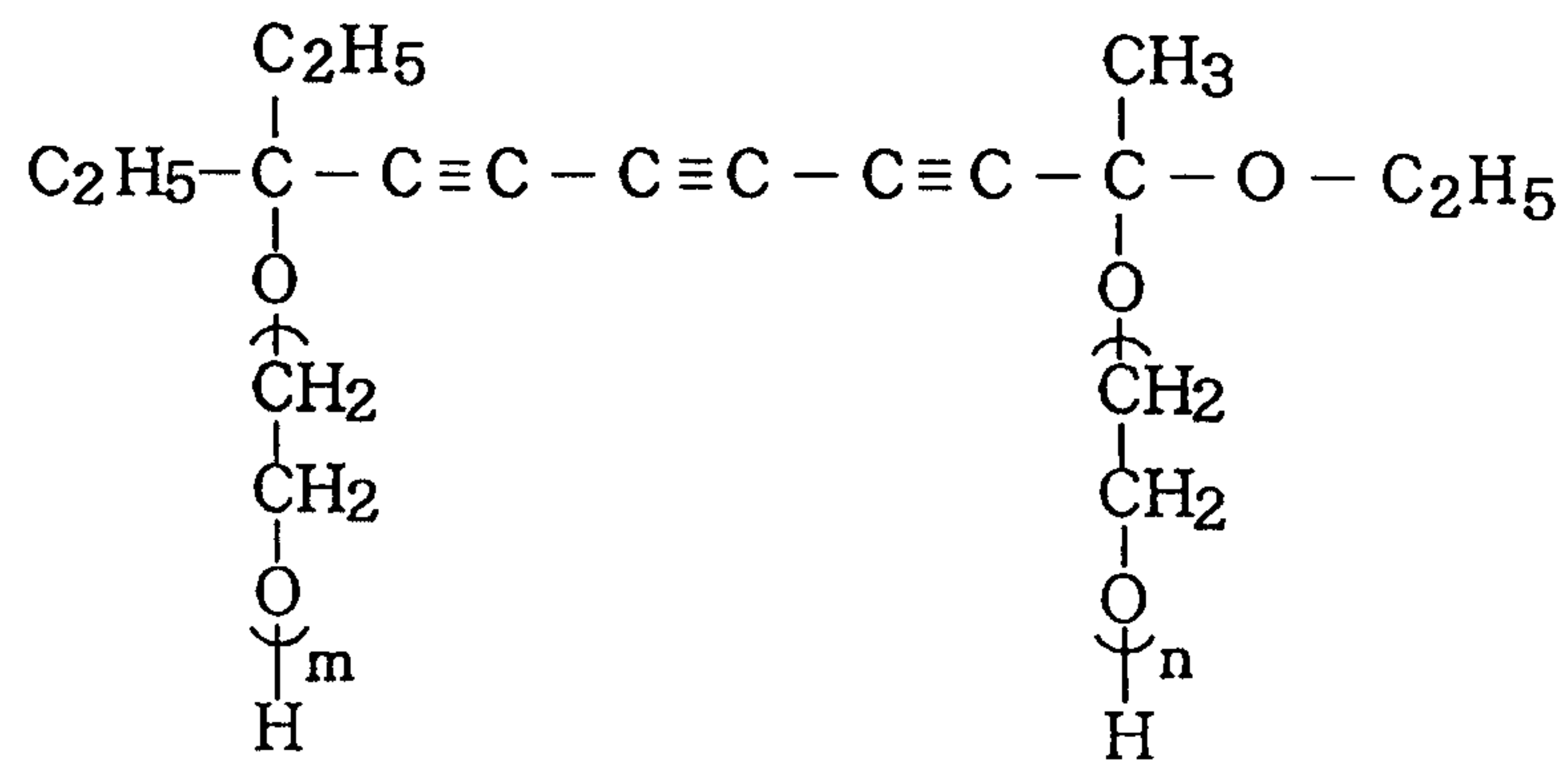
No.4

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No.5

20



25

The liquid medium constituting the ink of the present second invention may be an plain water-soluble organic solvent. The water-soluble solvents include polyalkylene glycols such as polyethylene glycol, and
5 polypropylene glycol; alkylene glycols having 2 to 6 carbon atoms such as ethylene glycol, propylene glycol, butylene glycol, triethylene glycol, hexylene glycol, diethylene glycol, and thiodiglycol; glycerin; 1,2,6-hexanetriol; lower alkyl ether of polyhydric alcohols
10 such as ethylene glycol methyl ether, diethylene glycol methyl (or ethyl) ether, and triethylene glycol monomethyl (or ethyl) ether; alcohols such as methyl alcohol, ethyl alcohol, n-propyl alcohol, isopropyl alcohol, n-butyl alcohol, sec-butyl alcohol, t-butyl
15 alcohol, isobutyl alcohol, benzyl alcohol, and cyclohexanol; amides such as dimethylformamide, and dimethylacetamide; ketones and ketone alcohols such as acetone, and diacetone alcohol; ethers such as tetrahydrofuran, and dioxane; and nitrogen-containing
20 heterocyclic ketones such as N-methyl-2-pyrrolidone, 2-pyrrolidone, 1,3-dimethyl-2-imidazolidinone.

Among the above water-soluble solvents, preferred are ethylene glycol, triethylene glycol, hexylene glycol, diethylene glycol, glycerin,
25 thiodiglycol, ethyl alcohol, isopropyl alcohol, cyclohexanol, and so forth. The solvent is preferably contained at a content of from 1 to 35 % based on the

total weight of the ink.

The dyes employed in the present invention include direct dyes, acid dyes, basic dyes, reactive dyes, disperse dyes, vat dyes, and the like. The
5 content of the dye is decided depending on the kinds of the liquid medium components and the required properties of the ink, and is generally in the range of from 0.5 to 15 %, preferably from 1 to 7 % by weight based on the total weight of the ink.

10 The main constituents of the ink of the present second invention are described above. Other additives may be added provided that the objects of the invention are achievable. The additives include clogging-preventing agents such as urea and its derivatives;
15 viscosity-adjusting agents such as polyvinyl alcohol, celluloses, and water-soluble resins; pH-controlling agents such as diethanolamine, triethanolamine, and buffer solutions; fungicides; surfactants, and so forth. To the ink of electrically chargeable type used
20 for ink-jet recording in which the ink droplets are charged, an resistivity-adjusting agent is preferably incorporated such as lithium chloride, ammonium chloride, and sodium chloride.

The inks of the first invention and the second
25 invention are suitable for ink-jet recording in which the ink droplets are ejected by action of thermal energy. However, the inks are naturally useful also

for other types of ink-jet recording and for general writing implements.

The recording apparatus suitable for recording with the ink of the present first invention and the present second invention includes those in which
5 thermal energy is given to the ink in a chamber in a recording head in correspondence with recording signals and thereby ink droplets are formed.

The third invention will be described in
10 detail.

The inventors of the present invention have noticed the necessary conditions shown below for forming color images in high quality on plain paper.

When different color inks are dotted in a
15 pattern as shown in Fig. 1, the different color inks are less liable to be mixed at the boundaries of the dotted colors, even if the adjacent color is dotted subsequently in a short time. In this case, however, disadvantages may be caused such that the central
20 portion surrounded by dots becomes blank, which may cause decrease of color density, and a slight shift of the ejected ink droplet from the aimed impact point may increase the area of the blank portion.

On the contrary, if the ink is dotted as shown
25 in Fig. 2 by satisfying the Equation [II] below, the above disadvantage is significantly reduced, and excellent images are obtained:

$$B \geq \sqrt{2} \times 10^3 \times 1/D \quad [II]$$

where B is a dot diameter (μm) formed on plain paper,
and D is a recording density (dots/mm). In this method
of dotting, however, different color inks are
5 necessarily mixed as shown by the shadowed portions in
Fig. 2, and thereby mixing of the different color inks
is liable to occur.

In Figs. 1 and 2, C, M and Y means a droplet of
cyan ink, magenta ink and yellow ink, respectively.

10 The inventors have investigated the method of
preventing the mixing of different color inks at the
color boundaries with the high quality of image being
maintained regarding the case where the inks are dotted
according to Equation [II]. As the result, it has been
15 found that the above problem is solved by adjusting the
feathering rate (A) shown by Equation [I] below on
plain paper to be in the range of from 2.5 to 3.5.

$$A = B/C \quad [I]$$

where B is a dot diameter (μm) formed on plain paper,
20 and C is a diameter (μm) of the ejected ink droplet.
At the feathering rate of less than 2.5,
the ink droplet attached on paper surface spreads less
and the ink layer does not become thin, thereby
different colors of inks coming to be mixed at the
25 boundaries of colors when inks are dotted under the
conditions shown in Fig. 2. On the contrary, at the
feathering rate of more than 3.5, the ink droplet

spreads excessively and the edge of the dot becomes unclear, thus providing images of low quality.

In order to control the feathering ratio in the range of from 2.5 to 3.5, nonionic surfactant is
5 incorporated into the ink in an amount of from 1 to 20 %, more preferably from 3 to 10 % by weight. With the amount of the nonionic surfactant of less than 1 % by weight, the feathering ratio becomes less than 2.5, thus causing color ink mixing at the color border,
10 while with the amount of the nonionic surfactant of more than 20 % by weight, the feathering rate becomes more than 3.5, thus the image quality liable to become low.

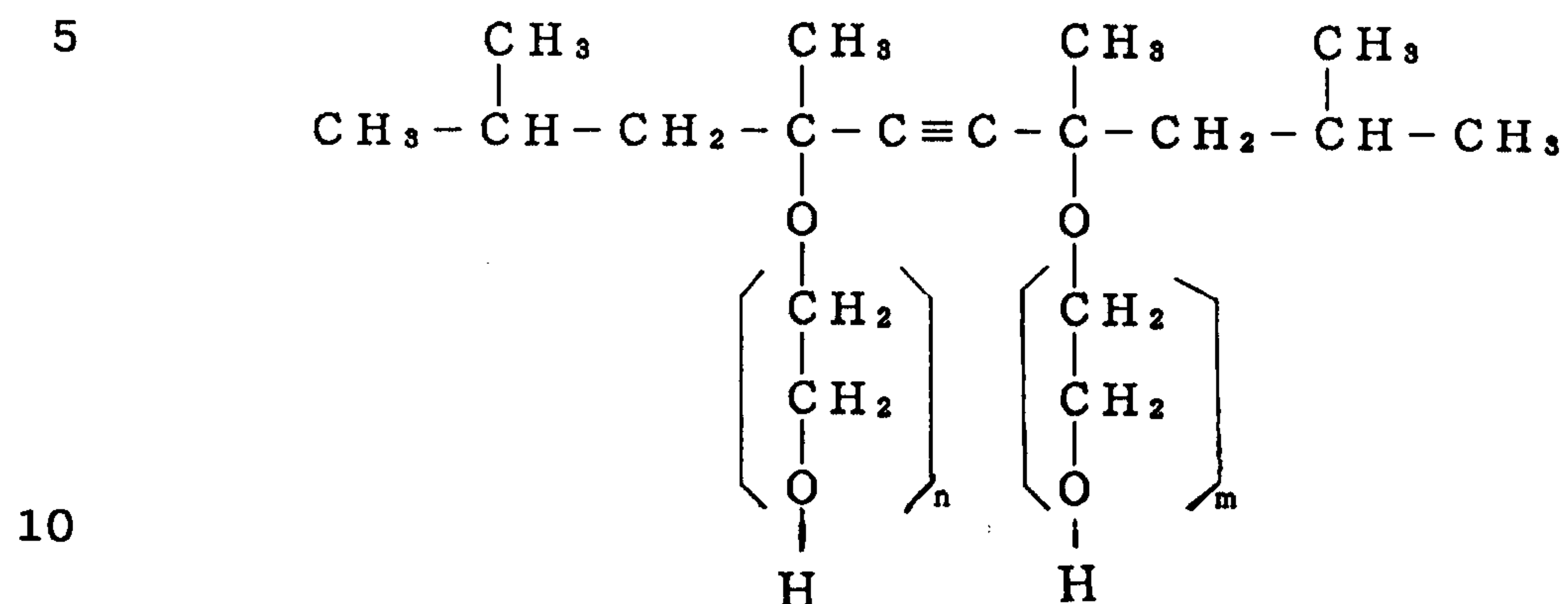
Simple use of surfactant in a large amount
15 gives rise to disadvantages of lowering of color density and image quality caused by excessive penetration of ink droplets toward the back face of the paper sheet, and of nonuniformity of color density in a solid print portion caused by nonuniform dyeing of the
20 fiber layer at the paper surface. The inventors of the present invention have found that color image recording with high quality is practicable when a nonionic surfactant is used as the surfactant and when printing is carried out using the ink containing it in an amount
25 of from 1 to 20 % by weight with controlling the amount of ink ejection in the range of from 10 to 70 pℓ, preferably from 20 to 50 pℓ per one nozzle for one

pulse. The present third invention has been accomplished on the basis of the above two findings.

5 The nonionic surfactant does not have selective affinity to a fiber layer on the surface of paper, whereby uniform dyeing is achievable and nonuniformity of color density is avoided. The ink for the color recording method of the present invention contains a surfactant in a large amount. Therefore, if the ink droplets are ejected in an amount of more than 70 pℓ per one nozzle for one pulse, the amount of the ink exceeds the absorbable and fixable limit of the fiber layer on the paper surface, causing penetration of ink into a pore layer under the fiber layer owing to the penetrating power of the surfactant, thus resulting in deterioration of image quality owing to lowered color density and irregular feathering. Accordingly the amount of the ink ejection has to be controlled to be in the range of from 10 to 70 pℓ per pulse.

20 The nonionic surfactants employed in the present third invention include polyoxyethylene alkyl ethers, polyoxyethylene phenyl ethers, polyoxyethylene-polyoxypropylene glycols, polyoxyethylene-polyoxypropylene alkyl ethers, polyethylene oxide adducts of acetylene glycol, etc. Of these, preferred are nonylphenyl ether-ethylene oxide adducts, ethylene oxide-propylene oxide copolymer (EO-PO adducts), 25 acetylene glycol-polyethylene oxide adducts;

particularly preferred are acetylene glycol-
polyethylene oxide adducts (acetylene glycol-EO
adducts) represented by the structural formula below.



where $m + n = 10$.

The water-soluble organic solvents employed in
addition to the nonionic surfactant in the present
third invention include amides such as
dimethylformamide, and dimethylacetamide; ketones such
as acetone; ethers such as tetrahydrofuran, and
dioxane; polyalkylene glycols such as polyethylene
glycol, and polypropylene glycol; alkylene glycols
having 2 to 6 carbon atoms such as ethylene glycol,
propylene glycol, butylene glycol, triethylene glycol,
thiodiglycol, hexylene glycol, and diethylene glycol;
glycerin; 1,2,6-hexanetriol; lower alkyl ether of
polyhydric alcohols such as ethylene glycol methyl (or
ethyl) ether, diethylene glycol methyl (or ethyl)
ether, and triethylene glycol monomethyl (or ethyl)
ether; N-methyl-2-pyrrolidone, 1,3-dimethyl-2-

imidazolidinone, triethanolamine, sulfolane, dimethylsulfoxide, and so forth.

The clogging-preventing agents include urea and derivatives of urea, sulfonamides, and the like.

5 The dyes employed in the present invention include direct dyes, acid dyes, reactive dyes, disperse dyes, vat dyes, and the like. The content of the dye is decided depending on kinds of the liquid medium components and the required properties of the ink, and
10 is generally in the range of from 0.5 to 15 %, preferably from 1 to 7 % by weight based on the total weight of the ink.

 The main constituents of the ink of the present third invention are described above. Other additives
15 may be added provided that the objects of the invention are achievable. The additives include viscosity-adjusting agents such as polyvinyl alcohol, celluloses, and water-soluble resins; pH-controlling agents such as diethanolamine, triethanolamine, and buffer solutions;
20 fungicides; and so forth. To formulate the ink of electrically chargeable type used for ink-jet recording in which the ink droplets are charged, an resistivity-adjusting agent is preferably added such as lithium chloride, ammonium chloride, and sodium chloride.

25 The recording method of the present third invention is particularly suitable for ink-jet recording in which ink droplets are ejected by the

action of thermal energy, but is also applicable to other ink-jet recording methods.

5 A recording apparatus is described below which produces ink droplets by thermal energy and is suitable for practising the recording of the present first invention, the present second invention, and the present third invention. The present invention is suitable for the recording system in which recording signal is applied to a recording ink in a recording head and ink droplets are ejected by the action of the generated thermal energy. The construction of the recording head, which is the main portion of the apparatus, is shown in Figs. 3, 4, and 5.

15 A head 13 is constructed by bonding a plate of glass, ceramics, or plastics having an ink flow path to a heat-generating head 15. (The the head is shown in the drawing, but the invention is not limited to this.) The heat-generating head 15 is constituted of a protection layer 16 formed of silicon oxide or the like, aluminum electrodes 17-1 and 17-2, a heat-generating resistance layer 18 formed of nichrome or the like, a heat accumulation layer 19, and a substrate plate 20 made of aluminum or the like having a high heat-radiating property.

25 Ink 21 reaches the ejection orifice 22, forming a meniscus 23 by action of pressure P not shown in the drawing.

On application of an electric signal to the electrodes 17-1 and 17-2, the region designated by a symbol "n" on the heat-generating head 15 generates abruptly heat to form a bubble in the portion of the ink 21 contacting therewith. The pressure generated by the bubble pushes out the meniscus 23 and ejects the ink 21 from the orifice 22 in a form of ink droplets 24, and the ink droplets are ejected to a recording medium 25. Fig. 5 shows a rough sketch of a multiple recording head constructed by juxtaposing a multiplicity of heads shown in Fig. 3. The recording head is prepared by bonding a glass plate 27 having a plurality of flow paths to a heat-generating head 28 similar to the one shown in Fig. 3.

Incidentally, Fig. 3 is a cross-sectional view of the head 13 along an ink flow path, and Fig. 4 is a cross-sectional view of the head at the line A-B in Fig. 3.

Fig. 6 illustrates an example of the ink-jet recording apparatus having such a head mounted therein.

In Fig. 6, a blade 61 as a wiping member is held at one end by a blade-holding member, forming a fixed end in a shape of a cantilever. The blade 61 is placed at a position adjacent to the recording region of the recording head, and is constituted such that it moves in the direction perpendicular to the moving direction of the recording head to come into contact

with the ejection nozzle face to cap the nozzles. An ink absorption member 63 is provided at a position adjacent to the blade 61, and is held so as to protrude into the moving path of the recording head in a manner similar to that of the blade 61. The aforementioned blade 61, the cap 62, and the absorption member 63 constitute an ejection-recovery section 64. The blade 61 and the absorption member 63 remove water, dust, and the like from the ink ejecting nozzle face.

A recording head 65 has an ejection energy-generating means for ejection, and conducts recording by ejecting ink onto a recording medium opposing to the ejection nozzle face. A carriage 66 is provided for supporting and moving the recording head 65. The carriage 66 is engaged slideably with a guide rod 67. A portion of the carriage 66 is connected (not shown in the drawing) to a belt 69 driven by a motor 68, so that the carriage 66 is movable along the guide rod 67 to the recording region of the recording head 65 and the adjacent region thereto.

A paper delivery portion 51 for delivery of a recording medium and a paper delivery roller 52 driven by a motor (not shown in the drawing) delivers the recording medium to the position opposing to the ejecting nozzle face of the recording head, and the recording medium is discharged with the progress of the recording to a paper discharge portion provided with

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paper-discharging rollers 53.

In the above constitution, when the recording head 65 returns to a home position at the completion of the recording or other timing, the cap 62 of the
5 ejection-recovery portion 64 is positioned out of the moving path of the recording head 65, and the blade 61 is made to protrude into the moving path. Therefore, the ejecting nozzle face of the recording head 65 is wiped therewith. The cap 62 moves to protrude toward
10 the moving path of the recording head when the cap 62 comes into contact with the ejecting nozzle face of the recording head for capping.

At the time when the recording head 65 moves from the home position to the record-starting position,
15 the cap 62 and the blade 61 are at the same position as in the above-mentioned wiping time, so that the ejection nozzle face of the recording head is wiped also in this movement.

The recording head moves to the home position
20 not only at the end of the recording and at the time of ejection recovery, but also at a predetermined interval during movement for recording in the recording region. By such movement, the wiping is conducted.

Fig. 7 illustrates an example of the ink
25 cartridge 45 that contains ink to be supplied through an ink supplying member such as a tube. The ink container portion 40, for example an ink bag, contains an ink to

be supplied, and has a rubber plug 42 at the tip. By inserting a needle (not shown in the drawing) into the plug 42, the ink in the ink bag 40 becomes suppliable. An ink absorption member 44 absorbs waste ink.

5 The ink container portion has preferably a liquid-contacting surface made of polyolefin, particularly preferably made of polyethylene.

 The ink-jet recording apparatus used in the present invention is not limited to the above-mentioned
10 one which has separately a head and an ink cartridge. Integration thereof as shown in Fig. 8 may suitably be used.

 In Fig. 8, a recording unit 70 houses an ink container portion such as an ink absorption member, and
15 the ink in the ink absorption member is ejected from a head 71 having a plurality of orifices. The ink absorption member may be made of a material such as polyurethane. An air-communication opening 72 is provided to communicate interior of the cartridge with
20 the open air. The recording unit 70 may be used in place of the recording head shown in Fig. 6, and is readily mountable to and demountable from the carriage 66.

 An ink-jet recording apparatus which ejects ink
25 droplets by action of thermal energy to the ink is exemplified above. The present invention, however, is applicable also to other ink-jet recording apparatuses

such as the one of piezo type which employs a piezoelectric element.

For practising the recording according to the present invention, a recording apparatus, for example,
5 is used which has four in number of recording heads shown in Fig. 5 juxtaposed on a carriage. Fig. 9 shows an example of the apparatus. Recording heads 81, 82, 83, and 84 are recording heads ejecting respectively recording inks of yellow, magenta, cyan, and black.
10 The heads are mounted on the aforementioned recording apparatus, and eject respective color inks in accordance with recording signals. The apparatus in Fig. 9 employs four recording heads, but the present invention is not limited thereto. One recording head
15 may be constructed to ejects all of the yellow, magenta, cyan, and black inks as shown in Fig. 10.

The present invention is described in more detail by reference to Examples and Comparative Examples. In the description, the terms "parts" and
20 "%" are based on weight unless otherwise mentioned. Hereinafter, the ethylene oxide adduct is simply referred to as "EO adduct".

The dyes and liquid medium in an amount (parts) shown below are employed in the Example and Comparative
25 Example to provide each 100 parts of inks, respectively.

Example 1

- 35 -

(Dyes)

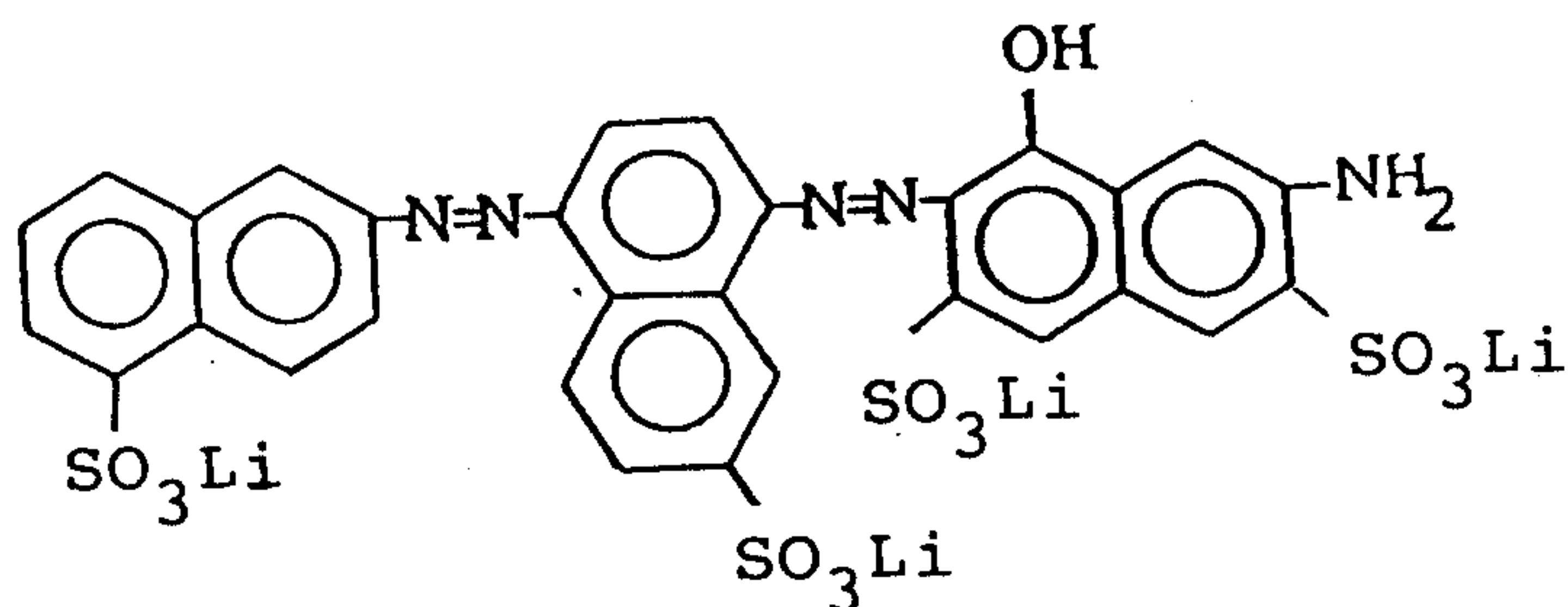
	Black:	C.I. Food Black 2	2 parts
		Dye A of Formula below	1.2 parts
		Dye B of Formula below	0.8 part
5	Yellow:	C.I. Direct Yellow 86	2.5 parts
	Cyan:	C.I. Direct Blue 199	3.5 parts
	Magenta:	Dye C of Formula below	3.5 parts

(Liquid medium)

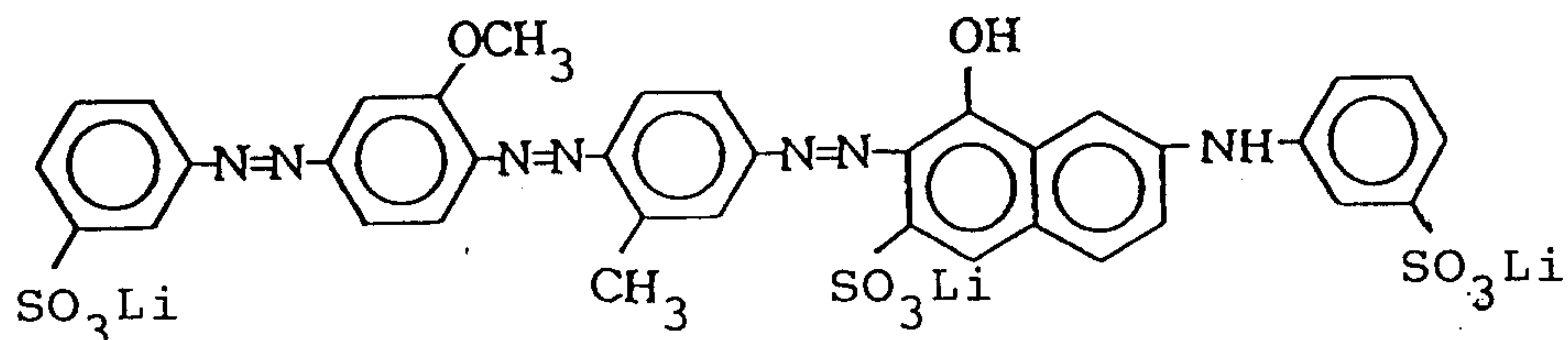
	Thiodiglycol	7.5 parts
10	Urea	7.5 parts
	Glycerin	7.5 parts
	Higher alcohol-EO adduct (n=15)*	1 part
	Pure water	balance

* Higher alcohol-EO adduct: BO-15TX trade-mark of Nikko Chemicals K.K.) is used.

Dye A

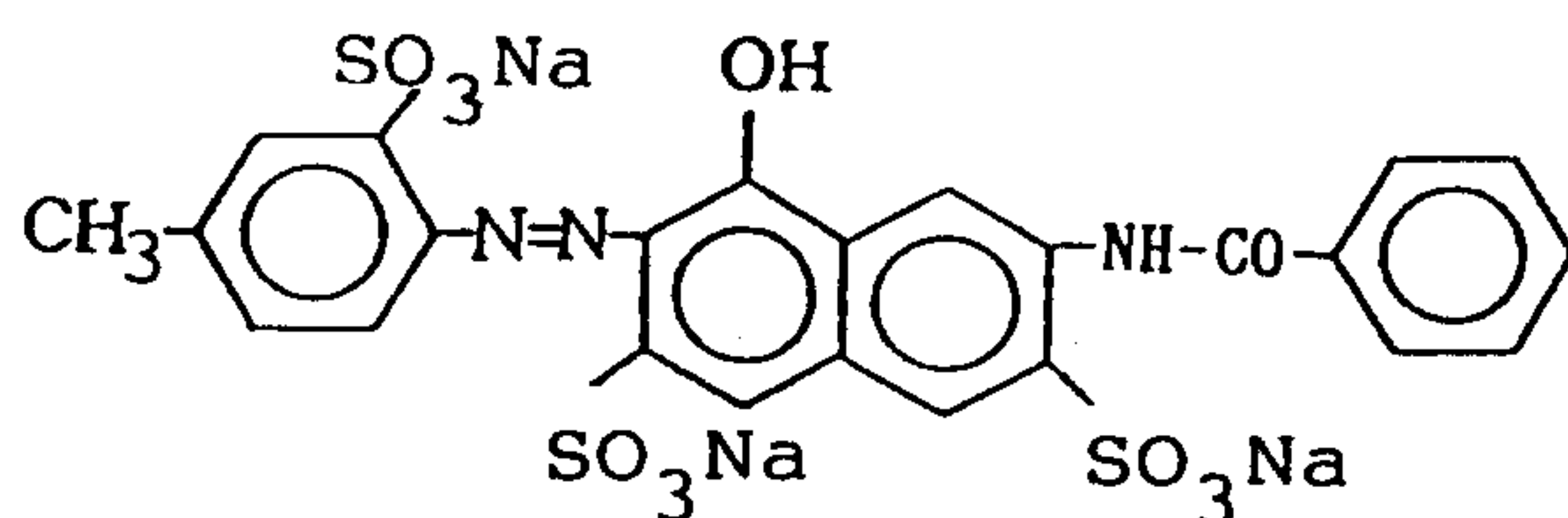


20 Dye B



Dye C

25



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Each of the four color compositions was stirred sufficiently, and was filtered under pressure through a Fluoropore Filter (trade-mark of Sumitomo Electric Industries, Ltd.) having a pore diameter of 0.22 μm to prepare the ink of the present invention. The respective inks were introduced into a color ink-jet printer BJC-820J (trade-mark of Canon K.K.) which conducts recording by forming ink droplets by applying thermal energy to the inks in the recording heads, and recording was conducted on commercial paper sheets for copying (Canon NP Dry SK), and bond paper sheets (Plover Bond Paper PB).

Evaluation was made as described below. The results are shown in Table 1.

(1) Bleeding:

Color samples were prepared by printing such that different colors are adjacent to each other, and the occurrence of bleeding was evaluated by the standard below. The evaluation was made for seven colors: black, yellow, cyan, and magenta; and red, green, and blue formed by dotting in superposition of two colors taken from the colors of yellow, cyan, and magenta.

o : No bleeding is observed at every boundary.
Δ : Bleeding is remarkable at the boundaries of red, green, and blue where a larger amount of ink is applied.

* trade-marks

x : Bleeding is remarkable at nearly all the boundaries.

(2) Color uniformity:

5 Uniformity at solid color print portions are examined visually.

o : Solid color print is completely uniform without irregularity.

Δ : Nonuniformity is remarkable at the portion where fiber density is high.

10 x : Color irregularity is much more remarkable.

(3) Occurrence of feathering:

Three hundred dots are printed continuously on a commercial paper sheet for copying and a commercial bond paper sheet such that the dots are not brought
15 into contact with each other. The dotted ink are dried in the air for 24 hours at room temperature. Irregular shape and irregular feathering of dots are counted under microscope. The evaluation is made by the percentage of the counted dot number according to the
20 standard below:

⊙ : not more than 10 %

o : 11 % to 30 %

Δ : 31 % to 50 %

x : not less than 51 %

25 (4) Ejection property:

The ink to be tested is filled to the printer, and alphabet and numeral letters are printed

2100201

continuously for 10 minutes with the printer.

Thereafter, printer is left standing without capping of the nozzles. After 10 minutes of intermission of the printing, the printing is started again. The ejection

5 property is evaluated from scratches and unsharped edges in printed letters after restarting the printing.

o : No scratch and no unsharped edge is observed from the first letter.

10 Δ : A part of the first letter is scratched or unsharped.

x : The first letter cannot be printed.

(5) Storage stability:

The ink is placed in an amount of 100 ml in a heat-resistant glass bottle, stoppered tightly, and
15 stored in a thermostatic chamber at 60°C. After 2 months of storage, the ink is used for printing, and evaluated.

o : No abnormality is observed.

20 x : Failure of discharge, or irregularity or discoloration of printed letters is observed.

(6) Anti-Clogging (crusting recovery):

The ink to be tested is filled to the printer, and alphabet and numeral letters are printed continuously for 10 minutes with the printer.

25 Thereafter, printer is left standing without capping of the nozzles. After one month of intermission of the printing, ejection recovery operation was conducted.

The evaluation was made by counting the required number of times of the ejection recovery operations for carrying out normal printing.

5 o : Printing is normal after 1 to 5 times of ejection recovery operation.

Δ : Printing is normal after 6 to 10 times of ejection recovery operation.

× : Printing is normal after 11 or more times of ejection recovery operation.

10 Examples 2 to 5

In respective Examples, the kind and the amount of the dyes used were as below:

(Dyes for Examples 2 to 4)

	Black:	C.I. Food Black 2	2 parts
15		Dye A	1.2 parts
		Dye B	0.8 part
	Yellow:	C.I. Direct Yellow 86	2.5 parts
	Cyan:	C.I. Direct Blue 199	3.5 parts
	Magenta:	Dye C	3.5 parts

20 (Dyes for Example 5)

	Black:	C.I. Food Black 2	2 parts
		Dye A	1.2 parts
		Dye B	0.8 part
	Yellow:	C.I. Direct Yellow 86	2.5 parts
25	Cyan:	C.I. Acid Blue 9	3.0 parts
	Magenta:	Dye C	3.5 parts

The liquid mediums used in respective Examples were as

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below:

(Liquid medium for Example 2)		
	Thiodiglycol	7.5 parts
	Urea	7.5 parts
5	Glycerin	7.5 parts
	Nonylphenyl ether-EO adduct	
	(n =9 to 10)	5 part
	Pure water	balance
(Liquid medium for Example 3)		
10	Thiodiglycol	7.5 parts
	Thiourea	7.5 parts
	Glycerin	7.5 parts
	Ethylene oxide-propylene oxide	
	copolymer (n=10, ℓ =7)	15 parts
15	Pure water	balance
(Liquid medium for Example 4)		
	Thiodiglycol	7.5 parts
	Urea	7.5 parts
	Glycerin	7.5 parts
20	Acetylene glycol-EO adduct	
	(n+m = 10)	5 parts
	Pure water	balance
(Liquid medium for Example 5)		
	Thiodiglycol	7.5 parts
25	Urea	7.5 parts
	Glycerin	7.5 parts
	Acetylene glycol-EO adduct	

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(n+m = 4)

1 parts

Pure water

balance

In the above, as acetylene glycol-EO adduct. Acetylenol
(trade-mark of Kawaken Fine Chemical K.K.) as the

5 nonylphenyl ether-EO adduct, Emulgen 909 (trade-mark of Kao Corporation), and as the ethylene oxide-propylene oxide copolymer, Karpole MH-50 (trade-mark of Asahi Denka Kogyo K.K.) are used, respectively.

10 The respective inks were prepared with the dye and the liquid medium shown above in the same manner as in Example 1. Printing properties, ejection properties, and the storage stability of the inks were evaluated in the same manner as in Example 1. The results are shown in Table 1.

15 Comparative Examples 1 to 5

In respective Comparative Examples, the kind and the amount of the dyes were are as below:

(Dyes for Comparative Examples 1 to 5)

20	Black:	C.I. Food Black 2	2 parts
		Dye A	1.2 parts
		Dye B	0.8 part
	Yellow:	C.I. Direct Yellow 86	2.5 parts
	Cyan:	C.I. Direct Blue 199	3.5 parts
	Magenta:	Dye C	3.5 parts

25 The liquid mediums used in respective Comparative Examples were as below:

(Liquid medium for Comparative Example 1)

	Thiodiglycol	7.5 parts
	Urea	7.5 parts
	Glycerin	7.5 parts
	Pure water	balance
5	(Liquid medium for Comparative Example 2)	
	Thiodiglycol	15 parts
	Glycerin	7.5 parts
	Acetylene glycol-EO adduct	
	(n+m = 10)	5 parts
10	Pure water	balance
	(Liquid medium for Comparative Example 3)	
	Urea	10 parts
	Glycerin	12.5 parts
	Acetylene glycol-EO adduct	
15	(n+m = 10)	5 parts
	Pure water	balance
	(Liquid medium for Comparative Example 4)	
	Thiodiglycol	7.5 parts
	Urea	7.5 parts
20	Glycerin	7.5 parts
	Anionic surfactant (Neopelex 25, made by Kao Corporation)	7 parts
	Pure water	balance
	(Liquid medium for Comparative Example 5)	
25	Thiodiglycol	7.5 parts
	Urea	7.5 parts
	Glycerin	7.5 parts

Cationic surfactant (Cation DDC-50,
made by Sanyo Chemical

Industries, Ltd.)

5 parts

Pure water

balance

5

The respective inks were prepared with the dye and the liquid medium shown above in the same manner as in Example 1. Printing properties, ejection properties, and the storage stability of the inks were evaluated in the same manner as in Example 1. The

10

results are shown in Table 1.

Table 1

Evaluation item	(1)		(2)		(3)		(4)	(5)	(6)
	SK	PB	SK	PB	SK	PB			
<u>Examples</u>									
1	o	o	o	o	o	o	o	o	o
2	o	o	o	o	o	o	o	o	o
3	o	o	o	o	o	o	o	o	o
4	o	o	o	o	⊙	⊙	o	o	o
5	o	o	o	o	⊙	⊙	o	o	o
<u>Comparative examples</u>									
1	x	x	x	x	⊙	⊙	o	o	o
2	o	o	o	o	⊙	⊙	Δ	o	x
3	o	o	o	o	o	o	x	o	Δ
4	o	o	Δ	x	x	x	x	x	Δ
5	Δ	x	Δ	x	Δ	Δ	x	x	x

SK: Commercial paper for copying

PB: Plover Bond paper

Examples 6 to 10 and Comparative Example 6

5 The dyes of black, cyan, magenta, and yellow,
and the amount thereof used in respective Examples and
Comparative Example are as shown below:

(Dyes)

	Black:	C.I. Food Black 2	2 parts
		Dye A	1.2 parts
10		Dye B	0.8 part
	Yellow:	C.I. Direct Yellow 86	2.5 parts
	Cyan:	C.I. Acid Blue 9	3.5 parts
	Magenta:	Dye C	3.5 parts

Example 6

15	Dye (black, yellow, cyan, or magenta)	
		in an amount as shown above
	Glycerin	8 parts
	Urea	5 parts
	Thiodiglycol	8 parts
20	Compound No.1	1 part
	Pure water	balance

The above ink compositions were respectively
stirred sufficiently, and filtered through a Fluoropore
Filter (pore diameter 0.22 μ m, trade name, made by
25 Sumitomo Electric Industries, Ltd.) to prepare inks of
this Example.

Example 7

Dye (black, yellow, cyan, or magenta)

in an amount as shown above

5	Glycerin	8 parts
	Urea	5 parts
	Thiodiglycol	8 parts
	Compound No.2	16 part
	Pure water	balance

10 The above ink compositions were prepared in the same manner as in Example 6 to prepare inks of this Example.

Example 8

Dye (black, yellow, cyan, or magenta)

in an amount as shown above

15	Glycerin	8 parts
	Urea	5 parts
	Thiodiglycol	8 parts
	Compound No.3	0.5 part
	Cyclohexanol	1 part
	Pure water	balance

20 The above ink compositions were prepared in the same manner as in Example 6 to prepare inks of this Example.

Example 9

Dye (black, yellow, cyan, or magenta)

25		in an amount as shown above
	Glycerin	8 parts
	Urea	5 parts

Thiodiglycol	8 parts
Compound No.4	10 parts
Pure water	balance

5 The above ink compositions were prepared in the same manner as in Example 6 to prepare inks of this Example.

Example 10

Dye (black, yellow, cyan, or magenta)
in an amount as shown above

10	Glycerin	8 parts
	Urea	5 parts
	Thiodiglycol	8 parts
	Compound No.5	5 parts
	Pure water	balance

15 The above ink compositions were prepared in the same manner as in Example 6 to prepare inks of this Example.

Comparative Example 6

Dye (black, yellow, cyan, or magenta)

20 in an amount as shown above

Glycerin	5 parts
Urea	5 parts
Thiodiglycol	6 parts
Pure water	balance

25 The above ink compositions were prepared in the same manner as in Example 6 to prepare inks of this Comparative Example.

< Evaluation >

The obtained inks of Examples 6 to 10 and Comparative Example 6 were used for printing on commercial paper sheets for copying (Canon NP dry SK, and Prober bond paper PB). The recording apparatus employed was similar to the one shown in Fig. 6. A color image was formed by use of four recording heads shown in Fig. 9. The recording heads were the same as the ones used in the ink-jet printer BJC-820J (trade name, made by Canon K.K.). The recording heads were driven under the driving conditions (or current-flowing conditions) of the applied voltage of 28 V, the pulse width of 3.2 μ sec, and the drive frequency of 5 kHz.

The inks were evaluated regarding the evaluation items below. The results are shown in Table 2.

(1) Bleeding:

Evaluated in the same manner as in Example 1.

(2) Uniformity of color:

Evaluated in the same manner as in Example 1.

(3) Rate of occurrence of feathering:

Three hundred dots are printed continuously on a commercial paper sheet for copying and a commercial bond paper sheet such that the dots are not brought into contact with each other. The dotted ink are dried in the air for 24 hours at room temperature. Irregular shape and irregular feathering of dots are counted

under microscope. The evaluation is made by the percentage of the counted dot number according to the standard below:

o : not more than 10 %

5 Δ : 10 % to 20 %

x : not less than 21 %

(4) Storage stability:

Evaluated in the same manner as in Example 1.

(5) Anti-Clogging (crusting recovery):

10 Evaluated in the same manner as in Example 1.

Table 2

	Evaluation item	(1)	(2)	(3)	(4)	(5)
15	Example 6	o	o	o	o	o
	Example 7	o	o	o	o	o
	Example 8	o	o	o	o	o
	Example 9	o	o	o	o	o
20	Example 10	o	o	o	o	o
	Comparative example 6	x	x	o	o	o

Examples 11 to 18 and Comparative Examples 7 to 10

25 A color ink-jet recording apparatus which has four heads of the same recording density for yellow, magenta, cyan, and black colors and conducts recording by generation of ink droplets upon applying thermal

energy to the inks in the recording head was employed. Three kinds of multiple-nozzle On-Demand type heads of recording densities of 300 dpi (11.8 dots/mm), 360 dpi (14.2 dots/mm), and 400 dpi (15.7 dots/mm) were used.

5 The color inks (yellow, magenta, cyan, and black) for respective Examples were prepared by stirring sufficiently the composition shown below and filtering the mixture through Fluoropore Filter (pore diameter of 0.22 μ m, trade name, made by Sumitomo Electric Industries, Ltd.) under pressure.

(Dyes)

	Black:	C.I. Food Black 2	2 parts
		Dye A	1.2 parts
		Dye B	0.8 part
15	Yellow:	C.I. Direct Yellow 86	2.5 parts
	Cyan:	C.I. Direct Blue 199	3.5 parts
	Magenta:	Dye C	3.5 parts

(Liquid medium)

	Thiodiglycol	7.5 parts
20	Urea	7.5 parts
	Glycerin	7.5 parts
	Surfactant	(as shown in Table 3)
	Pure water	balance

25 With the recording apparatus having the heads of recording density shown in Table 3 mounted thereon, recording was conducted at the ejection rate shown on commercial paper for copying (Canon NP dry SK, and

- 50 -

Xerox 4024^{*}), and commercial bond paper (Plover bond paper sheet PB), and the recorded matter was evaluated.

The printed dot diameters and the feathering rates derived from the dot diameter are shown in Table 3. The evaluation results are shown in Table 4.

Recording was carried out under environmental conditions of the temperature of $25 \pm 2^\circ\text{C}$ and the humidity of from 50 to 70 % RH, and the printed samples were evaluated after they were left for one day from the time they were printed.

The dot diameter ("B" in Equation [I]) in the present invention was derived by image processing of printed dots by means of a CCD camera to measure the area of the dot and conversion of the area to a diameter of precise circle. The ink droplet diameter ("C" in Equation [I]) was calculated from the equation below:

$$V = (4/3)\pi(C/2)^3 \times 10^{-3}$$

where V is the volume of a droplet (pl) ejected per one pulse.

The evaluation items:

- (1) Bleeding,
- (2) Uniformity of color, and
- (3) rate of feathering

were evaluated in the same manner as in Example 1.

- (4) Optical density:

The optical density of the printed matter was

* trade-mark

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measured by MacBeth Refractodensitometer RD-915 (trade-mark of MacBeth Co.). The average O.D. values of yellow, magenta, cyan, and black were evaluated according to the standard below:

- 5 o : not less than 1.0
 Δ : 0.9 to 1.0
 X : not more than 0.9

Table 3

Example	Surfactant		Recording density (dots/mm)	Dot diameter (B) (μ m)	Ink-drop diameter (C) (μ m)	Amount of ejection (p ℓ)	Ink-running rate (A)
	Type	Concentration (parts)					
11	Acetylene glycol-EO adduct	1.5	14.2	114.4	44	44.6	2.6
12	Acetylene glycol-EO adduct	5	14.2	123.2	44	44.6	2.8
13	Acetylene glycol-EO adduct	15	14.2	136.4	44	44.6	3.1
14	Acetylene glycol-EO adduct	15	15.7	91.8	27	10	3.4
15	Acetylene glycol-EO adduct	10	14.2	116.5	38.5	30	2.9
16	Acetylene glycol-EO adduct	5	11.8	131.0	48.5	60	2.7
17	EO-PO copolymer	7	15.7	97.2	36	24.4	2.7
18	Nonylphenyl ether-EO adduct	5	11.8	130.5	45	47.7	2.9
Comparative Example							
7	Acetylene glycol-EO adduct	0.5	14.2	101.2	44	44.6	2.3
8	Acetylene glycol-EO adduct	5	11.8	143.1	53	78.0	2.7
9	Acetylene glycol-EO adduct	2.5	14.2	162.8	44	44.6	3.7
10	Sodium dodecylbenzenesulfonate	5	15.7	98.1	44	44.6	2.2

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Table 4

	Bleeding	Feathering	Optical density	Density irregularity
<u>Example</u>				
11	Δ	○	○	○
12	○	○	○	○
13	○	Δ	○	○
14	○	○	Δ	○
15	○	○	○	○
16	○	Δ	○	○
17	○	○	○	○
18	○	○	○	○
<u>Comparative Example</u>				
7	x	x	Δ	Δ
8	○	x	x	○
9	○	x	x	○
10	x	x	x	x

As described above, the present invention gives
color images of high quality formed by dots of
precisely circle shape with excellent color density
without causing feathering, bleeding, and color
5 nonuniformity even on plain paper.

Furthermore, the present invention enables
excellent recording without failure of ejection after
intermission of printing with stability and without
nozzle clogging.

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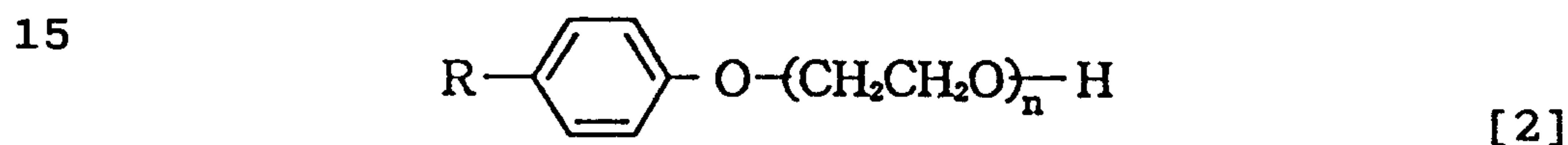
THE EMBODIMENTS OF THE INVENTION IN WHICH AN EXCLUSIVE PROPERTY OR PRIVILEGE IS CLAIMED ARE DEFINED AS FOLLOWS:

1. An ink for ink-jet recording, comprising a dye, water, and the components (a), (b), and (c) below:

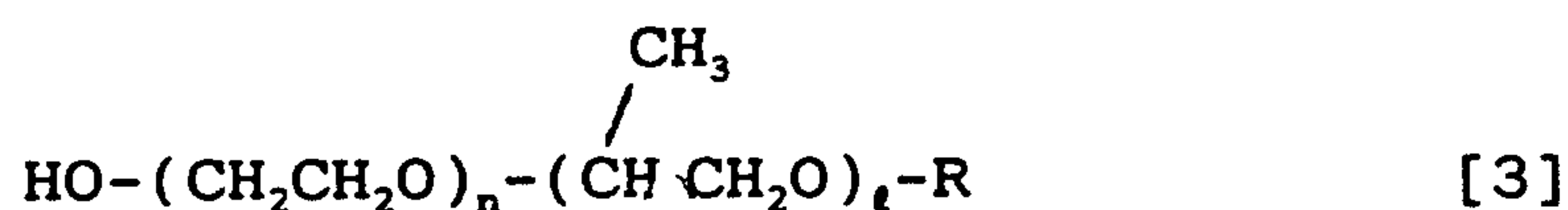
(a) at least one surfactant selected from the group
 5 consisting of higher alcohol-ethylene oxide adducts represented by General Formula [1], alkylphenol-ethylene oxide adducts represented by General Formula [2], ethylene oxide-propylene oxide copolymers represented by General Formula [3], and acetylene
 10 glycol-ethylene oxide adducts represented by General Formula [4], at a content of from 0.1 to 20 % by weight based on the total weight of the ink;



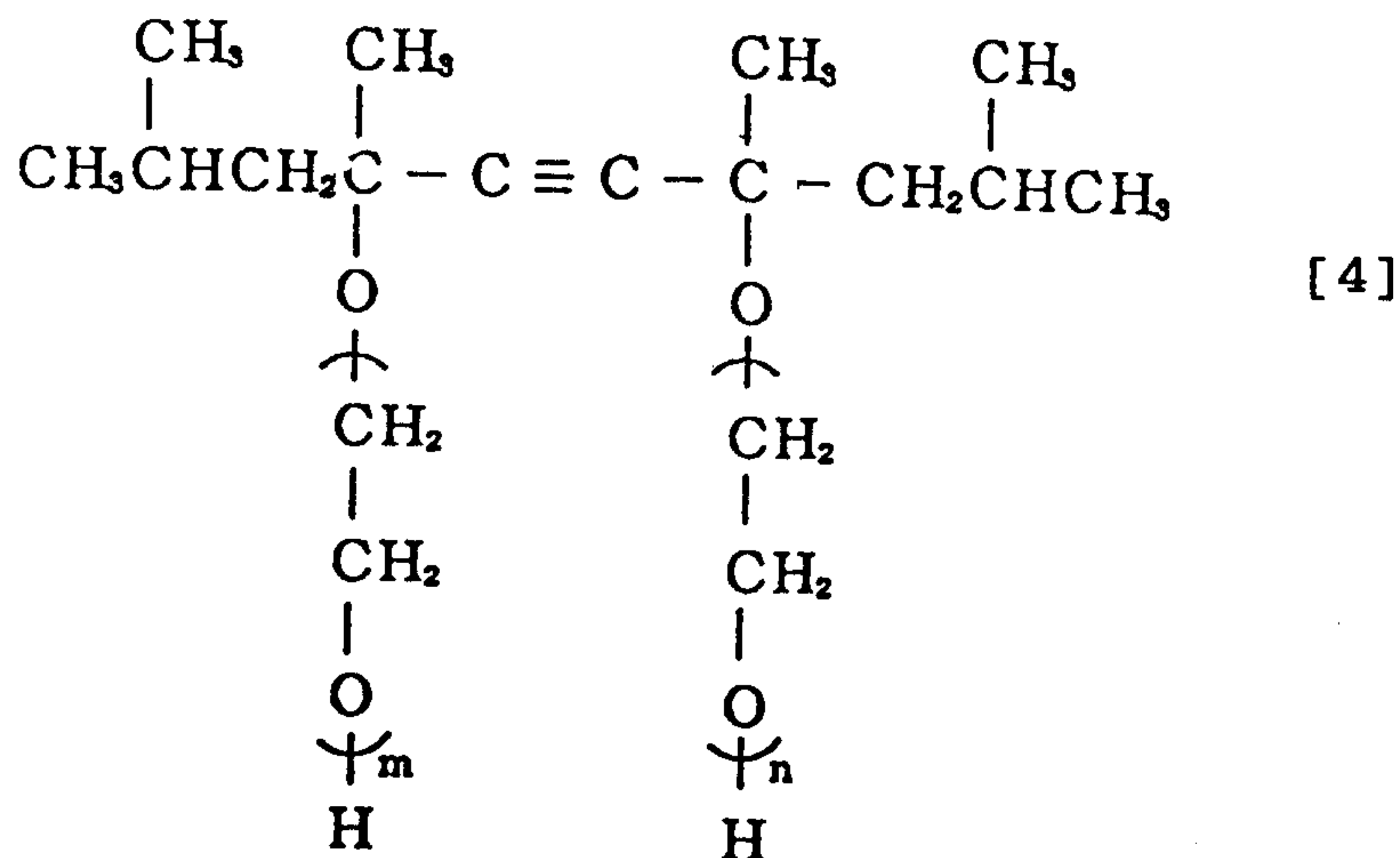
where R is alkyl, and n is an integer;



where R is alkyl, and n is an integer;



20 where R is alkyl or hydrogen, and n and l are respectively an integer;



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where m and n are respectively an integer;

(b) thiodiglycol; and

(c) urea or an derivative thereof.

2. An ink for ink-jet recording according to Claim 1, wherein the ink contains thiodiglycol at a content of from 1 to 30 % by weight.

3. An ink for ink-jet recording according to Claim 1, wherein the ink contains urea or the derivative thereof at a content of from 1 to 30 % by weight.

4. An ink for ink-jet recording according to Claim 1, wherein the value of n or n+m in General Formulas [1] to [4] is from 4 to 20.

5. An ink-jet recording method comprising the step of ejecting droplets of ink on to a recording medium, said ink comprising a dye, water, and the components (a), (b), and (c):

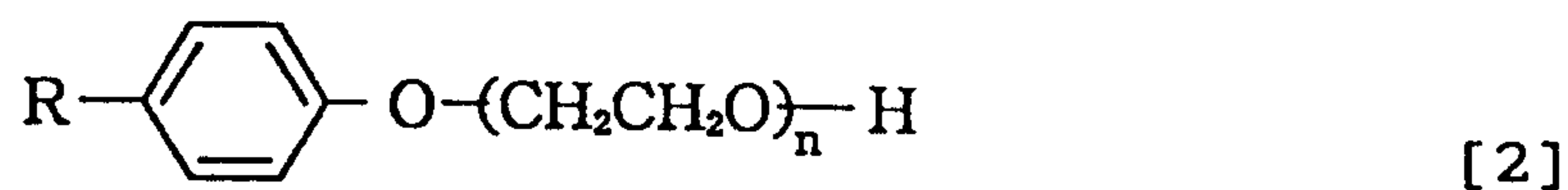
(a) at least one surfactant selected from the group consisting of higher alcohol-ethylene oxide adducts represented by General Formula [1], alkylphenol-ethylene oxide adducts represented by General Formula [2], ethylene oxide-propylene oxide copolymers represented by General Formula [3], and acetylene

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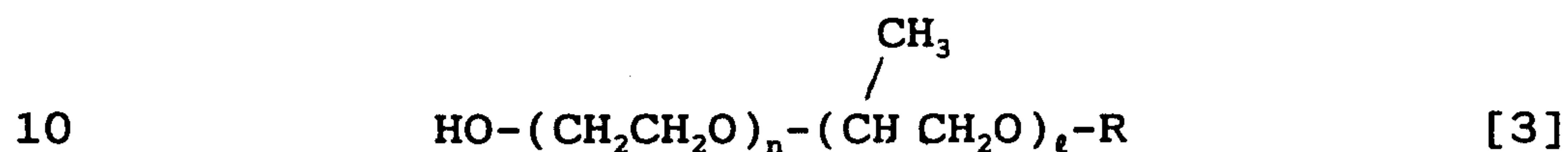
glycol-ethylene oxide adducts represented by General Formula [4], at a content of from 0.1 to 20 % by weight based on the total weight of the ink;



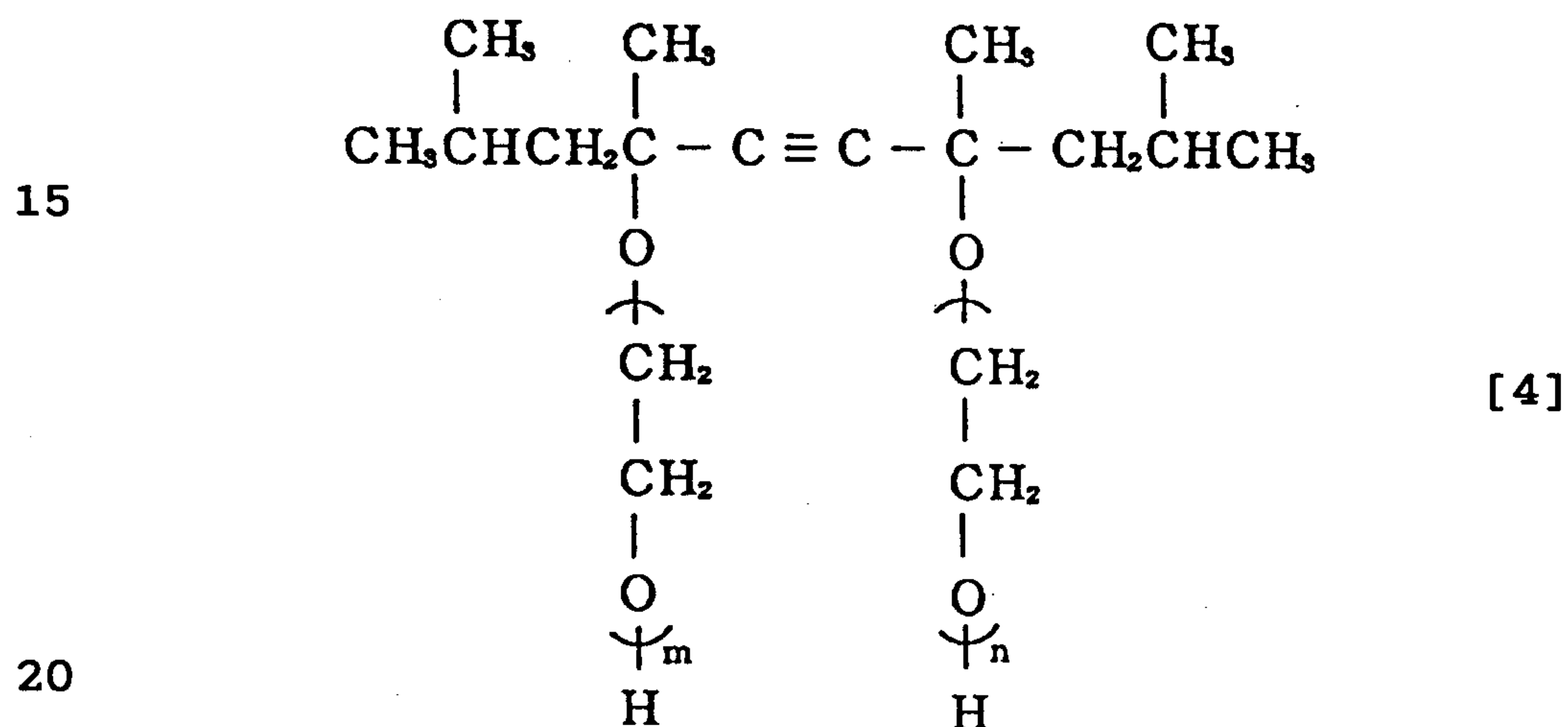
5 where R is alkyl, and n is an integer;



where R is alkyl, and n is an integer;



where R is alkyl or hydrogen, and n and l are respectively an integer;



20

where m and n are respectively an integer;

(b) thiodiglycol; and

(c) urea or an derivative thereof.

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6. An ink-jet recording method according to Claim 5, wherein ink droplets are ejected by action of

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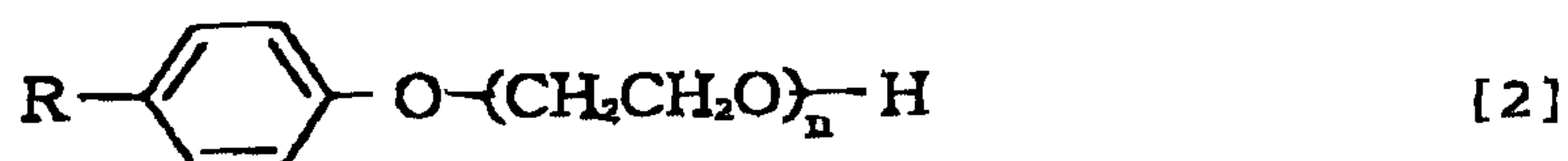
thermal energy applied to the ink.

7. A color ink-jet recording method comprising the step of ejecting droplets of ink of two or more colors onto adjacent or superposed positions on a recording medium, said ink comprising a dye, water and the components (a), (b), and (c):

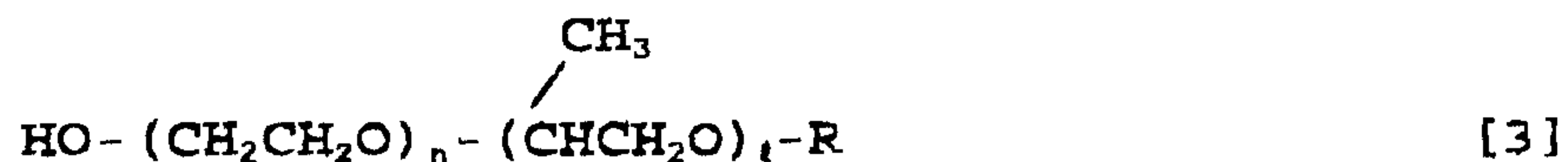
(a) at least one surfactant selected from the group consisting of higher alcohol-ethylene oxide adducts represented by General Formula [1], alkylphenol-ethylene oxide adducts represented by General Formula [2], ethylene oxide-propylene oxide copolymers represented by General Formula [3], and acetylene glycol-ethylene oxide adducts represented by General Formula [4], at a content of from 0.1 to 20 % by weight based on the total weight of the ink;



where R is alkyl, and n is an integer;

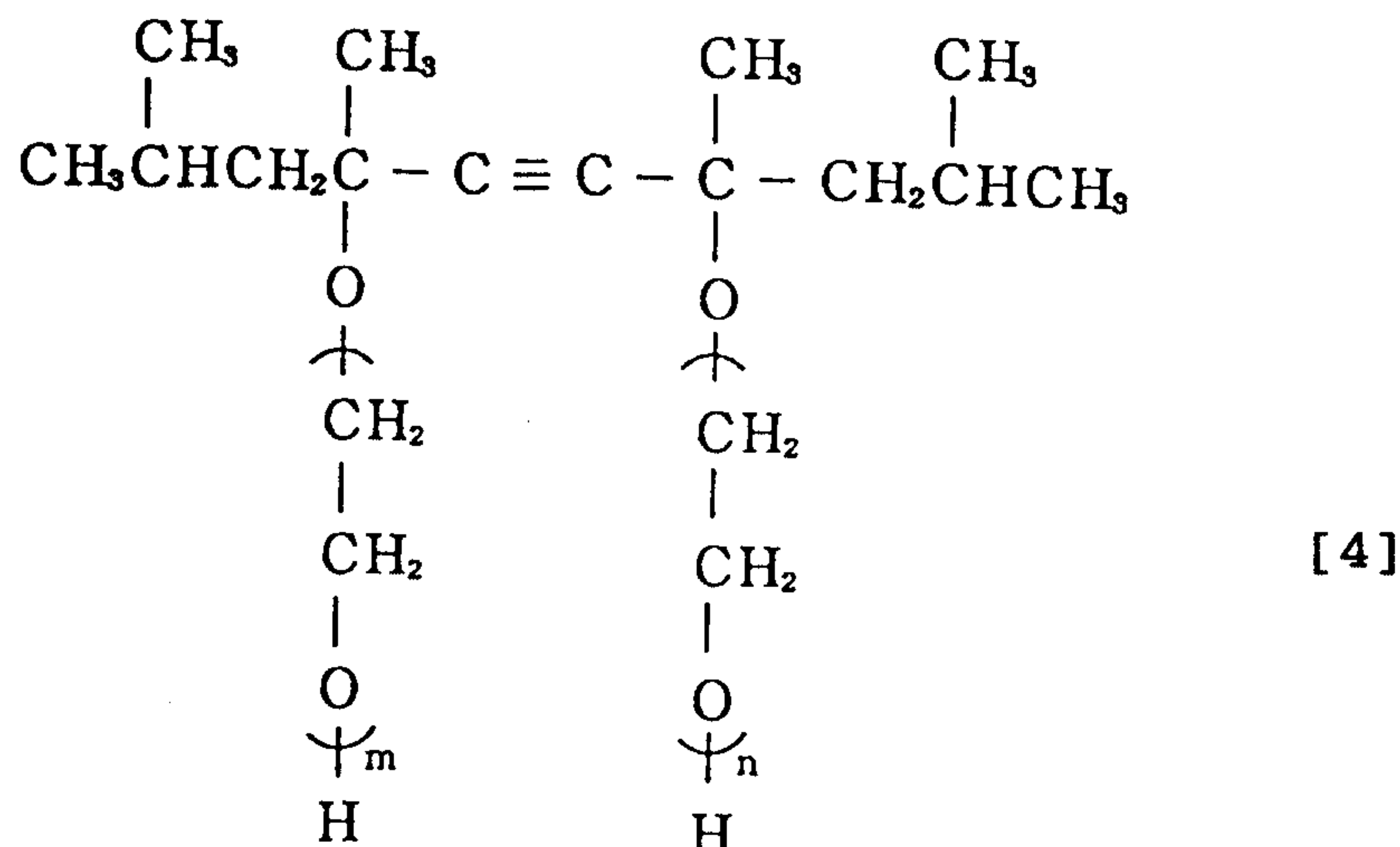


where R is alkyl, and n is an integer;



where R is alkyl or hydrogen, and n and l are respectively an integer;

5

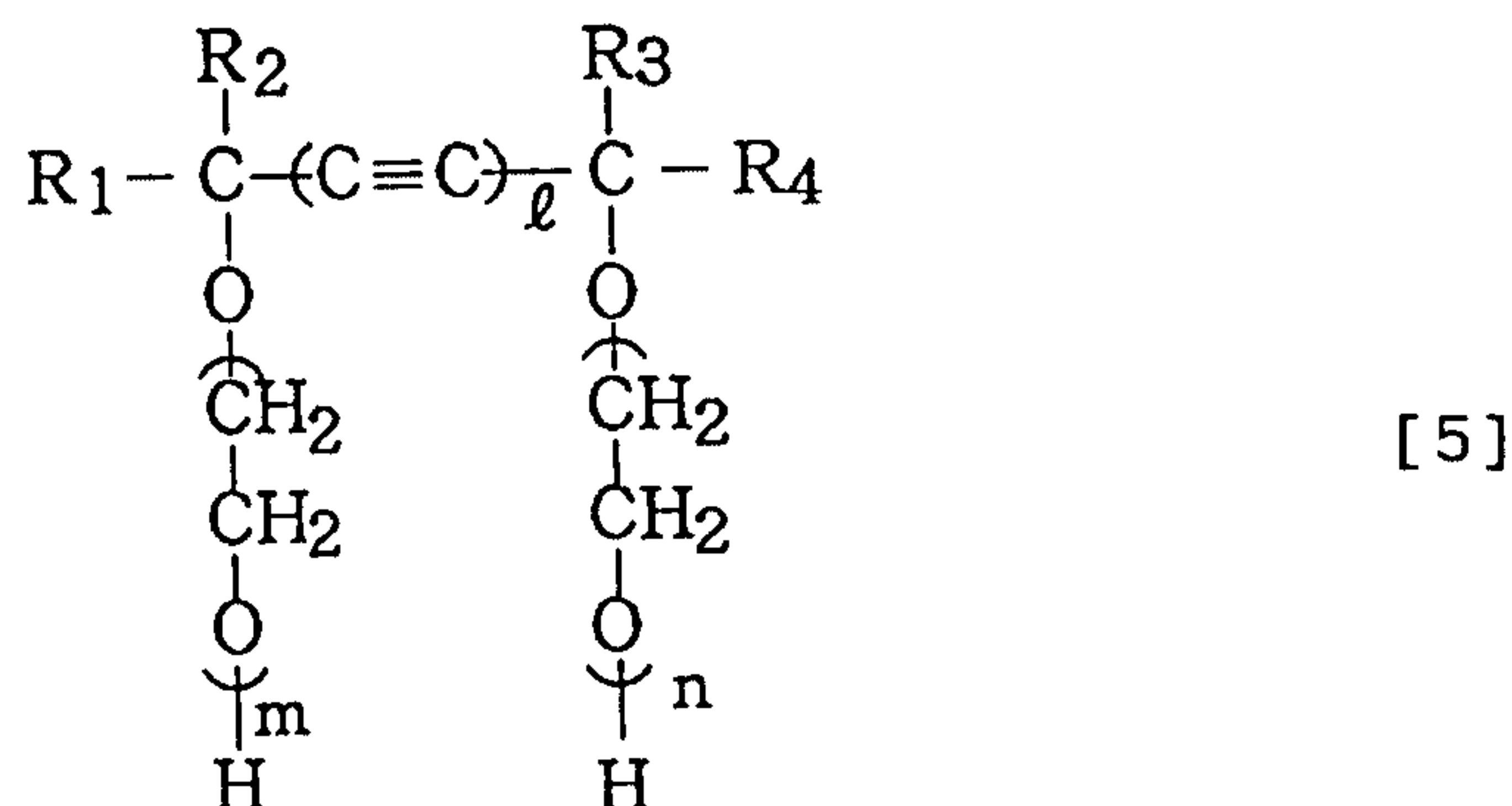


- 10 where m and n are respectively an integer;
 (b) thiodiglycol; and
 (c) urea or an derivative thereof.

8. A color ink-jet recording method according
 15 to Claim 7, wherein ink droplets are ejected by action
 of thermal energy applied to the ink.

9. An ink containing at least a dye, a water-
 soluble organic solvent, and water: said ink comprises
 20 further a compound of the formula

25



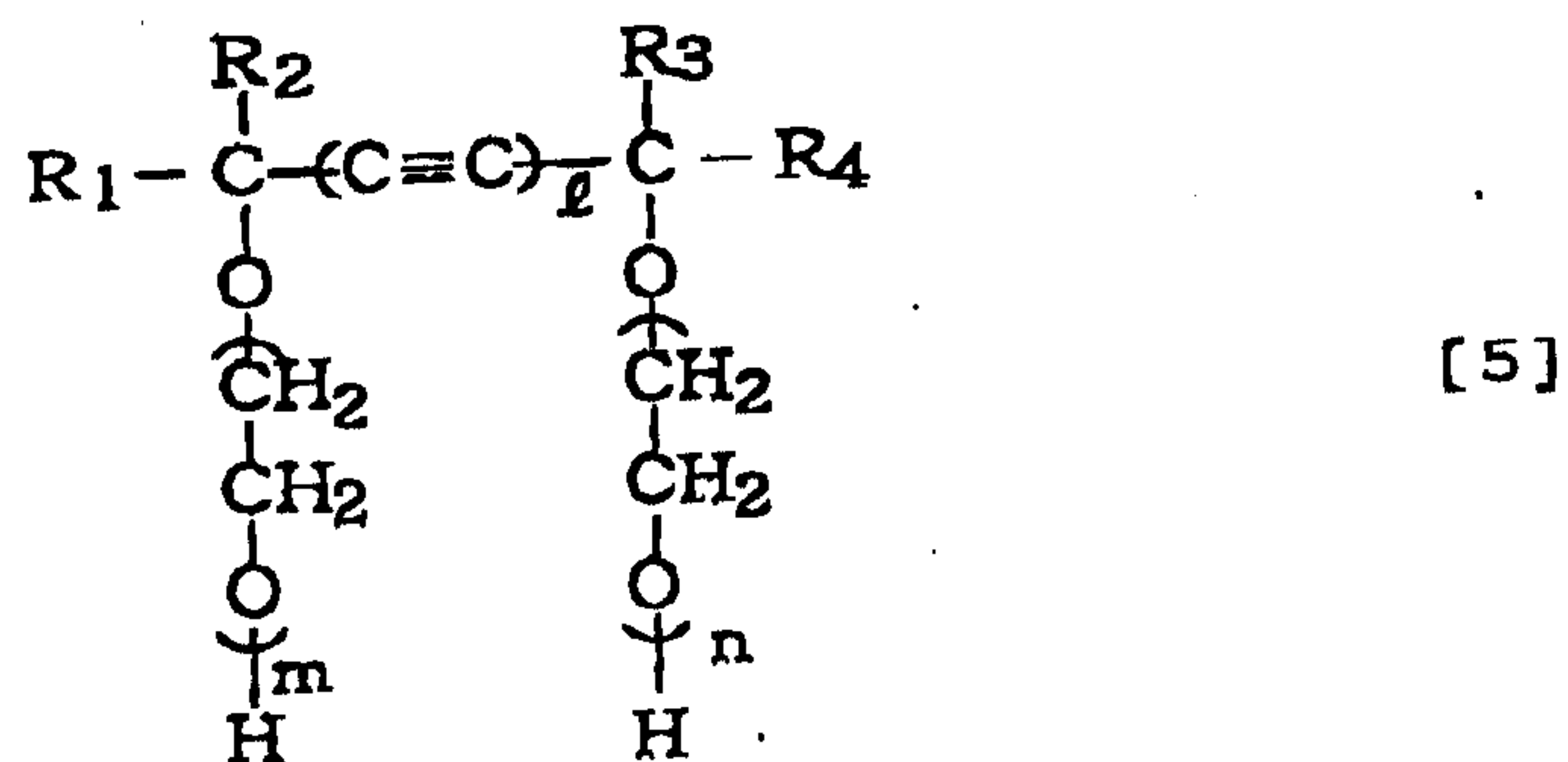
- 60 -

where R_1 , R_2 , R_3 , and R_4 are respectively hydrogen, an alkyl or alkenyl group of 1 to 4 carbon atoms, or a substituted or unsubstituted phenyl group at a content of from 0.1 to 20 % by weight based on the total weight of the ink; and $m+n$ is ranging from 0 to 50; and l is a number of 2 or more.

10. An ink according to Claim 9, wherein the ink contains the compound represented by General Formula [5] at a content of from 0.001 % to 20 % by weight.

11. An ink according to Claim 9, wherein the water-soluble organic solvent is selected from the group consisting of polyhydric alcohols, monohydric alcohols, and derivatives thereof.

12. An ink-jet recording method comprising the step of recording by depositing droplets of ink on a recording medium, said ink comprising a dye, a water soluble organic solvent, water, and a compound of the formula



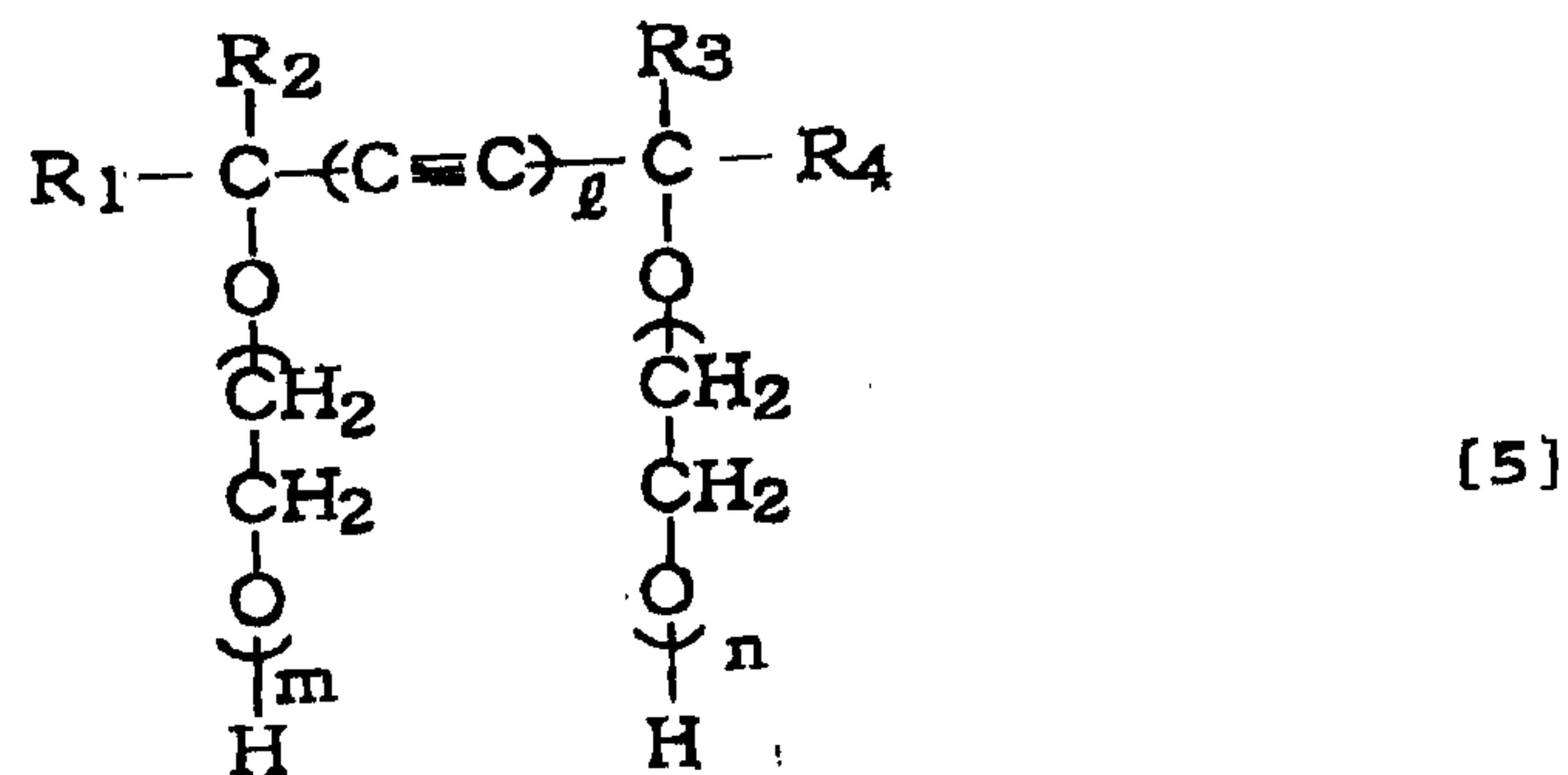
where R_1 , R_2 , R_3 , and R_4 are respectively hydrogen, an

- 61 -

alkyl or alkenyl group of 1 to 4 carbon atoms, or a substituted or unsubstituted phenyl group at a content of from 0.1 to 20 % by weight based on the total weight of the ink; and $m+n$ is ranging from 0 to 50; and l is a number of 2 or more.

13. An ink-jet recording method according to Claim 12, wherein ink droplets are ejected by action of thermal energy applied to the ink.

14. A color ink-jet recording method comprising the step of ejecting droplets of ink of two or more colors onto adjacent or superposed positions on a recording medium, said ink comprising a dye, a water-soluble organic solvent, water, and the compound of the formula



where R_1 , R_2 , R_3 , and R_4 are respectively hydrogen, an alkyl or alkenyl group of 1 to 4 carbon atoms, or a substituted or unsubstituted phenyl group; at a content of from 0.1 to 20 % by weight based on the total weight of the ink; and $m+n$ is ranging from 0 to 50; and l is a number of 2 or more.

15. A color ink-jet recording method according

to Claim 14, wherein ink droplets are ejected by action of thermal energy applied to the ink.

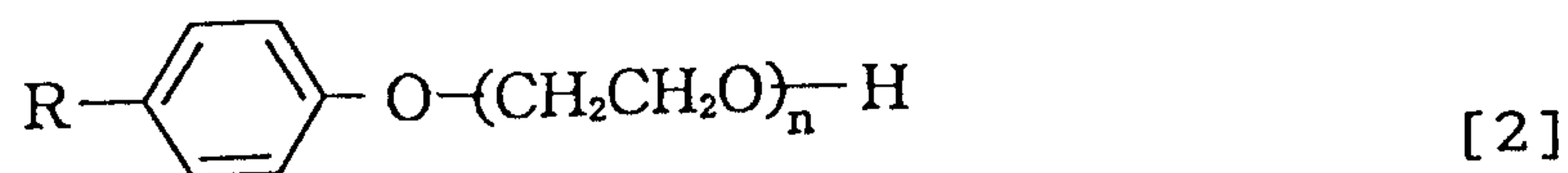
16. An ink-jet recording method according to
5 any of Claims 5, 7, 12, and 14, wherein the recording medium has fiber exposed on the surface thereof.

17. A color ink-jet recording method comprising the
10 step of ejecting droplets of two or more color inks in accordance of pulse signals onto adjacent or superposed position on a recording medium, wherein each of said inks comprises a dye, water, and the components (a), (b), and (c) below:

15 (a) at least one nonionic surfactant selected from the group consisting of higher alcohol-ethylene oxide adducts represented by General Formula [1], alkylphenol-ethylene oxide adducts represented by General Formula [2],
20 ethylene oxide-propylene oxide copolymers represented by General Formula [3], and acetylene glycol-ethylene oxide adducts represented by General Formula [4], in an amount of from 1.0 to 20.0% by weight based on the total weight of the ink;

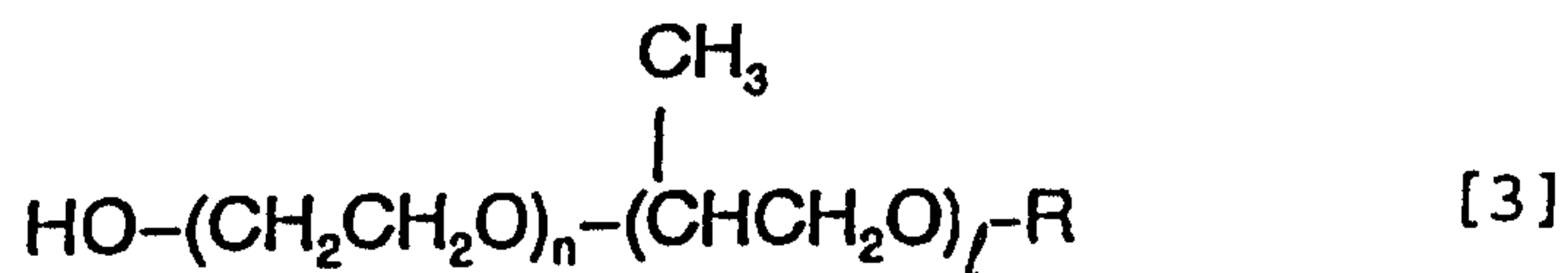


where R is alkyl, and n is an integer;



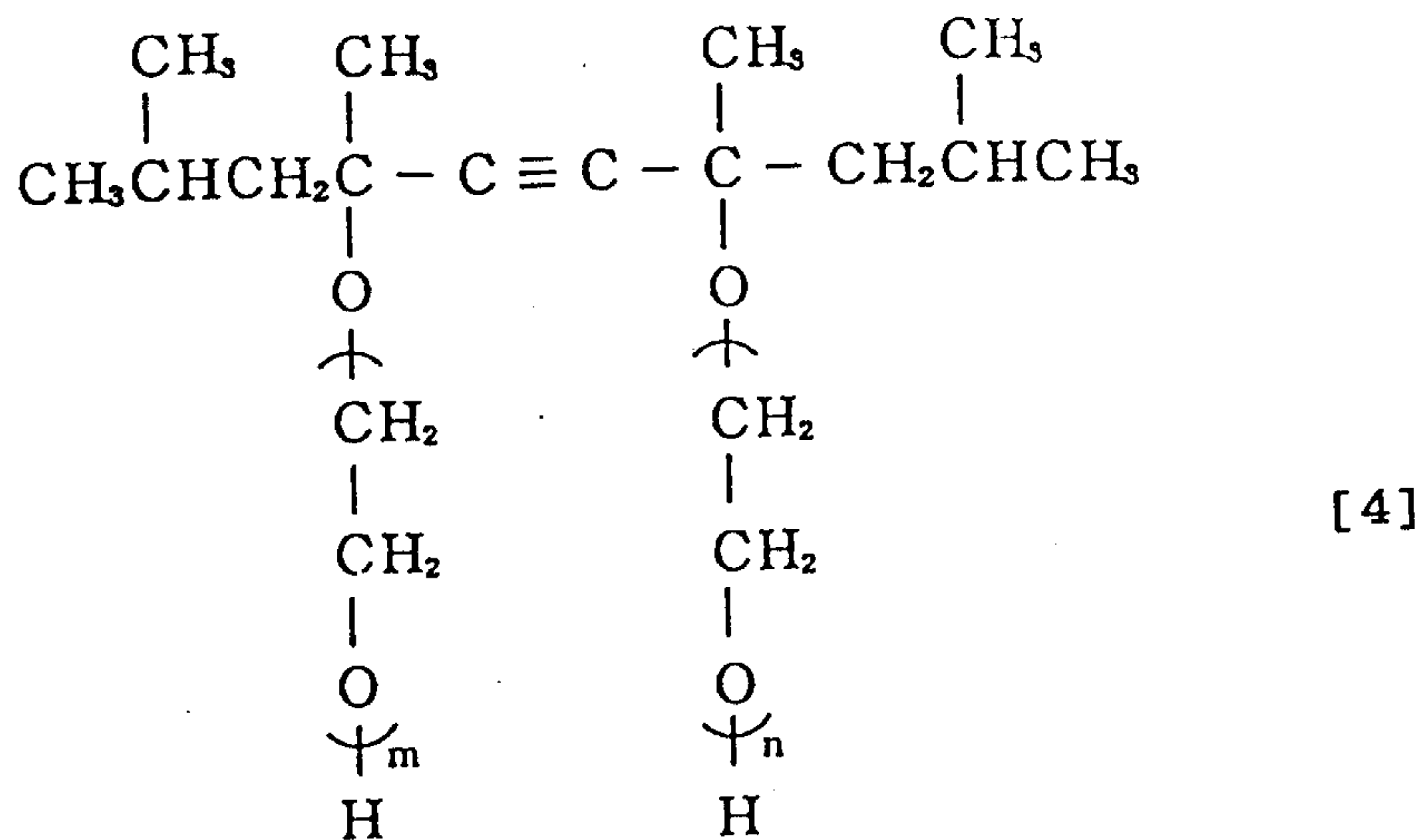
where R is alkyl, and n is an integer;

5



10 where R is alkyl or hydrogen, and n and l are respectively an integer;

15



20

where m and n are respectively an integer;

(b) thiodiglycol; and

(c) urea or a derivative thereof,

25

the ink ejected for one pulse is in an amount of from 10 to 70 p/, and the feathering rate (A) defined by Equation [I] is in the range of from 2.5 to 3.5:

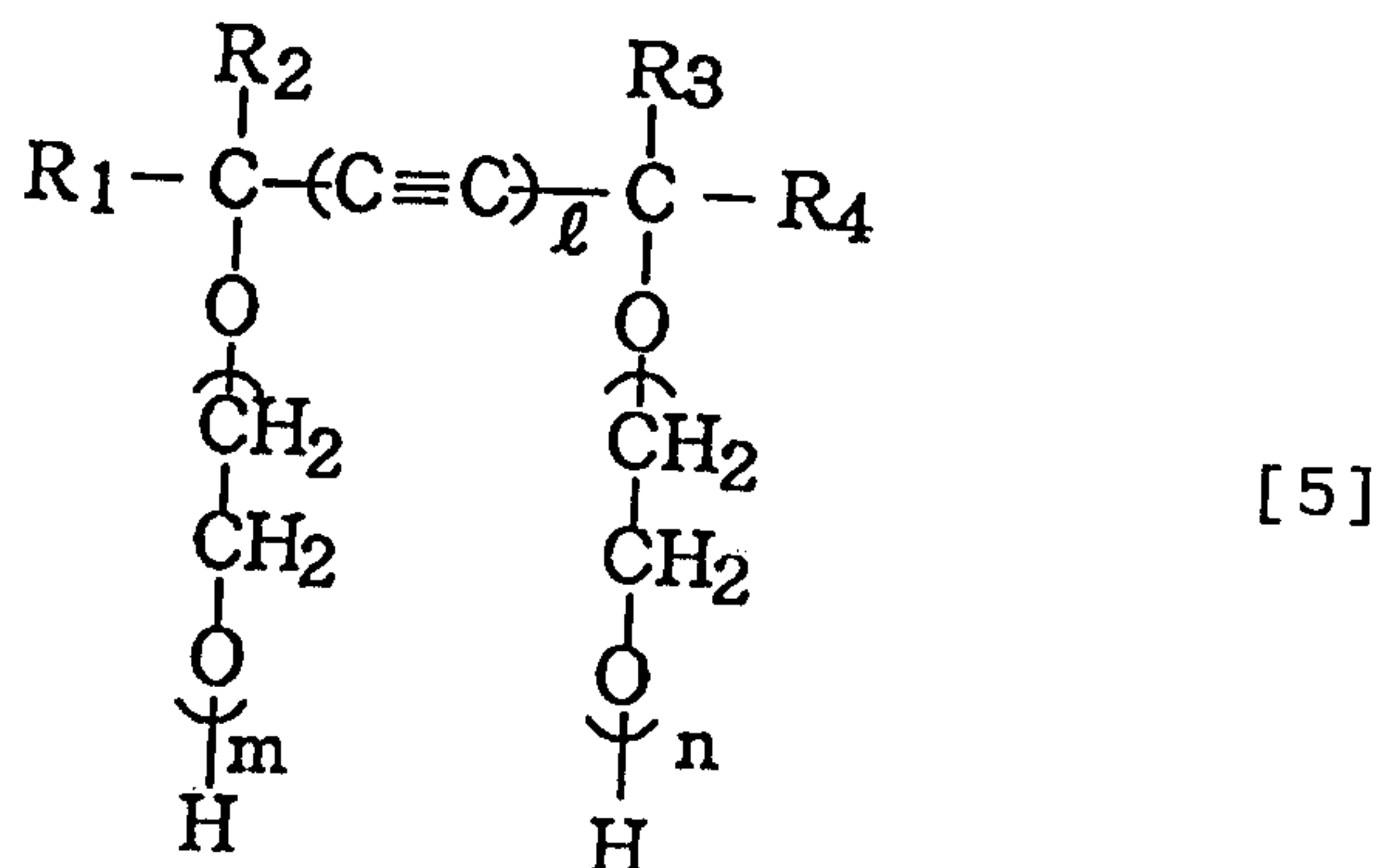
$$A = B/C \quad [I]$$

where B is a diameter (μm) of a dot formed on plain paper, and C is a diameter (μm) of the ejected ink droplet.

18. A color ink-jet recording method according to Claim 17, wherein the nonionic surfactant contains at least one selected from polyoxyethylene alkyl ether, polyoxyethylene phenyl ether, polyoxyethylene-polyoxypropylene glycol, polyoxyethylene-polyoxypropylene alkyl ether, and acetylene glycol-polyethylene oxide adducts.

19. A color ink-jet recording method according to Claim 17, wherein the recording medium has fiber exposed on the surface thereof.

20. A color ink-jet recording method comprising the step of ejecting droplets of two or more color inks containing at least a dye, a water-soluble organic solvent, and water in accordance of pulse signals onto adjacent or superposed position on a recording medium, wherein each of said inks comprises further (a) a nonionic surfactant of the formula



where R_1 , R_2 , R_3 , and R_4 are respectively hydrogen, an alkyl or alkenyl group of 1 to 4 carbon atoms, or a substituted or unsubstituted phenyl group, in an amount of from 1.0 to 20.0 % by weight based on the total weight of the ink; and $m+n$ is ranging from 0 to 50; and ℓ is a number of 2 or more,

(b) thiodiglycol; and

(c) urea or a derivative thereof,

the ink ejected for one pulse is in an amount of from 10 to 70 pℓ, and the feathering rate (A) defined by Equation [I] is in the range of from 2.5 to 3.5:

$$A = B/C \quad [I]$$

where B is a diameter (μm) of a dot formed on plain paper, and C is a diameter (μm) of the ejected ink droplet.

21. A color ink-jet recording method according to claim 20, wherein the nonionic surfactant contains at least one selected from acetylene glycol-polyethylene oxide adducts.

22. A color ink-jet recording method according to claim 20, wherein the recording medium has fiber exposed on the surface thereof.

FIG. 1

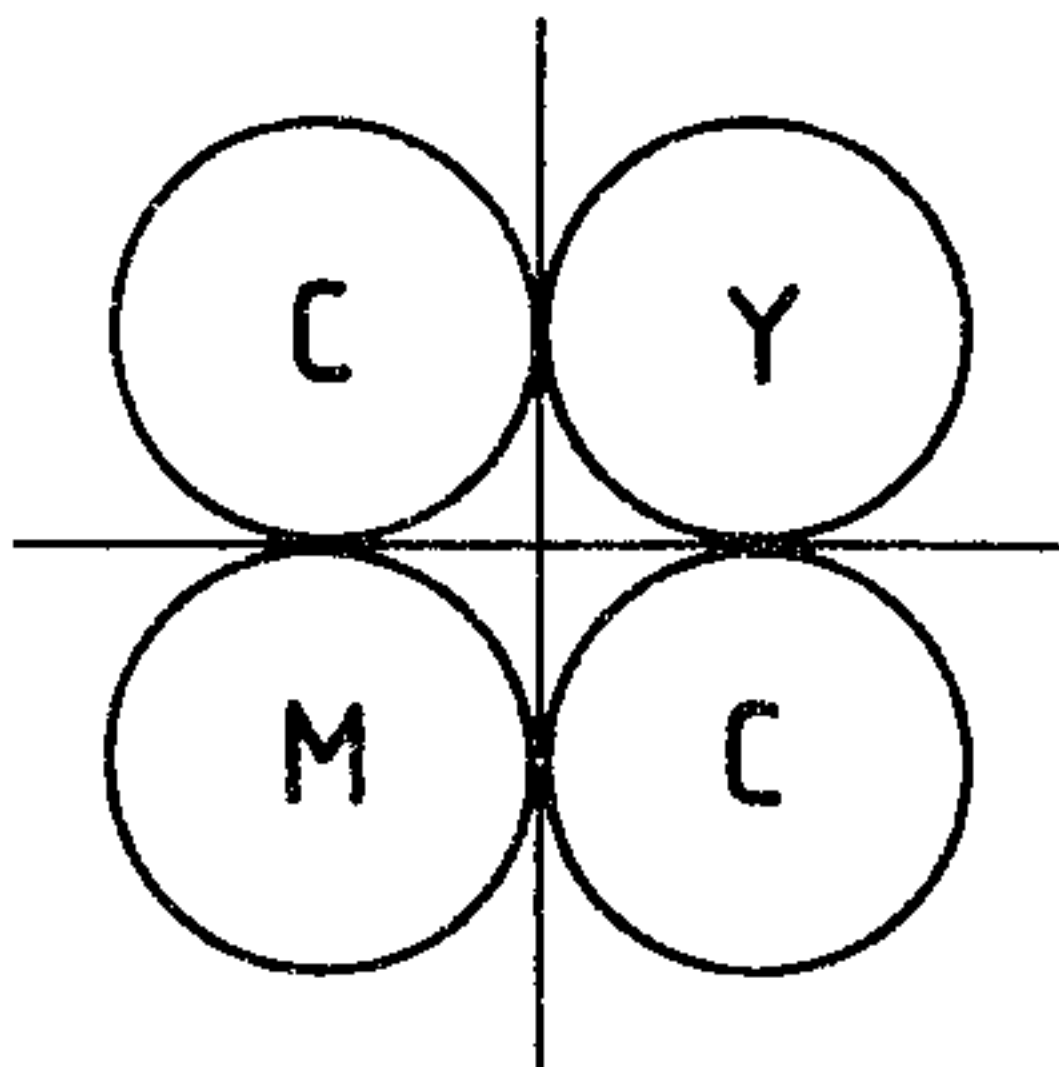


FIG. 2

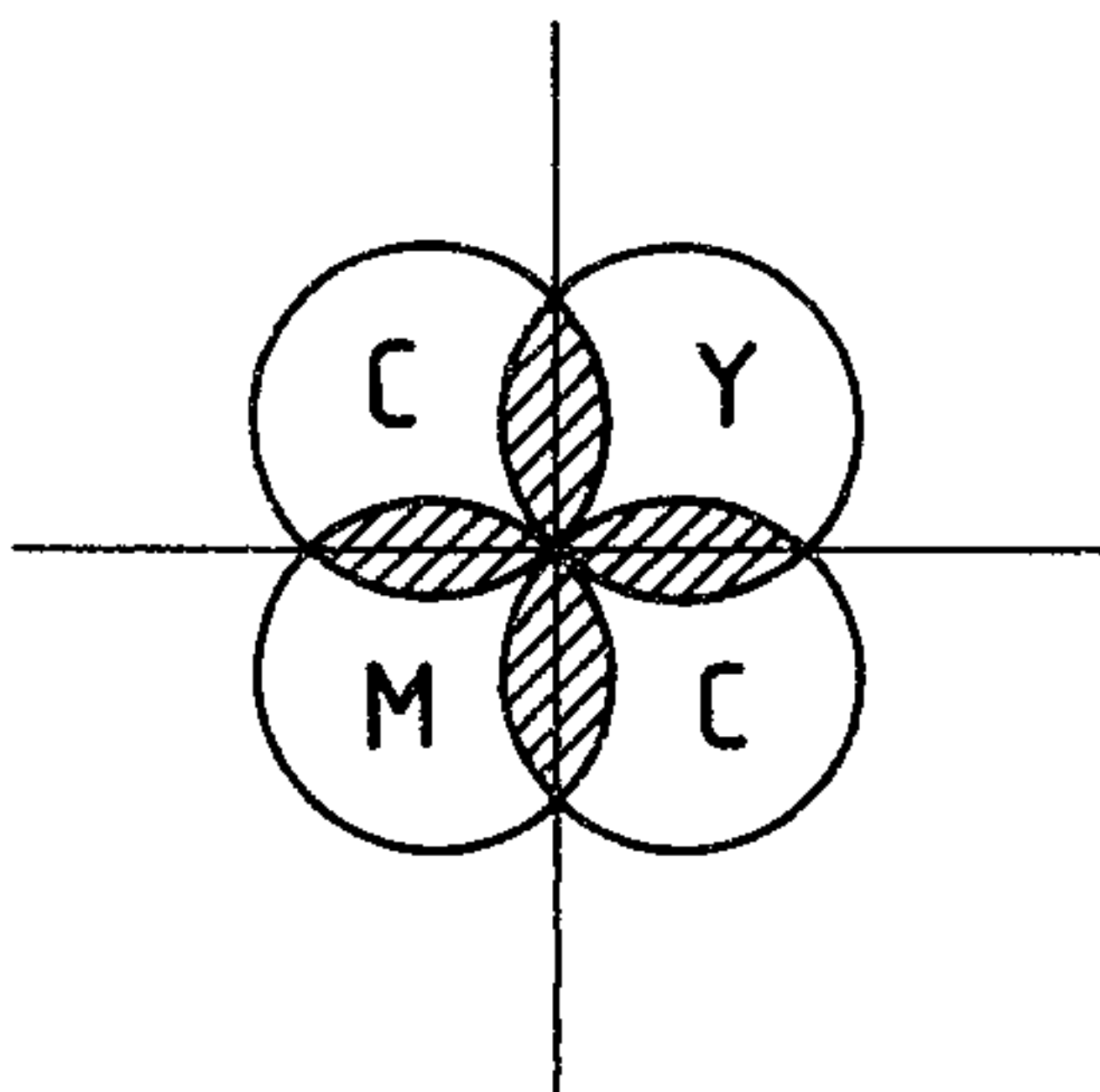
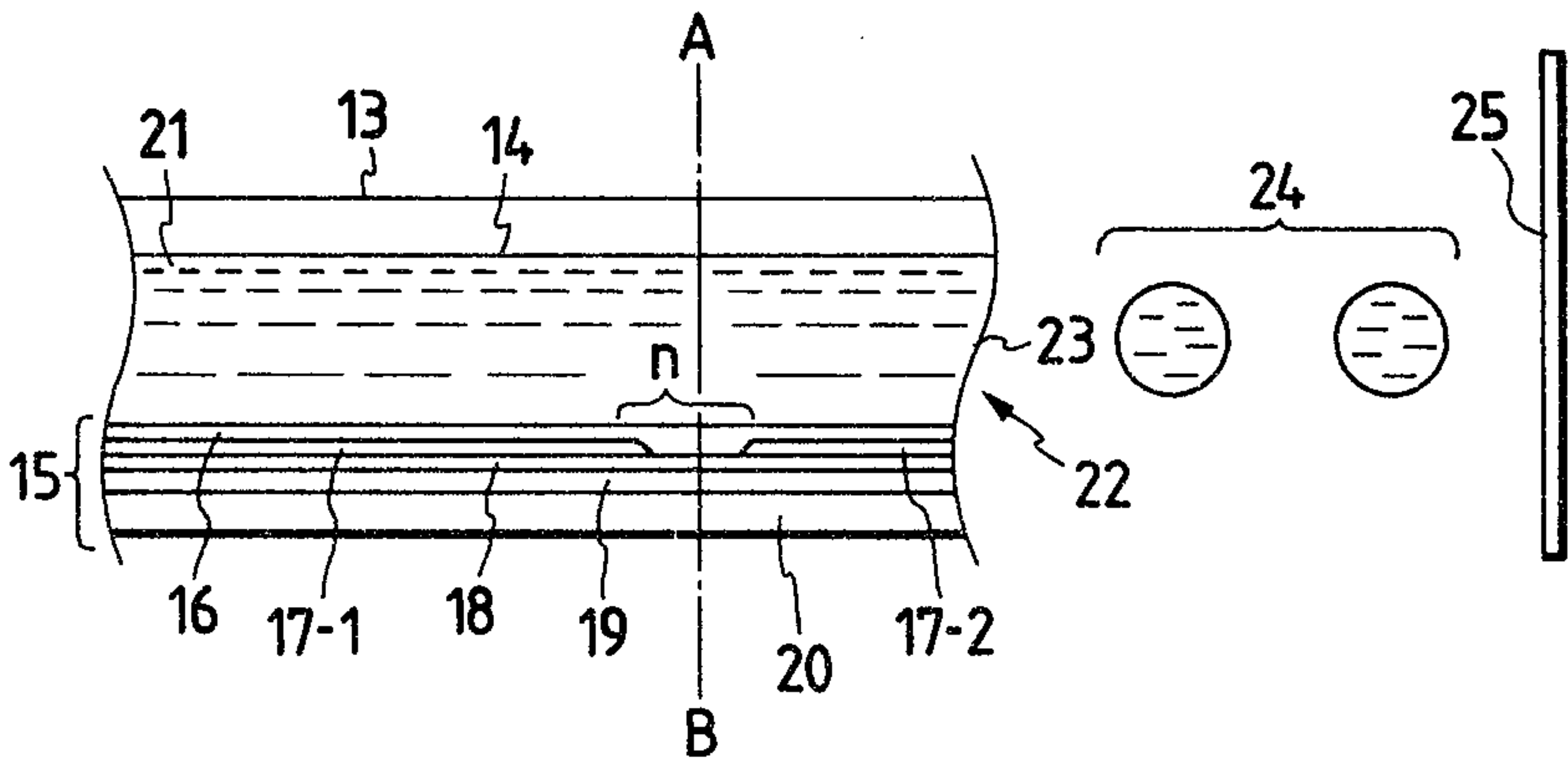


FIG. 3



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FIG. 4

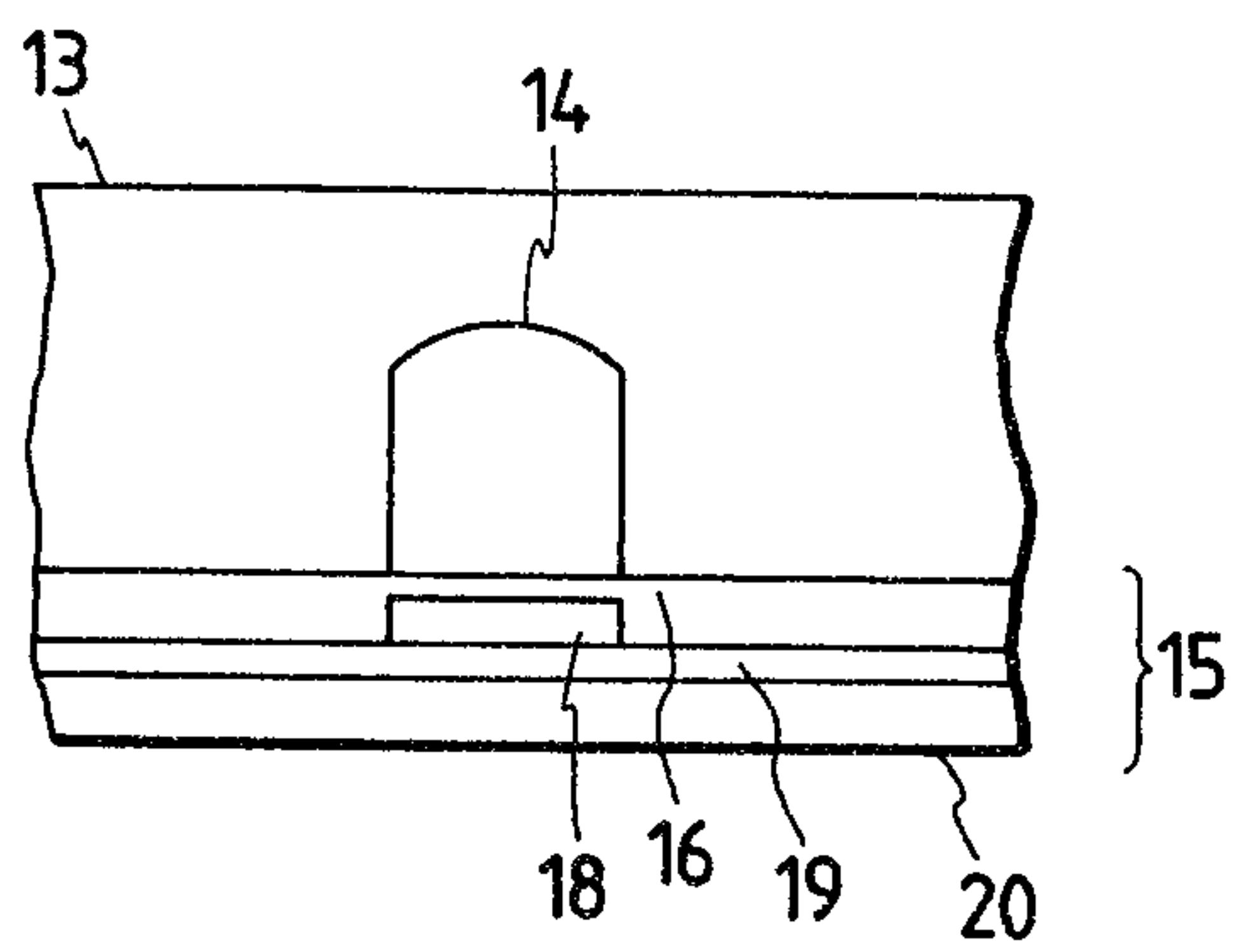
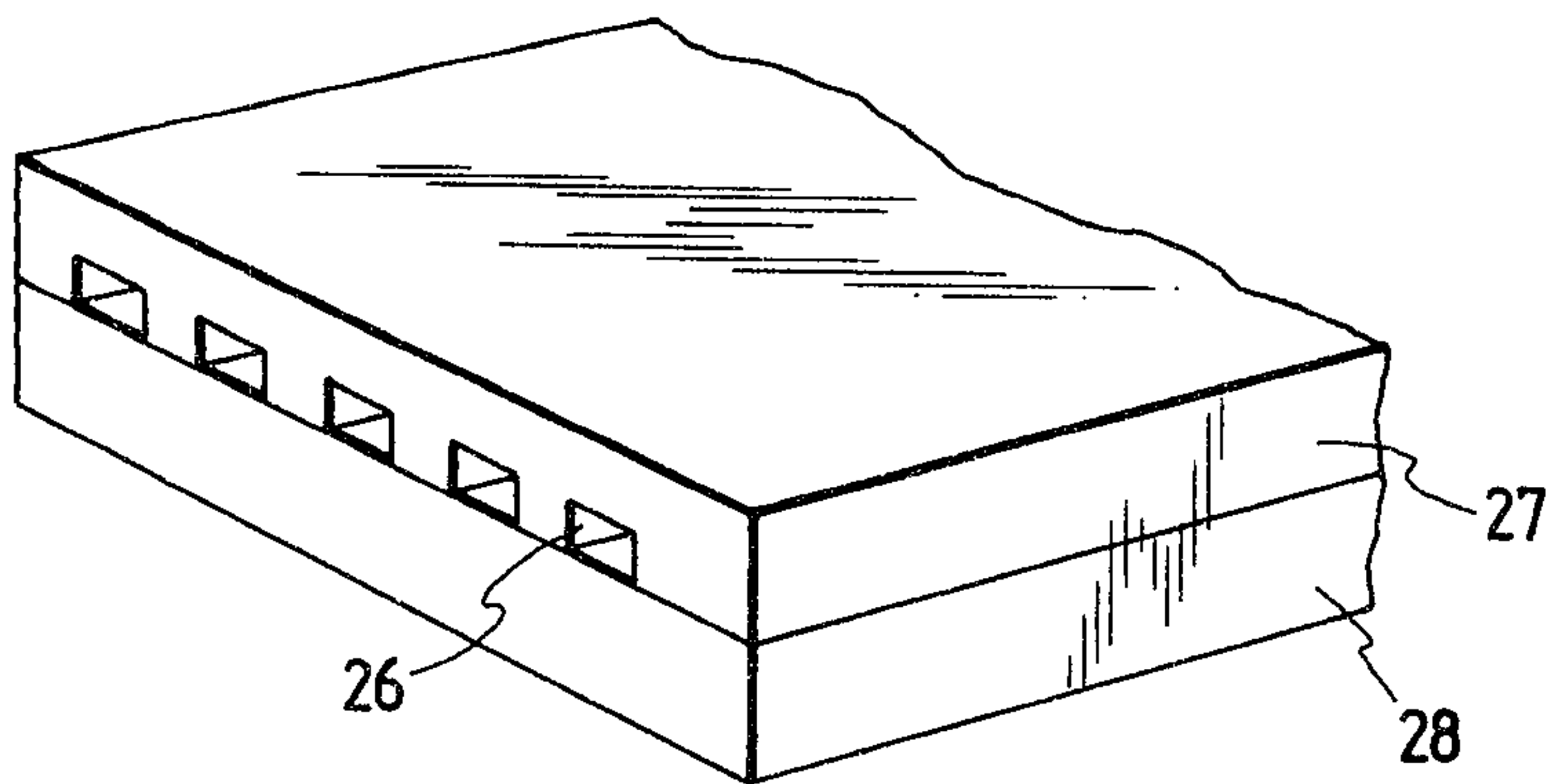
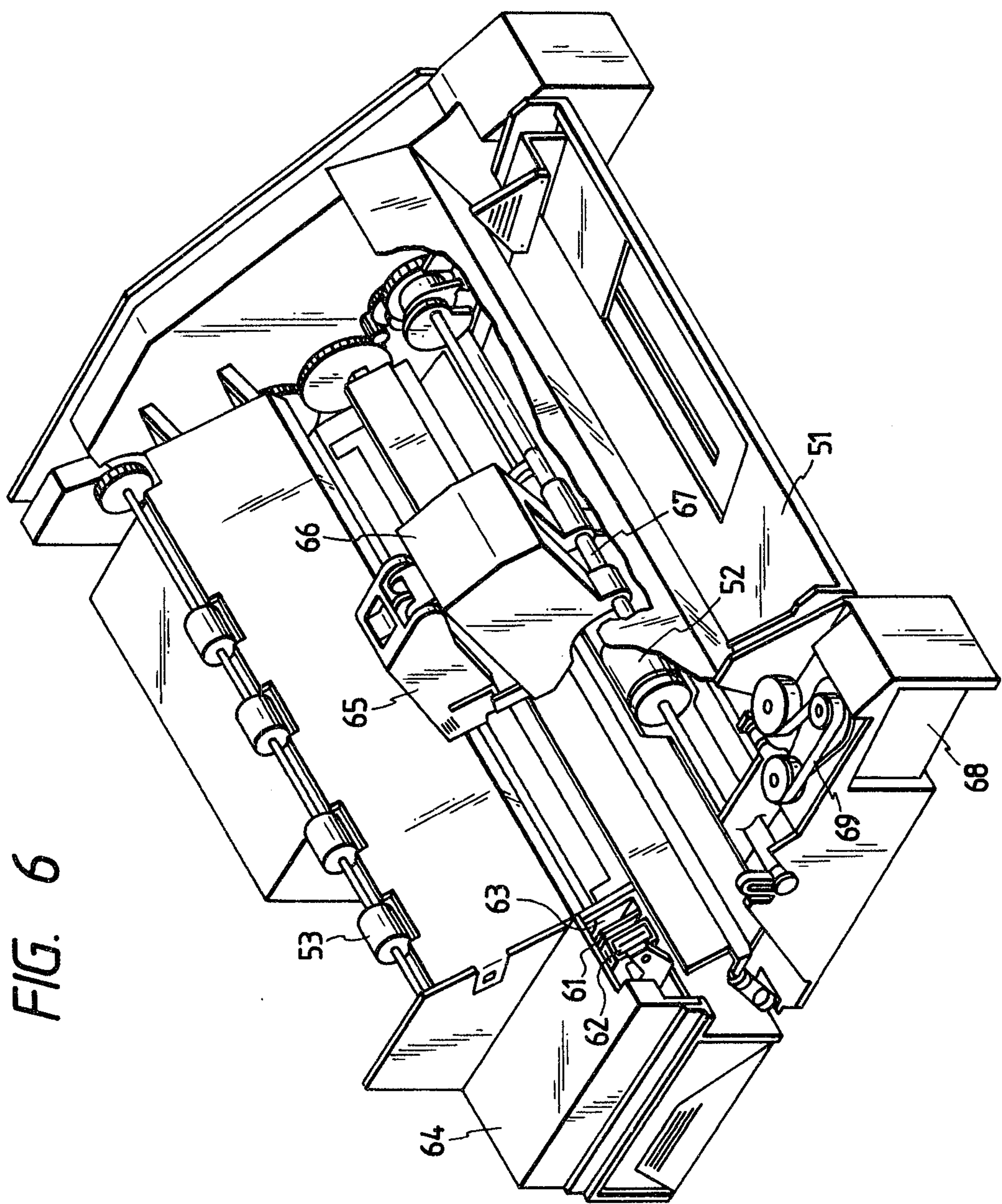


FIG. 5



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FIG. 6



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FIG. 7

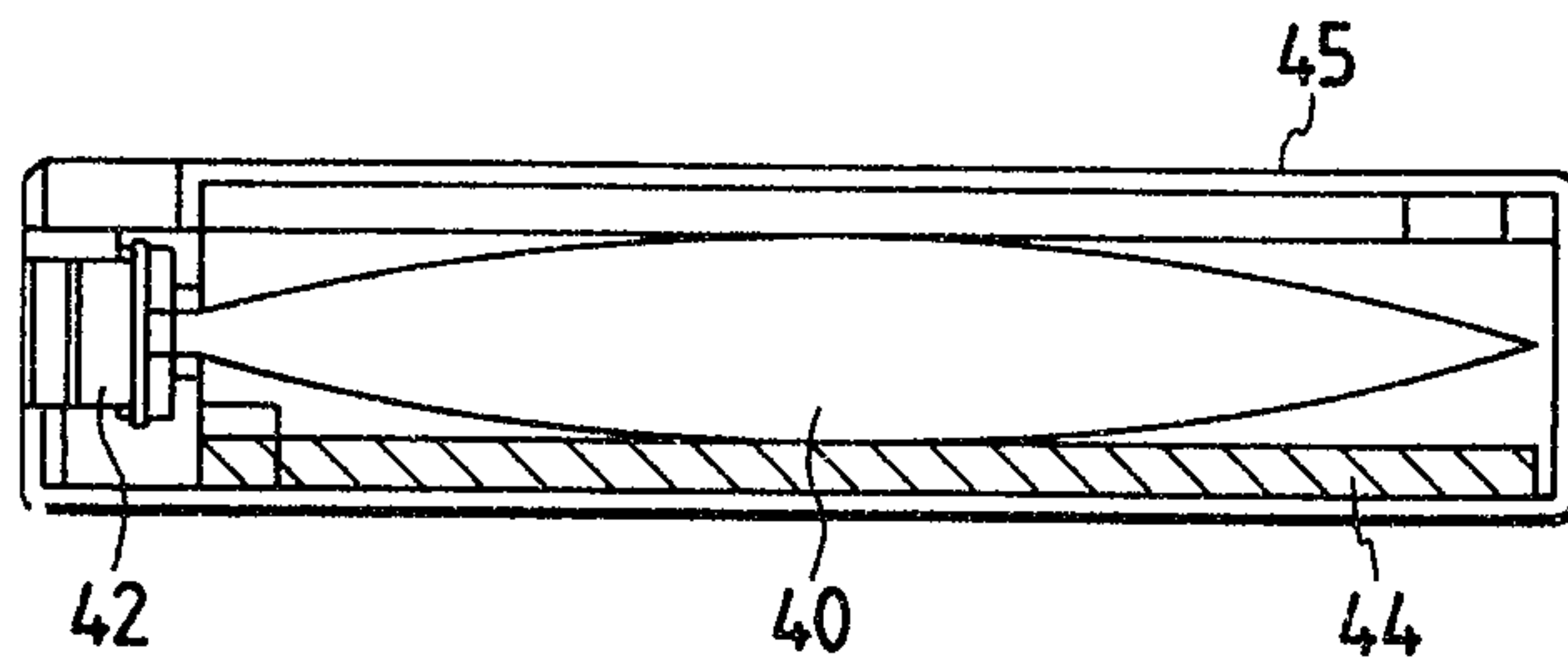
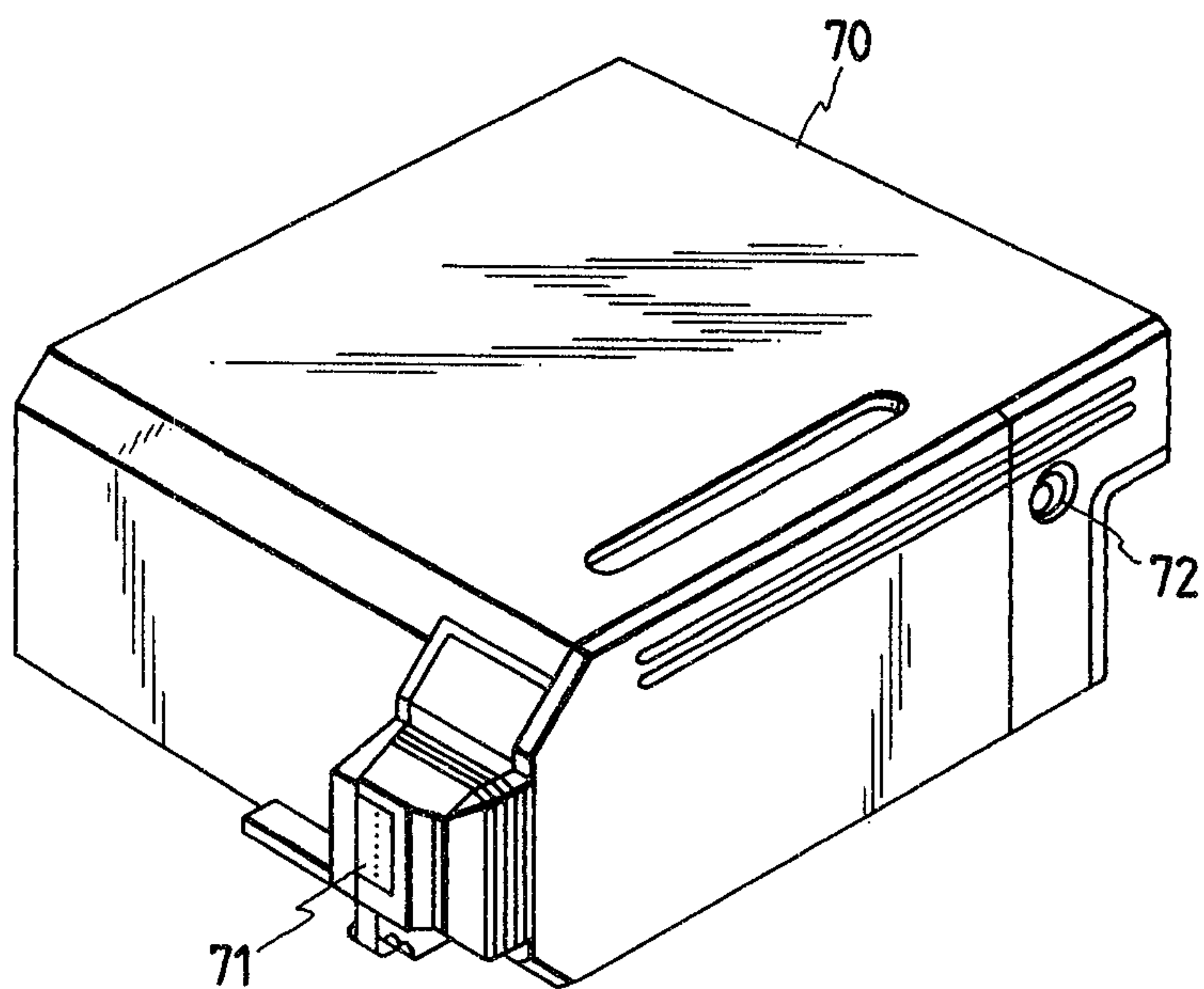


FIG. 8



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FIG. 9

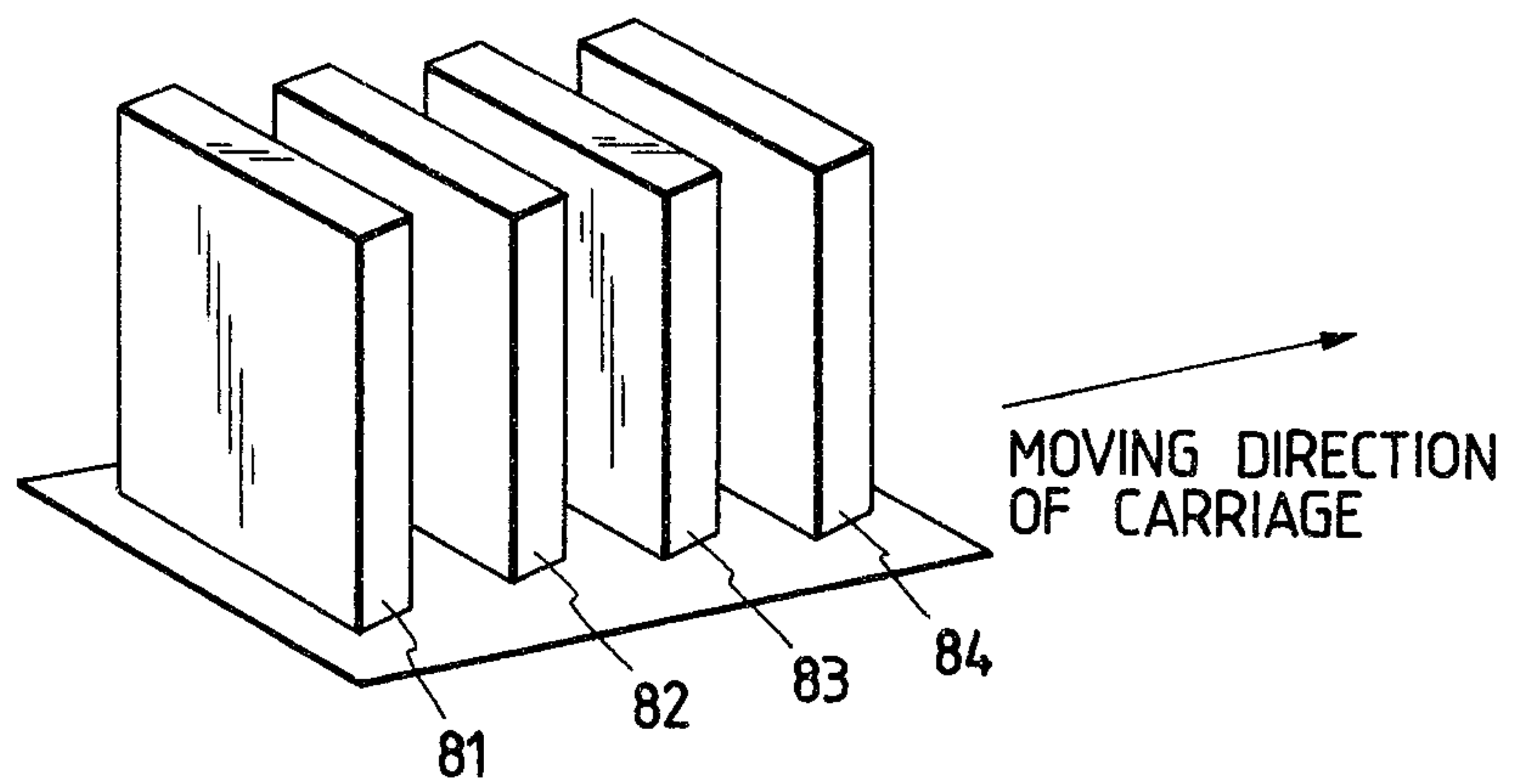
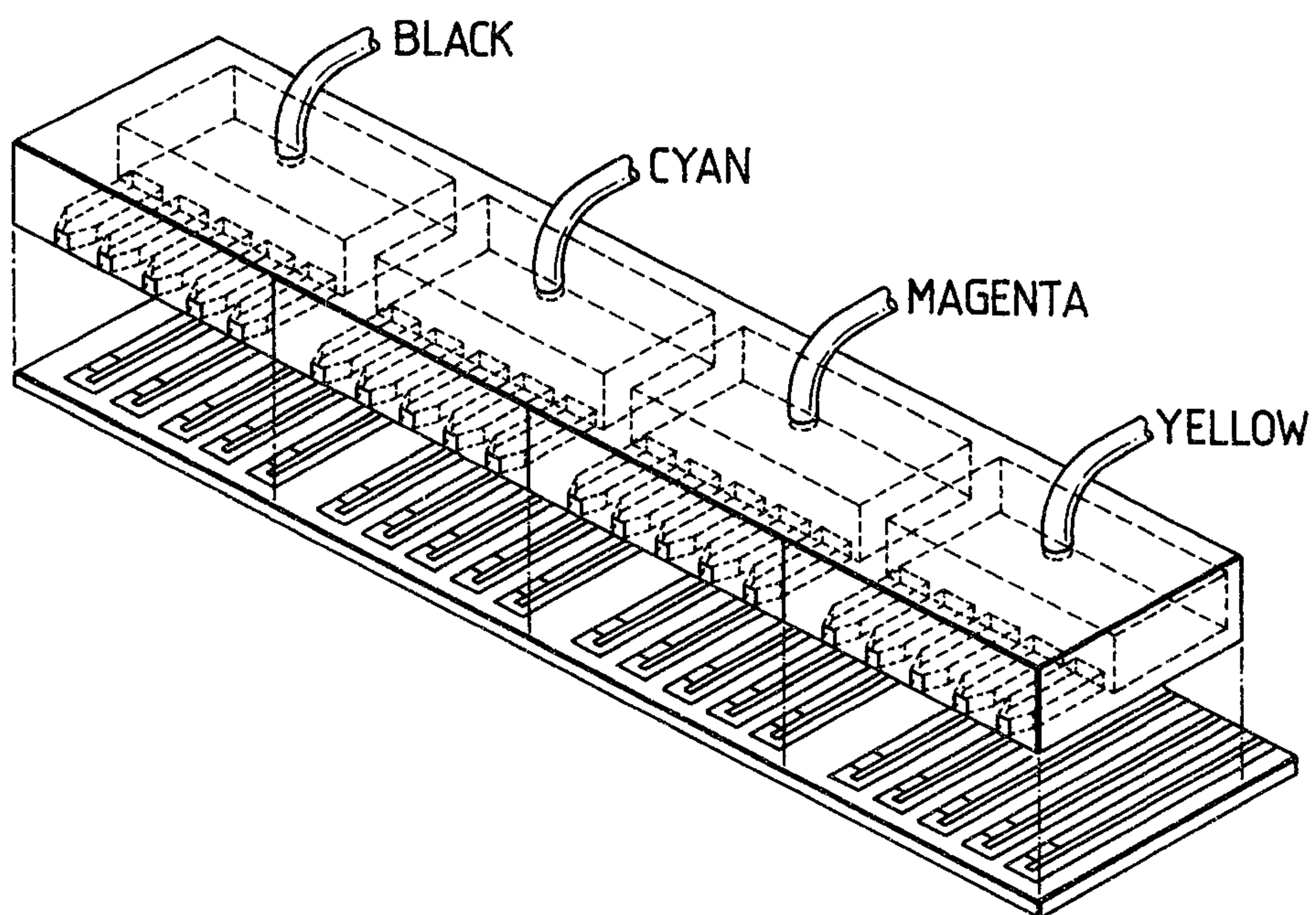


FIG. 10



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