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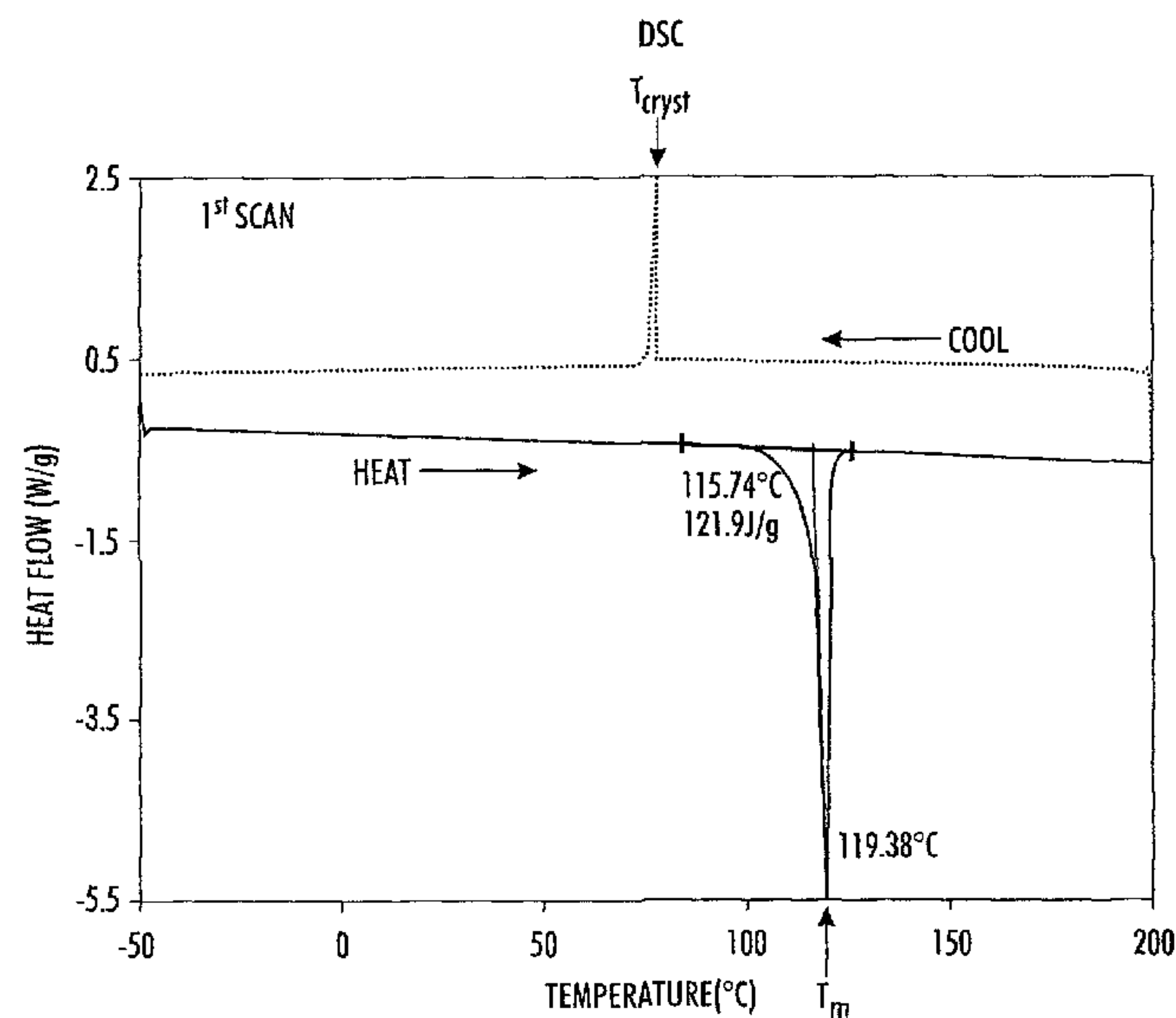
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(54) **Titre : ENCRE A CHANGEMENT DE PHASE ET METHODES DE FABRICATION CONNEXES**

(54) **Title: PHASE CHANGE INKS AND METHODS OF MAKING THE SAME**



(57) **Abrégé/Abstract:**

A solid ink composition comprising an amorphous component, a crystalline material, and optionally, a colorant, which are suitable for ink jet printing, including printing on coated paper substrates. In embodiments, the amorphous and crystalline components are both synthesized from an esterification reaction.

ABSTRACT

A solid ink composition comprising an amorphous component, a crystalline material, and optionally, a colorant, which are suitable for ink jet printing, including printing on coated paper substrates. In embodiments, the amorphous and crystalline components are both synthesized from an esterification reaction.

PHASE CHANGE INKS AND METHODS OF MAKING THE SAME

BACKGROUND

[0002] The present embodiments relate to solid ink compositions characterized by being solid at room temperature and molten at an elevated temperature at which the molten ink is applied to a substrate. These solid ink compositions can be used for ink jet printing. The present embodiments are directed to a novel solid ink composition comprising an amorphous component, a crystalline material, and optionally a colorant, and methods of making the same.

[0003] Ink jet printing processes may employ inks that are solid at room temperature and liquid at elevated temperatures. Such inks may be referred to as solid inks, hot melt inks, phase change inks and the like. For example, U.S. Pat. No. 4,490,731, discloses an apparatus for dispensing solid ink for printing on a recording medium such as paper. In thermal ink jet printing processes employing hot melt inks, the solid ink is melted by the heater in the printing apparatus and utilized (jetted) as a liquid in a manner similar to that of conventional thermal ink jet printing. Upon contact with the printing recording medium, the molten ink solidifies rapidly, enabling the colorant to substantially remain on the surface of the recording medium instead of being carried into the recording medium (for example, paper) by capillary action, thereby enabling higher print density than is generally obtained with liquid inks. Advantages of a phase change ink in ink jet printing are thus elimination of potential spillage of the ink during handling, a wide range of print density and quality, minimal paper cockle or distortion, and enablement of indefinite periods of nonprinting without the danger of nozzle clogging, even without capping the nozzles.

[0004] In general, phase change inks (sometimes referred to as "hot melt inks") are in the solid phase at ambient temperature, but exist in the liquid phase at the elevated operating temperature of an ink jet printing device. At the jet operating temperature, droplets of liquid ink are ejected from

the printing device and, when the ink droplets contact the surface of the recording medium, either directly or via an intermediate heated transfer belt or drum, they quickly solidify to form a predetermined pattern of solidified ink drops.

[0005] Phase change inks for color printing typically comprise a phase change ink carrier composition which is combined with a phase change ink compatible colorant. In a specific embodiment, a series of colored phase change inks can be formed by combining ink carrier compositions with compatible subtractive primary colorants. The subtractive primary colored phase change inks can comprise four component dyes or pigments, namely, cyan, magenta, yellow and black, although the inks are not limited to these four colors. These subtractive primary colored inks can be formed by using a single dye or pigment or a mixture of dyes or pigments.

[0006] Phase change inks are desirable for ink jet printers because they remain in a solid phase at room temperature during shipping, long term storage, and the like. In addition, the problems associated with nozzle clogging as a result of ink evaporation with liquid ink jet inks are largely eliminated, thereby improving the reliability of the ink jet printing. Further, in phase change ink jet printers wherein the ink droplets are applied directly onto the final recording medium (for example, paper, transparency material, and the like), the droplets solidify immediately upon contact with the recording medium, so that migration of ink along the printing medium is prevented and dot quality is improved.

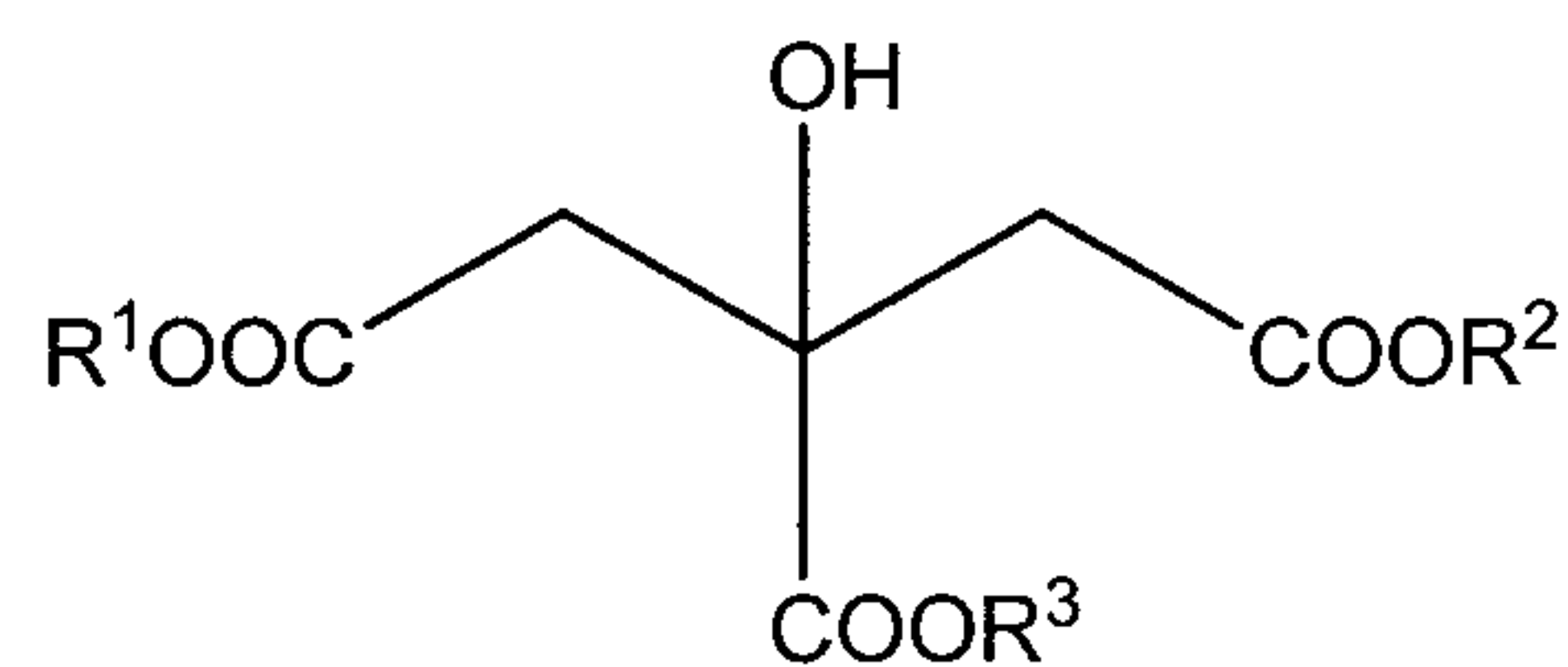
[0007] While the above conventional solid ink technology is generally successful in producing vivid images and providing economy of jet use and substrate latitude on porous papers, such technology has not been satisfactory for coated paper. Thus, while known compositions and processes are suitable for their intended purposes, a need remains for additional means for forming images or printing on coated paper substrates. As such, there is a need to find alternative compositions to provide customers with excellent image robustness on all substrates.

[0008]

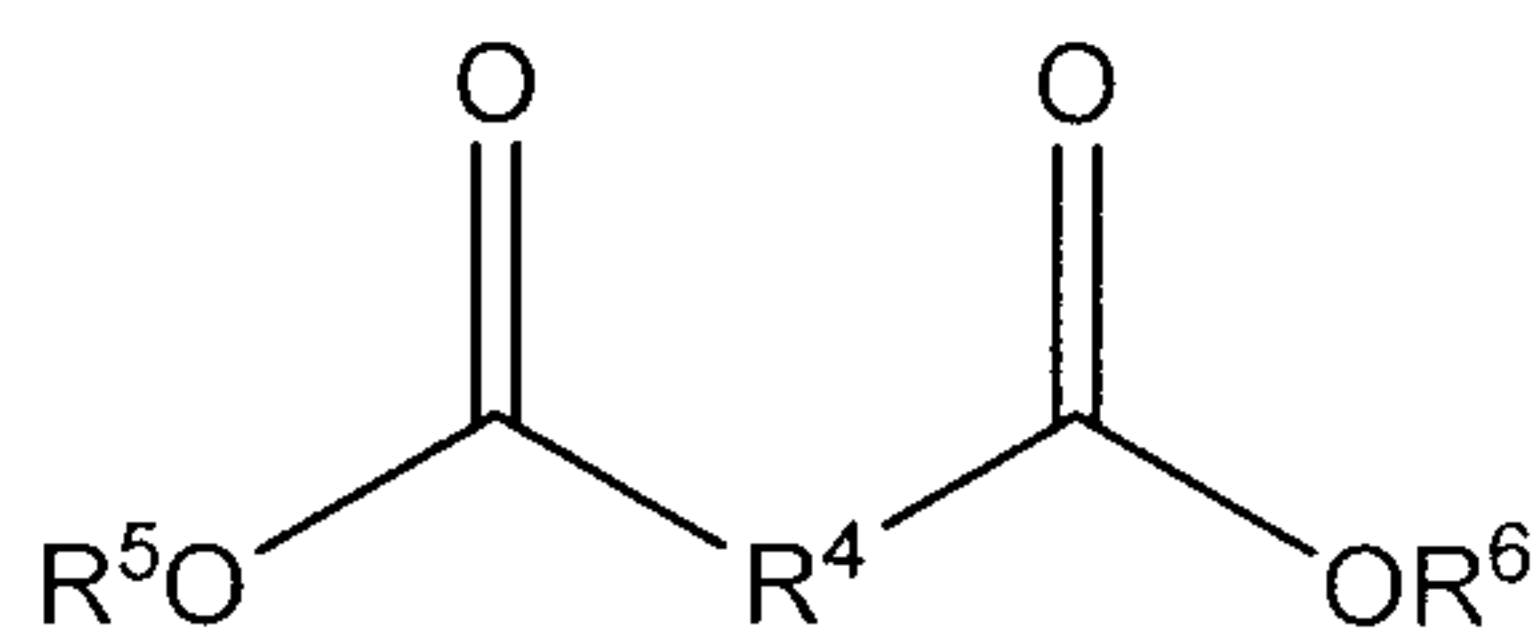
SUMMARY

[0009] According to embodiments illustrated herein, there is provided novel solid ink compositions comprising amorphous materials synthesized from citric acid suitable for ink jet printing, including printing on coated paper substrates.

[0010] According to an aspect of the present invention there is provided a phase change ink comprising: an amorphous component, wherein the amorphous component is an ester of citric acid having a formula of

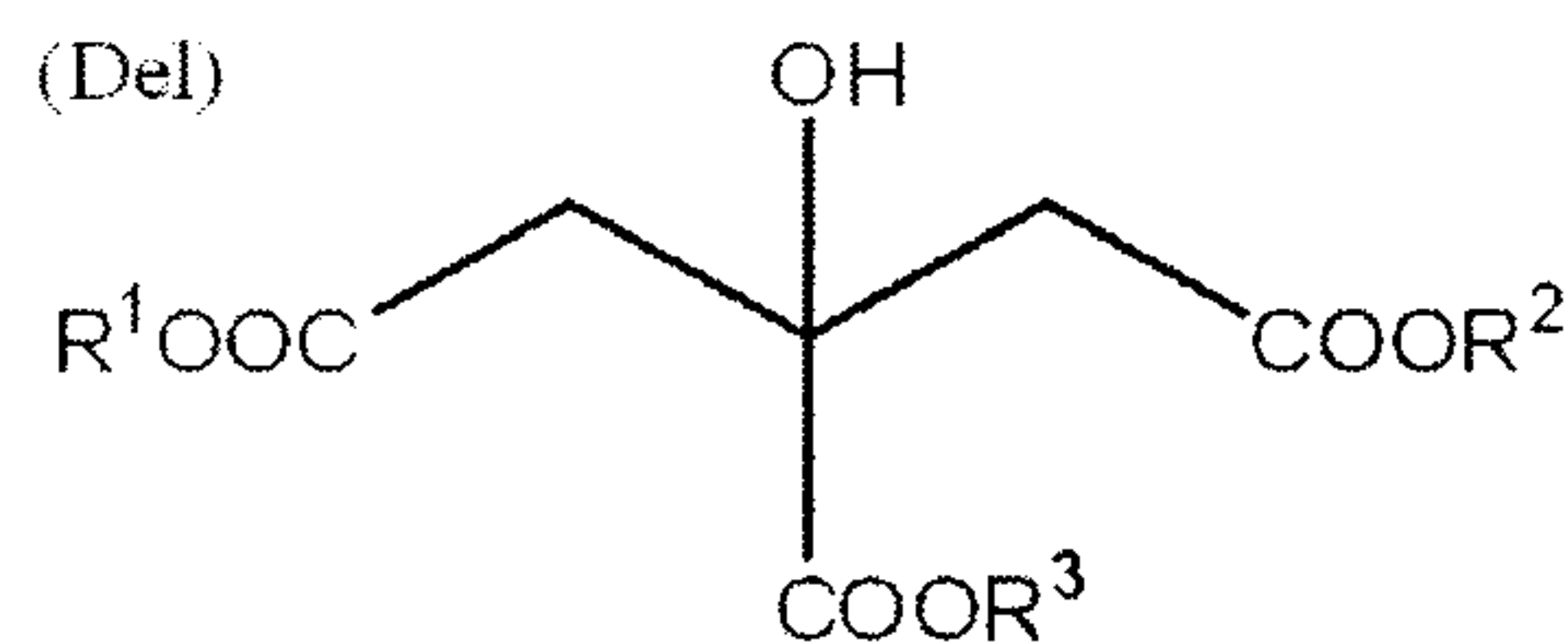


wherein R^1 , R^2 , and R^3 each, independently of the other or meaning that they can be the same or different, is selected from the group consisting of an alkyl group, wherein the alkyl portion can be straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to 40 carbon atoms, or a substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof; and a crystalline component, wherein the crystalline component is an ester of an aliphatic linear diacid having the following structure:

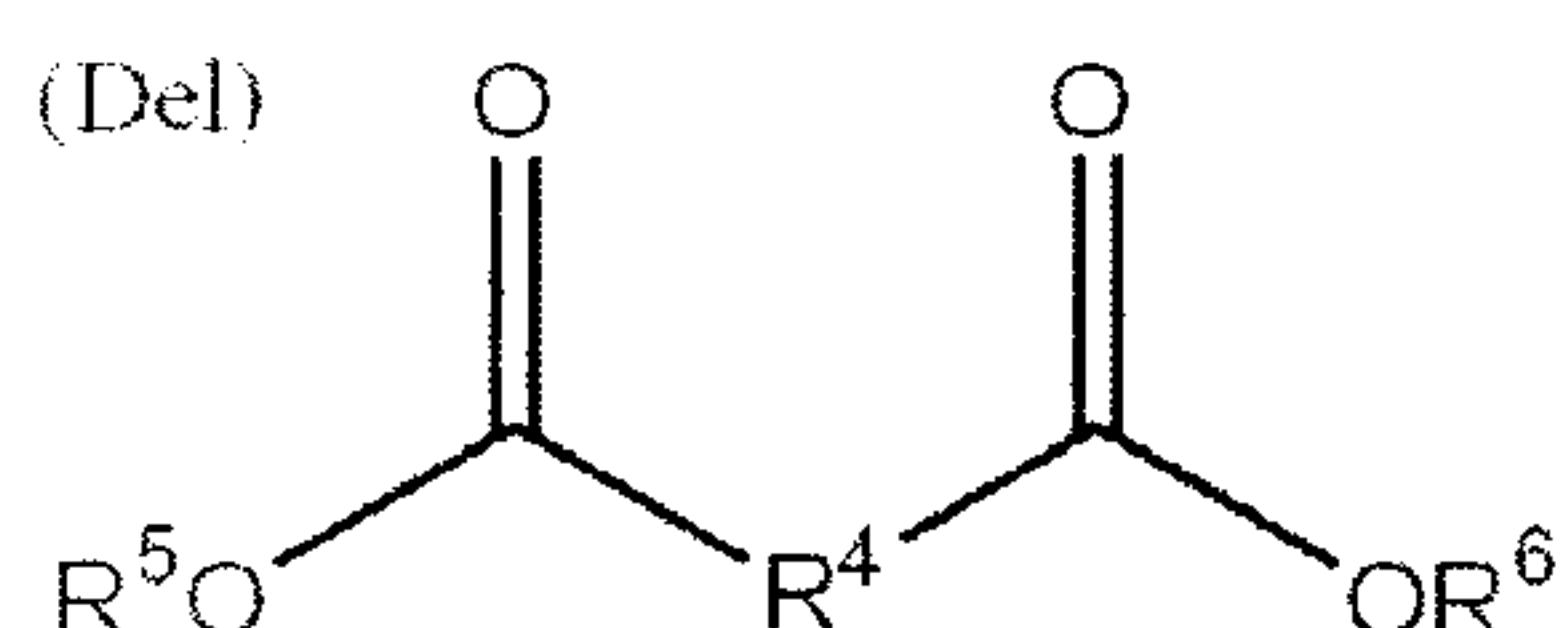


wherein R^4 may be substituted or unsubstituted alkyl chain and is selected from the group consisting of $-(\text{CH}_2)_1-$ to $-(\text{CH}_2)_{12}-$, and wherein R^5 and R^6 , each, independently of the other or meaning that they can be the same or different, is selected from the group consisting of an alkyl group, wherein the alkyl portion can be straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from about 1 to 40 carbon atoms, or an substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof.

[0011] According to a further aspect of the invention, there is provided a phase change ink comprising: an amorphous component, wherein the amorphous component is an ester of citric acid having a formula of

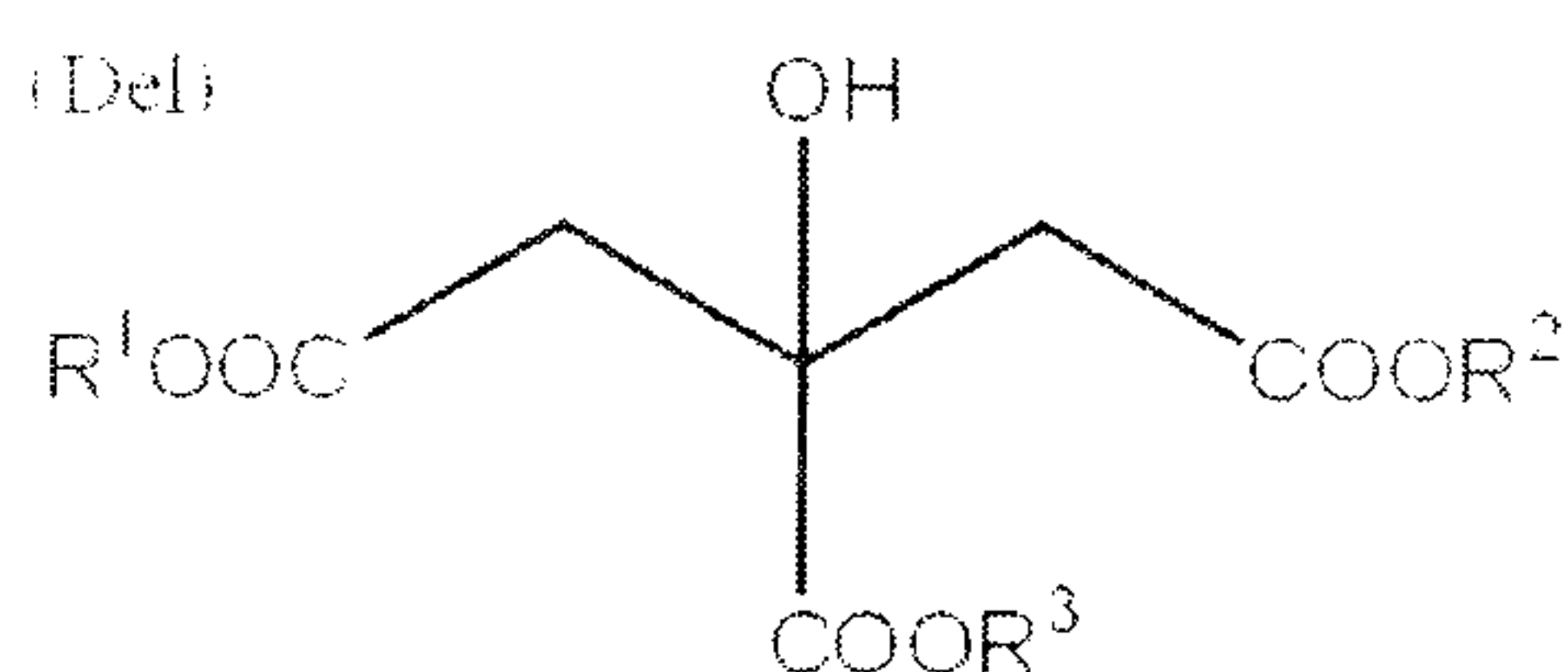


wherein R^1 , R^2 , and R^3 each, independently of the other or meaning that they can be the same or different, is selected from the group consisting of an alkyl group, wherein the alkyl portion can be straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to 40 carbon atoms, or a substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof; and a crystalline component, wherein the crystalline component is an ester of an aliphatic linear diacid having the following structure:

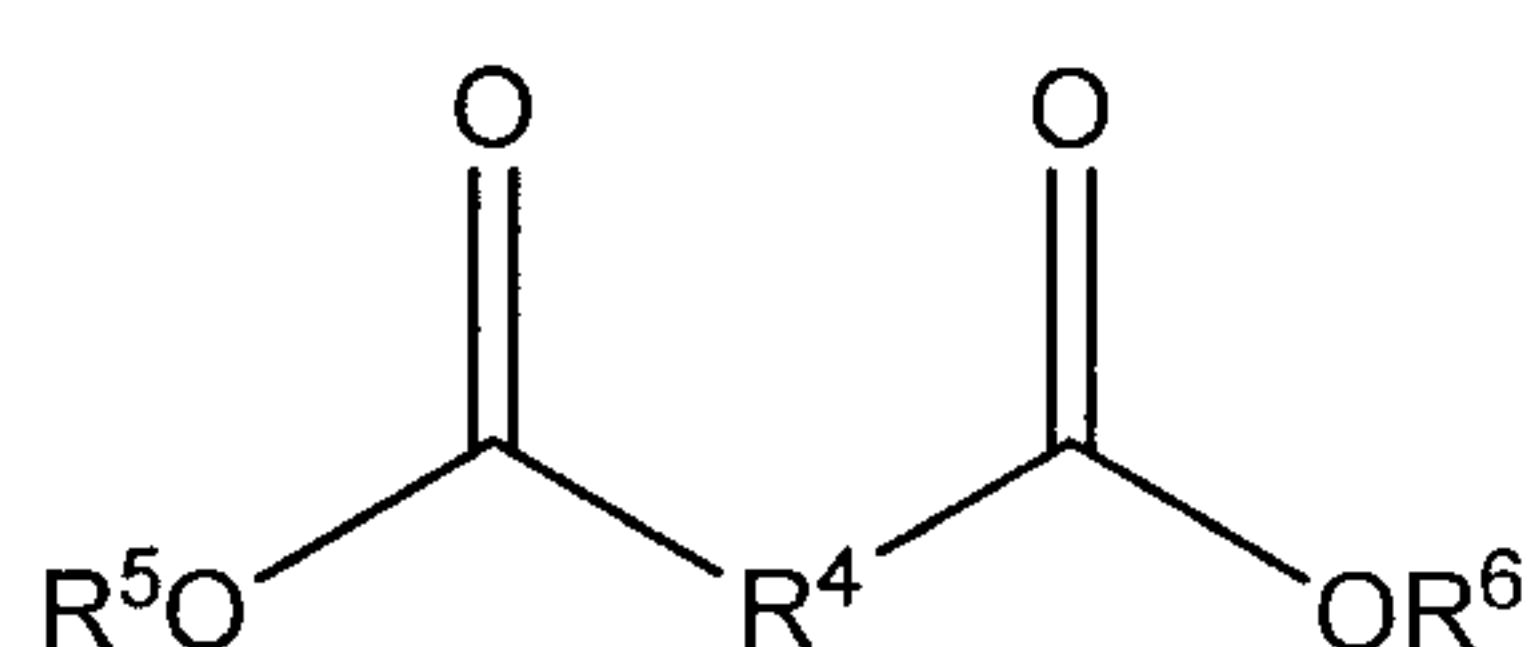


wherein R^4 may be substituted or unsubstituted alkyl chain and is selected from the group consisting of $-(CH_2)_1-$ to $-(CH_2)_{12}-$, and wherein R^5 and R^6 , each, independently of the other or meaning that they can be the same or different, is selected from the group consisting of an alkyl group, wherein the alkyl portion can be straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from about 1 to about 40 carbon atoms, or an substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof, and further wherein the crystalline component exhibits crystallization (T_{crys}) and melting (T_{melt}) peaks and the difference between the peaks ($T_{melt}-T_{crys}$) is less than 55°C , and further wherein the amorphous component has a T_g value of from about 10°C to about 50°C .

[0012] In yet another aspect of the present invention, there is provided a phase change ink comprising: an amorphous component, wherein the amorphous component is an ester of citric acid synthesized by an esterification reaction with at least one alcohol and having the formula:



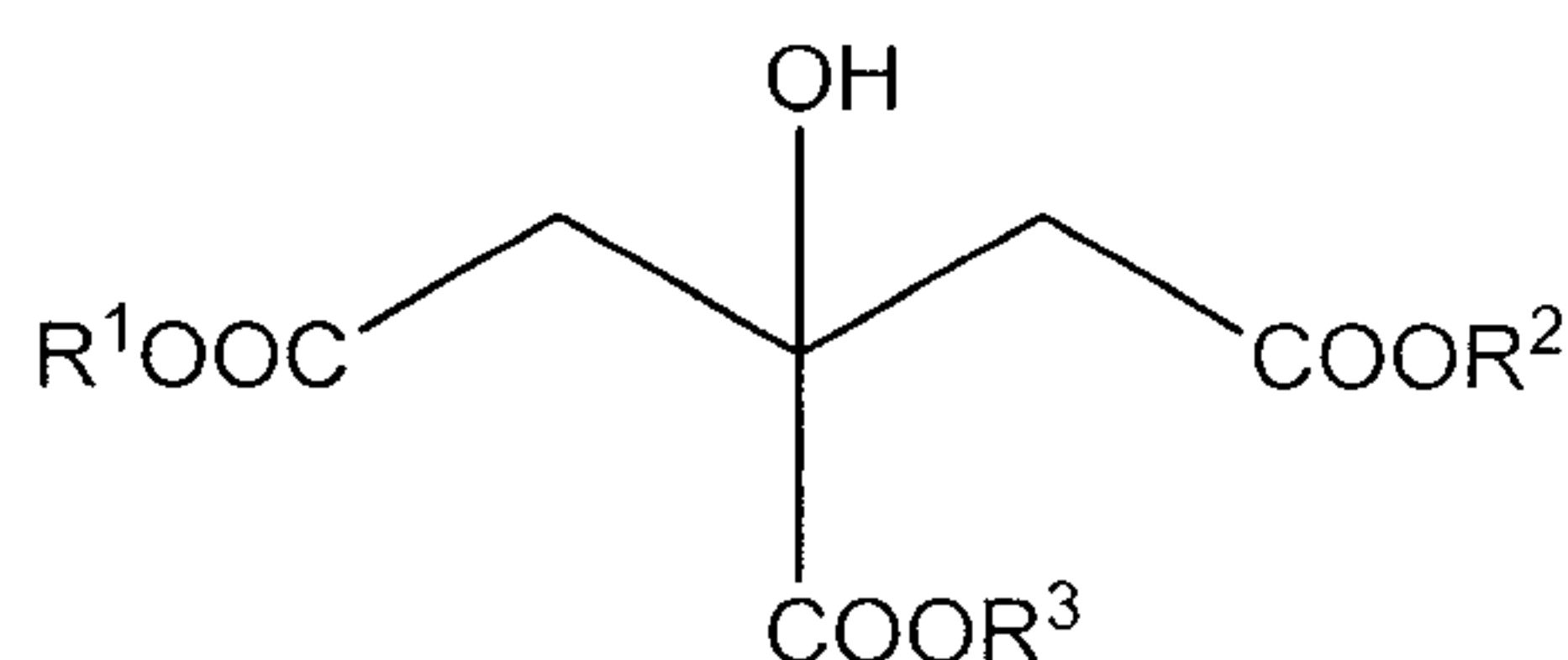
wherein R^1 , R^2 , and R^3 each, independently of the other or meaning that they can be the same or different, is selected from the group consisting of alkyl group, wherein the alkyl portion can be straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to 40 carbon atoms, or a substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof; and a crystalline component, wherein the crystalline component is an ester of an aliphatic linear diacid synthesized by an esterification reaction with at least one alcohol and having the following structure:



wherein R^4 may be substituted or unsubstituted alkyl chain and is selected from the group consisting of $-(\text{CH}_2)_1-$ to $-(\text{CH}_2)_{12}-$, and wherein R^5 and R^6 , each independently of the other or meaning that they can be the same or different, is selected from the group consisting of an alkyl group, wherein the alkyl portion can be straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from about 1 to 40 carbon atoms, or an substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof.

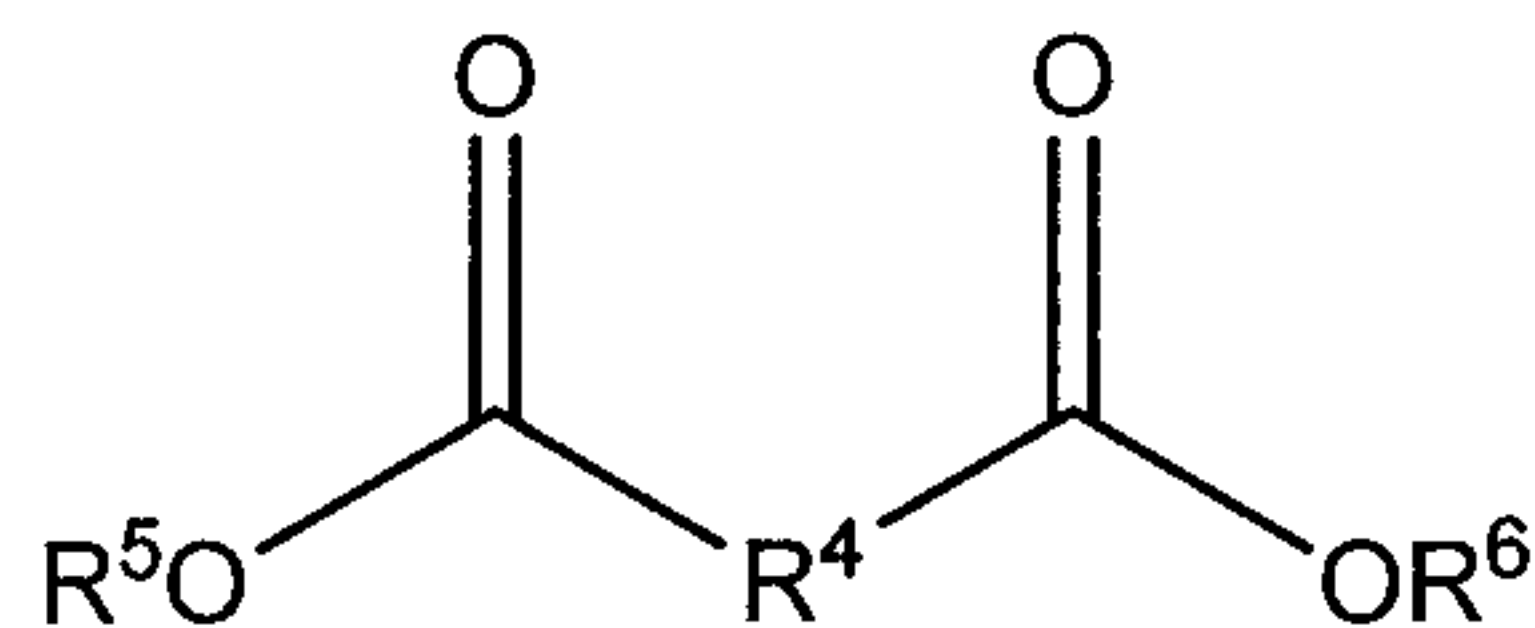
[0012a] In accordance with an aspect of the present invention, there is provided a phase change ink comprising:

an amorphous component, wherein the amorphous component is an ester of citric acid having a formula of



wherein R^1 , R^2 , and R^3 each, independently of the other, is selected from the group consisting of an alkyl group, wherein the alkyl portion is straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to 40 carbon atoms, or a substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof; and

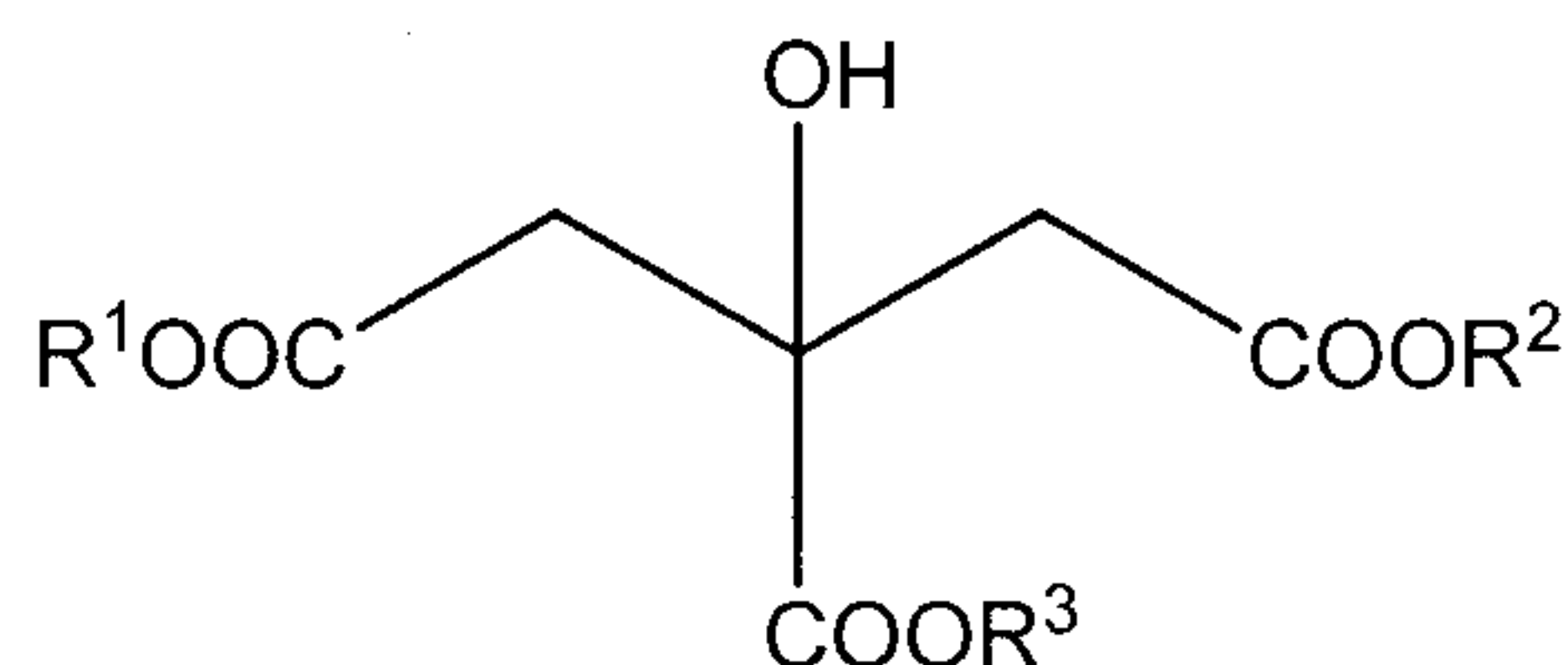
a crystalline component, wherein the crystalline component is an ester of an aliphatic linear diacid having the following structure:



wherein R^4 is a substituted or unsubstituted alkyl chain and is selected from the group consisting of $-(\text{CH}_2)_1-$ to $-(\text{CH}_2)_{12}-$, and wherein R^5 and R^6 , each independently of the other, is selected from the group consisting of an alkyl group, wherein the alkyl portion is straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from about 1 to 40 carbon atoms, or a substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof.

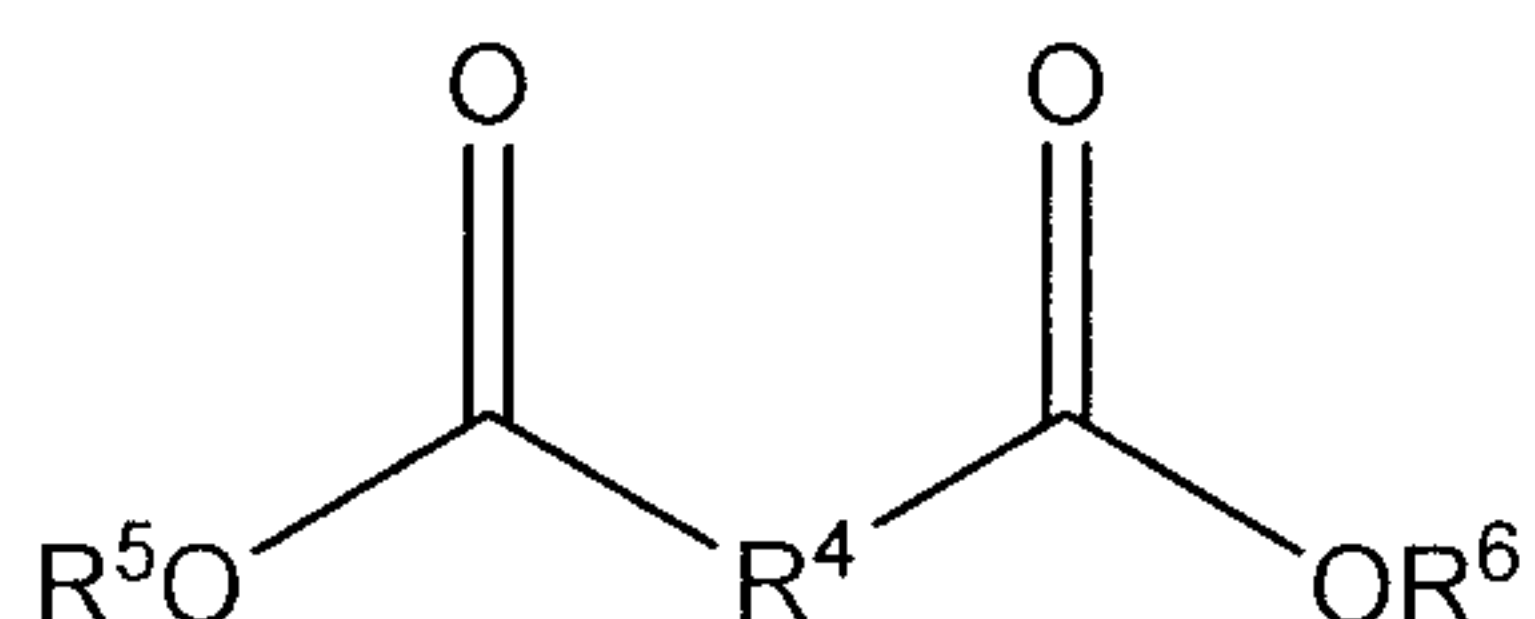
[0012b] According to another aspect of the present invention, there is provided a phase change ink comprising:

an amorphous component, wherein the amorphous component is an ester of citric acid having a formula of



wherein R^1 , R^2 , and R^3 each, independently of the other, is selected from the group consisting of an alkyl group, wherein the alkyl portion is straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to 40 carbon atoms, or a substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof;

a crystalline component, wherein the crystalline component is an ester of an aliphatic linear diacid having the following structure:



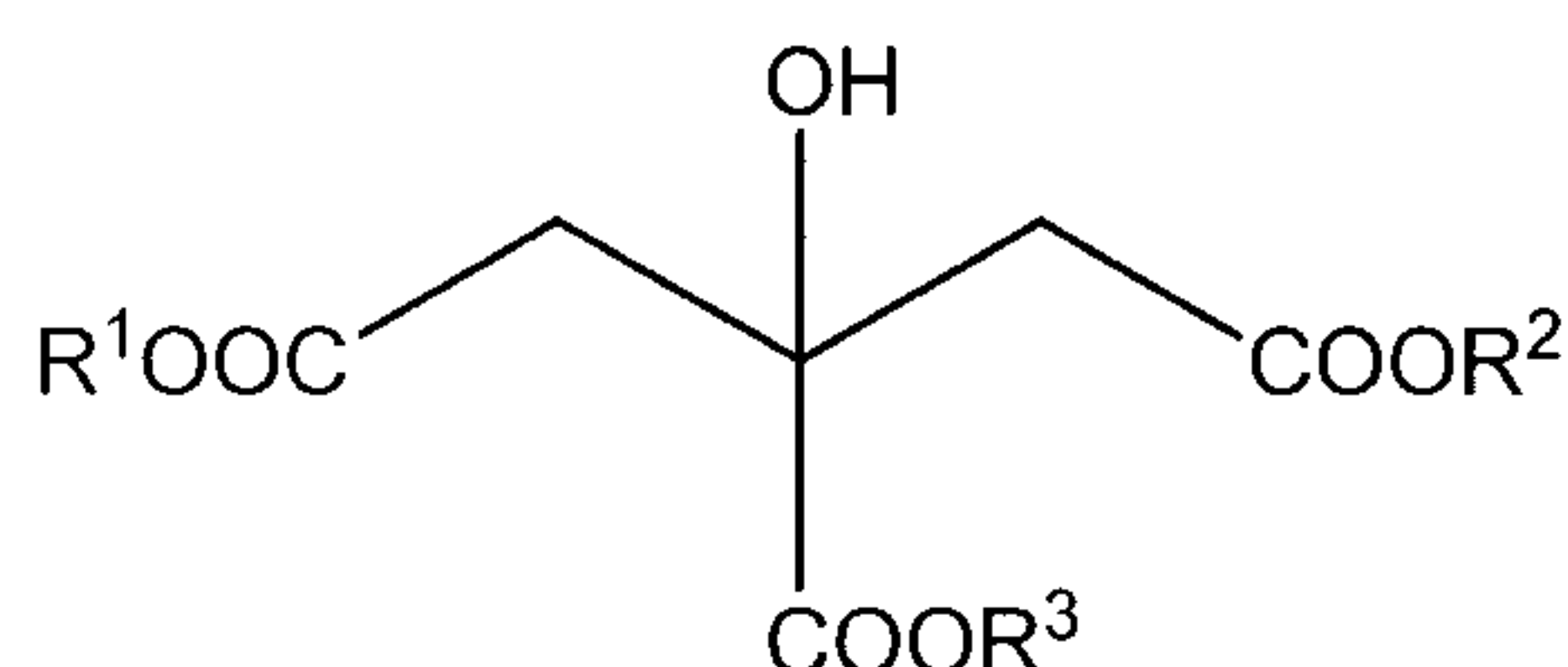
wherein R^4 is substituted or unsubstituted alkyl chain and is selected from the group consisting of $-(\text{CH}_2)_1-$ to $-(\text{CH}_2)_{12}-$, and wherein R^5 and R^6 , each independently of the other, is selected from the group consisting of an alkyl group, wherein the alkyl portion is straight, branched or cyclic, saturated or

unsaturated, substituted or unsubstituted, having from about 1 to 40 carbon atoms, or a substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof; and

an optional colorant, and further wherein the crystalline component exhibits crystallization (T_{crys}) and melting (T_{melt}) peaks and the difference between the peaks ($T_{\text{melt}} - T_{\text{crys}}$) is less than 55°C , and further wherein the amorphous component has a T_g value of from about 10 to 50°C .

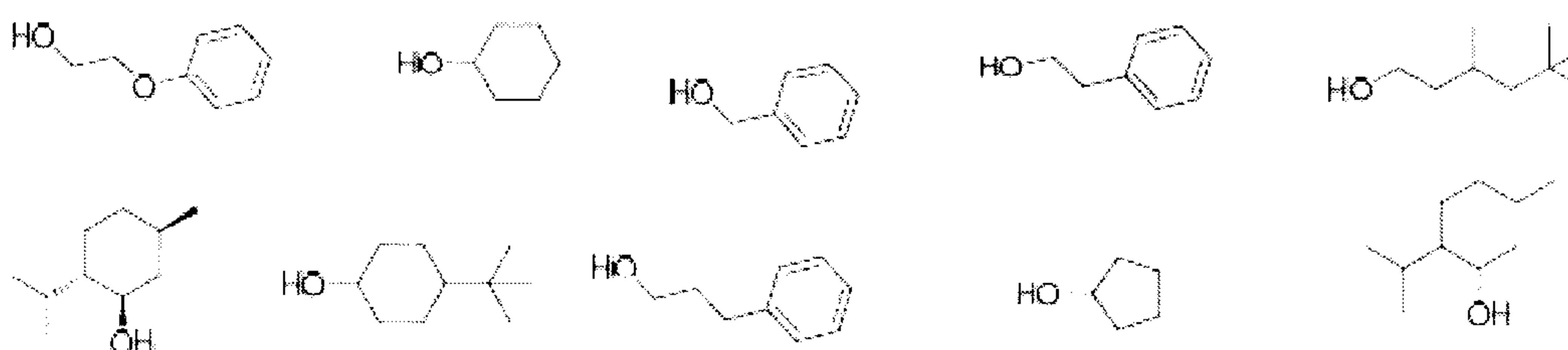
[0012c] In accordance with an aspect of the present invention, there is provided a phase change ink comprising:

an amorphous component, wherein the amorphous component is an ester of citric acid synthesized by an esterification reaction with at least one alcohol and having the formula:



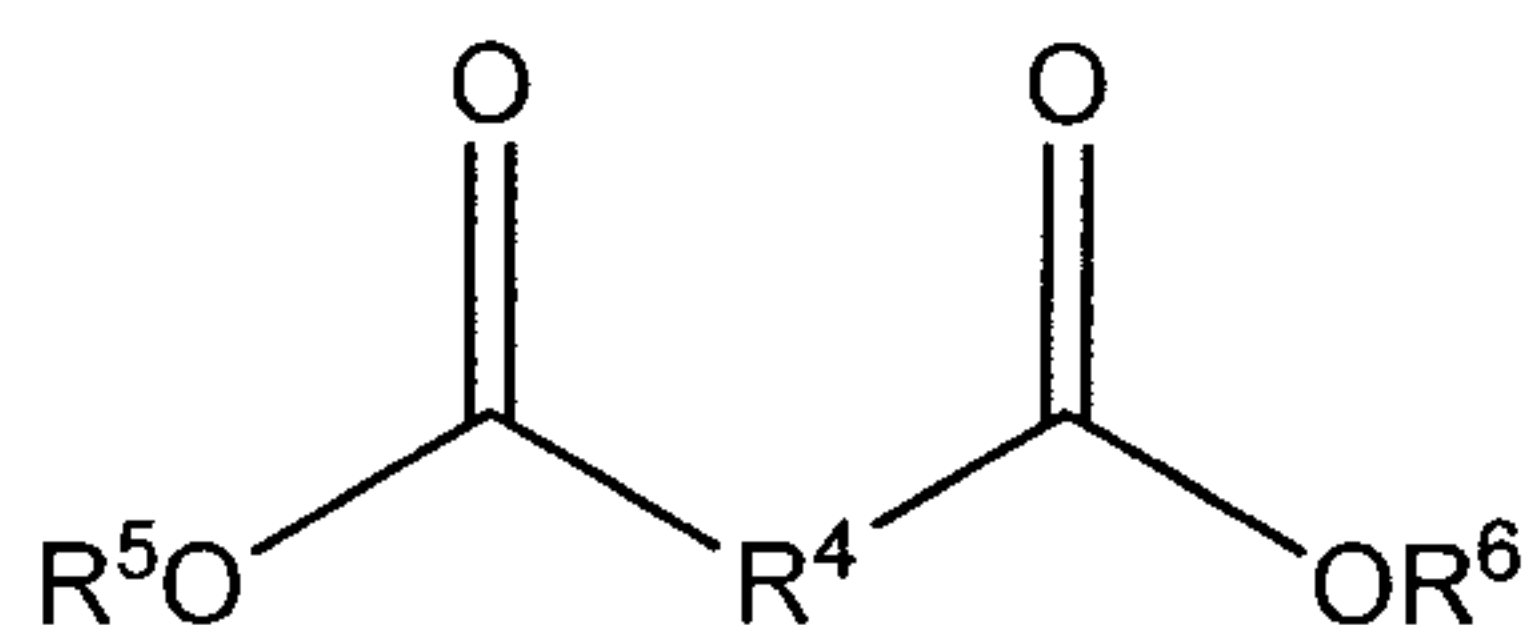
wherein R^1 , R^2 , and R^3 each, independently of the other, is selected from the group consisting of alkyl group, wherein the alkyl portion is straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to 40 carbon atoms, or a substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof;

wherein the alcohol for reacting with the citric acid is selected from the group consisting of



and mixtures thereof;

a crystalline component, wherein the crystalline component is an ester of an aliphatic linear diacid synthesized by an esterification reaction with at least one alcohol and having the following structure:

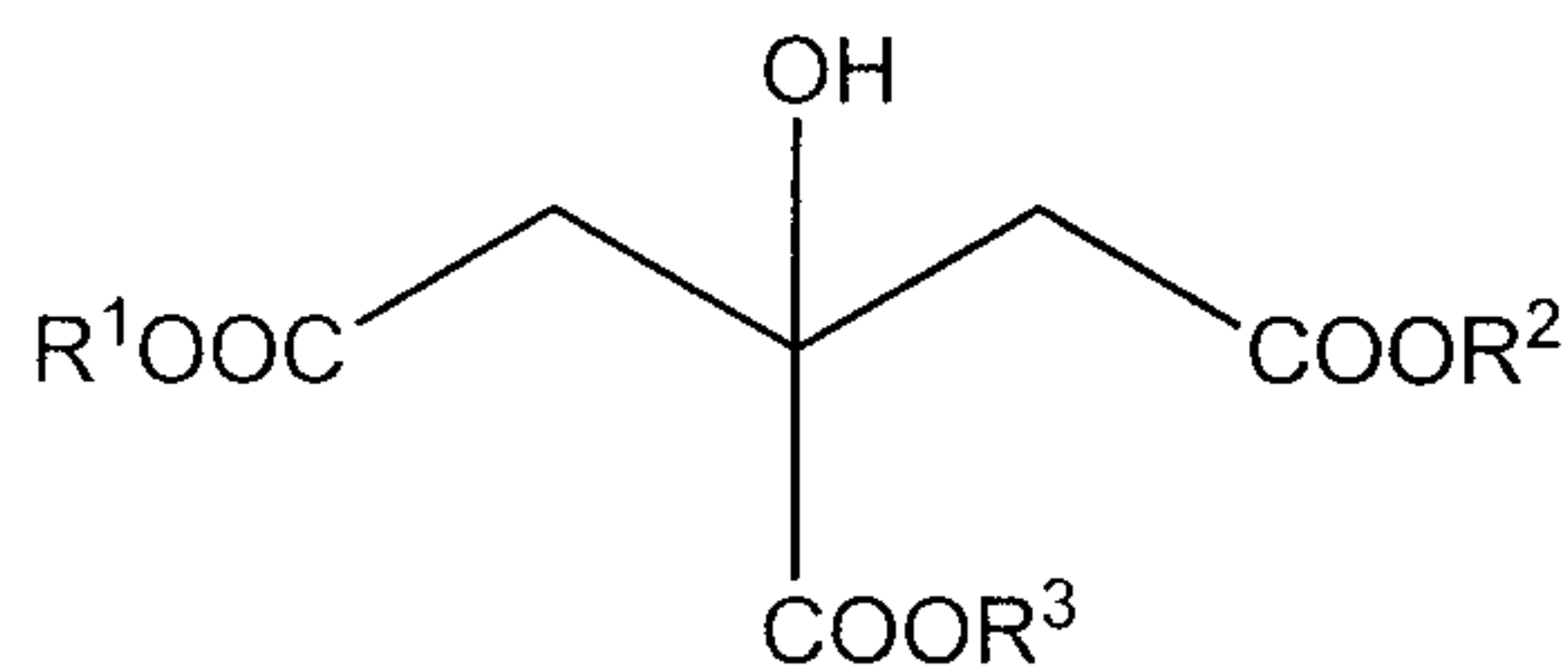


wherein R^4 is substituted or unsubstituted alkyl chain and is selected from the group consisting of $-(\text{CH}_2)_1-$ to $-(\text{CH}_2)_{12}-$, and wherein R^5 and R^6 , each independently of the other, is selected from the group consisting of an alkyl group, wherein the alkyl portion is straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from about 1 to 40 carbon atoms, or a substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof; and

an optional colorant.

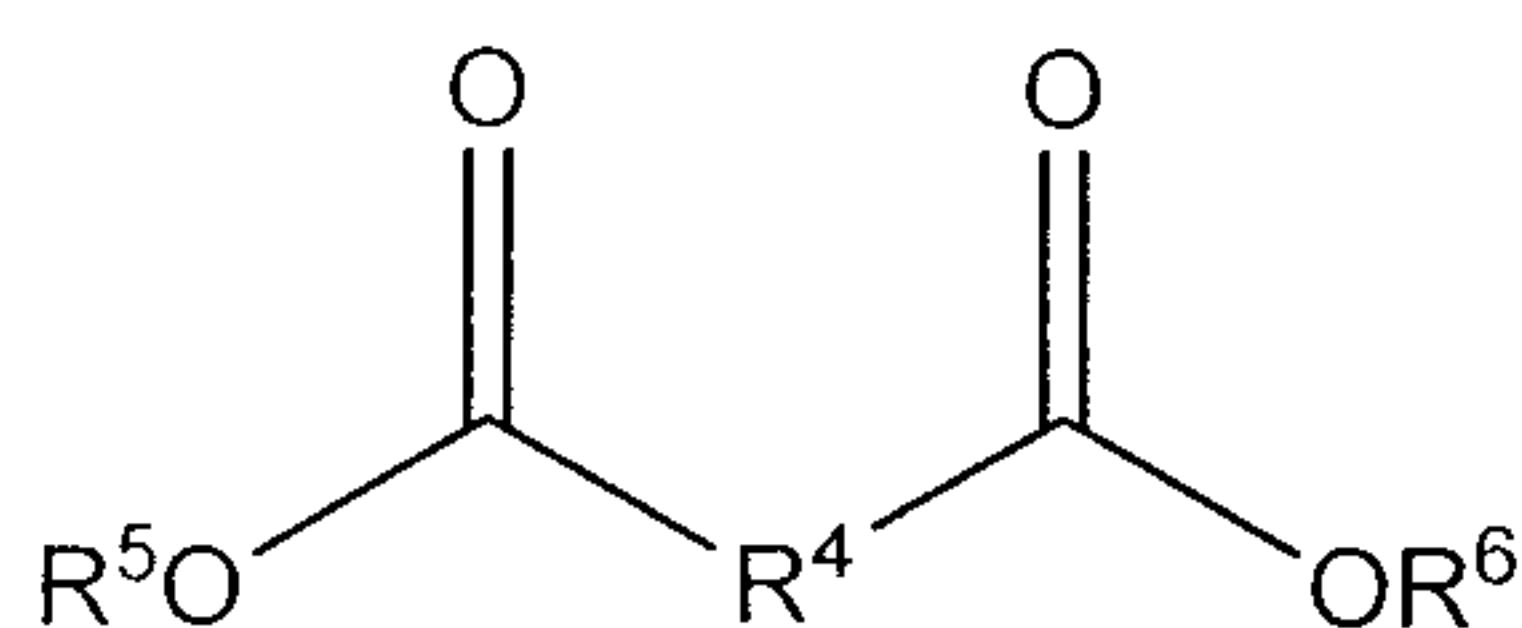
[0012c] In accordance with an aspect of the present invention there is provided a phase change ink comprising:

an amorphous component, wherein the amorphous component is an ester of citric acid having a formula of



wherein R^1 , R^2 , and R^3 each, independently of the other, is selected from the group consisting of an alkyl group, wherein the alkyl portion is straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to about 40 carbon atoms, or an substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof;

a crystalline component, wherein the crystalline component is an ester of an aliphatic linear diacid having the following structure:



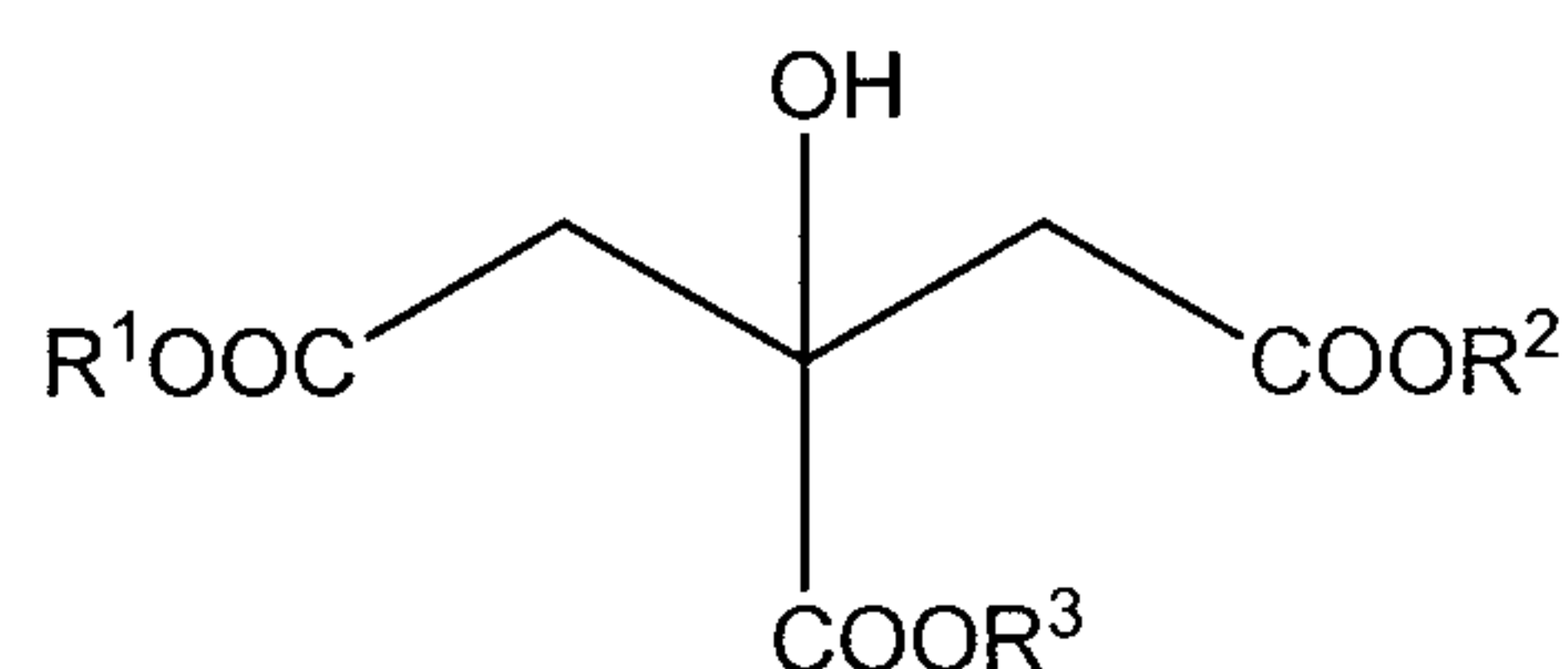
wherein R^4 is substituted or unsubstituted alkyl chain and is selected from the group consisting of $-(\text{CH}_2)_1-$ to $-(\text{CH}_2)_{12}-$, and wherein R^5 and R^6 , each independently of the other, is selected from the group consisting of an alkyl group, wherein the alkyl portion is straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from about 1 to about 40

carbon atoms, or an substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof; and

a colorant.

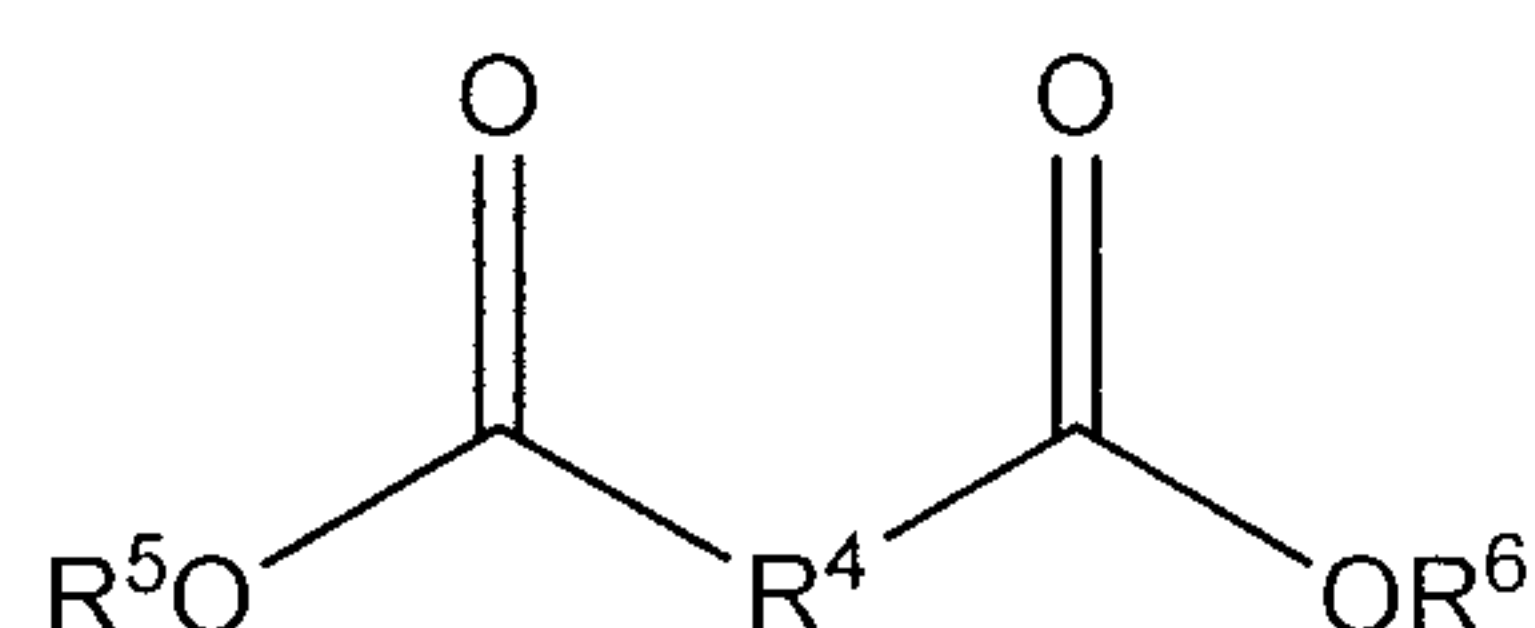
[0012d] In accordance with another aspect of the present invention, there is provided a phase change ink comprising:

an amorphous component, wherein the amorphous component is an ester of citric acid synthesized by an esterification reaction with at least one alcohol and having the formula:



wherein R^1 , R^2 , and R^3 each, independently of the other, is selected from the group consisting of alkyl group, wherein the alkyl portion is straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to 40 carbon atoms, or a substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof;

a crystalline component, wherein the crystalline component is an ester of an aliphatic linear diacid synthesized by an esterification reaction with at least one alcohol and having the following structure:



wherein R^4 is substituted or unsubstituted alkyl chain and is selected from the group consisting of $-(\text{CH}_2)_1-$ to $-(\text{CH}_2)_{12}-$, and wherein R^5 and R^6 , each independently of the other, is selected from the group consisting of a substituted or unsubstituted aromatic group, and mixtures thereof and wherein the alcohol for reacting with the aliphatic linear diacid is selected from the group consisting of phenol, p-cresol, 4-methoxyphenol, 4-methylbenzyl alcohol, 4-methoxybenzyl alcohol and mixtures thereof; and

an optional colorant.

[0012e] In accordance with an aspect, the amorphous component has a viscosity of at least 10^6 cps at room temperature.

[0012f] In accordance with another aspect, the phase change ink has a viscosity of less than about 15 cps at a temperature of about 140°C.

BRIEF DESCRIPTION OF THE DRAWINGS

[0013] For a better understanding of the present embodiments, reference may be had to the accompanying figures.

[0014] Figure 1 is differential scanning calorimetry (DSC) data of bis(4-methoxyphenyl) octanedioate according to the present embodiments (the DSC data was obtained on a Q1000 Differential Scanning Calorimeter (TA Instruments) at a rate of 10°C/min from -50 to 200 to -50°C);

[0015] Figure 2 is a graph illustrating rheology data of bis(4-methoxyphenyl) octanedioate according to the present embodiments; and

[0016] Figure 3 is a graph illustrating rheology data of the ink samples according to the present embodiments.

[0017] All of the rheology measurements were made on a RFS3 controlled strain Rheometer (TA instruments) equipped with a Peltier heating plate and using a 25 mm parallel plate. The method used was a temperature sweep from high to low temperatures, in temperature decrements of 5 °C, a soak (equilibration) time of 120 seconds between each temperature and at a constant frequency of 1 Hz.

DETAILED DESCRIPTION

[0018] In the following description, it is understood that other embodiments may be utilized and structural and operational changes may be made without departure from the scope of the present embodiments disclosed herein.

[0019] Solid ink technology broadens printing capability and customer base across many markets, and the diversity of printing applications will be facilitated by effective integration of printhead technology, print process and ink materials. The solid ink compositions are characterized by being solid at room temperature (e.g., 20-27 °C) and molten at an elevated temperature at which the molten ink is applied to a substrate. As discussed above, while current ink options are successful for porous paper substrates, these options are not always satisfactory for coated paper substrates.

[0020] It has been discovered that using a mixture of crystalline and amorphous components in solid ink formulations provides robust inks, and in particular, solid inks which demonstrate robust images on coated paper. Crystalline materials refer to those materials which exhibit melting and crystallization peaks by differential scanning calorimetry (DSC). Amorphous materials, in contrast, exhibit no melting and crystallization peaks, only glass transition temperature (T_g) or glass transition temperatures. For crystalline materials, small molecules generally tend to crystallize when solidifying and low molecular weight organic solids are generally crystals. While crystalline materials are generally harder and more resistant, such materials are also much more brittle, so that printed matter made using a mainly crystalline ink composition is fairly sensitive to damage. For amorphous materials, high molecular weight amorphous materials, such as polymers, become viscous and sticky liquids at high temperature, but do not show sufficiently low viscosity at high temperatures. As a result, the polymers cannot be jetted from print head nozzles at desirable jetting temperature (≤ 140 °C). In the present embodiments, however, it is discovered that a robust solid ink can be obtained through a blend of crystalline and amorphous components.

[0021] The present embodiments provide a new type of solid ink composition which comprises a blend of (1) crystalline and (2) amorphous components, generally in a weight ratio of from about 60:40 to about 95:5,

respectively. In more specific embodiments, the weight ratio of the crystalline to amorphous component is from about 65:35 to about 95:5, or is from about 70:30 to about 90:10. In one embodiment, the weight ratio is 70:30. In another embodiment, the weight ratio is 80:20. In general embodiments, the crystalline component comprises 60 percent or more by weight of the total weight of the solid ink. In general embodiments, the amorphous component comprises 5 percent or more by weight of the total weight of the solid ink.

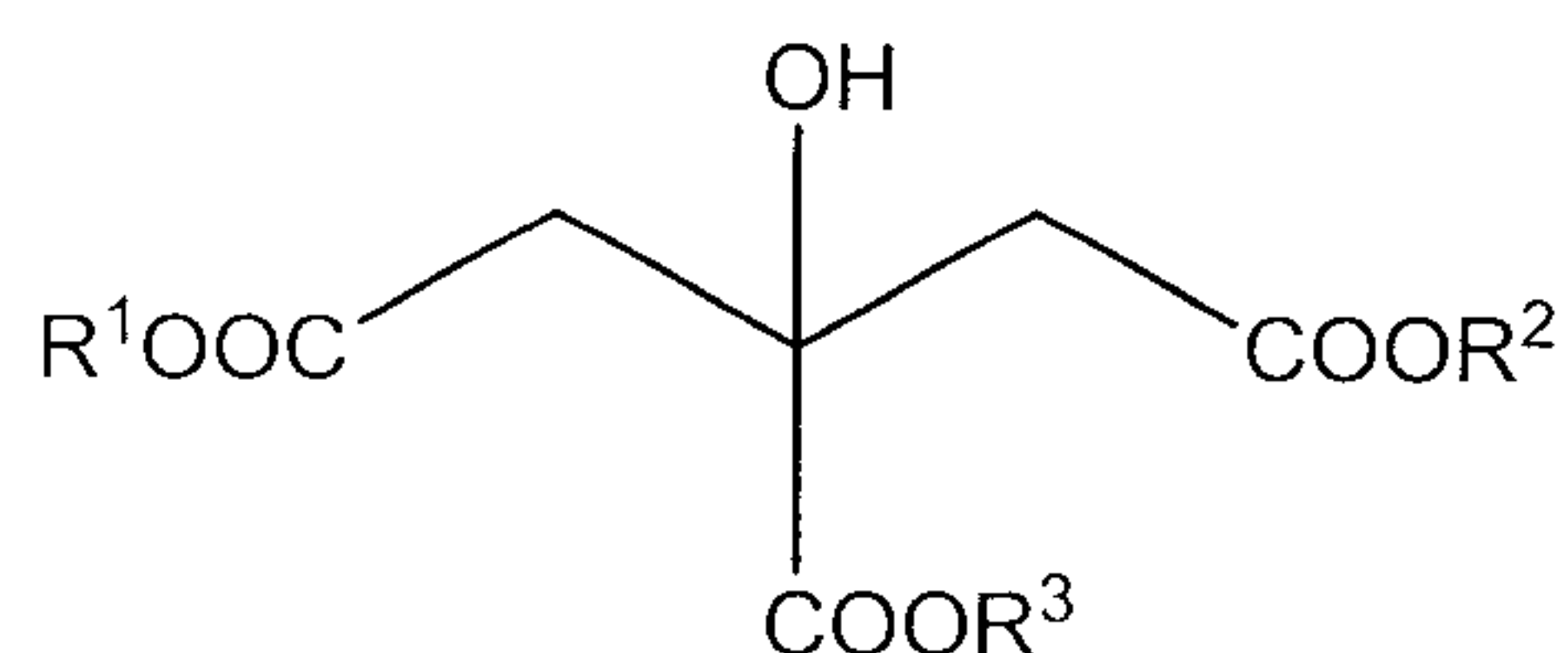
[0022] The crystalline component imparts hardness to the inks, cuts the tackiness of the amorphous resin and drives the phase change of the ink through rapid crystallization on cooling. The amorphous resin is designed to give the ink flexibility and toughness, as well as bind the other materials in the ink together. The amorphous materials used in the present embodiments are based upon small branched molecules.

[0023] The crystalline component in the ink formulation drives the phase change through rapid crystallization on cooling. The crystalline component also sets up the structure of the final ink film and creates a hard ink by reducing the tackiness of the amorphous component. These materials show no crystallization, relatively low viscosity when molten ($\leq 10^1$ centipoise (cps), or from about 0.5 to about 10 cps, or from about 1 to about 10 cps, or from about 1.5 to about 9 cps) in the jetting range (from about 95 to about 150°C, or from about 100 to about 140°C,) and high viscosity ($> 10^6$ cps) at room temperature. Because the crystalline components dictate the phase change of the ink, rapid crystallization is required to allow further immediate print processing if required (*i.e.*, spreading, duplex printing, *etc.*) and to prevent excessive showthrough on uncoated substrates. By differential scanning calorimetry (DSC) (10°C/min from -50 to 200 to -50°C), desirable crystalline components show sharp crystallization and melting peaks, and the ΔT ($T_{\text{melt}} - T_{\text{crys}}$) is less than 55°C. The phase transition temperature of the crystalline component generally occurs between 70 and 130 °C. The melting point must be below 150°C, which is the upper limit of the jetting temperature, or preferably below about 145°C, or below about 140°C. The melting point is preferably above 65°C to prevent blocking and print transfer upon standing at

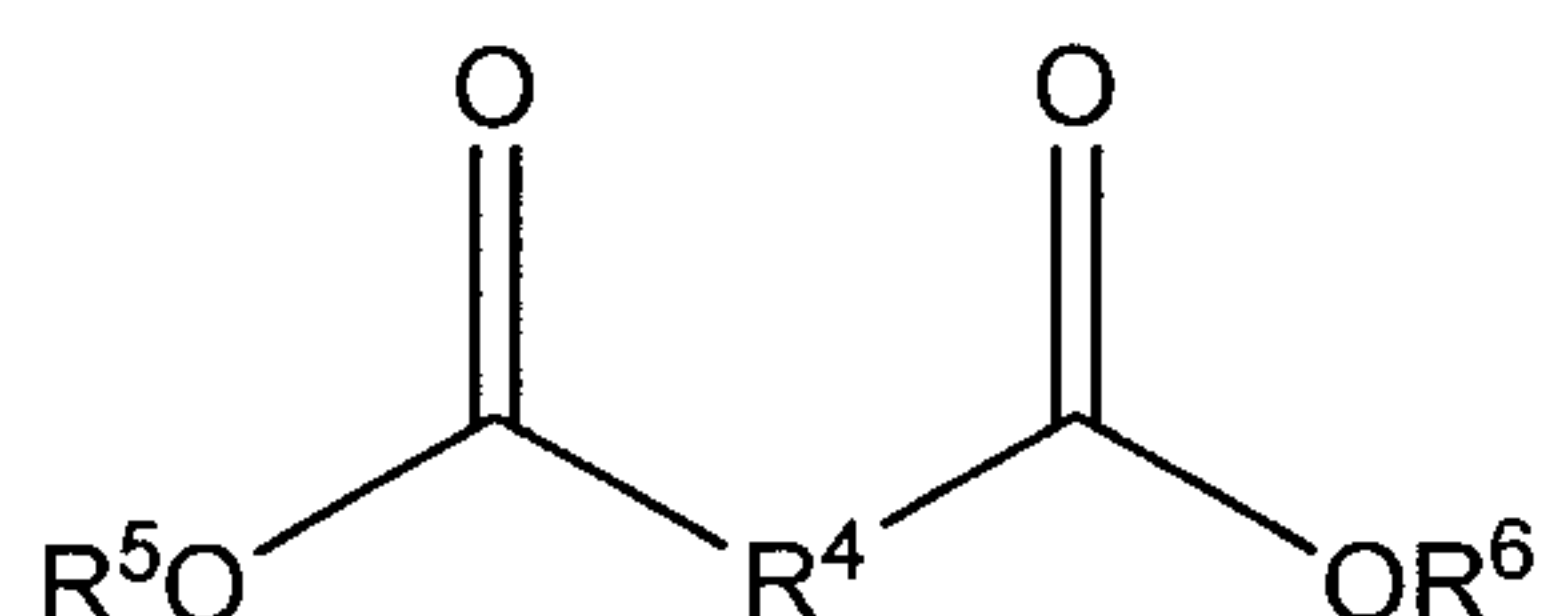
temperatures up to 65°C, or more preferably above about 66°C, or above about 67°C.

[0024] The amorphous components provide tackiness and impart robustness to the printed ink. In the present embodiments, desirable amorphous materials have relatively low viscosity ($< 10^2$ cps, or from about 1 to about 100 cps, or from about 5 to about 95 cps, or from about 10 to about 90 cps) at about 140°C, but very high viscosity (about $> 10^6$ cps) at room temperature. Generally, the viscosity of the amorphous components is greater than 10^6 cps at a temperature of below 40 °C. The low viscosity at about 140°C provides wide formulation latitude while the high viscosity at room temperature imparts robustness. The amorphous materials have T_g s but do not exhibit crystallization and melting peaks by DSC (10°C/min from -50 to 200 to -50°C). The T_g values are typically from about 10 to about 50°C, or from about 10 to about 45°C, or from about 10 to about 40°C, or from about 10 to about 35°C, to impart the desired toughness and flexibility to the inks. The selected amorphous materials have low molecular weights, such as less than 1000 g/mol, or from about 100 to about 1000 g/mol, or from about 200 to about 1000 g/mol, or from about 300 to about 1000 g/mol. Higher molecular weight amorphous materials such as polymers become viscous and sticky liquids at high temperatures, but have viscosities that are too high to be jettable with piezoelectric printheads at desirable temperatures.

[0025] Generally, the amorphous component is an ester of citric acid having a formula of



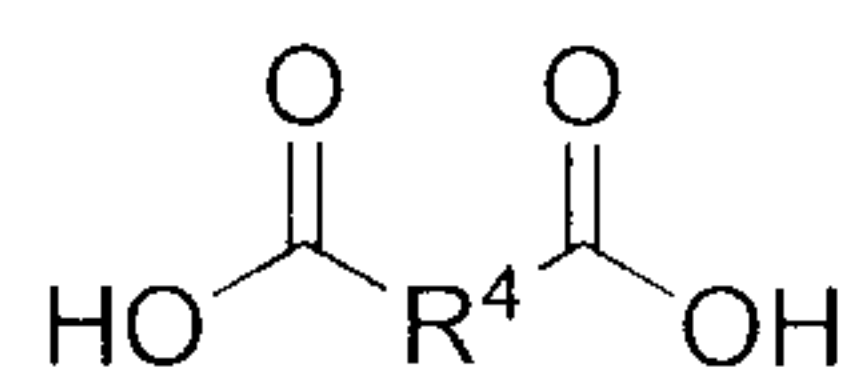
wherein R^1 , R^2 , and R^3 each, independently of the other or meaning that they can be the same or different, is selected from the group consisting of alkyl group, wherein the alkyl portion can be straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to about 40 carbon atoms, or an substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof. Generally, the crystalline component has the following structure:



[0026] wherein R^4 may be substituted or unsubstituted alkyl chain and is selected from the group consisting of $-(CH_2)_{1-}$ to $-(CH_2)_{12-}$, and wherein R^5 and R^6 , each independently of the other or meaning that they can be the same or different, is selected from the group consisting of an alkyl group, wherein the alkyl portion can be straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from about 1 to about 40 carbon atoms, or an substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof.

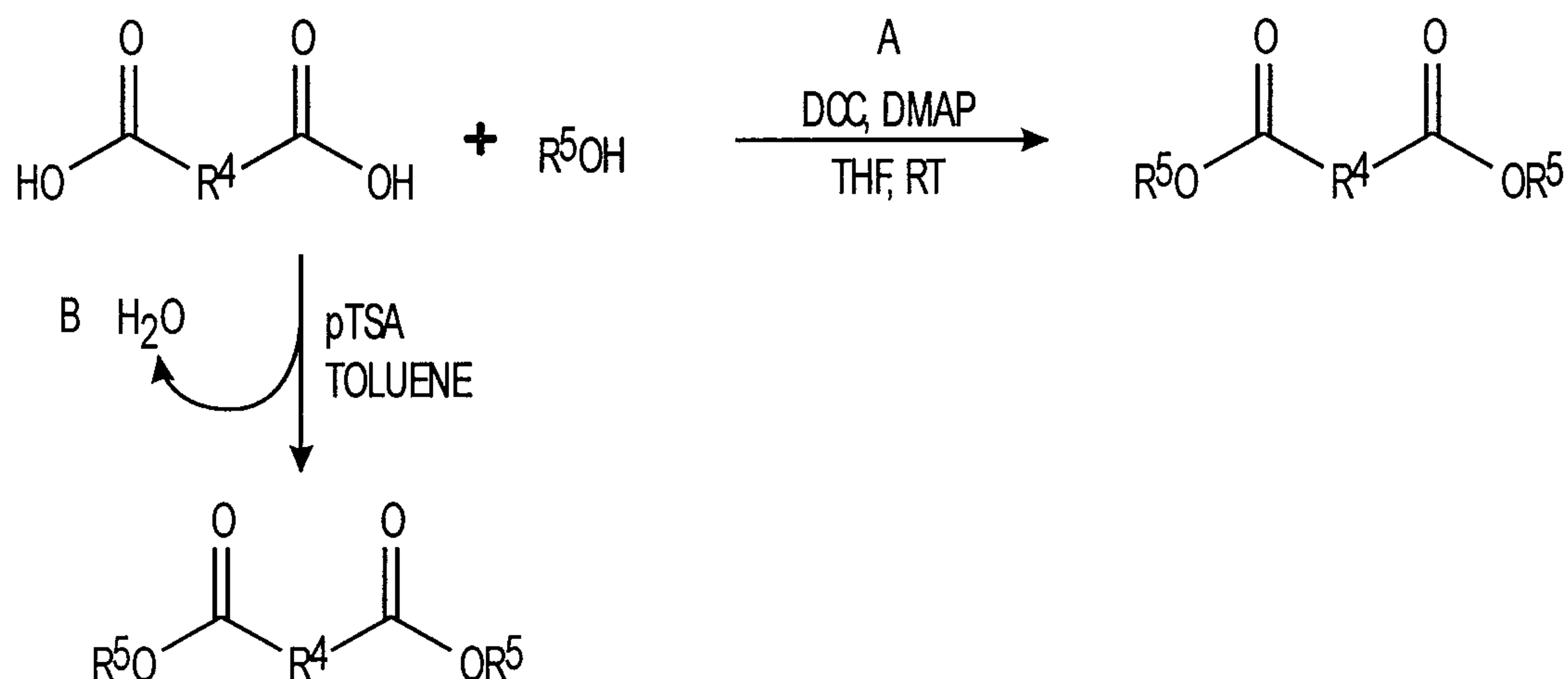
[0027] The crystalline materials are synthesized by an esterification reaction of aliphatic linear diacids or aliphatic linear acid chlorides. The materials show sharp crystallization, relatively low viscosity ($<10^1$ cps, or from about 0.5 to about 10 cps, or from about 1 to about 10 cps, or from about 2 to about 10 cps at a jetting temperature of about 140°C), but very high viscosity ($>10^6$ cps) at room temperature. These materials have a melting temperature (T_{melt}) of less than 150°C , or from about 65 to about 150°C , or from about 66 to about 145°C , or from about 67 to about 140°C , and a crystallization temperature (T_{crys}) of greater than 65°C , or from more preferably above about 66 or above about 67°C . In a specific embodiment, the crystalline material has T_{melt} of 116°C and T_{crys} of 80°C .

[0028] Linear diacids were selected as backbone materials for the crystalline component owing to their simplicity of structure, wide availability, potential bio-derived content (*i.e.* azelaic acid) and highly crystalline nature. The linear diacid backbone materials screened for the present embodiments had the following structures:

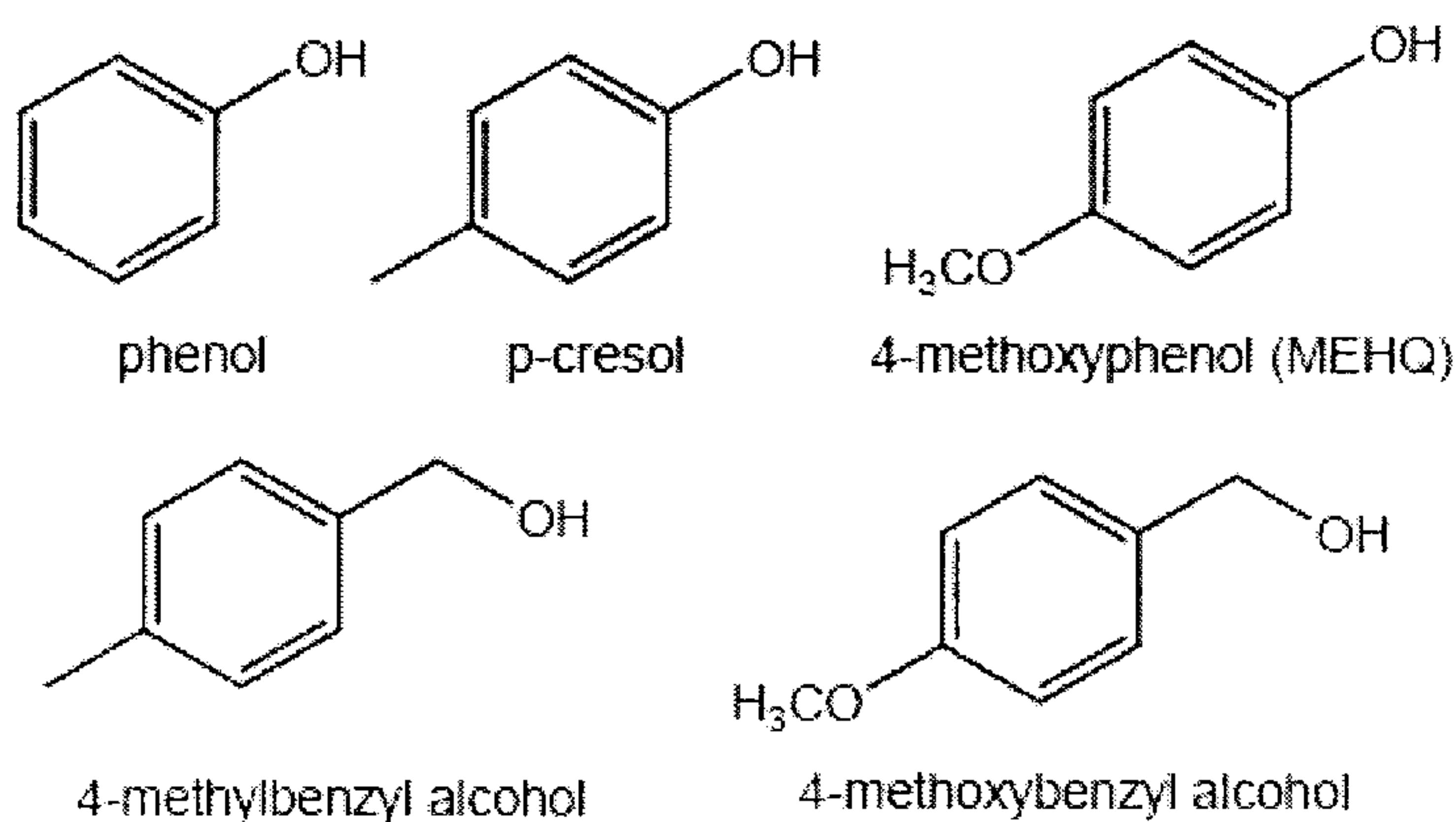


wherein R^4 is linear alkyl chain with the number of carbon atom of 1-12. However, based on the data obtained, potential linear diacid backbone materials are not limited to only these candidates.

[0029] During screening, a variety of alcohols were reacted to make diesters as shown below in Scheme 1:



wherein R^4 is linear alkyl chain with the number of carbon atom of 1-12 and R^5OH is generally an aromatic alcohol with various R groups as substituents. For example, in embodiments, R^5OH may be selected from the group consisting of



and mixtures thereof.

[0030] The reaction was conducted by either (A) a simple one-step Steglich esterification using Dicyclohexylcarbodiimide (DCC) and 4-dimethylaminopyridine (DMAP) reagents at room temperature or (B) condensing the alcohol and the diacid in toluene with p-toluene sulfonic acid as catalyst. Route B was generally reserved for reactions with 4-methylbenzyl alcohol. In situations where the desired products were not attainable using the conditions described in Scheme 1 (*i.e.*, because of incomplete or side reactions), the corresponding dichlorides were reacted with the alcohols in tetrahydrofuran (THF) using DMAP as a base and catalyst, as shown below:



wherein R^4 and R^5OH are as defined above.

Although advantageous, the crystalline component of these inks is not restricted to esters derived from dicarboxylic acids and can be extended to esters derived from diols.

[0031] The amorphous materials are synthesized by a one-step esterification reaction of citric acid. These materials show no crystallization, have relatively low viscosity ($< 10^2$ cps, or from about 1 to about 100 cps, or from about 5 to about 95 cps) at high temperatures, but very high viscosity ($> 10^6$ cps) at room temperature.

[0032] The low viscosity at about 140°C of the above components provide wide formulation latitude. The high viscosity at room temperature imparts robustness. These characteristics make the materials good candidates for the crystalline and amorphous components for the solid ink of the present embodiments.

[0033] In the present embodiments, the solid ink composition is obtained by using novel crystalline and amorphous materials synthesized from esterification reactions. The solid ink composition may also comprise the crystalline and amorphous material in combination with a colorant. The present embodiments comprise a balance of amorphous and crystalline materials to realize a sharp phase transition from liquid to solid and facilitate hard and robust printed images, while maintaining a desired level of viscosity. Prints made with this ink demonstrated advantages over commercially available inks, such as for example, better robustness against scratch. Thus, the resulting ink compositions comprising a blend of the crystalline and amorphous components show good rheological profiles and improved performance in inks. Print samples created by the solid ink composition on coated paper by K-proof demonstrated remarkable robustness. Furthermore, these ester bases have additional advantages of being low cost, and from a potential bio-derived source.

[0034] A K-proofer is a common test fixture in a print shop. In this case, the K-proofer has been modified to heat the printing plate to melt the

solid ink. The K-Proofer used has three rectangular gravure patterns each approximately 9.4 x 4.7 cm. The cell density of the first rectangle is nominally 100%, the second 80%, and the third 60%. In practice this K-proof plate results in films (or pixels) of about 5 microns in thickness (or height). Test ink is spread over the heated gravure plate and a test print is made by passing a wiping blade across the plate surface immediately followed by a rubber roll upon which a test paper has been secured. As the paper roll passes ink is transferred from the gravure cells to the paper.

[0035] In the present embodiments, the solid ink composition may also comprise the crystalline and amorphous material in combination with a colorant. The present embodiments comprise a balance of amorphous and crystalline materials to realize a sharp phase transition from liquid to solid and facilitate hard and robust printed images, while maintaining a desired level of viscosity. Prints made with this ink demonstrated advantages over commercially available inks, such as for example, better robustness against scratch. Thus, the resulting ink compositions comprising a blend of the crystalline and amorphous components show good rheological profiles and that meet the many requirements for ink jet printing.

[0036] The ink composition, in specific embodiments, comprises a colorant, which may be a pigment or dye, present in the ink composition in an amount of at least from about 0.1 percent to about 50 percent by weight, or at least from about 0.2 percent to about 20 percent by weight, or from about 0.5 percent to about 10 percent by weight of the total weight of the ink composition. In embodiments, the crystalline material is present an amount of from about 60 percent to about 95 percent by weight, or from about 65 percent to about 95 percent by weight, or from about 70 percent to about 90 percent by weight of the total weight of the ink composition. In embodiments, the amorphous material is present an amount of from about 5 percent to about 40 percent by weight, or from about 5 percent to about 35 percent by weight, or from about 10 percent to about 30 percent by weight of the total weight of the ink composition.

[0037] In embodiments, the resulting solid ink has a viscosity of from about 1 to about 14 cps, or from about 2 to about 13 cps, or from about 3 to about 12 cps, at a temperature of about 140°C. In embodiments, the solid ink

has a viscosity of about $> 10^6$ cps, at room temperature. In embodiments, the solid ink has a T_{melt} of from about 65 to about 150°C, or from about 65 to about 135°C, from about 70 to about 130°C and a T_{crys} of from about 40 to about 140°C, or from about 45 to about 130°C, from about 50 to about 125°C, as determined by DSC at a rate of 10 °C/min.

[0038] THE CRYSTALLINE COMPONENT

[0039] As stated previously, the esterification reaction used to produce the crystalline component was conducted by a one-step reaction.

[0040] Figure 1 shows the differential scanning calorimetry (DSC) data of bis(4-methoxyphenyl) octanedioate. This material exhibited a sharp, well-defined melting temperature (T_m) of 116°C and crystallization temperature (T_{cryst}) of 80°C, which indicates that the material is a crystalline solid. The relatively narrow gap between T_m and T_{cryst} translates to a rapid phase change, making this material an especially good candidate for the crystalline component of the ink. Figure 2 shows the rheology data of bis(4-methoxyphenyl) octanedioate. This material has a relatively low viscosity ($< 10^2$ cps) at high temperatures, but very high viscosity ($> 10^6$ cps) at room temperature. The low viscosity in the jetting range (100-140°C) provides high formulation latitude. The high viscosity at room temperature imparts hardness. These characteristics also make this material a good candidate for the crystalline component.

[0041] THE AMORPHOUS COMPONENT

[0042] The esterification was conducted by a one-step reaction. Out of ten different alcohols reacted, DL-menthol was identified as the best material to form a stable amorphous tri-ester. Tri-esters of L-menthol and *t*-butylcyclohexanol also solidified amorphously, but also partially crystallized. Tri-esters of phenethyl alcohol and cyclohexanol crystallized in a refrigerator. The rest of the synthesized tri-esters were viscous liquid at room temperature. Suitable alcohols to be used with the present embodiments may be selected from the group consisting of alkyl alcohols, wherein the alkyl portion of the alcohol can be straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to about 40 carbon atoms, or a substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof. In embodiments, three or more molar equivalents of alcohol may be

used in the reaction to produce tri-esters of citric acid. If two molar equivalents of alcohol are used, the result is mostly di-esters, and if one molar equivalent of alcohol is used, the result is mostly mono-esters.

[0043] The ink of embodiments may further include conventional additives to take advantage of the known functionality associated with such conventional additives. Such additives may include, for example, at least one antioxidant, defoamer, slip and leveling agents, clarifier, viscosity modifier, adhesive, plasticizer and the like.

[0044] The ink may optionally contain antioxidants to protect the images from oxidation and also may protect the ink components from oxidation while existing as a heated melt in the ink reservoir. Examples of suitable antioxidants include N,N'-hexamethylene bis(3,5-di-tert-butyl-4-hydroxy hydrocinnamamide) (IRGANOX 1098, available from BASF); 2,2-bis(4-(2-(3,5-di-tert-butyl-4-hydroxyhydrocinnamoyloxy))ethoxyphenyl)propane (TOPANOL-205™, available from Vertullus); tris(4-tert-butyl-3-hydroxy-2,6-dimethyl benzyl)isocyanurate (Aldrich); 2,2'-ethylidene bis(4,6-di-tert-butylphenyl)fluoro phosphonite (ETHANOX-398, available from Albermarle Corporation); tetrakis(2,4-di-tert-butylphenyl)-4,4'-biphenyl diphosphonite (Aldrich); pentaerythritol tetrastearate (TCI America); tributylammonium hypophosphite (Aldrich); 2,6-di-tert-butyl-4-methoxyphenol (Aldrich); 2,4-di-tert-butyl-6-(4-methoxybenzyl)phenol (Aldrich); 4-bromo-2,6-dimethylphenol (Aldrich); 4-bromo-3,5-dimethylphenol (Aldrich); 4-bromo-2-nitrophenol (Aldrich); 4-(diethyl aminomethyl)-2,5-dimethylphenol (Aldrich); 3-dimethylaminophenol (Aldrich); 2-amino-4-tert-amylphenol (Aldrich); 2,6-bis(hydroxymethyl)-p-cresol (Aldrich); 2,2'-methylenediphenol (Aldrich); 5-(diethylamino)-2-nitrosophenol (Aldrich); 2,6-dichloro-4-fluorophenol (Aldrich); 2,6-dibromo fluoro phenol (Aldrich); α-trifluoro-o-cresol (Aldrich); 2-bromo-4-fluorophenol (Aldrich); 4-fluorophenol (Aldrich); 4-chlorophenyl-2-chloro-1,1,2-tri-fluoroethyl sulfone (Aldrich); 3,4-difluoro phenylacetic acid (Aldrich); 3-fluorophenylacetic acid (Aldrich); 3,5-difluoro phenylacetic acid (Aldrich); 2-fluorophenylacetic acid (Aldrich); 2,5-bis (trifluoromethyl) benzoic acid (Aldrich); ethyl-2-(4-(4-(trifluoromethyl)phenoxy)phenoxy)propionate (Aldrich); tetrakis (2,4-di-tert-butyl phenyl)-4,4'-biphenyl diphosphonite (Aldrich); 4-tert-amyl phenol (Aldrich); 3-(2H-benzotriazol-2-yl)-4-hydroxy phenethylalcohol

(Aldrich); NAUGARD 76™, NAUGARD 445™, NAUGARD 512™, AND NAUGARD 524™ (manufactured by Chemtura Corporation), and the like, as well as mixtures thereof. The antioxidant, when present, may be present in the ink in any desired or effective amount, such as from about 0.25 percent to about 10 percent by weight of the ink or from about 1 percent to about 5 percent by weight of the ink.

[0045] In embodiments, the phase change ink compositions described herein also include a colorant. The ink of the present embodiments can thus be one with or without colorants. Any desired or effective colorant can be employed in the phase change ink compositions, including dyes, pigments, mixtures thereof, and the like, provided that the colorant can be dissolved or dispersed in the ink carrier. Any dye or pigment may be chosen, provided that it is capable of being dispersed or dissolved in the ink carrier and is compatible with the other ink components. The phase change carrier compositions can be used in combination with conventional phase change ink colorant materials, such as Color Index (C.I.) Solvent Dyes, Disperse Dyes, modified Acid and Direct Dyes, Basic Dyes, Sulphur Dyes, Vat Dyes, and the like. Examples of suitable dyes include Neozapon Red 492 (BASF); Orasol Red G (Pylam Products); Direct Brilliant Pink B (Oriental Giant Dyes); Direct Red 3BL (Classic Dyestuffs); Supranol Brilliant Red 3BW (Bayer AG); Lemon Yellow 6G (United Chemie); Light Fast Yellow 3G (Shaanxi); Aizen Spilon Yellow C-GNH (Hodogaya Chemical); Bemachrome Yellow GD Sub (Classic Dyestuffs); Cartasol Brilliant Yellow 4GF (Clariant); Cibanone Yellow 2G (Classic Dyestuffs); Orasol Black RLI (BASF); Orasol Black CN (Pylam Products); Savinyl Black RLSN (Clariant); Pyrazol Black BG (Clariant); Morfast Black 101 (Rohm & Haas); Diaazol Black RN (ICI); Thermoplast Blue 670 (BASF); Orasol Blue GN (Pylam Products); Savinyl Blue GLS (Clariant); Luxol Fast Blue MBSN (Pylam Products); Sevron Blue 5GMF (Classic Dyestuffs); Basacid Blue 750 (BASF); Keyplast Blue (Keystone Aniline Corporation); Neozapon Black X51 (BASF); Classic Solvent Black 7 (Classic Dyestuffs); Sudan Blue 670 (C.I. 61554) (BASF); Sudan Yellow 146 (C.I. 12700) (BASF); Sudan Red 462 (C.I. 26050) (BASF); C.I. Disperse Yellow 238; Neptune Red Base NB543 (BASF, C.I. Solvent Red 49); Neopen Blue FF-4012 (BASF); Lampronol Black BR (C.I. Solvent Black 35) (ICI); Morton

Morplas Magenta 36 (C.I. Solvent Red 172); metal phthalocyanine colorants-such as those disclosed in U.S. Pat. No. 6,221,137. Polymeric dyes can also be used, such as those disclosed in, for example, U.S. Pat. No. 5,621,022 and U.S. Pat. No. 5,231,135, and commercially available from, for example, Milliken & Company as Milliken Ink Yellow 869, Milliken Ink Blue 92, Milliken Ink Red 357, Milliken Ink Yellow 1800, Milliken Ink Black 8915-67, uncut Reactint Orange X-38, uncut Reactint Blue X-17, Solvent Yellow 162, Acid Red 52, Solvent Blue 44, and uncut Reactint Violet X-80.

[0046] Pigments are also suitable colorants for the phase change inks. Examples of suitable pigments include PALIOGEN Violet 5100 (BASF); PALIOGEN Violet 5890 (BASF); HELIOGEN Green L8730 (BASF); LITHOL Scarlet D3700 (BASF); SUNFAST Blue 15:4 (Sun Chemical); Hostaperm Blue B2G-D (Clariant); Hostaperm Blue B4G (Clariant); Permanent Red P-F7RK; Hostaperm Violet BL (Clariant); LITHOL Scarlet 4440 (BASF); Bon Red C (Dominion Color Company); ORACET Pink RF (BASF); PALIOGEN Red 3871 K (BASF); SUNFAST Blue 15:3 (Sun Chemical); PALIOGEN Red 3340 (BASF); SUNFAST Carbazole Violet 23 (Sun Chemical); LITHOL Fast Scarlet L4300 (BASF); SUNBRITE Yellow 17 (Sun Chemical); HELIOGEN Blue L6900, L7020 (BASF); SUNBRITE Yellow 74 (Sun Chemical); SPECTRA PAC C Orange 16 (Sun Chemical); HELIOGEN Blue K6902, K6910 (BASF); SUNFAST Magenta 122 (Sun Chemical); HELIOGEN Blue D6840, D7080 (BASF); Sudan Blue OS (BASF); NEOPEN Blue FF4012 (BASF); PV Fast Blue B2GO1 (Clariant); IRGALITE Blue GLO (BASF); PALIOGEN Blue 6470 (BASF); Sudan Orange G (Aldrich), Sudan Orange 220 (BASF); PALIOGEN Orange 3040 (BASF); PALIOGEN Yellow 152, 1560 (BASF); LITHOL Fast Yellow 0991 K (BASF); PALIOTOL Yellow 1840 (BASF); NOVOPERM Yellow FGL (Clariant); Ink Jet Yellow 4G VP2532 (Clariant); Toner Yellow HG (Clariant); Lumogen Yellow D0790 (BASF); Suco-Yellow L1250 (BASF); Suco-Yellow D1355 (BASF); Suco Fast Yellow D1355, D1351 (BASF); HOSTAPERM Pink E 02 (Clariant); Hansa Brilliant Yellow 5GX03 (Clariant); Permanent Yellow GRL 02 (Clariant); Permanent Rubine L6B 05 (Clariant); FANAL Pink D4830 (BASF); CINQUASIA Magenta (DU PONT); PALIOGEN Black L0084 (BASF); Pigment Black K801 (BASF); and carbon blacks such as

REGAL 330™ (Cabot), Nipex 150 (Evonik) Carbon Black 5250 and Carbon Black 5750 (Columbia Chemical), and the like, as well as mixtures thereof.

[0047] Pigment dispersions in the ink base may be stabilized by synergists and dispersants. Generally, suitable pigments may be organic materials or inorganic. Magnetic material-based pigments are also suitable, for example, for the fabrication of robust Magnetic Ink Character Recognition (MICR) inks. Magnetic pigments include magnetic nanoparticles, such as for example, ferromagnetic nanoparticles.

[0048] Also suitable are the colorants disclosed in U.S. Pat. No. 6,472,523, U.S. Pat. No. 6,726,755, U.S. Pat. No. 6,476,219, U.S. Pat. No. 6,576,747, U.S. Pat. No. 6,713,614, U.S. Pat. No. 6,663,703, U.S. Pat. No. 6,755,902, U.S. Pat. No. 6,590,082, U.S. Pat. No. 6,696,552, U.S. Pat. No. 6,576,748, U.S. Pat. No. 6,646,111, U.S. Pat. No. 6,673,139, U.S. Pat. No. 6,958,406, U.S. Pat. No. 6,821,327, U.S. Pat. No. 7,053,227, U.S. Pat. No. 7,381,831 and U.S. Pat. No. 7,427,323.

[0049] In embodiments, solvent dyes are employed. An example of a solvent dye suitable for use herein may include spirit soluble dyes because of their compatibility with the ink carriers disclosed herein. Examples of suitable spirit solvent dyes include Neozapon Red 492 (BASF); Orasol Red G (Pylam Products); Direct Brilliant Pink B (Global Colors); Aizen Spilon Red C-BH (Hodogaya Chemical); Kayanol Red 3BL (Nippon Kayaku); Spirit Fast Yellow 3G; Aizen Spilon Yellow C-GNH (Hodogaya Chemical); Cartasol Brilliant Yellow 4GF (Clariant); Pergasol Yellow 5RA EX (Classic Dyestuffs); Orasol Black RLI (BASF); Orasol Blue GN (Pylam Products); Savinyl Black RLS (Clariant); Morfast Black 101 (Rohm and Haas); Thermoplast Blue 670 (BASF); Savinyl Blue GLS (Sandoz); Luxol Fast Blue MBSN (Pylam); Sevron Blue 5GMF (Classic Dyestuffs); Basacid Blue 750 (BASF); Keyplast Blue (Keystone Aniline Corporation); Neozapon Black X51 (C.I. Solvent Black, C.I. 12195) (BASF); Sudan Blue 670 (C.I. 61554) (BASF); Sudan Yellow 146 (C.I. 12700) (BASF); Sudan Red 462 (C.I. 260501) (BASF), mixtures thereof and the like.

[0050] The colorant may be present in the phase change ink in any desired or effective amount to obtain the desired color or hue such as, for example, at least from about 0.1 percent by weight of the ink to about 50

percent by weight of the ink, at least from about 0.2 percent by weight of the ink to about 20 percent by weight of the ink, and at least from about 0.5 percent by weight of the ink to about 10 percent by weight of the ink.

[0051] In embodiments, the ink carriers for the phase change inks may have melting points of from about 65 °C to about 150 °C, for example from about 70 °C to about 140 °C, from about 75 °C to about 135 °C, from about 80 °C to about 130 °C, or from about 85 °C to about 125 °C as determined by, for example, differential scanning calorimetry at a rate of 10°C/min. Furthermore, these inks have a jetting viscosity of about 1 cps to about 13 cps, such as from about 2 cps to about 13 cps, from about 4 cps to about 12 cps, at a temperature of about 140 °C.

[0052] The ink compositions can be prepared by any desired or suitable method. For example, each of the components of the ink carrier can be mixed together, followed by heating, the mixture to at least its melting point, for example from about 60 °C to about 150 °C, 80 °C to about 145 °C and 85 °C to about 140 °C. The colorant may be added before the ink ingredients have been heated or after the ink ingredients have been heated. When pigments are the selected colorants, the molten mixture may be subjected to grinding in an attritor or media mill apparatus or other high energy mixing equipment to affect dispersion of the pigment in the ink carrier. The heated mixture is then stirred for about 5 seconds to about 30 minutes or more, to obtain a substantially homogeneous, uniform melt, followed by cooling the ink to ambient temperature (typically from about 20 °C to about 25 °C). The inks are solid at ambient temperature. The inks can be employed in apparatus for direct printing ink jet processes and in indirect (offset) printing ink jet applications. Another embodiment disclosed herein is directed to a process which comprises incorporating an ink as disclosed herein into an ink jet printing apparatus, melting the ink, and causing droplets of the melted ink to be ejected in an imagewise pattern onto a recording substrate. A direct printing process is also disclosed in, for example, U.S. Pat. No. 5,195,430. Yet another embodiment disclosed herein is directed to a process which comprises incorporating an ink as disclosed herein into an ink jet printing apparatus, melting the ink, causing droplets of the melted ink to be ejected in an imagewise pattern onto an intermediate transfer member, and transferring

the ink in the imagewise pattern from the intermediate transfer member to a final recording substrate. In a specific embodiment, the intermediate transfer member is heated to a temperature above that of the final recording sheet and below that of the melted ink in the printing apparatus. In another specific embodiment, both the intermediate transfer member and the final recording sheet are heated; in this embodiment, both the intermediate transfer member and the final recording sheet are heated to a temperature below that of the melted ink in the printing apparatus; in this embodiment, the relative temperatures of the intermediate transfer member and the final recording sheet can be (1) the intermediate transfer member is heated to a temperature above that of the final recording substrate and below that of the melted ink in the printing apparatus; (2) the final recording substrate is heated to a temperature above that of the intermediate transfer member and below that of the melted ink in the printing apparatus; or (3) the intermediate transfer member and the final recording sheet are heated to approximately the same temperature. An offset or indirect printing process is also disclosed in, for example, U.S. Pat. No. 5,389,958. In one specific embodiment, the printing apparatus employs a piezoelectric printing process wherein droplets of the ink are caused to be ejected in imagewise pattern by oscillations of piezoelectric vibrating elements. Inks as disclosed herein can also be employed in other hot melt printing processes, such as hot melt acoustic ink jet printing, hot melt thermal ink jet printing, hot melt continuous stream or deflection ink jet printing, and the like. Phase change inks as disclosed herein can also be used in printing processes other than hot melt ink jet printing processes.

[0053] Any suitable substrate or recording sheet can be employed, including plain papers such as XEROX 4200 papers, XEROX Image Series papers, Courtland 4024 DP paper, ruled notebook paper, bond paper, silica coated papers such as Sharp Company silica coated paper, JuJo paper, HAMMERMILL LASERPRINT paper, and the like, glossy coated papers such as XEROX Digital Color Elite Gloss, Sappi Warren Papers LUSTROGLOSS, specialty papers such as Xerox DURAPAPER, and the like, transparency materials, fabrics, textile products, plastics, polymeric films, inorganic recording mediums such as metals and wood, and the like, transparency

materials, fabrics, textile products, plastics, polymeric films, inorganic substrates such as metals and wood, and the like.

[0054] The inks described herein are further illustrated in the following examples. All parts and percentages are by weight unless otherwise indicated.

[0055] It will be appreciated that various of the above-disclosed and other features and functions, or alternatives thereof, may be desirably combined into many other different systems or applications. Also, various modifications, variations or improvements therein may be subsequently made by those skilled in the art, and are also intended to be encompassed by the invention.

[0056] While the description above refers to particular embodiments, it will be understood that many modifications may be made without departing from the scope thereof. The accompanying claims are intended to cover such modifications as would fall within the true scope of the invention.

[0057] The presently disclosed embodiments are, therefore, to be considered in all respects as illustrative and not restrictive, the scope of embodiments being indicated by the appended claims rather than the foregoing description. All changes that come within the meaning of and range of equivalency of the claims are intended to be embraced therein.

EXAMPLES

[0058] The examples set forth herein below and are illustrative of different compositions and conditions that can be used in practicing the present embodiments. All proportions are by weight unless otherwise indicated. It will be apparent, however, that the present embodiments can be practiced with many types of compositions and can have many different uses in accordance with the disclosure above and as pointed out hereinafter.

[0059] **Example 1**

[0060] **Preparation of Bis(4-methoxyphenyl) octanedioate**

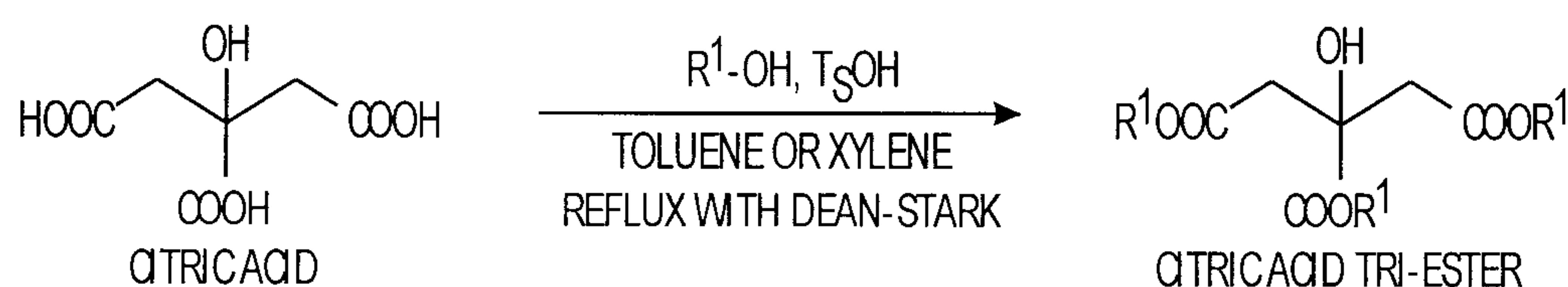
[0061] In a typical synthesis of, for example, bis(4-methoxyphenyl) octanedioate, suberic acid (10 g, 57.4 mmol), DMAP (1.052 g, 8.61 mmol) and dry tetrahydrofuran (Volume: 300 ml) were added to a 250 mL 1-necked round-bottomed flask, equipped with a stir bar, and stirred to give a slightly

hazy solution. Next, DCC (26.1 g, 126 mmol) was dissolved in about 10 mL dry THF and added to the reaction, and stirred for 15 min. A cloudy white precipitate formed. Finally, 4-methoxyphenol (14.25 g, 115 mmol) was added, and stirred overnight. The dicyclohexylurea (DCHU) byproduct was removed by filtration, the filtrate concentrated *in vacuo* to furnish a solid residue. The residue was dissolved in THF and recrystallized using hexanes to give 14.46g of an off-white crystalline product (65% yield). The product was characterized by ^1H NMR and acid # analysis (2.86 mg KOH/g).

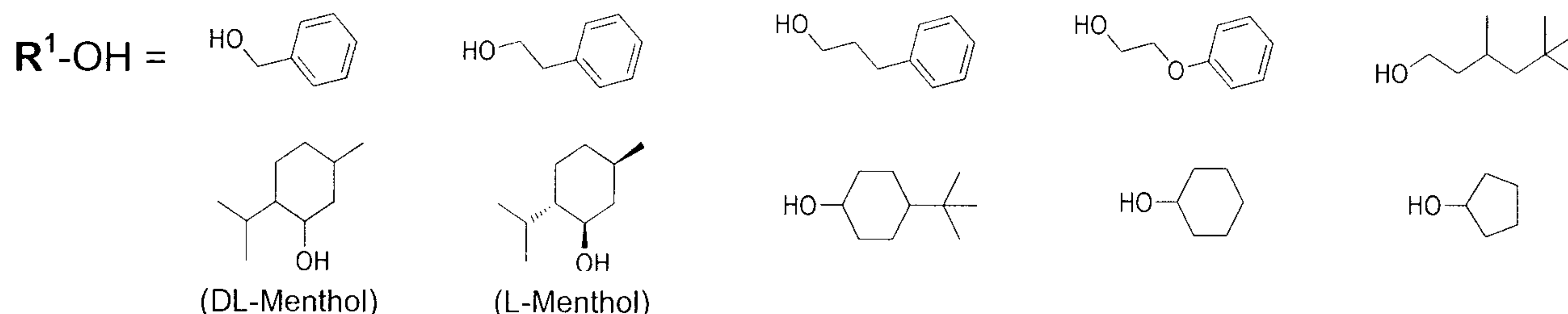
[0062] Example 2

[0063] Preparation of Tri-DL-menthyl citrate

[0064] In a typical synthesis of, for example, tri-DL-menthyl citrate (TMC), citric acid (20.0 g, 104 mmol), DL-menthol (48.8 g, 312 mmol), and xylene (250 ml) were added to a 500 mL flask, equipped with a Dean-Stark trap, to give a suspension. *p*-Toluenesulfonic acid monohydrate (0.396 g, 2.08 mmol) was added and the mixture was refluxed for 21 hours with azeotropic removal of water. The reaction mixture was cooled down to room temperature and washed with 10 wt % KOH aq. (1x) and brine (2x), then dried over MgSO_4 . After filtration and removal of the solvent, the residue was dried under vacuum with stirring at 120 °C to obtain 49.3 g (yield: 78%) of amorphous solid. The sample was characterized by ^1H NMR and acid number analysis (16.34 mgKOH/g). The synthesis scheme is illustrated below:



wherein



[0065] In embodiments, R^1 of R^1 -OH is selected from the group consisting of an alkyl group, wherein the alkyl portion can be straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to about 40 carbon atoms, or a substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof.

[0066] Preparation of the Solid Ink 1

[0067] Trimenthol ester of citric acid (TMC) was used as the amorphous candidate material. TMC, crystalline material, and 3 weight percent of cyan dye (Ciba Orasol Blue GN) were stirred in the molten state at 120°C to yield a homogenous liquid mixture and then cooled down to obtain ink samples. The ratio of crystalline:amorphous was 70:30. The formulation of Ink 1 is tabulated in Table 1.

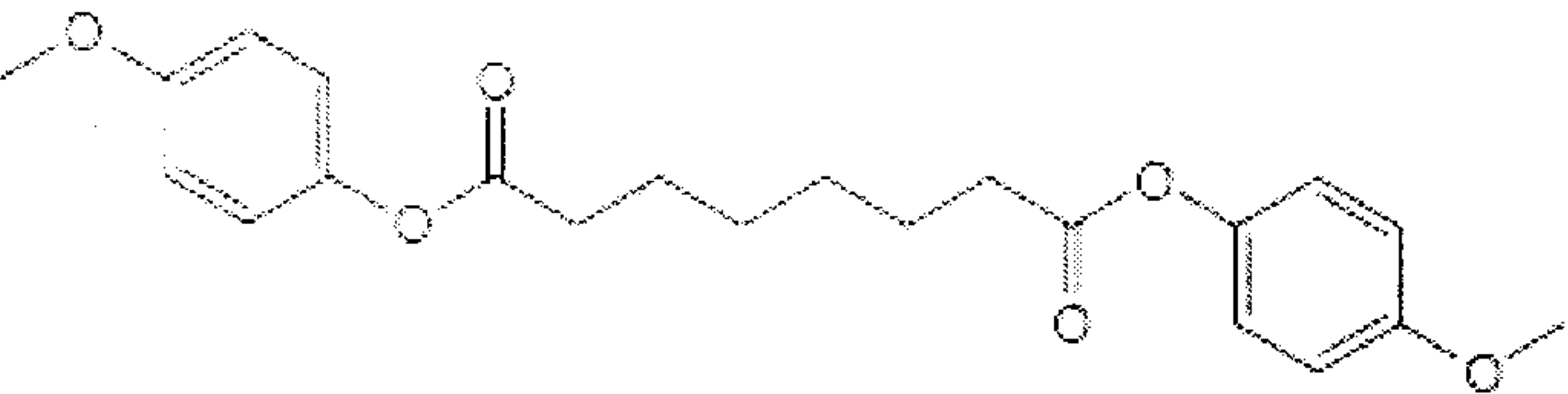
Table 1

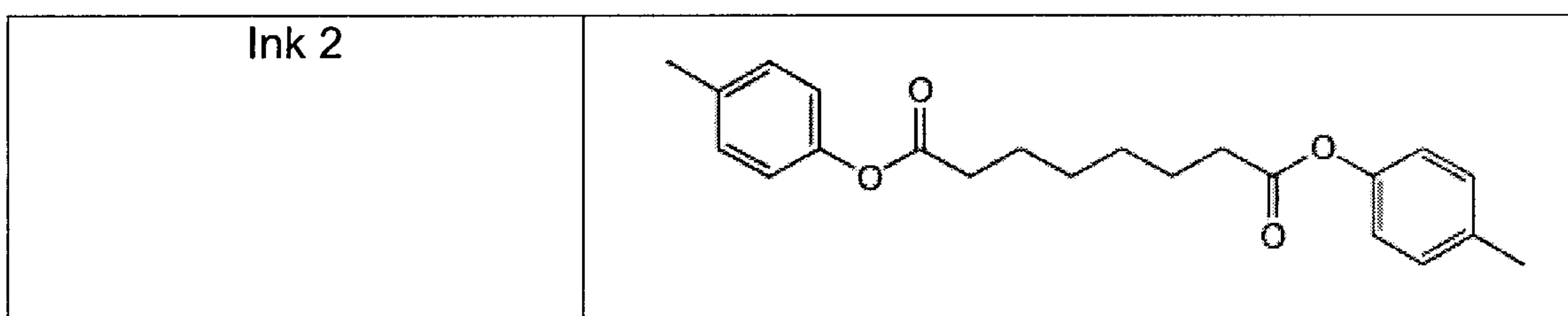
Ink 1 (30:70 Amorphous:Crystalline)		
Component	Weight Percent	Weight (g)
Trimenthol citrate	29.1	1.15
bis(4-methoxyphenyl) octanedioate	67.9	2.72
Cyan dye (Orasol Blue GN)	3.0	0.12
TOTAL	100.0	4

[0068] Preparation of the Solid Ink 2

[0069] Ink 2 was prepared in the same manner as Ink 1 except that a different crystalline component was used. In particular, di-p-tolyl octanedioate was used in place of bis(4-methoxyphenyl) octanedioate. Table 2 shows the crystalline components used in Ink 1 and Ink 2.

Table 2

Ink	Crystalline Component Structure
Ink 1	



[0070] Figure 3 shows rheology data of Ink 1 and Ink 2. All the inks showed phase transitions to $>10^6$ cps in desirable temperature range ($60\text{ }^{\circ}\text{C} < T < 130\text{ }^{\circ}\text{C}$) and the phase transition temperature is adjustable by changing the crystalline/amorphous ratio. Furthermore, viscosities at around $140\text{ }^{\circ}\text{C}$ (jetting temperature) were about 10 cps and again adjustable by changing the ratio.

[0071] Print Performance

[0072] The inks were printed using a K-proofer (manufactured by RK Print Coat Instrument Ltd., Litlington, Royston, Heris, SG8 0OZ, U.K.) onto Xerox Digital Color Elite Gloss, 120 gsm (DCEG) to form robust images that could not be easily removed from the substrate. When a scratch/gouge finger with a curved tip at an angle of about 15° from vertical, with a weight of 528 g applied, was drawn across the image at a rate of approximately 13 mm/s no ink was visibly removed from the image. The scratch/gouge tip is similar to a lathe round nose cutting bit with radius of curvature of approximately 12mm.

[0073] Summary

[0074] In summary, the present embodiments provide solid ink formulations developed for ink jet printing which contains at least one crystalline material and at least one amorphous material. The inks may also include a colorant, such as a pigment or dye. The novel crystalline and amorphous materials are synthesized from esterification reactions. For example, the crystalline component is derived from aliphatic linear diacids or aliphatic linear acid chlorides while the amorphous component is derived from citric acid. The resulting crystalline and amorphous materials have desirable physical properties which provide for robust inks.

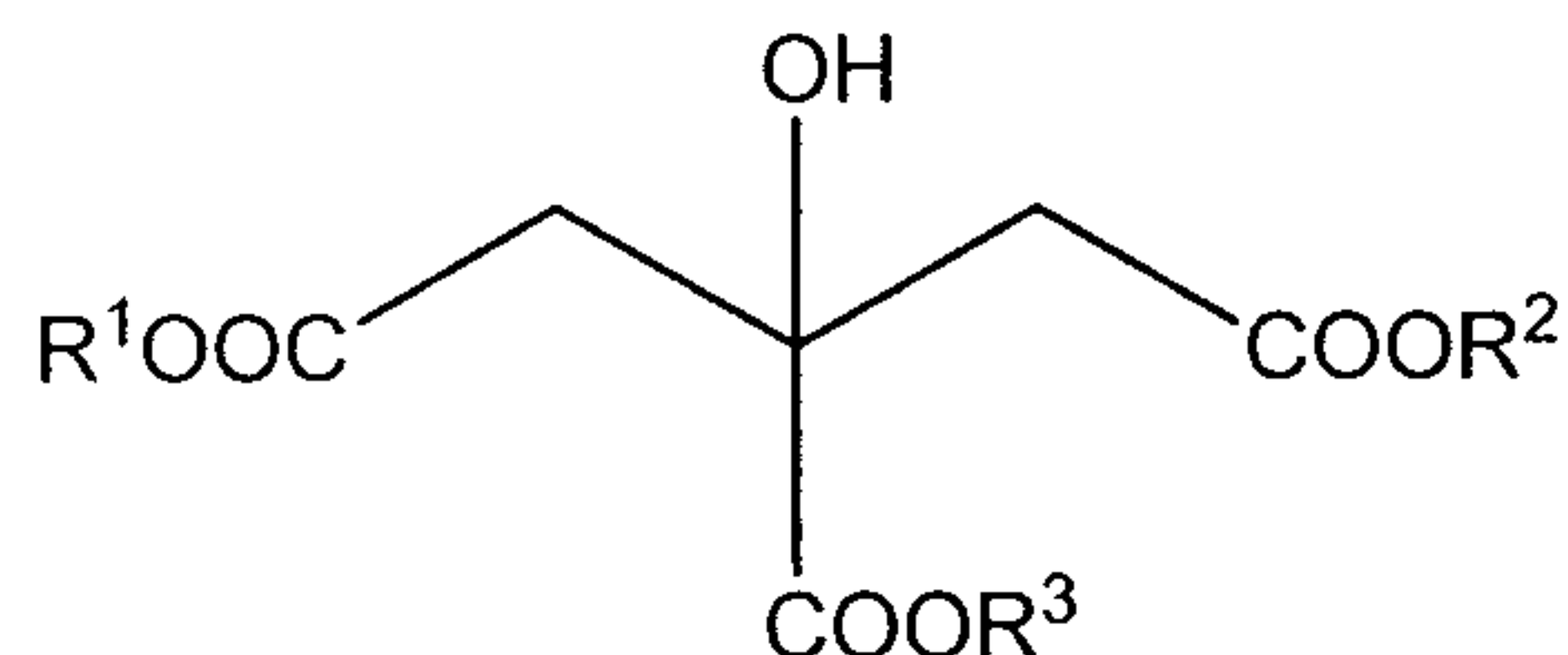
[0075] The claims, as originally presented and as they may be amended, encompass variations, alternatives, modifications, improvements, equivalents, and substantial equivalents of the embodiments and teachings

disclosed herein, including those that are presently unforeseen or unappreciated, and that, for example, may arise from applicants/patentees and others. Unless specifically recited in a claim, steps or components of claims should not be implied or imported from the specification or any other claims as to any particular order, number, position, size, shape, angle, color, or material.

CLAIMS

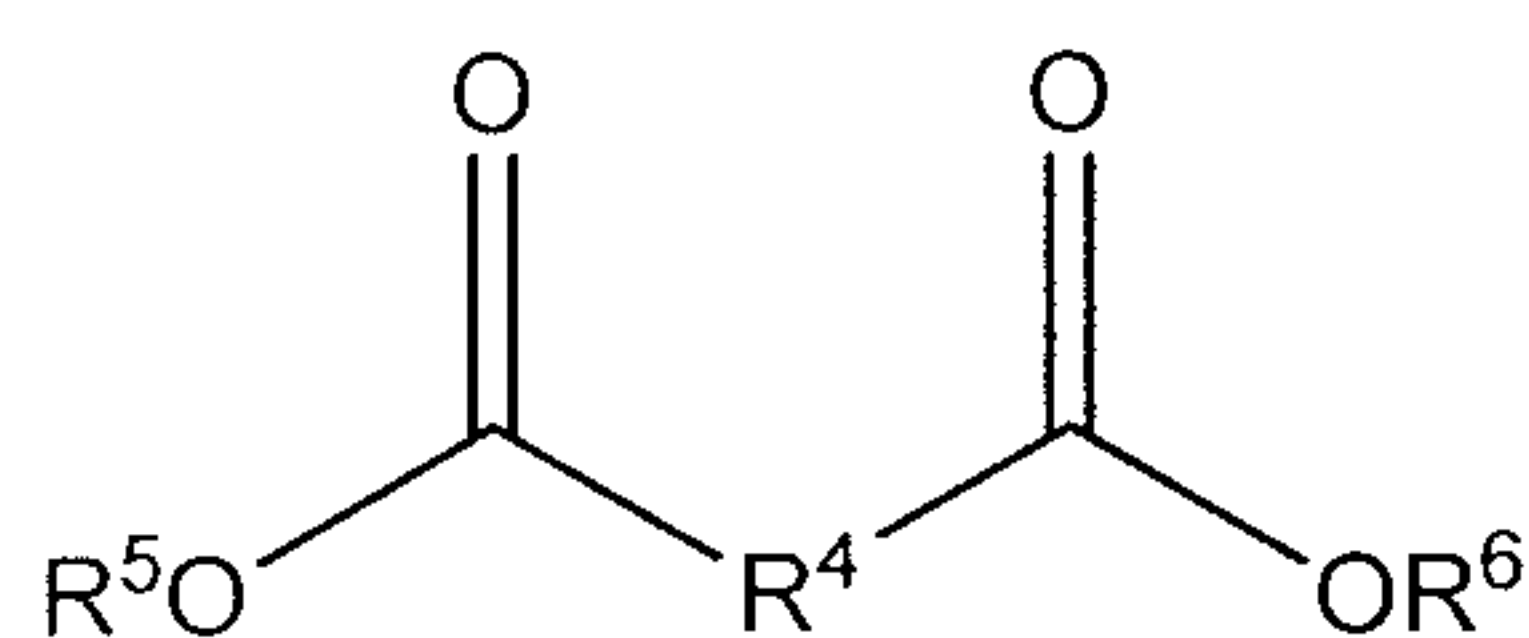
WHAT IS CLAIMED IS:

1. A phase change ink comprising:
an amorphous component, wherein the amorphous component is an ester of citric acid having a formula of



wherein R^1 , R^2 , and R^3 each, independently of the other, is selected from the group consisting of an alkyl group, wherein the alkyl portion is straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to 40 carbon atoms, or a substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof; and

a crystalline component, wherein the crystalline component is an ester of an aliphatic linear diacid having the following structure:

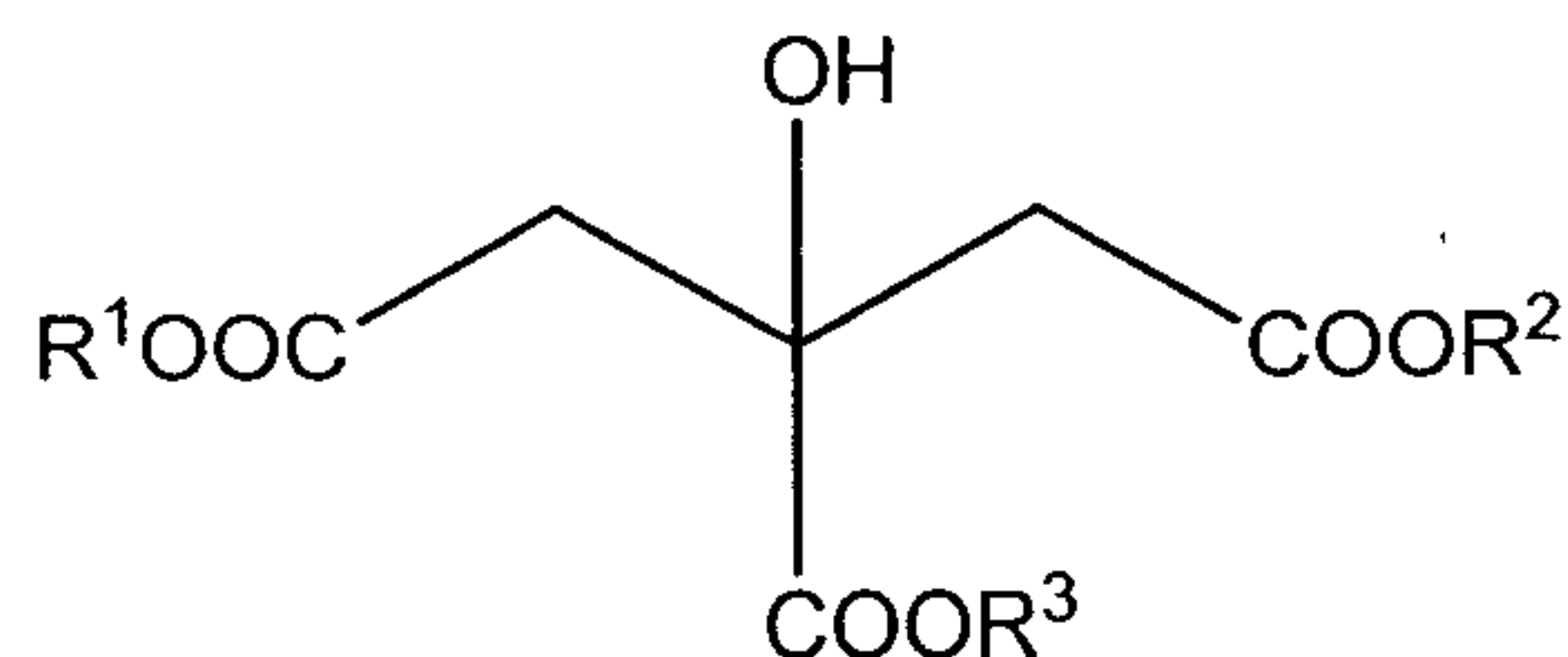


wherein R^4 is a substituted or unsubstituted alkyl chain and is selected from the group consisting of $-(\text{CH}_2)_1-$ to $-(\text{CH}_2)_{12}-$, and wherein R^5 and R^6 , each independently of the other, is selected from the group consisting of an alkyl group, wherein the alkyl portion is straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from about 1 to 40 carbon atoms, or a substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof.

2. The phase change ink of claim 1, wherein the crystalline and amorphous components are blended in a weight ratio of from about 65:35 to about 95:5.

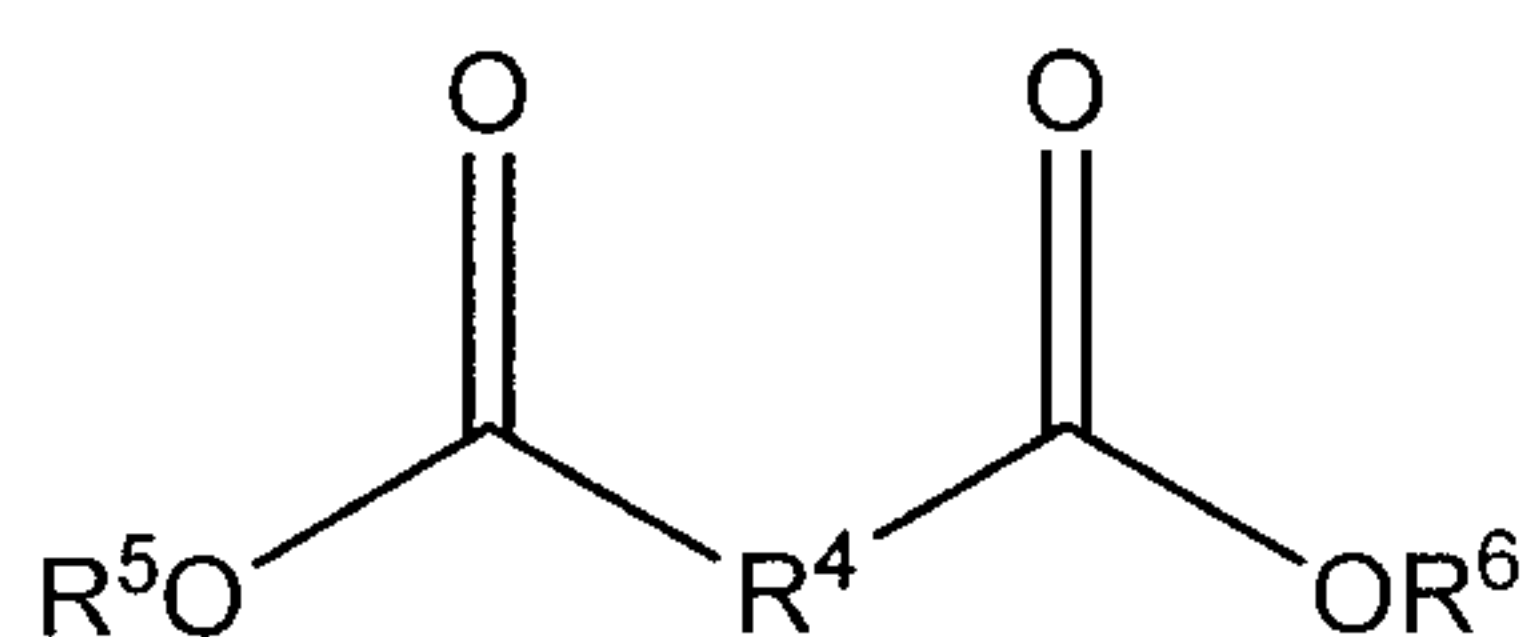
3. The phase change ink of claim 2, wherein the crystalline and amorphous components are blended in a weight ratio of from about 70:30 to about 90:10.

4. The phase change ink of claim 1, wherein the crystalline component is present in an amount of from about 60 percent to about 95 percent by weight of the total weight of the phase change ink.
5. The phase change ink of claim 1, wherein the amorphous component is present in an amount of from about 5 percent to about 40 percent by weight of the total weight of the phase change ink.
6. The phase change ink of claim 1 further comprising a colorant selected from the group consisting of a pigment, dye and mixtures thereof.
7. The phase change ink of claim 1, wherein the crystalline component has a viscosity of from about 0.5 to about 10 cps at a temperature of about 140°C.
8. The phase change ink of claim 7, wherein the crystalline component has a viscosity of from about 1 to about 10 cps at a temperature of about 140°C.
9. The phase change ink of claim 1, wherein the crystalline component is in a crystalline state at room temperature.
10. The phase change ink of claim 1, wherein the amorphous component has a viscosity of from about 1 to about 100 cps at a temperature of about 140°C.
11. The phase change ink of claim 1, wherein the amorphous component has a viscosity of at least 10^6 cps at room temperature.
12. The phase change ink of claim 1 having a viscosity of less than about 15 cps at a temperature of about 140°C.
13. The phase change ink of claim 1 having a viscosity of greater than about 10^6 cps at a temperature between about 20 to about 27 °C.
14. The phase change ink of claim 1, wherein the amorphous component has a molecular weight of less than 1000 g/mol.
15. The phase change ink of claim 14, wherein the amorphous component has a molecular weight of from about 300 to about 1000 g/mol.
16. The phase change ink of claim 1, wherein the amorphous component has a T_g value of from about 10 to about 50°C.
17. A phase change ink comprising:
an amorphous component, wherein the amorphous component is an ester of citric acid having a formula of



wherein R^1 , R^2 , and R^3 each, independently of the other, is selected from the group consisting of an alkyl group, wherein the alkyl portion is straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to 40 carbon atoms, or a substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof;

a crystalline component, wherein the crystalline component is an ester of an aliphatic linear diacid having the following structure:

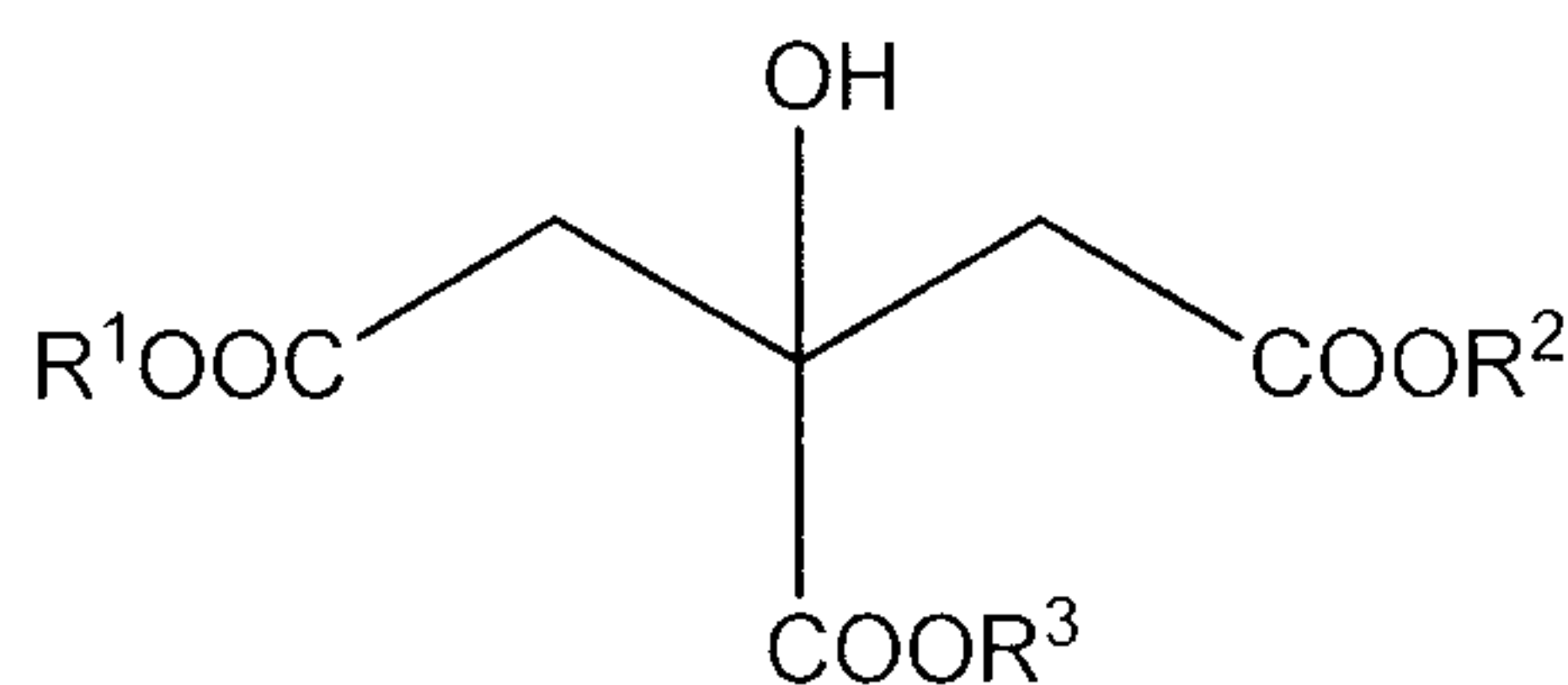


wherein R^4 is substituted or unsubstituted alkyl chain and is selected from the group consisting of $-(\text{CH}_2)_1-$ to $-(\text{CH}_2)_{12}-$, and wherein R^5 and R^6 , each independently of the other, is selected from the group consisting of an alkyl group, wherein the alkyl portion is straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from about 1 to 40 carbon atoms, or a substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof; and

an optional colorant, and further wherein the crystalline component exhibits crystallization (T_{crys}) and melting (T_{melt}) peaks and the difference between the peaks ($T_{\text{melt}}-T_{\text{crys}}$) is less than 55°C , and further wherein the amorphous component has a T_g value of from about 10 to 50°C .

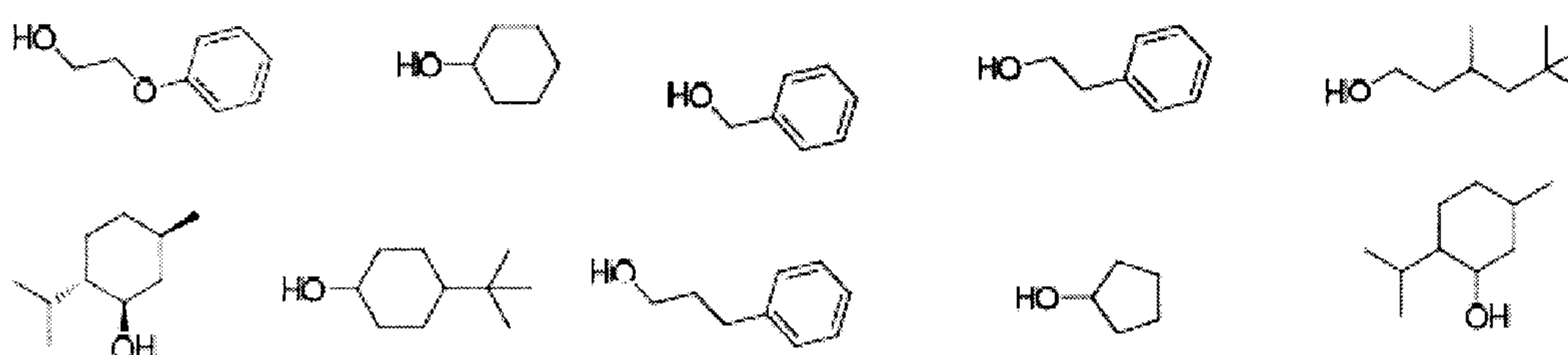
18. A phase change ink comprising:

an amorphous component, wherein the amorphous component is an ester of citric acid synthesized by an esterification reaction with at least one alcohol and having the formula:



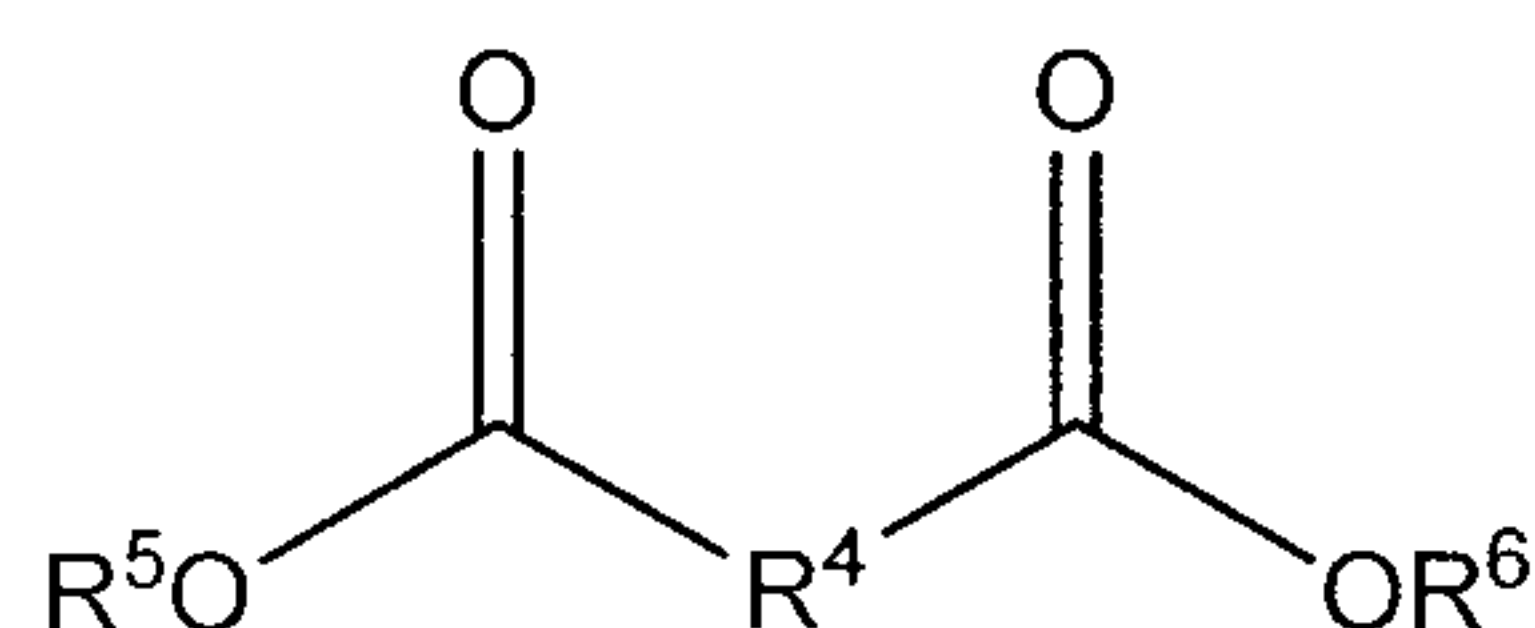
wherein R^1 , R^2 , and R^3 each, independently of the other, is selected from the group consisting of alkyl group, wherein the alkyl portion is straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to 40 carbon atoms, or a substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof;

wherein the alcohol for reacting with the citric acid is selected from the group consisting of



and mixtures thereof;

a crystalline component, wherein the crystalline component is an ester of an aliphatic linear diacid synthesized by an esterification reaction with at least one alcohol and having the following structure:

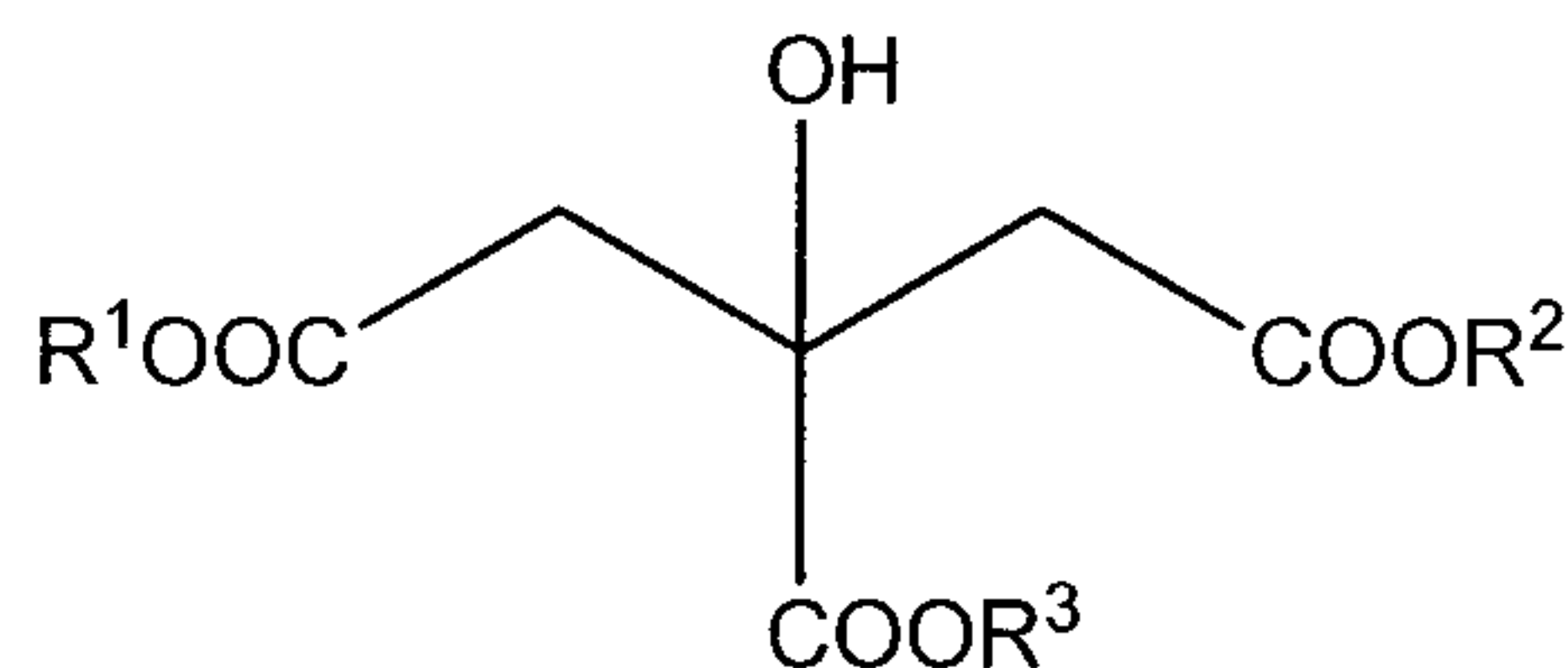


wherein R^4 is substituted or unsubstituted alkyl chain and is selected from the group consisting of $-(CH_2)_1-$ to $-(CH_2)_{12}-$, and wherein R^5 and R^6 , each independently of the other, is selected from the group consisting of an alkyl group, wherein the alkyl portion is straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from about 1 to 40 carbon atoms, or a substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof; and

an optional colorant.

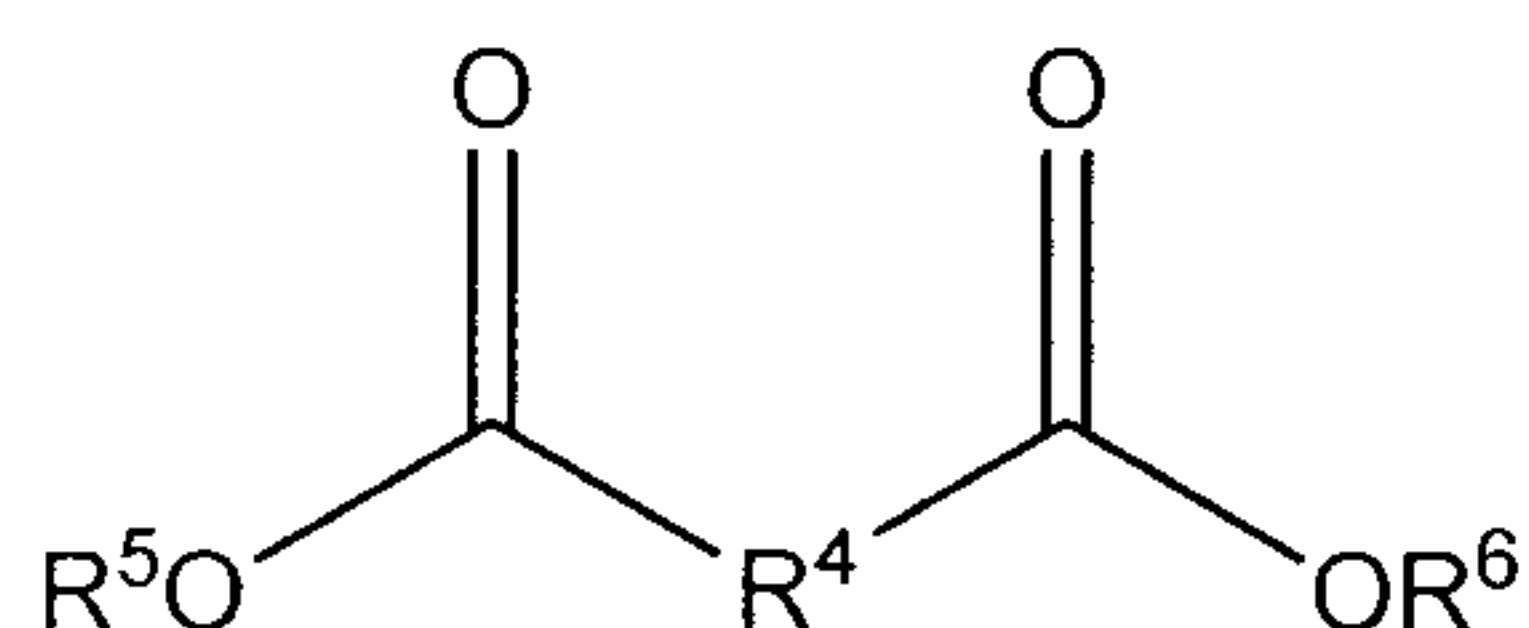
19. The phase change ink of claim 18, wherein the alcohol for reacting with the aliphatic linear diacid is selected from the group consisting of phenol, p-cresol, 4-methoxyphenol, 4-methylbenzyl alcohol, 4-methoxybenzyl alcohol and mixtures thereof.

20. A phase change ink comprising:
 an amorphous component, wherein the amorphous component
 is an ester of citric acid having a formula of



wherein R^1 , R^2 , and R^3 each, independently of the other, is selected from the group consisting of an alkyl group, wherein the alkyl portion is straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to about 40 carbon atoms, or an substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof;

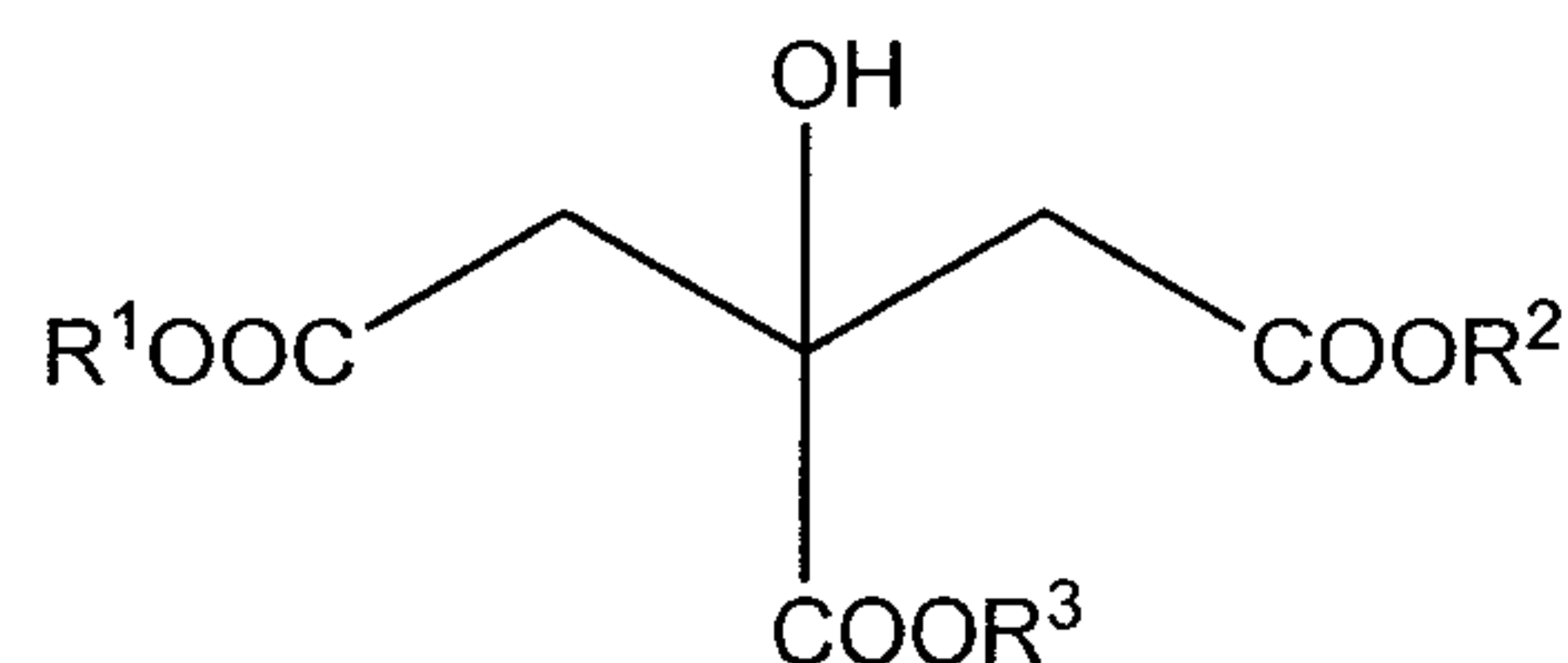
a crystalline component, wherein the crystalline component is an ester of an aliphatic linear diacid having the following structure:



wherein R^4 is substituted or unsubstituted alkyl chain and is selected from the group consisting of $-(\text{CH}_2)_1-$ to $-(\text{CH}_2)_{12}-$, and wherein R^5 and R^6 , each independently of the other, is selected from the group consisting of an alkyl group, wherein the alkyl portion is straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from about 1 to about 40 carbon atoms, or an substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof; and

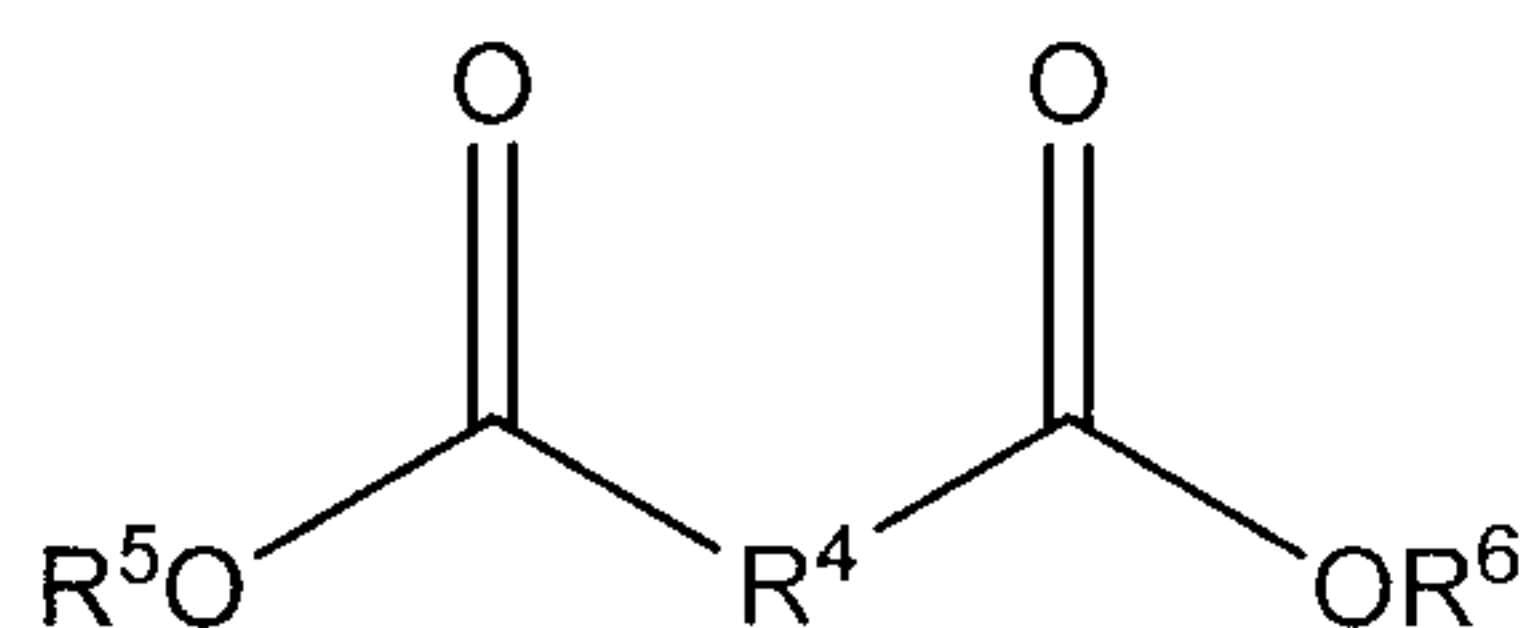
a colorant.

21. A phase change ink comprising:
 an amorphous component, wherein the amorphous component
 is an ester of citric acid synthesized by an esterification reaction with at least one alcohol and having the formula:



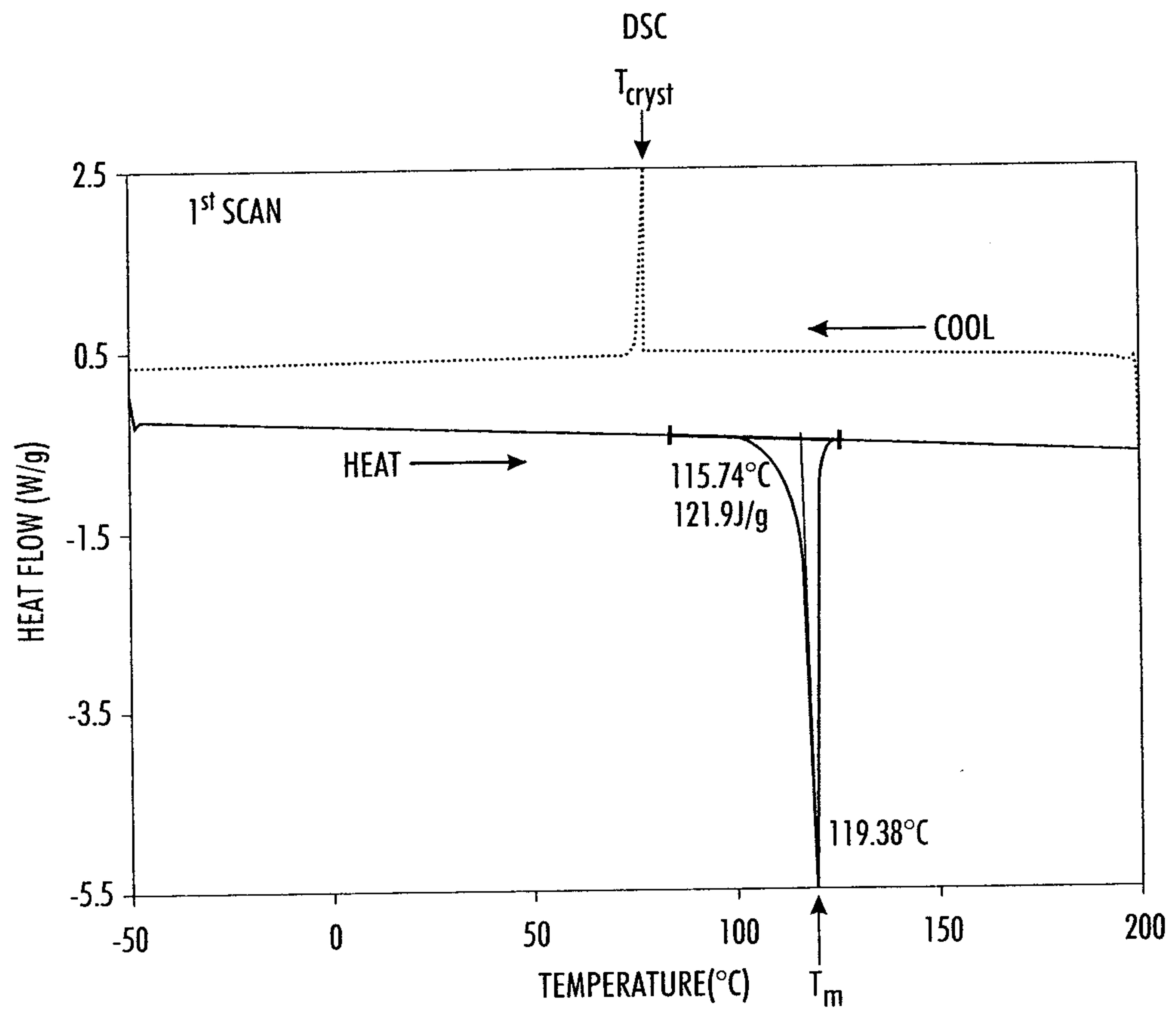
wherein R^1 , R^2 , and R^3 each, independently of the other, is selected from the group consisting of alkyl group, wherein the alkyl portion is straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to 40 carbon atoms, or a substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof;

a crystalline component, wherein the crystalline component is an ester of an aliphatic linear diacid synthesized by an esterification reaction with at least one alcohol and having the following structure:

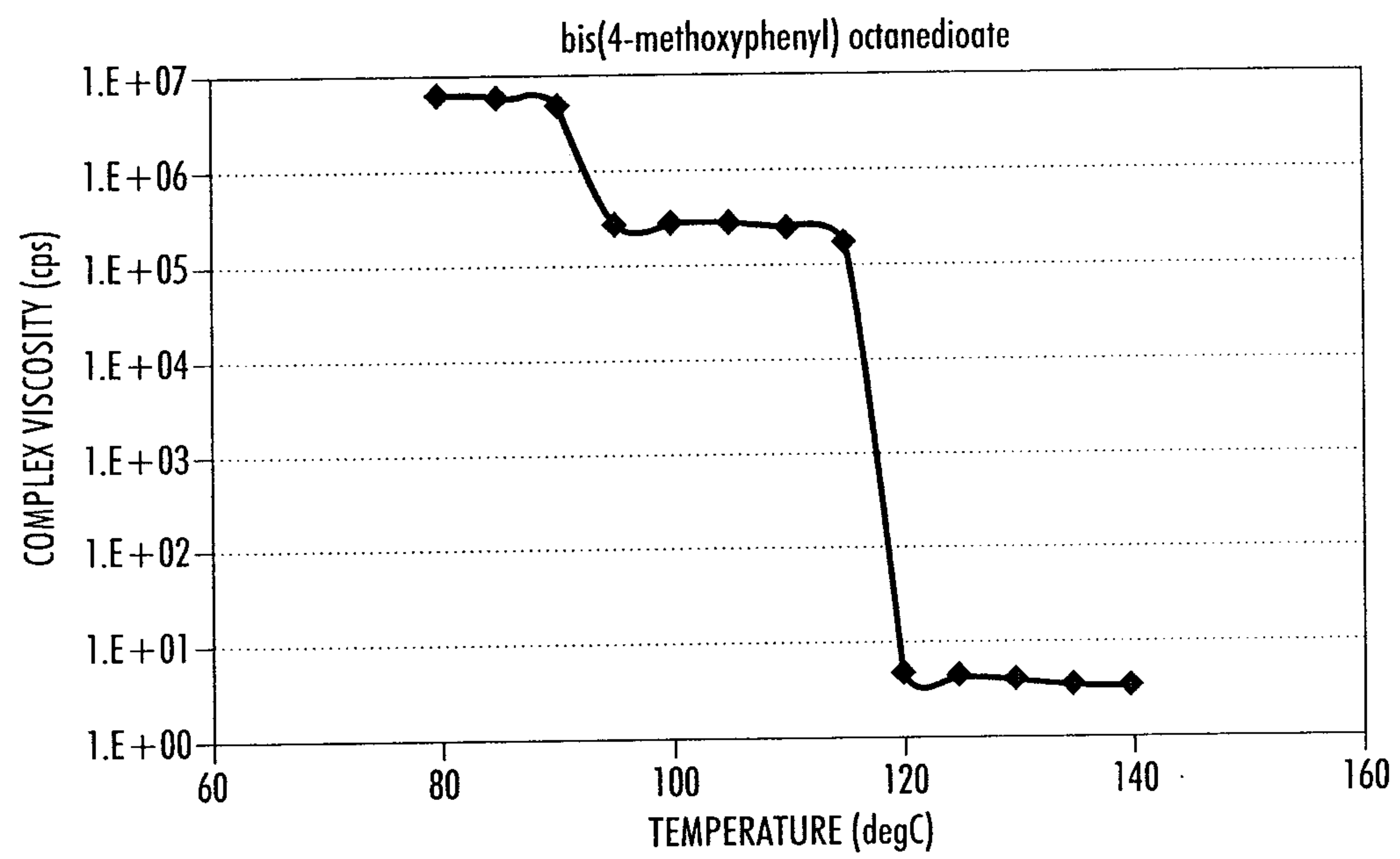


wherein R^4 is substituted or unsubstituted alkyl chain and is selected from the group consisting of $-(\text{CH}_2)_1-$ to $-(\text{CH}_2)_{12}-$, and wherein R^5 and R^6 , each independently of the other, is selected from the group consisting of a substituted or unsubstituted aromatic group, and mixtures thereof and wherein the alcohol for reacting with the aliphatic linear diacid is selected from the group consisting of phenol, p-cresol, 4-methoxyphenol, 4-methylbenzyl alcohol, 4-methoxybenzyl alcohol and mixtures thereof; and an optional colorant.

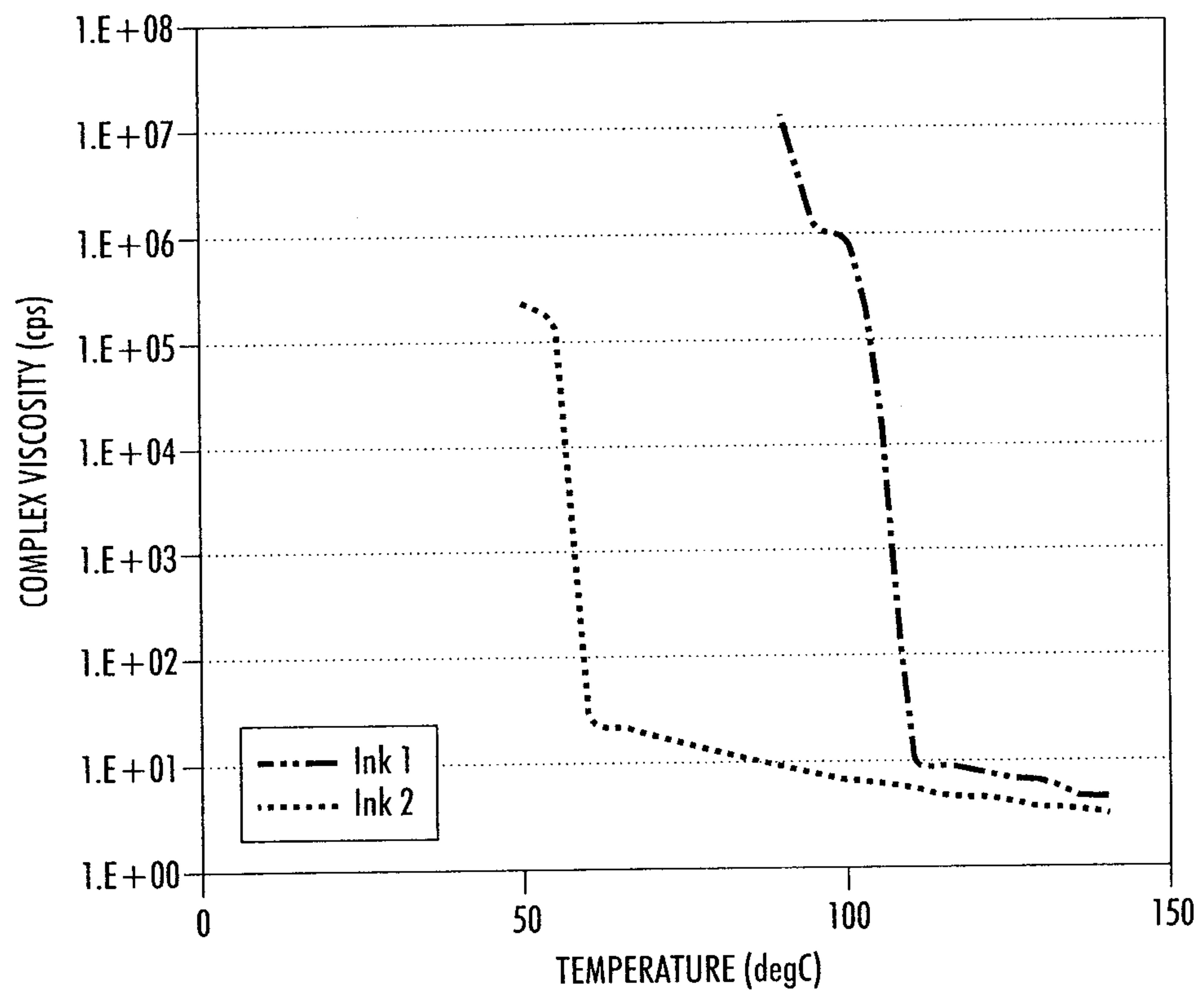
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**FIG. 1**

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**FIG. 2**

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**FIG. 3**

