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(54) Title: LAMINATE FOR VIGNETTE AND TONAL IMAGE PRINTING

(57) Abstract: In accordance with the present subject matter there is provided a laminate for vignette and tonal image printing comprising: a top printable layer of polyethylene polymer selected from the group consisting of metallocene linear low density polyethylene (mLLDPE), linear low density polyethylene (LLDPE) with high melt flow index (MFI), low density polyethylene (LDPE), and combinations thereof; a middle layer comprising of at least one surface film layer of a blend of linear low density polyethylene (LLDPE), and high density polyethylene (HDPE); a inner polyethylene (PE) layer; wherein said printable layer exhibits a gel count in the range of 1-10 per sqm. There is also provided a process for manufacturing the laminate for vignette and tonal image printing.



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LAMINATE FOR VIGNETTE AND TONAL IMAGE PRINTING

TECHNICAL FIELD

[0001] The subject matter described herein in general relates to a laminate for vignette and tonal image printing, a tube container made from the laminate, and process of making the laminate tube container.

BACKGROUND

[0002] The use of laminates for packaging is well known in the industry. The laminates used for packaging desirably have physical properties such as, for example, strength, stiffness, abrasion and chemical resistance, and capability of good quality printing.

[0003] Surface Printing of general purpose image such as bold and solid text panel or cartoon characters on the filmic surface have certain challenges to overcome. Polymer intrinsic gels, indentation marks and surface roughness does not allow the inks, specifically the UV curing viscous inks, to cover the image surface with uniform and homogenous dot gain. Missing dots are seen as voids and flaws in the print reproduction and goes in to rejection bin.

[0004] Thus there is a need for providing a laminate surface having a good quality printing properties.

SUMMARY

[0005] The present disclosure relates to a laminate layer surface for vignette and tonal image printing comprising: a top printable layer of polyethylene polymer selected from the group consisting of metallocene linear low density polyethylene (mLLDPE), linear low density polyethylene (LLDPE) with high melt flow index (MFI), low density polyethylene (LDPE), and combinations thereof; a middle layer comprising of at least one surface film layer of a blend of linear low density polyethylene (LLDPE), and high density polyethylene (HDPE); a inner polyethylene (PE) layer; wherein said printable layer surface exhibits a gel count in the range of 1-10 per sqm.

[0006] The present disclosure relates to a laminate for vignette and tonal image printing comprising: a top printable single layer of a blend of metallocene linear low density polyethylene (mLLDPE), and low density polyethylene (LDPE) with a blend ratio in the range of 2:1 to 1:1,

wherein the printable layer has a thickness of 20 microns; a middle layer comprising of a surface film layer, wherein the surface film is a three layer combination of a blend of linear low density polyethylene (LLDPE), and high density polyethylene (HDPE) with a blend ratio in the range of 1:1 to 1:9, wherein the surface film layer has a thickness of 70 microns; a first co-extruded polymer layer comprising of a primary layer of only linear low density polyethylene (LLDPE) with thickness in the range of 15 microns in contact with the surface film layer, and a secondary layer of EAA with thickness of 15 microns in contact with a barrier layer of aluminum foil with thickness of 12 microns; a second co-extruded polymer layer comprising of a secondary layer of EAA with thickness of 15 microns in contact with the barrier layer, and a primary layer of only linear low density polyethylene (LLDPE) with thickness of 15 microns in contact with inner polyethylene (PE) layer; an inner polyethylene (PE) layer, wherein the inner polyethylene (PE) layer is a three layer combination of linear low density polyethylene (LLDPE), and high density polyethylene (HDPE), wherein the inner polyethylene (PE) layer has a thickness of 40 microns, wherein said printable layer exhibits a gel count in the range of 1-10 per sqm.

[0007] The present disclosure relates to a laminate for vignette and tonal image printing comprising: a top printable single layer of a blend of metallocene linear low density polyethylene (mLLDPE), and low density polyethylene (LDPE) with a blend ratio in the range of 2:1 to 1:1, wherein the printable layer has a thickness of 20 microns; a middle layer comprising of a surface film layer, wherein the surface film is a three layer combination of a blend of linear low density polyethylene (LLDPE), and high density polyethylene (HDPE) with a blend ratio in the range of 1:1 to 1:9, wherein the surface film layer has a thickness of 70 microns; a first co-extruded polymer layer comprising of a primary layer of only linear low density polyethylene (LLDPE) with thickness of 12 microns in contact with surface film layer, and a secondary layer of only linear low density polyethylene (LLDPE) with thickness of 12 microns in contact with a barrier layer of EVOH film with thickness of 79 microns; a second co-extruded polymer layer comprising of a secondary layer of only linear low density polyethylene (LLDPE) with thickness of 12 microns in contact with the barrier layer, and a primary layer of only linear low density polyethylene (LLDPE) with thickness of 12 microns in contact with inner polyethylene (PE) layer; an inner polyethylene (PE) layer, wherein the inner polyethylene (PE) layer is a three layer combination of linear low density polyethylene (LLDPE), and high density polyethylene

(HDPE), wherein the inner polyethylene (PE) layer has a thickness of 40 microns, wherein said printable layer exhibits a gel count in the range of 1-10 per sqm.

[0008] The present disclosure relates to a process of manufacturing the laminate as described herein, said process comprising the steps of: a. obtaining an inner polyethylene (PE) layer; b. 5 contacting the inner polyethylene (PE) layer with a first co-extruded polymer layer, a barrier layer, and a second co-extruded polymer layer to obtain a composite semi-laminate; c. contacting the composite semi-laminate with a surface film layer to obtain a semi-laminated substrate; d. contacting the semi-laminated substrate with a blend of metallocene linear low density polyethylene (mLLDPE), and low density polyethylene (LDPE) to obtain a surface coated 10 laminate; and e. cooling and compressing the surface coated laminate to obtain the laminate for vignette and tonal image printing.

[0009] The present disclosure also relates to a tube container made of the laminate as described herein.

[0010] The present disclosure further relates to a process of manufacturing the tube container 15 from the said laminate as described herein.

[0011] These and other features, aspects and advantages of the present subject matter will be better understood with reference to the following description and appended claims. This summary is provided to introduce a selection of concepts in a simplified form. This summary is not intended to identify key features or essential features of the claimed subject matter, nor is it 20 intended to be used to limit the scope of the claimed subject matter.

BRIEF DESCRIPTION OF DRAWINGS

[0012] The detailed description is described with reference to the accompanying figures. In the figures, the left-most digit(s) of a reference number identifies the figure in which the reference 25 number first appears. The same numbers are used throughout the drawings to reference like features and components.

[0013] Figure 1 illustrates a process flow for the preparation of a laminate for vignette and tonal image printing, according to an implementation of the present disclosure.

[0014] Figure 2 illustrates a laminate for vignette and tonal image printing comprising aluminum 30 foil as the barrier layer, according to an implementation of the present disclosure.

[0015] Figure 3 illustrates a laminate for vignette and tonal image printing comprising EVOH film as the barrier layer, according to an implementation of the present disclosure.

DETAILED DESCRIPTION

[0016] Those skilled in the art will be aware that the present disclosure is subject to variations and modifications other than those specifically described. It is to be understood that the present disclosure includes all such variations and modifications. The disclosure also includes all such steps, features, compositions and compounds referred to or indicated in this specification, individually or collectively and any and all combinations of any or more of such steps or features.

Definitions

[0017] For convenience, before further description of the present disclosure, certain terms employed in the specification, and examples are collected here. These definitions should be read in the light of the remainder of the disclosure and understood as by a person of skill in the art. The terms used herein have the meanings recognized and known to those of skill in the art, however, for convenience and completeness, particular terms and their meanings are set forth below.

[0018] The articles “a”, “an” and “the” are used to refer to one or to more than one (i.e., to at least one) of the grammatical object of the article.

[0019] The terms “comprise” and “comprising” are used in the inclusive, open sense, meaning that additional elements may be included. Throughout this specification, unless the context requires otherwise the word “comprise”, and variations, such as “comprises” and “comprising”, will be understood to imply the inclusion of a stated element or step or group of element or steps but not the exclusion of any other element or step or group of element or steps.

[0020] The term “including” is used to mean “including but not limited to”. “Including” and “including but not limited to” are used interchangeably.

[0021] Ratios, concentrations, amounts, and other numerical data may be presented herein in a range format. It is to be understood that such range format is used merely for convenience and brevity and should be interpreted flexibly to include not only the numerical values explicitly recited as the limits of the range, but also to include all the individual numerical values or sub-

ranges encompassed within that range as if each numerical value and sub-range is explicitly recited. For example, a temperature range of about 120°C to about 150°C should be interpreted to include not only the explicitly recited limits of about 120°C to about 150°C, but also to include sub-ranges, such as 125°C to 145°C, 130°C to 150°C, and so forth, as well as individual amounts, including fractional amounts, within the specified ranges, such as 122.2°C, 140.6°C, and 141.3°C, for example.

[0022] As discussed above, Gel count affects the printing properties of the surface. Gels originate either from the intrinsic properties of the polymer itself or due to the heat exposure and cross polymerization during the extrusion process. General purpose unprinted or slightly printed packaging film could have gel count between 20 to 50 nos. /m² and gel size of 10-30 micron. However, for tonal printing and high precision commercial printing, gel count must be below 10 nos. /m₂ and gel size of 2-10 micron. The present disclosure relates to a laminate which allows for vignette and tonal image printing. The top layer of the laminate has a low gel count which provides a flawless print surface.

[0023] In one implementation, the present disclosure relates to a laminate for vignette and tonal image printing comprising: a top printable layer of polyethylene polymer selected from the group consisting of metallocene linear low density polyethylene (mLLDPE), linear low density polyethylene (LLDPE) with high melt flow index (MFI), low density polyethylene (LDPE), and combinations thereof; a middle layer comprising of at least one surface film layer of a blend of linear low density polyethylene (LLDPE), and high density polyethylene (HDPE); an inner polyethylene (PE) layer; wherein said printable layer exhibits a gel count in the range of 1-10 per sqm.

[0024] In one implementation, the present disclosure relates to a laminate for vignette and tonal image printing comprising a top printable layer of polyethylene polymer selected from the group consisting of metallocene linear low density polyethylene (mLLDPE), linear low density polyethylene (LLDPE) with high melt flow index (MFI), low density polyethylene (LDPE), and combinations thereof.

[0025] In one implementation, the printable layer of polyethylene polymer is a blend of mLLDPE, and LDPE. In one implementation, the blend of mLLDPE to LDPE has a blend ratio in the range of 3:1 to 1:1. In another implementation, the blend of mLLDPE to LDPE has a blend ratio in the range of 2:1 to 1:1.

[0026] In one implementation, the printable layer of polyethylene polymer is a blend of LLDPE with high MFI, and LDPE. In one implementation, the blend ratio of LLDPE with high MFI to LDPE is in the range of 3:1 to 1:1. In another implementation, the blend ratio of LLDPE with high MFI to LDPE is in the range of 2:1 to 1:1. In one implementation, the MFI is in the range of 6.0 to 20.0

[0027] In one implementation, the printable layer of polyethylene polymer has a density in the range of 0.91 to 0.925 g/cc. In one implementation, the printable layer of polyethylene polymer has a thickness in the range of 15 to 30 microns. In one implementation, the printable layer of polyethylene polymer has a thickness of 20 microns.

[0028] In one implementation, the printable layer of polyethylene polymer exhibits a gel count in the range of 1-10 per sqm. In another implementation, the printable layer of polyethylene polymer exhibits a gel count of 9 per sqm.

[0029] In one implementation, the present disclosure relates to a laminate for vignette and tonal image printing comprising a middle layer comprising of at least one surface film layer of a blend of LLDPE, and HDPE. In one implementation, the blend of LLDPE and HDPE has a blend ratio in the range of 1:1 to 1:9.

[0030] In one implementation, the surface film layer is at least a three layer combination of a blend of LLDPE, and HDPE. In another implementation, the surface film layer is a three layer combination of a blend of LLDPE, and HDPE.

[0031] In one implementation, the surface film layer has a thickness in the range of 50 to 150 microns. In another implementation, the surface film layer has a thickness of 70 microns. In one implementation, the surface film layer has a density in the range of 0.945 to 0.965 g/cc.

[0032] In one implementation, the surface film layer further comprises a colorant. In one implementation, the colorant is selected from the group consisting of titanium dioxide (TiO₂), zinc disulfide (ZnS₂), zinc oxide (ZnO), barium sulfate (BaSO₄) and Calcium Carbonate (CaCO₃).

[0033] In one implementation, the surface film layer comprises of at least one layer of a blend of LLDPE, HDPE, and a colorant. In one implementation, the blend of LLDPE, HDPE, and a colorant has a blend ratio in the range of 45:50:5 to 20:70:10.

[0034] In one implementation, the present disclosure relates to a laminate for vignette and tonal image printing comprising a middle layer comprising of at least one surface film layer of a blend

of LLDPE, and HDPE, wherein the middle layer comprises of a barrier layer placed in between first and second co-extruded polymer layers, wherein the first co-extruded polymer layer is in contact with the surface film layer and the second co-extruded polymer layer is in contact with the inner PE layer.

5 [0035] In one implementation, the barrier layer is selected from the group consisting of aluminum foil, ethyl vinyl alcohol (EVOH) film, and combinations thereof. In one implementation, the barrier layer is aluminum foil. In one implementation, the barrier layer of aluminum foil has thickness in the range of 9 to 40 microns. In another implementation, the barrier layer of aluminum foil has thickness of 12 microns. In another implementation, the
10 barrier layer is EVOH film. The EVOH film is a multilayer film having at least five layers. In one implementation, the EVOH film has five layers. In one implementation, the EVOH film has six layers. In one implementation, the EVOH film has seven layers. In one implementation, the barrier layer of EVOH film has thickness in the range of 54 to 88 microns. In another implementation, the barrier layer of EVOH film has thickness of 79 microns.

15 [0036] In one implementation, the barrier layer is placed in between first and second co-extruded polymer layers. The first co-extruded polymer layer is in contact with the surface film layer and the barrier layer and the second co-extruded polymer layer is in contact with the barrier layer and the inner PE layer.

[0037] In one implementation, the first co-extruded layer comprises of a primary layer in contact
20 with the surface film layer and a secondary layer in contact with the barrier layer. The primary layer is a layer of only LLDPE. The secondary layer is a layer selected from the group consisting of an ethylene acrylic acid (EAA) layer and a layer of only LLDPE. In one implementation, the primary layer is a layer of only LLDPE and the secondary layer is an EAA layer. In another implementation, the primary layer is a layer of only LLDPE and the secondary layer is a layer of
25 only LLDPE.

[0038] In one implementation, the primary layer with thickness in the range of 10 to 25 microns is in contact with the surface film layer. In another implementation, the primary layer with thickness of 15 microns is in contact with the surface film layer. In one implementation, the secondary layer with thickness in the range of 10 to 25 microns is in contact with the barrier
30 layer. In one implementation, the secondary layer with thickness of 15 microns is in contact with

the barrier layer. In yet another implementation, the secondary layer with thickness of 12 microns is in contact with the barrier layer.

[0039] In one implementation, the second co-extruded layer comprises of a primary layer in contact with the inner PE layer and a secondary layer in contact with the barrier layer. The primary layer is a layer of only LLDPE. The secondary layer is a layer selected from the group consisting of an EAA layer and a layer of only LLDPE. In one implementation, the primary layer is a layer of only LLDPE and the secondary layer is an EAA layer. In another implementation, the primary layer is a layer of only LLDPE and the secondary layer is a layer of only LLDPE.

[0040] In one implementation, the primary layer with thickness in the range of 10 to 25 microns is in contact with the inner PE layer. In another implementation, the primary layer with thickness of 15 microns is in contact with the inner PE layer. In one implementation, the secondary layer with thickness in the range of 10 to 25 microns is in contact with the barrier layer. In one implementation, the secondary layer with thickness of 15 microns is in contact with the barrier layer. In yet another implementation, the secondary layer with thickness of 12 microns is in contact with the barrier layer.

[0041] In one implementation, the barrier layer is aluminum foil. The barrier layer made of aluminum foil has thickness of 12 microns. The barrier layer is placed in between a first co-extruded polymer layer comprising of a primary layer of only LLDPE with a thickness of 15 microns and a secondary layer of EAA with a thickness of 15 microns, and a second co-extruded polymer layer comprising of a primary layer of only LLDPE with a thickness of 15 microns and a secondary layer of EAA with a thickness of 15 microns.

[0042] In one implementation, the barrier layer is an EVOH film having five layers. The five layer of the film comprises of a layer of PE with TIE on either side of the EVOH layer. TIE polymer is a maleic anhydride grafted PE co-polymer. The barrier layer made of EVOH film has thickness of 79 microns. The barrier layer is placed in between a first co-extruded polymer layer comprising of a primary layer of only LLDPE with a thickness of 12 microns and a secondary layer of only LLDPE with a thickness of 12 microns, and a second co-extruded polymer layer comprising of a primary layer of only LLDPE with a thickness of 12 microns and a secondary layer of only LLDPE with a thickness of 12 microns.

[0043] In one implementation, the present disclosure relates to a laminate for vignette and tonal image printing comprising an inner PE layer. In one implementation, the inner PE layer is the product contact layer.

[0044] In one implementation, the inner PE layer comprises of at least one layer of a blend of LLDPE, and HDPE. In one implementation, the inner PE layer is a three layer combination of LLDPE, and HDPE. The blend of LLDPE and HDPE has a blend ratio in the range of 1:1 to 1:9.

[0045] In one implementation, the inner PE layer has a thickness in the range of 40 to 100 microns. In another implementation, the inner PE layer has a thickness of 40 microns. In one implementation, the inner PE layer has a density in the range of 0.945 to 0.965 g/cc.

[0046] In one implementation, the present disclosure relates to a laminate for vignette and tonal image printing comprising: a top printable single layer of a blend of metallocene linear low density polyethylene (mLLDPE), and low density polyethylene (LDPE) with a blend ratio in the range of 2:1 to 1:1, wherein the printable layer has a thickness of 20 microns; a middle layer comprising of a surface film layer, wherein the surface film is a three layer combination of a blend of linear low density polyethylene (LLDPE), and high density polyethylene (HDPE) with a blend ratio in the range of 1:1 to 1:9, wherein the surface film layer has a thickness of 70 microns; a first co-extruded polymer layer comprising of a primary layer of only linear low density polyethylene (LLDPE) with thickness in the range of 15 microns in contact with the surface film layer, and a secondary layer of EAA with thickness of 15 microns in contact with a barrier layer of aluminum foil with thickness of 12 microns; a second co-extruded polymer layer comprising of a secondary layer of EAA with thickness of 15 microns in contact with the barrier layer, and a primary layer of only linear low density polyethylene (LLDPE) with thickness of 15 microns in contact with inner polyethylene (PE) layer; an inner polyethylene (PE) layer, wherein the inner polyethylene (PE) layer is a three layer combination of linear low density polyethylene (LLDPE), and high density polyethylene (HDPE), wherein the inner polyethylene (PE) layer has a thickness of 40 microns, wherein said printable layer exhibits a gel count in the range of 1-5 per sqm.

[0047] In one implementation of the present disclosure, **Figure 2** illustrates an exemplary structure of a laminate for vignette and tonal image printing **800**. In one implementation, the present disclosure relates to a laminate for vignette and tonal image printing **800** comprising: a top printable single layer **850** of a blend of metallocene linear low density polyethylene

(mLLDPE), and low density polyethylene (LDPE) with a blend ratio in the range of 2:1 to 1:1, wherein the printable layer **850** has a thickness of 20 microns; a middle layer **860** comprising of a surface film layer **834**, wherein the surface film is a three layer combination of a blend of linear low density polyethylene (LLDPE), and high density polyethylene (HDPE) with a blend ratio in the range of 1:1 to 1:9, wherein the surface film layer **834** has a thickness of 70 microns; a first co-extruded polymer layer **836** comprising of a primary layer of only linear low density polyethylene (LLDPE) with thickness in the range of 15 microns in contact with the surface film layer **834**, and a secondary layer of EAA with thickness of 15 microns in contact with a barrier layer of aluminum foil **844** with thickness of 12 microns; a second co-extruded polymer layer **846** comprising of a secondary layer of EAA with thickness of 15 microns in contact with the barrier layer **844**, and a primary layer of only linear low density polyethylene (LLDPE) with thickness of 15 microns in contact with inner polyethylene (PE) layer **870**; an inner polyethylene (PE) layer **870**, wherein the inner polyethylene (PE) layer is a three layer combination of linear low density polyethylene (LLDPE), and high density polyethylene (HDPE), wherein the inner polyethylene (PE) layer **870** has a thickness of 40 microns, wherein said printable layer **850** exhibits a gel count in the range of 1-10 per sqm.

[0048] In one implementation, the present disclosure relates to a laminate for vignette and tonal image printing comprising: a top printable single layer of a blend of metallocene linear low density polyethylene (mLLDPE), and low density polyethylene (LDPE) with a blend ratio in the range of 2:1 to 1:1, wherein the printable layer has a thickness of 20 microns; a middle layer comprising of a surface film layer, wherein the surface film is a three layer combination of a blend of linear low density polyethylene (LLDPE), and high density polyethylene (HDPE) with a blend ratio in the range of 1:1 to 1:9, wherein the surface film layer has a thickness of 70 microns; a first co-extruded polymer layer comprising of a primary layer of only linear low density polyethylene (LLDPE) with thickness of 12 microns in contact with surface film layer, and a secondary layer of only linear low density polyethylene (LLDPE) with thickness of 12 microns in contact with a barrier layer of EVOH film with thickness of 79 microns; a second co-extruded polymer layer comprising of a secondary layer of only linear low density polyethylene (LLDPE) with thickness of 12 microns in contact with the barrier layer, and a primary layer of only linear low density polyethylene (LLDPE) with thickness of 12 microns in contact with inner polyethylene (PE) layer; an inner polyethylene (PE) layer, wherein the inner polyethylene (PE)

layer is a three layer combination of linear low density polyethylene (LLDPE), and high density polyethylene (HDPE), wherein the inner polyethylene (PE) layer has a thickness of 40 microns, wherein said printable layer exhibits a gel count in the range of 1-10 per sqm.

[0049] In one implementation of the present disclosure, **Figure 3** illustrates an exemplary

5 structure of a laminate for vignette and tonal image printing **900**. In one implementation, the present disclosure relates to a laminate for vignette and tonal image printing **900** comprising: a top printable single layer **950** of a blend of metallocene linear low density polyethylene (mLLDPE), and low density polyethylene (LDPE) with a blend ratio in the range of 2:1 to 1:1, wherein the printable layer **950** has a thickness of 20 microns; a middle layer **960** comprising of
10 a surface film layer **934**, wherein the surface film is a three layer combination of a blend of linear low density polyethylene (LLDPE), and high density polyethylene (HDPE) with a blend ratio in the range of 1:1 to 1:9, wherein the surface film layer **934** has a thickness of 70 microns; a first co-extruded polymer layer **936** comprising of a primary layer of only linear low density polyethylene (LLDPE) with thickness of 12 microns in contact with surface film layer **934**, and a
15 secondary layer of only linear low density polyethylene (LLDPE) with thickness of 12 microns in contact with a barrier layer of EVOH film **944** with thickness of 79 microns; a second co-extruded polymer layer **946** comprising of a secondary layer of only linear low density polyethylene (LLDPE) with thickness of 12 microns in contact with the barrier layer **944**, and a primary layer of only linear low density polyethylene (LLDPE) with thickness of 12 microns in
20 contact with inner polyethylene (PE) layer **970**; an inner polyethylene (PE) layer **970**, wherein the inner polyethylene (PE) layer is a three layer combination of linear low density polyethylene (LLDPE), and high density polyethylene (HDPE), wherein the inner polyethylene (PE) layer **970** has a thickness of 40 microns, wherein said printable layer **950** exhibits a gel count in the range of 1-10 per sqm.

25 [0050] In one implementation, the present disclosure relates to a laminate for vignette and tonal image printing wherein the laminate thickness is in the range of 154 to 470 microns. In another implementation, the laminate thickness is 202 microns. In another implementation, the laminate thickness is 257 microns.

[0051] In one implementation, the present disclosure relates to a process for preparation of a
30 laminate for vignette and tonal image printing said process comprising the steps of: a. obtaining an inner polyethylene (PE) layer; b. contacting the inner polyethylene (PE) layer with a first co-

extruded polymer layer, a barrier layer, and a second co-extruded polymer layer to obtain a composite semi-laminate; c. contacting the composite semi-laminate with a surface film layer to obtain a semi-laminated substrate; d. contacting the semi-laminated substrate with a blend of metallocene linear low density polyethylene (mLLDPE), and low density polyethylene (LDPE) to obtain a surface coated laminate; and e. cooling and compressing the surface coated laminate to obtain the laminate for vignette and tonal image printing.

[0052] In one implementation, the present disclosure relates to a tube container made of the laminate for vignette and tonal image printing. The tube container is designed to hold semi liquid products.

[0053] In one implementation, the present disclosure relates to a process of manufacturing the tube container from the said laminate. The process comprises the steps of forming a tube body(sleeve) with the help of tube body maker which consists of tube forming mandrel, inner and outer magnetic band, high frequency generator for tube side seaming, cooling mandrel, sleeve cutting and transferring device to carry the sized sleeve to tube header. Sized sleeve is transferred to the tube heading mandrel individually. It is then compression moulded with molten HDPE to form tube shoulder and threaded neck portion, following which it is cooled down to room temperature, autocapped and unloaded to the auto packing device. The autopacker packs the ready to use printed and capped tubes which are then palletized for onward shipment to the specific customer.

Examples

[0054] The disclosure will now be illustrated with working examples, which is intended to illustrate the working of disclosure and not intended to take restrictively to imply any limitations on the scope of the present disclosure. Other examples are also possible which are within the scope of the present disclosure.

Example 1

Process for preparing a laminate

[0055] The process for preparing a laminate in accordance to the present disclosure is depicted in Figure 1.

[0056] Process for preparing the laminate 1 with Aluminum foil as the barrier layer

[0057] The process included obtaining a three layer natural PE film made of HDPE and LLDPE in a blend ratio of 2:1. The three layer natural PE film having a thickness of 40 micron was

mounted on the main unwinder **102**. Natural PE film i.e. primary substrate was taken forward and threaded through a first laminating head **202**, where first co-extruded polymer melt was extruded onto the primary substrate. The first co-extruded polymer melt consists of one thermoplastic polymer (LLDPE) with higher melt flow index in excess of 7.0 and another melt of co-polymer of polyethylene (EAA) with melt flow index excess of 6.0. Layer thickness of LLDPE and EAA was 15 micron each and layer ratio 1:1. From the first Secondary Unwinder **402**, a layer of aluminum foil, 12 micron was added to the Laminating head **202** which got bonded together with the help of co-extruded hot polymer melt from first co-extruder head **304**, to form a composite semi laminate. Composite semi laminate (82 micron) then flows forward to a second laminating head **204** where another coextruded hot polymer melt containing 15 micron EAA and 15 micron LLDPE were added from second co-extruder head **306**. Simultaneously, additional 70 micron three layer White PE film containing LLDPE and HDPE in a blend ratio of 2:1 from sandwich unwinder **404** was added to the laminating head **204**. White PE film comprises of 6% (w/w) of TiO₂. As soon as the semi laminated substrate, coextruded hot polymer melted and 70 micron White PE film passed through the laminating head NIP roll **612**, a composite semi laminate of 182 micron was formed. Composite multilayer semi laminate (182 micron) was passed through the coating Head **206** where 20 micron polymer hot melt comprising of mLLDPE and LDPE in a blend ratio of 2:1 and having a MFI of 6 to 20 was extruded on the semi composite laminate print surface from extruder **308**. Once the semi composite laminate and extruded hot polymer melt passed through coating head NIP roll **712** and Mirror finish Chill roll **714**, hot polymer melt, along with semi composite laminate solidified and replicated the mirror finish surface similar to the Chill roll **714**. Mirror finished multilayer laminate (202 micron) was then moved to the rewinder **104** for coiling and roll buildup.

[0058] Table 1 shows the different layers present in the laminate 1 for vignette and tonal image printing. The composition is shown from outside to inside.

[0059] Table 1. Material composition of laminate 1.

IND. LAYER	MATERIAL TYPE		LAYER THICKNESS IN MIC	TOLER ANCE ± %
TOP	mLLDPE+LDPE	SINGL E	20	10

COATING	(BLEND)	COATING LAYER		
WHITE PE FILM	HDPE +LLDPE	(3 LAYER COMBINATION FILM	70	10
CO-EXTRUDED POLYMER	LLDPE , 100%	SINGLE LAYER	15	10
	EAA, 100%	SINGLE LAYER	15	10
AL-FOIL	ENAW - 1200	SINGLE LAYER	12	10
CO-EXTRUDED POLYMER	EAA , 100%	SINGLE LAYER	15	10
	LLDPE, 100%	SINGLE LAYER	15	10
NATURAL PE FILM	LLDPE + HDPE	(3 LAYER COMBINATION FILM)	40	10

[0060] Process for preparing the laminate 2 with EVOH film as the barrier layer

[0061] The process included obtaining a three layer natural PE film made of HDPE and LLDPE in a blend ratio of 2:1. The three layer natural PE film having a thickness of 40 micron was mounted on the main unwinder **102**. Natural PE film i.e. primary substrate was taken forward and threaded through a first laminating head **202**, where first co-extruded polymer melt was

extruded onto the primary substrate. The first co-extruded polymer melt consists of two layers of thermoplastic polymer (LLDPE). Layer thickness of each LLDPE layer was 12 micron each. From the first Secondary Unwinder **402**, five layers of EVOH film, 79 micron (20 micron LLDPE, 12 micron TIE, 15 micron EVOH, 12 micron TIE, and 20 micron LLDPE) was added to the Laminating head **202** which got bonded together with the help of co-extruded hot polymer melt from first co-extruder head **304**, to form a composite semi laminate. Composite semi laminate(143 micron) then flows forward to a second laminating head **204** where another coextruded hot polymer melt containing two layers each of 12 micron LLDPE were added from second coextruder head **306**. Simultaneously, additional 70 micron three layer white PE multilayer film containing LLDPE and HDPE in a blend ratio of 1:2 from sandwich unwinder **404** was added to the laminating head **204**. White PE film comprises of 6% (w/w) of TiO₂. As soon as the semi laminated substrate, coextruded hot polymer melted and 70 micron white PE film passed through the laminating head NIP roll **612**, a composite semi laminate of 237 micron was formed. The composite semi laminate (237 micron) was passed through the coating Head **206** where 20 micron polymer hot melt comprising of mLLDPE and LDPE in a blend ratio of 2:1 and having a MFI of 6 to 20 was extruded on the semi composite laminate print surface from extruder **308**. Once the semi composite laminate and extruded hot polymer melt passed through coating head NIP roll **712** and Mirror finish Chill roll **714**, hot polymer melt, along with semi composite laminate solidified and replicated the mirror finish surface similar to the Chill roll **714**. Mirror finished multilayer laminate (257 micron) was then moved to the rewinder **104** for coiling and roll buildup.

[0062] Table 2 shows the different layers present in the laminate 2 for vignette and tonal image printing. The composition is shown from outside to inside.

[0063] Table 2. Material composition for laminate 2.

IND. LAYER	MATERIAL TYPE		LAYER THICKNESS IN MIC	TOLER ANCE ± %
TOP COATING	mLLDPE+LDPE (BLEND)	SINGL E COATI NG	20	10

		LAYER		
WHITE PE FILM	HDPE +LLDPE	(3 LAYER COMBINATION FILM	70	10
CO-EXTRUDED POLYMER	LLDPE , 100%	SINGLE LAYER	12	10
	LLDPE, 100%	SINGLE LAYER	12	10
EVOH multilayer film (5 to 7 layer)	PE//TIE//EVOH//TIE//PE	SINGLE LAYER	79	10
CO-EXTRUDED POLYMER	LLDPE , 100%	SINGLE LAYER	12	10
	LLDPE, 100%	SINGLE LAYER	12	10
NATURAL PE FILM	LLDPE + HDPE	(3 LAYER COMBINATION FILM)	40	10

[0064] Process for preparing a regular laminate without top PE coating

[0065] The process included obtaining a three layer natural PE film made of HDPE and LLDPE in a blend ratio of 2:1. The three layer natural PE film having a thickness of 40 micron was mounted on the main unwinder **102**. Natural PE film i.e. primary substrate was taken forward and threaded through a first laminating head **202**, where first co-extruded polymer melt was extruded onto the primary substrate. The first co-extruded polymer melt consists of one thermoplastic polymer (LLDPE) with higher melt flow index in excess of 7.0 and another melt of

co-polymer of polyethylene(EAA) with melt flow index excess of 6.0. Layer thickness of LLDPE and EAA was 15 micron each and layer ratio 1:1. From the first Secondary Unwinder **402**, a layer of aluminum foil, 12 micron was added to the Laminating head **202** which got bonded together with the help of co-extruded hot polymer melt from first co-extruder head **304**,
5 to form a composite semi laminate. Composite semi laminate (82 micron) then flows forward to a second laminating head **204** where another coextruded hot polymer melt containing 15 micron EAA and 15 micron LLDPE were added from second coextruder head **306**. Simultaneously, additional 70 micron three layer White PE film in a blend ratio of 2:1 from sandwich unwinder **404** was added to the laminating head **204**. White PE film comprises of 6% (w/w) of TiO₂. As
10 soon as the semi laminated substrate, coextruded hot polymer melted and 70 micron White PE film passed through the laminating head NIP roll **612**, a composite semi laminate of 182 micron was formed.

Example 2

15 **Print trials on the laminate for vignette and tonal image printing**

[0066] Print trials were carried out on laminate 1 having Aluminum foil as the barrier layer. The result was compared to a regular laminate that lacked the mirror finished outer surface layer.

[0067] Tables 3, and 4 describe the properties of the laminate that affect the quality of print on the laminate.

20 [0068] Table 3 depicts printing properties of comparable aluminum foil based multilayer regular laminate and aluminum foil based multilayer laminate with coated top layer finishing. Table 3 shows that the regular laminate has a higher gel count of 25 as compared to the surface coated laminate of the present invention which has a gel count of 9. Gel count is equivalent to the print defect count, that is the gel count directly affects the printing properties. As observed from Table
25 3, 106 spots were validated for testing the print quality. For the regular laminate, 25 out of 106 spots showed print defect, i.e. 23.6% of the impression validated were found defective. On the contrary for the top layer coated laminate of the present invention, only 9 out of 106 spots showed print defect, i.e., 8.5% were found to be defective. From the results, it can be inferred that the top layer coated laminate of the present invention shows a better printing quality than a
30 comparable regular laminate.

[0069] Table 3. Print trial of comparable aluminum foil based multilayer laminate one with std. laminate and the other with 3rd. layer PE finishing coating

Print job: OXY BLEACH	Unit of Measurement	Regular Aluminum foil based Laminate, 182 mic. thickness	3rd. stn. PE Coated Aluminum foil based Laminate, 202 mic. thickness
Impression Validated	Nos	106	106
Print defect Count	Nos	25	9
	%	23.6%	8.5%
Laminate Area Validated	SqM	1.1	1.1
Gel Count, causing print	Nos	25	9
	Nos/ SqM	22.7	8.2

Advantages gained in the example illustrative process in this subject matter:

- 5 [0070] Although the subject matter has been described in considerable detail with reference to certain examples and implementations thereof, other implementations are possible. As such, the spirit and scope of the appended claims should not be limited to the description of the preferred examples and implementations contained therein.

- [0071] The laminate as described herein provides a flaw less surface for good quality printing.
- 10 The laminate surfaces as described in the present disclosure is very smooth, is homogeneous and free from any polymer Gels and surface indentations. The gel count of the laminate is low in the range of 1-10 nos./ sqm which results in high quality printing of the surface.

I/We Claim:

1. A laminate for vignette and tonal image printing comprising:

a top printable layer of polyethylene polymer selected from the group consisting of metallocene linear low density polyethylene (mLLDPE), linear low density polyethylene (LLDPE) with high melt flow index (MFI), low density polyethylene (LDPE), and combinations thereof;

a middle layer comprising of at least one surface film layer of a blend of linear low density polyethylene (LLDPE), and high density polyethylene (HDPE);

a inner polyethylene (PE) layer;

wherein said printable layer exhibits a gel count in the range of 1-10 per sqm .

2. The laminate as claimed in claim 1, wherein the printable layer of polyethylene polymer is a blend of metallocene linear low density polyethylene (mLLDPE), and low density polyethylene (LDPE) with a blend ratio in the range of 3:1 to 1:1.

3. The laminate as claimed in claim 1, wherein the printable layer of polyethylene polymer is blend of linear low density polyethylene (LLDPE) with high melt flow index (MFI), and low density polyethylene (LDPE) with a blend ratio in the range of 3:1 to 1:1, , wherein melt flow index is in the range of 6.0 to 20.0.

4. The laminate as claimed in claim 1, wherein the surface film layer is at least a three layer combination of a blend of linear low density polyethylene (LLDPE), and high density polyethylene (HDPE) with a blend ratio in the range of 1:1 to 1:9.

5. The laminate as claimed in claim 1, wherein the surface film layer further comprises a colorant selected from the group consisting of titanium dioxide (TiO₂), zinc disulfide (ZnS₂), zinc oxide (ZnO), barium sulfate (BaSO₄) and Calcium Carbonate (CaCO₃).

6. The laminate as claimed in claim 1, wherein the middle layer comprises of a barrier layer placed in between first and second co-extruded polymer layers, wherein the first co-extruded polymer layer is in contact with the surface film layer and the second co-extruded polymer layer is in contact with the inner polyethylene layer.

7. The laminate as claimed in claim 6, wherein the barrier layer is selected from the group consisting of aluminum foil, ethyl vinyl alcohol (EVOH) film, and combinations thereof.

8. The laminate as claimed in claim 6, wherein the first co-extruded polymer layer comprises of a primary layer of only linear low density polyethylene (LLDPE) and a secondary layer selected from the group consisting of an EAA layer and a layer of only linear low density polyethylene (LLDPE), wherein the primary layer is in contact with surface film layer and the secondary layer is in contact with the barrier layer.
9. The laminate as claimed in claims 6, wherein the second co-extruded polymer layer comprises of a primary layer of only linear low density polyethylene (LLDPE) and a secondary layer selected from the group consisting of an ethylene acrylic acid (EAA) layer and a layer of only linear low density polyethylene (LLDPE), wherein the primary layer is in contact with the inner polyethylene (PE) layer and the secondary layer is in contact with the barrier layer.
10. The laminate as claimed in claim 1, wherein the inner polyethylene (PE) layer comprising of at least one layer of a blend of linear low density polyethylene (LLDPE), and high density polyethylene (HDPE) with a blend ratio in the range of 1:1 to 1:9.
11. A laminate for vignette and tonal image printing comprising:
a top printable single layer of a blend of metallocene linear low density polyethylene (mLLDPE), and low density polyethylene (LDPE) with a blend ratio in the range of 2:1 to 1:1, wherein the printable layer has a thickness of 20 microns;
a middle layer comprising of a surface film layer, wherein the surface film is a three layer combination of a blend of linear low density polyethylene (LLDPE), and high density polyethylene (HDPE) with a blend ratio in the range of 1:1 to 1:9, wherein the surface film layer has a thickness of 70 microns; a first co-extruded polymer layer comprising of a primary layer of only linear low density polyethylene (LLDPE) with thickness in the range of 15 microns in contact with the surface film layer, and a secondary layer of ethylene acrylic acid (EAA) with thickness of 15 microns in contact with a barrier layer of aluminum foil with thickness of 12 microns; a second co-extruded polymer layer comprising of a secondary layer of ethylene acrylic acid (EAA) with thickness of 15 microns in contact with the barrier layer, and a primary layer of only linear low density polyethylene (LLDPE) with thickness of 15 microns in contact with inner polyethylene (PE) layer;

an inner polyethylene (PE) layer, wherein the inner polyethylene (PE) layer is a three layer combination of linear low density polyethylene (LLDPE), and high density polyethylene (HDPE), wherein the inner polyethylene (PE) layer has a thickness of 40 microns, wherein said printable layer exhibits a gel count in the range of 1-10 per sqm.

12. A laminate for vignette and tonal image printing comprising:

a top printable single layer of a blend of metallocene linear low density polyethylene (mLLDPE), and low density polyethylene (LDPE) with a blend ratio in the range of 2:1 to 1:1, wherein the printable layer has a thickness of 20 microns;

a middle layer comprising of a surface film layer, wherein the surface film is a three layer combination of a blend of linear low density polyethylene (LLDPE), and high density polyethylene (HDPE) with a blend ratio in the range of 1:1 to 1:9, wherein the surface film layer has a thickness of 70 microns; a first co-extruded polymer layer comprising of a primary layer of only linear low density polyethylene (LLDPE) with thickness of 12 microns in contact with surface film layer, and a secondary layer of only linear low density polyethylene (LLDPE) with thickness of 12 microns in contact with a barrier layer of ethyl vinyl alcohol (EVOH) film with thickness of 79 microns; a second co-extruded polymer layer comprising of a secondary layer of only linear low density polyethylene (LLDPE) with thickness of 12 microns in contact with the barrier layer, and a primary layer of only linear low density polyethylene (LLDPE) with thickness of 12 microns in contact with inner polyethylene (PE) layer; an inner polyethylene (PE) layer, wherein the inner polyethylene (PE) layer is a three layer combination of linear low density polyethylene (LLDPE), and high density polyethylene (HDPE), wherein the inner polyethylene (PE) layer has a thickness of 40 microns, wherein said printable layer exhibits a gel count in the range of 1-10 per sqm.

13. A process of manufacturing the laminate as claimed in claim 1, said process comprising the steps of:

a. obtaining an inner polyethylene (PE) layer;

b. contacting the inner polyethylene (PE) layer with a first co-extruded polymer layer, a barrier layer, and a second co-extruded polymer layer to obtain a composite semi-laminate;

c. contacting the composite semi-laminate with a surface film layer to obtain a semi-laminated substrate;

d. contacting the semi-laminated substrate with a blend of metallocene linear low density polyethylene (mLLDPE), and low density polyethylene (LDPE) to obtain a surface coated laminate; and

e. cooling and compressing the surface coated laminate to obtain the laminate for vignette and tonal image printing.

14. A tube container made of the laminate as claimed in any of the claims 1 to 12.

15. A process of manufacturing the tube container from the said laminate as claimed in claim

1.

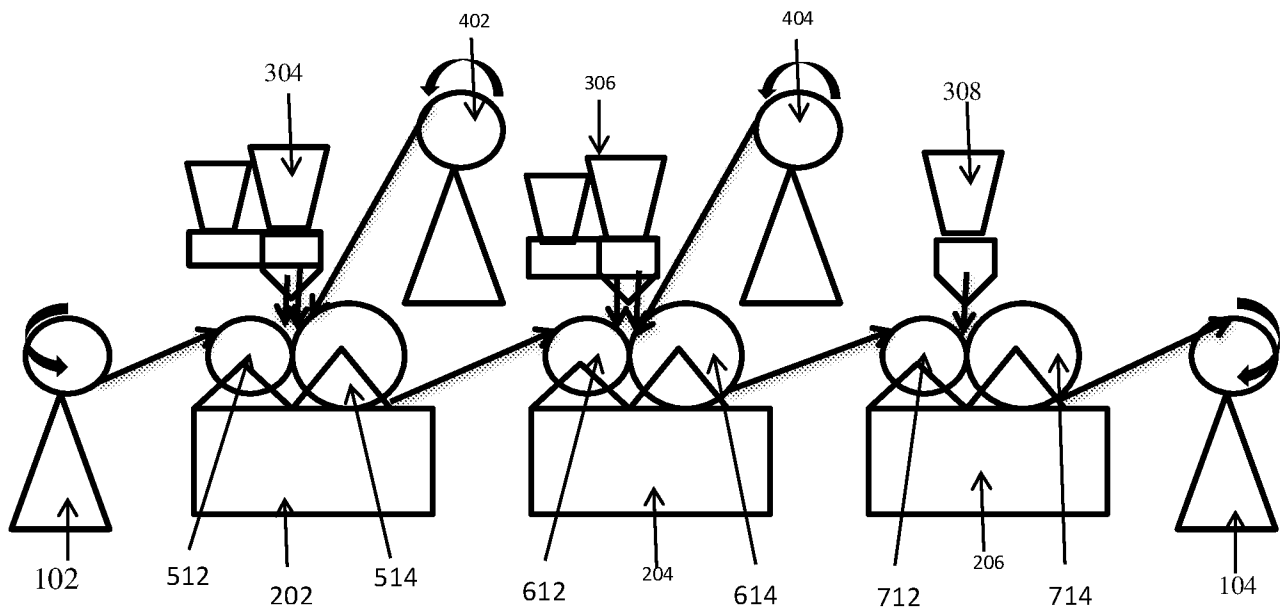


Figure 1

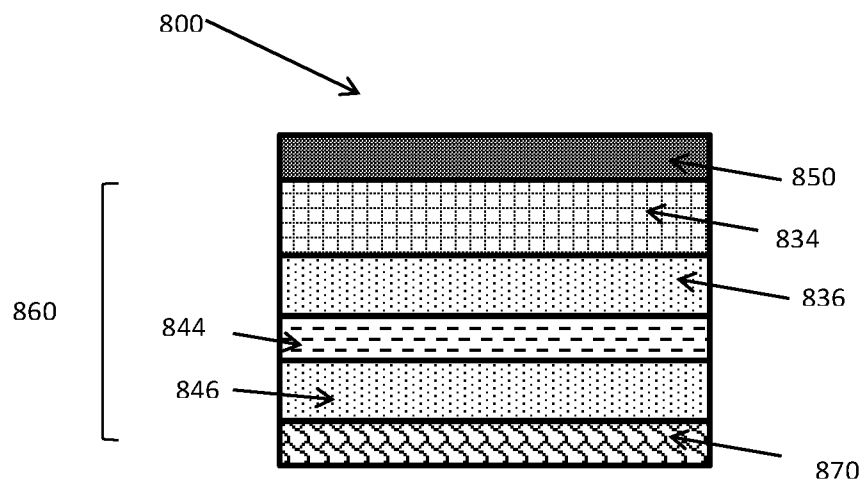


Figure 2

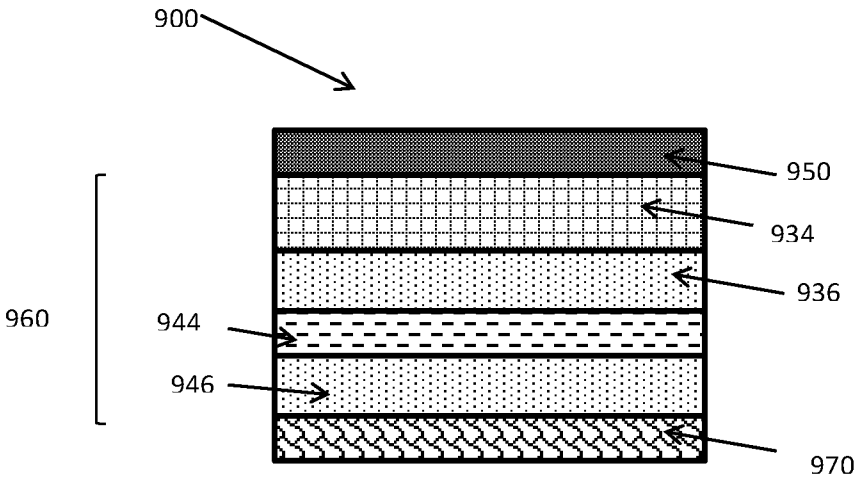


Figure 3

INTERNATIONAL SEARCH REPORT

International application No
PCT/IN2017/050010

A. CLASSIFICATION OF SUBJECT MATTER		
INV.	B32B15/085	B32B15/20
	B32B1/08	
		B32B27/20
		B32B27/30
		B32B27/32
ADD.		
According to International Patent Classification (IPC) or to both national classification and IPC		
B. FIELDS SEARCHED		
Minimum documentation searched (classification system followed by classification symbols)		
B32B		
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched		
Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)		
EPO-Internal, WPI Data		
C. DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	WO 2011/004001 A1 (ALTERNAPAK HOLDING B V [NL]; MENALDA ALBERT [NL]; VAN DER STAPPEN CORN) 13 January 2011 (2011-01-13) page 2, line 29 - line 35 page 3, line 38 - page 4, line 7 page 5, line 23 - line 31 page 6, line 8 - page 8, line 12 examples claims -----	1-15
A	DATABASE WPI Week 200219 Thomson Scientific, London, GB; AN 2002-143797 XP002769972, & JP 2001 301777 A (DAINIPPON PRINTING CO LTD) 31 October 2001 (2001-10-31) abstract ----- -/--	1-15
☒ Further documents are listed in the continuation of Box C. ☒ See patent family annex.		
* Special categories of cited documents : "A" document defining the general state of the art which is not considered to be of particular relevance "E" earlier application or patent but published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art "&" document member of the same patent family		
Date of the actual completion of the international search		Date of mailing of the international search report
9 May 2017		19/05/2017
Name and mailing address of the ISA/ European Patent Office, P.B. 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040, Fax: (+31-70) 340-3016		Authorized officer Mazet, Jean-François

INTERNATIONAL SEARCH REPORT

International application No

PCT/IN2017/050010

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	DATABASE WPI Week 200872 Thomson Scientific, London, GB; AN 2008-M13201 XP002769973, & CN 101 100 123 A (GUO R) 9 January 2008 (2008-01-09) abstract -----	1-15

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Information on patent family members

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			CN 102470646 A	23-05-2012
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