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(54) Title: HIGH PERFORMANCE LOW ENVIRONMENTAL IMPACT DETACKIFIER

(57) Abstract: The current invention relates to composition and method for treating impurities in a circulating water system. The circulating water system impurities may be oversprayed paint in paint spray booth applications. The composition includes an aqueous solution of a cationized starch, a polybasic aluminum salt such as aluminum chlorohydrate or polyaluminum chloride and a solution of a medium to high MW aqueous flocculant. The composition is particularly useful when added to recirculating scrubber water in paint spray booths for effectively treating both water based and solvent based paints.

HIGH PERFORMANCE LOW ENVIRONMENTAL IMPACT DETACKIFIER

TECHNICAL FIELD

This invention relates to improved separation of paint and spray residue from water streams in the painting and finishing industry. The invention allows for improved detackification and sludge separation while still being a new "greener" technology that greatly reduces its environmental impact.

BACKGROUND

Any discussion of the prior art throughout the specification should in no way be considered as an admission that such prior art is widely known or forms part of common general knowledge in the field.

The spray painting of automobile bodies, engines, and a variety of industrial and consumer articles is conducted in specialized enclosures called paint spray booths. These booths provide a controlled work area for the painting operations both enhancing worker safety and minimizing the possibility of contaminants adversely impacting the finished paint job. Booths can vary significantly in size and design but all have a work area where the actual painting is done and a backsection/underbooth area where paint overspray is removed from the air. In small or low production systems this is accomplished by pulling the paint laden air through a series of disposable filters. More commonly, a moving stream of air generated by booth exhaust fans pulls the paint overspray through a curtain or spray of recirculating water effectively scrubbing the paint particles from the air into the water phase. The water and scrubbed paint particles are carried to a sump basin where the paint particles are separated from the water so that the water can be recycled and the waste paint solids disposed of safely.

Paint is by definition a highly adhesive film forming material. It tends to readily adhere to any exposed booth surfaces where it can build and eventually reduce air and water flow, block drains, damage pumps and plug screens. This reduces booth efficiency and significantly increases operating costs. For this reason chemical "detackifiers" are usually added to the recirculating water. These act to improve the scrubbing efficiency of the booth, prevent the paint from adhering to booth surfaces and aid in the collection and removal of paint solids from the recirculating water stream.

In the past, solvent-based or solvent borne paints were most commonly employed in spray booths. More recently, increased environmental awareness has resulted in Federal regulations limiting the amount of VOCs that can be released. This has resulted in an increased use of waterborne paints and reformulation of existing solvent based ones to reduce VOCs. These materials, while not as tacky as solvent based ones are much more difficult to separate from water and due to their surfactant load are much more prone towards generating significant

amounts of foam and require different treatments than their solvent based analogs.

Consequently, a need has developed for “detackifiers” that not only reduce the stickiness of traditional paints but also deal with the need to control foam and improve collection of newer, reformulated water based and HAPS compatible solvent based paints (ones determined not to contain any materials regulated as Hazardous Air Pollutants). Current economic concerns and environmental awareness has also dictated that these products be cost effective and perform in a “green” sustainable manner.

A wide variety of chemicals have been proposed as treatments for wet spray booth waters containing oversprayed paint including water swellable clays, Mannich type polymers and amphoteric metal salts which form metal hydroxides at pH values >7. For example, US Pat. No. 4,564,464 teaches the use of pumpable, hectorite clay containing slurries, containing suitable thinning agents and water conditioning agents such as water-soluble phosphates. While able to treat both solvent and waterborne paints, this type of treatment generates excessive volumes of difficult to dewater sludge and tends to promote unwanted biological growth.

US Pat. No. 4,888,386 teaches the use of a melamine-formaldehyde based polymer in conjunction with a polyvinyl alcohol and a styrene acrylate copolymer to treat both water and solvent based paints very effectively. However, low levels of free formaldehyde present in this composition as with any Mannich type polymer have raised concerns for worker exposure. In addition, these materials are not easily biodegradable making sludge disposal a concern.

US Pat. No. 5,068,279 teaches a method for scavenging free formaldehyde from a high activity melamine-formaldehyde type detackifier to improve safety and reduce to VOC. This treated product performs well with all types of paints and is the current global standard. However, it is deemed “old” technology and concerns about formaldehyde and biodegradability persist.

US Pat. No. 5,250,189 teaches the use of polybasic aluminum salts such as preferably aluminum chlorohydrate (ACH) within designated pH and alkalinity ranges to provide improved collection of water-based paints. Although this can do an excellent job in collecting water-based paints, the treatment provides poor detackification results with solvent borne paint due to the hydrophilicity of the aluminum salt.

A more recent innovation, US Pat. No. 6,673,263 B2, teaches the incorporation of a minute amount (<0.5%) of a chitin-based polymer (chitosan) under acid conditions to a dilute solution of aluminum chlorohydrate (ACH). The chitosan acts to partially crosslink with the aluminum salt as the pH is increased improving its efficacy as a coagulant. The addition of the chitosan is claimed to make the composition a “green” chemistry.

Chinese Pat. No. 1919475 teaches feeding a water-soluble cationic starch to the inlet of the recirculating water pump of a booth and an aluminum salt and/or polyamide based flocculant to the return line. This is potentially a significantly "greener" approach and initially appears similar to the present invention. However, the Chinese patent recognizes the inherent incompatibility of the three components and so requires feeding each component separately at a separate feedpoint using a separate pump. This imposes an extra level of difficulty on the process since the individual products must first interact with each other in relatively fixed proportions to effectively detackify and collect the paint solids. By feeding them separately the necessary balance becomes much more difficult to achieve on an ongoing basis.

Accordingly, what is needed is a single component, cost effective, "green" sustainable chemistry that can effectively detackify and collect all types of paint.

SUMMARY

Unless the context clearly requires otherwise, throughout the description and the claims, the words 'comprise', 'comprising' and the like are to be construed in an inclusive sense as opposed to an exclusive or exhaustive sense; that is to say in the sense of "including but not limited to".

The current invention describes the following key aspects:

1. It is an advantage of the invention to improve detackifying properties in the recirculation of water in the paint and finishing process.
2. It is an advantage of the invention to improve the separation of paint products from the recirculating water in the paint and finishing process.
3. It is an advantage of the invention to provide improve detackifying ability and improve the separation of paint products in the recirculating water in the paint and finishing process while being a green technology that produces a much lower environmental impact.
4. It is an advantage of the invention to work effectively with a wide range of paint and finishing products with varying analogs.

In one aspect of the present invention, there is provided a composition for addition to a circulating water system containing an impurity, the composition comprising: a component consisting of cationized starch, a polybasic metal salt, and a polymer having at least 0.1% hydroxyl functionality and at least partially crosslinked via the polybasic metal salt, wherein the cationized starch does not react with a hydroxyl group on the polymer.

Preferably, the composition further comprises a transport component.

[followed by page 3a]

Preferably, the transport component is water.

Preferably, the composition is a liquid concentrate.

Preferably, the polybasic metal salt is an amphoteric salt of aluminium. More preferably, the amphoteric salt of aluminium salt is selected from one or a combination of the following: polyaluminium chloride, polyaluminium silicate sulfate, polyaluminium nitrate, polyaluminium hydroxychlorosulfate, poly aluminium nitrate sulfate, and aluminium chlorohydrate.

Preferably, the cationized starch is selected from one or more of the following: starch, guar gum, gum arabic, hydroxyethyl cellulose, hydroxypropyl cellulose, and methylcellulose gum.

Preferably, the cationized starch has a degree of substitution of 0.01 to 1.0.

Preferably, the polymer is a synthetic or natural polymeric flocculant, or the polymer is selected from one or more of the following: guar gum, chitosan, and acrylamide.

Where the polymer is a synthetic or natural polymeric flocculant, the synthetic or natural polymeric flocculant preferably has a molecular weight of at least 2.5×10^5 .

Preferably, the water stream of the circulating water system has a pH from 6.0 to 10.0.

Preferably, the circulating water system is used with a paint spray unit.

Preferably, the impurity is waterborne or solvent borne paint.

Preferably, the composition is comprised of: 1 to 60 % cationized starch component, 5 to 75 % polybasic metal salt, and 0.1 to 20% polymer.

In a further aspect of the present invention, there is provided a process for removing impurities from a circulating water system using the composition as herein described, wherein the composition is combined with the flow stream of the circulating water system,

Preferably, a pH modifier is added to the circulating water system to maintain the pH between 6.0 and 10.0.

DETAILED DESCRIPTION

The present invention includes a composition for treating oversprayed paint. The composition includes (a) a 1-35% solution of a cationic starch with a degree of substitution of 0.01-1.0; (b) a 1-50% solution of a polybasic metal salt such as aluminum chlorohydrate, polyaluminum chloride or polyaluminum nitrate; and (c) a 0.1-35% solution of an aqueous polymer (or copolymer or terpolymer) solution containing at least 0.1% hydroxyl functionality and a molecular weight of $>$ or $= 2.5 \times 10^5$. These materials would be combined to give a final composition containing 1 to 60% by weight of the cationized component, 5 to 75% of the polybasic metal salt and 0.1 to 20% of the polymer. A preferred composition would contain 35

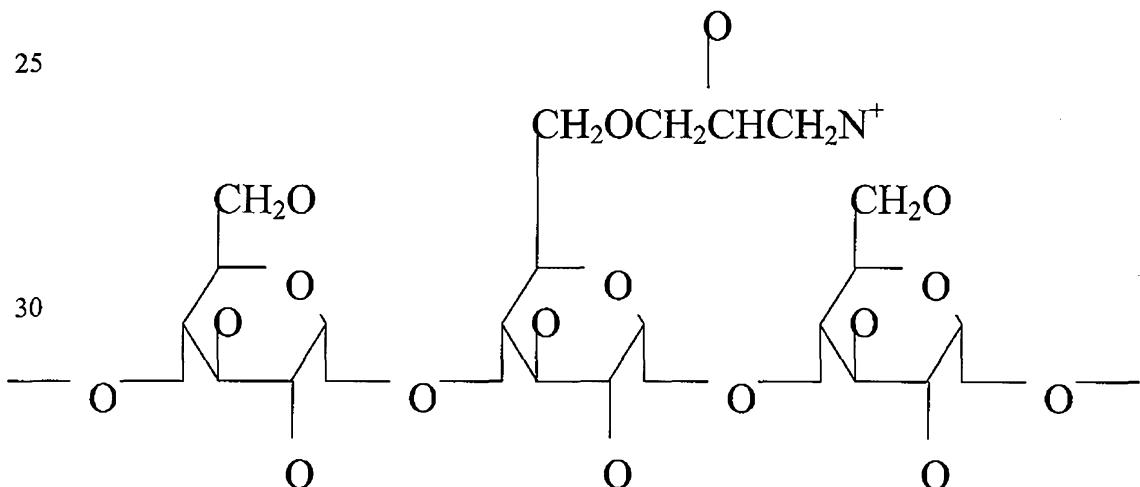
[followed by page 4]

to 55% of the cationized component 45 to 65% of the polybasic metal salt and 0.1% to 5% of the polymer by weight. The composition is particularly useful as a liquid concentrate that can be added to recirculating water systems in paint spray booths to treat both solvent borne (SB) and waterborne (WB) paints.

5 Another embodiment of the present invention comprises a method of treating oversprayed
paint particles in a circulating water system. In such a method, oversprayed paint is contacted
with a water system that includes a composition comprising (a) an aqueous solution of a cationic
starch, (b) a complex metal salt, (c) a polymer solution having at least 0.1% of hydroxyl
functionality and (d) water, where the components a, b, and c are all contained in a single liquid
10 concentrate product, and are applied to the water system simultaneously and at a fixed ratio. The
composition as described acts to detackify and flocculate oversprayed paint particles. The
method described may also include a step of separating the treated oversprayed paint particles
from the water.

The combination of the three components to form a stable, effective composition is not trivial. The polymer must be able to partially crosslink with the aluminum salt but not so much as to form an insoluble gel. The starch must have enough cationic charge to enable it to interact with the paint solids but not enough to react with the hydroxyl functionality of the polymer. The aluminum salt must be polybasic enough to crosslink with a hydroxyl group on a polymer. To provide a stable product the individual products must be matched to each other. They must be fed in a specific order, in specific proportions in a defined pH range so that they will not interact with each other until fed into the process water.

As previously stated, the instant invention includes an aqueous solution of a cationic starch having the following generalized structure:



It also includes a polybasic aluminum salt and a polymer containing an amount of a hydroxyl functional group sufficient to allow it to crosslink with the aluminum salt at pH values greater than approximately 5.0.

5 Starch, sometimes referred to as amylose is a polysaccharide carbohydrate consisting of a large number of glucose units joined together by glycosidic bonds. Starch is produced by all green plants as an energy store and is a major food source for humans. Pure starch is a white, tasteless and odorless powder that is insoluble in cold water or alcohol. It consists of two types of molecules: the linear and helical amylose and the branched amylopectin. Depending on the plant, starch generally contains 20 to 25% amylose and 75 to 80% amylopectin.

10 The base starch referred to in the instant invention maybe derived from any of the common commercially used starch sources including but not limited to wheat, maize (corn), tapioca, potato, rice, sweet potato, sago, mung bean, and arrowroot.

15 Starches may be cationized by several methods. The present invention is independent of the method used to cationize the starch. It does require that the starch has an effective degree of substitution and must be readily available from commercial suppliers, produced by any means. The degree of substitution of a cationic starch is described by the average number of substituents per anhydroglucose unit and has a potential maximum value of three. (The preceding schematic (Fig 1) is included for informational purposes only and does not consider any branching that may occur off the original amylose unit.) The cationization process produces a polymer having a 20 strong positive charge that improves solubility and permits interaction with negatively charged surfaces. The process also adds an amine functionality to the existing hydroxyl functionality, lending itself to reactive chemistry on either side group. The cationic starch used in the instant invention has a degree of substitution between 0.01 and 1.0 making it suitable for use as a flocculant. It is provided as an aqueous solution of 1 to 35% solids. Suitable products are 25 available commercially from Dober, Alco, or ISC.

Other materials that could be cationized and might provide similar performance may include guar gum, gum Arabic, hydroxyethyl cellulose, hydroxypropyl cellulose, and methylcellulose gum. The composition of the instant invention further includes a polybasic metal salt that is useful in treating water based or latex types of paints and can interact with 30 polymeric flocculants that contain hydroxyl functionality at neutral or alkaline pH values to form a crosslinked gel. Preferred embodiments would include complex polymeric aluminum salts such as but not limited to polyaluminum chloride (PAC), polyaluminum silicate sulfate (PASS), polyaluminum nitrate, polyaluminum hydroxychlorosulfate and aluminum chlorohydrate. This salt would be provided as an aqueous solution containing from 1 to 50% solids.

The composition also includes a natural or synthetic polymeric flocculant containing at least 0.1% hydroxyl functionality and a molecular weight of at least 2.5×10^5 . The polymer should be easily biodegradable and be capable of reacting with a complex polymeric salt of an amphoteric metal to form a crosslinked gel at neutral or alkaline pH values. Suitable products 5 could include polymers (or copolymers or terpolymers) of synthetic polymers such as acrylamide or natural polymers such as chitosan or guar gum.

The composition of the instant invention is typically prepared by first adding the required amount of starch to a reaction vessel fitted with a mixer. The mixer is turned on and dilute sulfuric acid added if needed to adjust the pH of the starch solution to a value of 5.5 to 6.0. 10 (Other acids can be used if necessary including but not limited to hydrochloric acid, nitric acid, phosphoric acid or acetic acid.) While mixing vigorously, the polymeric flocculant is added to the starch solution and mixed until uniform. (15 – 30 minutes at 100rpm should be sufficient).

After the starch polymer solution has been mixed thoroughly the polybasic metal salt is added to the mixture while continuing to mix. Significant thickening may be experienced at this 15 point. Continue mixing the resultant blend for an additional 15 to 30 minutes or until it is uniform.

The composition of the instant invention is preferably prepared as a liquid concentrate. This concentrate can then be added to the recirculating water system of a paint spray booth for use as a primary detackifying additive and or coagulating additive for oversprayed paint solids. 20 Use concentrations in such systems would typically be in the range of 10 to 1,000 ppm based on water flow and paint loading.

In applications of the instant invention, the pH of the recirculating water system is preferably maintained between 6.0 and 10.0 and more preferably between 7.5 and 9.0. Since the composition of the instant invention is slightly acidic, its use may influence the pH of the 25 recirculating water system over time so the pH may have to be periodically adjusted using methods and products commonly used in similar applications such as NaOH, KOH, soda ash, or sodium metasilicate.

In the context of the instant invention the detackifying composition previously described is fed to the recirculating water system of a paint booth. The paint overspray makes contact with 30 the recirculating water in the booth scrubber section. In contacting the water containing the instant invention the paint overspray becomes rapidly detackified and coagulated causing it to separate from the system water as a sludge layer.

Additionally, other polymeric compounds may be utilized in conjunction with the composition of the instant invention to act as co-flocculants and facilitate more rapid separation

of the paint solids from the recirculating water system. Preferred embodiments would include high molecular weight polymers of acrylamide. These would include copolymers containing amine or hydroxyl functional groups.

5

EXAMPLES

The foregoing may be better understood by reference to the following examples, which are intended to illustrate methods for carrying out the invention and are not intended to limit the scope of the invention.

To demonstrate the effectiveness of the instant invention the following procedure was 10 employed. For each test, 200 ml of cold tap water was added to an open mouth, one-pint glass jar equipped with a magnetic stir bar. While stirring at high speed, 0.2 ml of the product to be evaluated was added to the jar and the pH adjusted to 8-9 with caustic if needed. As stirring continued, 10-12 drops (0.5 ml) of a mixture of commercially available automotive paints was 15 added to the vortex. The samples were allowed to mix for 30 seconds then 1.5ml of a 1% solution of Nalco ULTIMER 7757 added to facilitate separation of the paint solids and allowed to mix for an additional 30 seconds after which time the mixer was turned off. After allowing the sample to stand for 30 seconds the samples were evaluated for tackiness and final water quality. Separate tests were run for each composition utilizing mixtures of solvent borne basecoats and water borne basecoats respectively.

20

Example 1

This example demonstrates the effectiveness of the instant invention with a composition prepared as described previously as Treatment "A".

25

| Paint | Tack | Smear | Sludge Appearance | Water clarity (ntu) |
|----------|------|-------|-------------------|---------------------|
| SB Blend | None | None | Fluffy | Good 4.7 |
| WB Blend | None | None | Fluffy | Good 6.8 |

Example 2

The subsequent examples demonstrate the importance of each of the components in the performance of the instant invention. In example 2, the polymeric component has been removed leaving only the cationic starch and the aluminum chlorohydrate (ACH). (In this and all subsequent examples the amounts of the remaining chemistry was increased to maintain an equal active solids for all tests.)

| Paint | Tack | Smear | Sludge Appearance | Water clarity (ntu) |
|----------|----------------|-------------|-------------------|---------------------|
| SB Blend | Poor v. sticky | Poor smeary | Wet sticky | Poor 105 |
| WB blend | None | some | Not cohesive | Poor 112 |

10

Example 3

In example 3, the cationic starch component has been removed leaving only the polymer and aluminum chlorohydrate (ACH).

| Paint | Tack | Smear | Sludge Appearance | Water clarity (ntu) |
|----------|--------------|-------------|-------------------|---------------------|
| SB Blend | Poor stringy | Poor Smeary | Gooey blobs | Poor 89 |
| WB Blend | None | Slight | Wet v. fine | Fair 51 |

15

Example 4

In example 4, the aluminum chlorohydrate (ACH) has been removed leaving only the polymer and cationic starch.

| Paint | Tack | Smear | Sludge Appearance | Water clarity (ntu) |
|----------|---------------|-------------|-------------------|---------------------|
| SB Blend | Fair sl tacky | Poor smeary | Gooey blobs | Poor 99 |
| WB Blend | Some | none | Rubbery blob | Poor 104 |

CLAIMS

The claims defining the invention are as follows:

1. A composition for addition to a circulating water system containing an impurity, the composition comprising: a component consisting of cationized starch, a polybasic metal salt, and a polymer having at least 0.1% hydroxyl functionality and at least partially crosslinked via the polybasic metal salt, wherein the cationized starch does not react with a hydroxyl group on the polymer.
2. The composition of claim 1, further comprising a transport component.
3. The composition of claim 2, wherein the transport component is water.
4. The composition of any one of the preceding claims, wherein the composition is a liquid concentrate.
5. The composition of any one of the preceding claims, wherein the polybasic metal salt is an amphoteric salt of aluminium.
6. The composition of claim 5, wherein the amphoteric salt of aluminium salt is selected from one or a combination of the following: polyaluminium chloride, polyaluminium silicate sulfate, polyaluminium nitrate, polyaluminium hydroxychlorosulfate, poly aluminium nitrate sulfate, and aluminium chlorohydrate.
7. The composition of any one of the preceding claims, wherein the cationized starch is selected from one or more of the following: starch, guar gum, gum arabic, hydroxyethyl cellulose, hydroxypropyl cellulose, and methylcellulose gum.
8. The composition of any one of the preceding claims, wherein the cationized starch has a degree of substitution of 0.01 to 1.0.
9. The composition of any one of the preceding claims, wherein the polymer is a synthetic or natural polymeric flocculant.
10. The composition of any one of claims 1 to 8, wherein the polymer is selected from one or more of the following: guar gum, chitosan, and acrylamide.

11. The composition of claim 9, wherein the synthetic or natural polymeric flocculant has a molecular weight of at least 2.5×10^5 .
12. The composition of any one of the preceding claims, wherein the water stream of the circulating water system has a pH from 6.0 to 10.0.
13. The composition of any one of the preceding claims, wherein the circulating water system is used with a paint spray unit.
14. The composition of any one of the preceding claims, wherein the impurity is waterborne or solvent borne paint.
15. The composition of any one of the preceding claims, wherein the composition is comprised of: 1 to 60 % cationized starch component, 5 to 75 % polybasic metal salt, and 0.1 to 20% polymer.
16. A process for removing impurities from a circulating water system using the composition of any one of claims 1 to 15, wherein the composition is combined with the flow stream of the circulating water system,
17. The process of claim 16, wherein a pH modifier is added to the circulating water system to maintain the pH between 6.0 and 10.0.