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(54) **Title:** OPTICAL REFLECTORS, REFLECTION FILMS AND SHEETS

(57) **Abstract:** Films, sheets or profiles useful as optical reflectors may be prepared by extruding a melt-processable acrylic resin composition comprised of acrylic polymer, white pigment and, optionally one or more additives such as impact modifiers, matting agents, UV stabilizers, antioxidants and processing additives onto a layer of ABS, acrylic or other thermoplastic. Alternatively, a monolithic film or sheet or profile useful as an optical reflector is obtained by forming the acrylic resin composition using a melt-processing technique such as extrusion or injection molding without a substrate layer.



OPTICAL REFLECTORS, REFLECTION FILMS AND SHEETS

Field of the Invention

5 The invention pertains to structures based on acrylic polymers and white pigments which are useful as optical reflectors or optical reflection films or sheets or profiles.

Discussion of the Related Art

10 Optical reflectors or optical reflection films have been widely used in LED-backlit units in liquid crystal displays (including handhelds, notebooks, desktop monitors and LCD TVs), automotive LED lighting, LED luminaire and LED lighting fixture applications. Such optical reflectors or optical reflection films offer high optical reflectance in the visible wavelength region and excellent UV resistance.

15 Traditionally, white optical reflectors have been made from metal (Ag, Al) deposited PET (polyethylene terephthalate) films or white barium sulfate- or CaCO_3 -pigmented porous PET films, which are not fully UV resistant. The Ag or Al deposited mirror films/or parts usually require an additional electrical insulation layer. There has been an on-going need to develop improved optical reflectors or optical reflection films

20 which fully meet the target performance requirements for such end use applications (e.g., high brightness, high diffused light scattering, excellent long-term UV resistance, excellent color retention (no yellowing), corrosion resistance, dimensional stability, heat resistance, excellent mechanical properties and environmental stability).

 LED light sources offer much longer service life (up to 50,000-100,000 hrs)

25 and high energy efficiency. From the LED light sources, the temperature could be as high as up to 105 °C. Therefore, the polymer materials used in LED lighting units should have sufficient thermal stability to avoid any thermal deformation, including warping, when they are close to LED lamps. For the optical reflectors used in LED lighting and LED-backlight units, it is desired to have long-term excellent UV

30 resistance, high optical reflectance (greater than 90% at 560 nm) in the photopic light region, high diffused Lambertian light scattering, excellent thermal dimensional stability, and excellent environmental stability. For LED lighting and LED-backlit units, high light reflectance in films is required to improve the light brightness while the high diffused light scattering is desired to increase the light recycling and light

35 uniformity.

Brief Summary of the Invention

One aspect of the invention provides a film, profile, or sheet suitable for use as an optical reflector. The film, profile, or sheet comprises a layer of a melt-processable resin composition comprised of an acrylic polymer, a white pigment and optionally one or more other components such as impact modifiers, polyvinylidene fluoride (PVDF) and its copolymers, matting agents, UV stabilizers, antioxidants, and processing additives. The film, profile, or sheet may be monolithic (a single layer) or multi-layer.

In one embodiment of the invention, the film, profile, or sheet comprises:

- a) a substrate film layer comprised of a thermoplastic polymer; and
- b) a layer of a melt-processable acrylic resin composition on at least one side of the substrate film layer, wherein the acrylic resin composition is comprised of an acrylic polymer and a white pigment.

Another aspect of the invention provides methods of making a film, profile, or sheet suitable for use as an optical reflector. Such methods may, for example, comprise applying a layer of a melt-processable acrylic resin composition by a melt-processing technique such as extrusion or molding to at least one side of a substrate film layer comprised of a thermoplastic polymer, wherein the acrylic resin composition comprises an acrylic polymer and a white pigment, with impact modifier and/or matting agent and/or diffusing agent and/or UV stabilizer and/or antioxidant and/or processing additive optionally also being present. One aspect of the invention provides a method which comprises co-extruding the melt-processable acrylic resin composition and a composition comprised of the thermoplastic polymer.

The acrylic resin composition may also be extruded, injection molded or otherwise melt-processed by itself (without a substrate film layer) to form a monolithic (single layer) film or sheet, which is also suitable for use as an optical reflector.

Still further aspects of the invention provide an LED lighting unit comprising, as a back light reflector, a film, profile, or sheet comprised of a substrate film layer comprised of a thermoplastic polymer and a layer of a melt-processable acrylic resin composition on at least one side of the substrate film layer, wherein the acrylic resin composition is comprised of an acrylic polymer and a white pigment, as well as a lighting device comprised of a light emitting diode and a film comprised of a substrate film layer comprised of a thermoplastic polymer and a layer of a melt-processable

acrylic resin composition on at least one side of the substrate film layer, wherein the acrylic resin composition is comprised of an acrylic polymer and a white pigment, optionally in combination with other components as previously mentioned.

In additional aspects, the invention provides an LED lighting unit comprising,
5 as a back light reflector, a monolithic film or sheet of a melt-processable acrylic resin composition comprised of an acrylic polymer, a white pigment and, as optional additional components, impact modifier, matting agent, diffusing agent, UV stabilizer, antioxidant, and/or processing additive as well as a lighting device comprised of a light emitting diode and a monolithic film comprised of the aforementioned melt-
10 processable acrylic resin composition.

Films, profiles, and sheets in accordance with the present invention may have one or more of the following advantages as compared to other materials known in the optical reflector or optical reflection film art: very high optical reflectance, long-term UV resistance, excellent color retention (no yellowing), excellent adhesion between
15 the acrylic resin composition layer(s) and the substrate film layer, diffused light scattering, excellent thermal dimensional stability and/or heat resistance, excellent mechanical properties and environmental stability, as well as excellent electrical insulation characteristics. The films, profiles, and sheets of the present invention are capable of offering much better color retention and gloss retention than conventional
20 optical reflectors made from extruded white polycarbonate (PC), PET, PEN and PETG films.

Detailed Description of the Invention

The substrate film layer component used in one embodiment of the present invention may be comprised of any suitable thermoplastic polymer such as, for
25 example, an acrylic (e.g., a polymethylmethacrylate or a copolymer of methyl methacrylate and one or more other types of acrylic monomers, wherein the acrylic may be impact-modified), ABS (acrylonitrile-styrene-butadiene resin), ASA (acrylonitrile-styrene-acrylate resin), SAN (styrene-acrylonitrile resin), polyethylene terephthalate (PET), polyethylene naphthalate (PEN), PET-co-PEN, glycol-modified
30 polyethylene terephthalate (PETG), PET-co-PETG, ABS/PC blends, and polycarbonate (PC). Any of the conventional thermoplastic additives such as stabilizers, fillers, pigments, PVDF and its copolymers, plasticizers and the like may also be present in the substrate film layer, in addition to the thermoplastic polymer.

Thus, the substrate film layer may be formed from a composition comprised of the thermoplastic polymer and one or more additives. For example, the composition may be melt-processed by a technique such as extrusion or co-extrusion to provide the substrate film layer. The substrate film layer in various embodiments of the invention
5 may be clear or opaque (e.g., white, grey, black). Typically, the substrate film layer is in the form of a relatively thin, flat sheet or film of substantially uniform thickness. The thickness of the substrate film layer may, for example, be from 100 to 3000 μm or from 200 to 1500 μm . The substrate film layer may be a single unitary layer of a polymer or polymer blend or may contain two or more layers of different polymers or
10 polymer blends.

The substrate film layer may be selected so as to improve the mechanical integrity of the resulting optical reflector as well as its optical performance, in combination with one or more layers of melt-processable acrylic resin composition.

To improve the adhesion of the layer of acrylic resin composition, one or both
15 sides of the substrate film layer may be primed. Suitable methods for treating the substrate film layer surface to enhance adhesion include corona or plasma treatment, functional silane treatment, application of an organic- or polymer-based primer coating, and the like.

The acrylic resin composition may be placed as a layer on one or both sides of
20 the substrate film layer. Providing an acrylic resin composition layer on both sides of a clear substrate film layer has been found to provide further enhancement of the total optical reflectance. It is believed that the additional reflection from a second acrylic resin composition layer/substrate film layer interface is responsible for improving the total optical reflectance in the visible optical wavelength region as compared to a
25 clear substrate film layer coated on one side only or as compared to a white substrate film layer coated on both sides.

If both sides are coated, the same acrylic resin composition may be employed on both sides or different acrylic resin compositions may be used. The acrylic resin composition is melt-processable and is comprised of an acrylic polymer and a white
30 pigment. The melt-processable acrylic resin composition is characterized by the absence of volatile components such as solvents and water. In various embodiments of the invention the acrylic resin composition is formulated such that it has a melt flow index of more than 0.4, 1, or 2 g/10 minutes under 3.8 Kg at 230°C. The acrylic polymer may be any polymer containing recurring units of acrylic monomers and

generally is a thermoplastic (although crosslinked acrylic polymers may also be utilized). The acrylic polymer may, for example, have a linear, branched, grafted or block copolymer structure. Suitable acrylic monomers include any of the polymerizable acrylate and methacrylate monomers known in the art. Examples of acrylic monomers include acrylic acid, methacrylic acid, and esters of acrylic and methacrylic acid such as C₁-C₆ alkyl esters of (meth)acrylic acid (e.g., methyl methacrylate, methyl acrylate, ethyl acrylate, ethyl methacrylate, n-butyl acrylate, n-butyl methacrylate and the like). The acrylic monomers may be homopolymerized or copolymerized. Acrylic copolymers include both polymers wherein two or more different acrylic monomers are copolymerized as well as polymers wherein an acrylic monomer (or mixture of acrylic monomers) is copolymerized with one or more non-acrylic monomers such as a vinyl aromatic monomer (e.g., styrene), an olefin (e.g., ethylene), (meth) acrylonitrile, a vinyl monomer, or the like.

In one embodiment of the invention, the monomer(s) used to prepare the acrylic polymer are selected such that the resulting polymer has a relatively high glass transition temperature (T_g). For example, the acrylic polymer may have a T_g of at least 80°C, at least 85°C, at least 90°C, at least 95°C, at least 100°C, at least 105°C, at least 110°C, at least 115°C, at least 120°C, or at least 125°C. In another embodiment, the acrylic polymer used has a relatively low T_g. Such a low T_g acrylic polymer may, however, be crosslinked and then used in the acrylic resin compositions of the present invention, provided the composition remains melt-processable. The T_g of a polymer may be measured by differential scanning calorimetry during the second heating process using a heating rate of 10°C/min.

The term “polymer” as used herein means both homopolymers and copolymers. The term “copolymer” as used herein means a polymer having two or more different monomer units. The copolymer could be a terpolymer with three or more different monomer units, or have four or more different monomer units. The copolymer may be a random copolymer, a gradient copolymer, or could be a block copolymer formed by a controlled radical polymerization process. The copolymer could also be a graft copolymer, or have a controlled structure such as a star or comb. In one embodiment, the acrylic polymer is formed by a free radical polymerization process, and the process can be any polymerization method known in the art,

including but not limited to emulsion, solution, suspension polymerization, and can be done in bulk, semi-bulk or delayed feed.

In one embodiment, the acrylic polymer is a copolymer which contains at least 50 weight percent of methylmethacrylate monomer units, and preferably at least 75 weight percent and more preferably at least 85 weight percent methylmethacrylate monomer units. The copolymer in this embodiment contains from 1 to just less than 50, preferably 2 to 25, and more preferably 5 to 15 weight percent of at least one higher Tg monomer (high Tg monomer as used herein means the Tg of the homopolymer of that monomer). The Tg of the high Tg monomer may be, for example, at least 120°C or at least 125°C. Useful high Tg monomers include, but are not limited to, methacrylic acid, acrylic acid, itaconic acid, alpha methyl styrene, maleic anhydride, maleimide, isobornyl methacrylate, norbornyl methacrylate, t-butyl methacrylate, cyclohexyl methacrylate, acrylamide and methacrylamide

The acrylic copolymer may contain one or more other vinyl monomers copolymerizable with methyl methacrylate, including but not limited to other acrylate and methacrylate monomers or other ethylenically unsaturated monomers, included but not limited to, styrene, alpha methyl styrene, and acrylonitrile. Crosslinkers may also be present in the monomer mixture. Other methacrylate and acrylate monomers useful in the monomer mixture include, but are not limited to, methyl acrylate, ethyl acrylate and ethyl methacrylate, butyl acrylate, iso-octyl methacrylate and acrylate, lauryl acrylate and lauryl methacrylate, stearyl acrylate and stearyl methacrylate, isobornyl acrylate and methacrylate, methoxy ethyl acrylate and methacrylate, 2-ethoxy ethyl acrylate and methacrylate, dimethylamino ethyl acrylate and methacrylate monomers.

In one embodiment, the acrylic copolymer contains an acid functional monomer such as acrylic acid, methacrylic acid, maleic acid, itaconic acid or other alpha-beta unsaturated carboxylic acid monomers. The acid functional monomer content of the copolymer may be, for example, 2 to 8 or 3 to 6 weight %. In one embodiment, the balance of the copolymer may be methyl methacrylate or a monomer mixture comprised of methyl methacrylate and at least one other monomer selected from ethyl acrylate, methyl acrylate or butyl acrylate. For example, the copolymer may comprise 2 to 8 weight % acid functional monomer and 0 to 10 weight % of one or more monomers selected from ethyl acrylate, methyl acrylate and butyl acrylate, with the balance (to 100 weight %) being methyl methacrylate.

If the acrylic polymer is a copolymer, the copolymer may be, for example, a random copolymer, a block copolymer, or a graft copolymer.

The amount of acrylic polymer in the acrylic resin composition may be varied as desired, but typically the acrylic polymer content of the melt-processable acrylic layer is at least 45 weight % or at least 50 weight %. In certain embodiments, the acrylic layer does not contain more than 99 weight % or more than 95 weight % acrylic polymer, with the balance of the composition being made up of the white pigment and optionally impact modifier, matting agent, UV stabilizer, antioxidant, processing additives and other adjuvants.

The acrylic polymer may, in one embodiment of the invention be impact-modified. That is, the acrylic resin composition may comprise one or more impact modifiers in addition to the acrylic polymer and the white pigment. The impact modifier may be prepared or obtained separately from the acrylic modifier and then combined with the acrylic polymer to prepare the acrylic resin composition, or the acrylic polymer may be impact-modified during its preparation. Any of the impact modifiers known in the acrylic resin art may be employed for this purposes including, for example, block copolymers, random copolymers, graft copolymers, homopolymers, core-shell impact modifiers and the like. Typically, the impact modifier will either be rubbery (elastomeric) having a T_g below 20°C or below 0°C or contain at least one phase or segment that is rubbery and has a T_g below 20°C or below 0°C.

In certain embodiments, the impact modifiers are core-shell multi-layer polymers and/or block copolymers having at least one hard and at least one soft block. The core-shell (multi-layer) impact modifiers could have a soft (rubber or elastomer) core and a hard shell, a hard core covered with a soft elastomer layer and then a hard shell, or other core-shell morphology known in the art. The rubber layers are composed of low glass transition (T_g) polymers, including, but not limited to, polymers of butyl acrylate (BA), ethylhexyl acrylate (EHA), butadiene (BD), butylacrylate/styrene, siloxane and many other combinations. The elastomeric or rubber layer may be crosslinked by a multifunctional monomer for improved energy absorption. Crosslinking monomers suitable for use as the crosslinker in the core-shell impact modifier are well known to those skilled in the art, and are generally monomers copolymerizable with the monounsaturated monomer present, and having ethylenically multifunctional groups that have approximately equal reactivity.

Examples include, but are not limited to, divinylbenzene, glycol of di- and trimethacrylates and acrylates, triol triacrylates, methacrylates, and allyl methacrylates, etc. A grafting monomer may also be used to enhance the interlayer grafting of impact modifiers and the matrix/modifier particle grafting. The grafting monomers can be any polyfunctional crosslinking monomers.

For soft core multi-layered impact modifiers, the core may comprise from 30 to 85 percent by weight of the impact modifier and the outer shells may comprise from 15 to 70 weight percent of the impact modifier. The crosslinker in the elastomeric layer may range from 0 to 5.0% by weight.

If impact modifier is present in the acrylic resin composition, it may comprise, for example, up to 40 % by weight of the acrylic resin composition. For example, the impact modifier content of the acrylic resin composition may be 5 to 40 weight % or 15 to 35 weight %. In one embodiment, the weight ratio of acrylic polymer: impact modifier is from 1:1 to 3:1.

The acrylic resin composition further contains one or more white pigments. The pigments generate diffused lighting scattering in the visible wavelength region. The white pigments should have a relatively high refractive index (e.g., $n > 1.5$) while the Celcor® hollow particles (from Arkema Coating Resins) with a lower refractive index also can generate high light scattering. Typically, suitable pigments are particulate in form having, for example, average particle sizes of from 50 to 2000 nm or 100 to 1500 nm. Larger particle size pigments may also be employed; as the average particle size increases, the pigment may impart a matting effect to the layer of acrylic resin composition (i.e., reduce the surface gloss), which may be advantageous in certain applications. Suitable white pigments include, but are not limited to, zinc oxide, PdS, titanium dioxide and barium sulfate. The titanium dioxide may be rutile titanium dioxide produced by the chloride process. The pigment may be treated with an inorganic- or organic-based material to improve UV resistance and/or light scattering. The white pigment content of the acrylic resin composition is generally at least 1 weight %, at least 2 weight % or at least 4 weight %. Typically, the acrylic resin composition does not contain more than 60 weight % white pigment, although in certain embodiments the acrylic resin composition does not contain more than 50 weight % or more than 40 weight % white pigment.

In addition to the white pigment, the acrylic resin composition may contain one or more matting agents and/or diffusing agents which serve to promote diffused

light scattering (in the bulk and on the surface) for better light uniformity in the films and sheets of the present invention. The matting agents are generally particulate and may, for example, be relatively large particles of inorganic substances (e.g., barium sulfate, metal oxides such as alumina and silicon oxides) or organic (including

5 polymeric) substances (e.g., Paraloid[®] EXL5136 and other optical properties modifiers sold by Dow Chemical under the Paraloid EXL brand name, Orgasol[®] polyamide from Arkema, acrylic matting agents sold by the Altuglas division of Arkema such as Altuglas[®] BS130 and BS110, Acryperl[®] 100 sold by Arkema,

10 fluorohomopolymers and fluorocopolymers such as polyvinylidene fluoride (PVDF) or vinylidene fluoride/hexafluoropropylene copolymers). Hollow particles, and in particular hollow sphere particles may also be used as diffusing agents. The polymeric matting agents may have relatively small average particle size, e.g., 5 to 100 μm . The matting agent content of the acrylic resin composition may be, for example, up to 20 weight % (e.g., 1 to 15 weight %). In one embodiment, an amount of matting agent is

15 present in the acrylic resin composition which is effective to provide the film, profile, or sheet with a surface gloss at a measuring angle of 60 degrees of less than 30 GU or less than 10 GU (e.g., 4-9 GU).

Low surface gloss may also be achieved through micro-scaled surface embossing techniques such as the use of embossing rolls and textured/matting mold

20 surfaces used in injection moldings.

Additionally, the acrylic resin composition may contain one or more UV stabilizers (e.g., Tinuvin[®] 234, Tinuvin[®] 360, Tinuvin[®] 328, Tinuvin[®] 329), antioxidants (e.g., Irganox[®] 1010, Irganox[®] 1035, Irganox[®] 1076, Irganox[®] 245) and/or processing additives (e.g., Irgafos[®] 126, Irgafos[®] 168), typically at levels of 0.5

25 to 5 weight % in total.

In one embodiment, the melt-processable acrylic resin composition comprises 40 to 91.5 weight % acrylic polymer having a Tg of at least 90°C, 2 to 40 weight % white pigment having a refractive index $n > 1.5$, 5 to 40 weight % core-shell impact modifier, 1 to 15 weight % particulate polymeric matting agent, and 0.5 to 5 weight %

30 total of one or more additives selected from the group consisting of UV stabilizers, antioxidants and processing additives, the total equaling 100%.

The components of the acrylic resin composition may be selected so as to provide an optical reflectance in the finished film or sheet of at least 90%, at least 96% or at least 98% at 560 nm.

The acrylic resin composition may be placed as a layer on one or both sides of the substrate film layer, with a primer coat optionally being present between the acrylic resin composition layer and the surface of the substrate film layer. Typically, the acrylic resin composition layer is 100 μm to 1000 μm or 150 μm to 700 μm in thickness. Generally speaking, the acrylic resin composition layer is substantially uniform in thickness and extends over the entire surface of the substrate film layer. Alternatively, as explained further below, a monolithic film or sheet is formed by extrusion, injection molding or other such melt processing technique, with no substrate film layer being present. When injection molded, the monolithic film or sheet typically has a thickness of 100 to 4000 μm or 300 to 3000 μm .

To prepare films and sheets in accordance with the invention, the following procedure may be used. A melt-processable acrylic resin composition may first be obtained by compounding acrylic resin, white pigment and any other desired additives (e.g., impact modifier, matting agent, UV stabilizer, antioxidant, and/or processing additives) in a twin screw extruder or the like at an elevated temperature effective to melt or soften the acrylic polymer sufficiently to achieve good mixing of the various components to form pellets, beads, or the like by extrusion through a die and pelletization. The pigment may be pre-blended in a portion of acrylic polymer prior to being compounded with the rest of the acrylic polymer and other components. The compounded product thus obtained may be further dried, if so desired, prior to extrusion, co-extrusion, extrusion coating, (co)injection molding, in-molding decoration (IMD) or other such melt processing forming method to provide the films and sheets of the present invention. It is also possible to melt-compound the components of the acrylic resin composition and form an optical reflective sheet or film in accordance with the invention directly without first preparing the aforementioned beads or pellets.

In one embodiment of the invention, a suitable substrate film layer is selected and a layer of the melt-processable acrylic resin composition extruded on at least one side of the substrate film layer. Application of the acrylic coating by an extrusion method or other melt processing technique is advantageous in that it avoids the need to place the components of the acrylic coating in a liquid medium such as an organic solvent or water (as an aqueous dispersion) and subsequently remove the liquid medium by drying after the acrylic resin composition layer has been applied to the substrate film layer.

The surface of the substrate film layer to be coated by an extrusion technique may have first been primed. Extrusion of the acrylic resin composition may be carried out using any suitable method known in the art, such as through the use of co-extrusion or the like. Generally, it will be desirable to apply a substantially uniform layer of the acrylic resin composition, typically having a thickness sufficient to provide an acrylic resin composition layer of from 100 to 1000 μm in thickness. If both sides of the substrate film layer are to be coated, each side may be coated successively or both sides may be coated simultaneously. The acrylic resin compositions applied to each side may be the same as or different from each other. A micro-scaled surface embossing process may be employed. The coated film may thereafter be cut or otherwise fabricated to have the dimensions or configuration suitable for use in an LED lighting fixture, an automotive LED lighting, or a LED backlit unit.

In another embodiment of the invention, the acrylic resin composition layer(s) and the substrate film layer are extruded simultaneously in a co-extrusion process. That is, the substrate film layer is not preformed and the acrylic resin composition layer(s) extruded thereon, but rather is formed by a melt-processing technique at the same time as the acrylic resin composition layer(s).

In another embodiment of the invention, no substrate film layer is employed. Instead, a monolithic film or sheet is formed by extrusion, injection molding or other such melt-processing technique. That is, the acrylic resin composition is melt-processed and shaped by extrusion or injection molding or the like to form the monolithic film or sheet. In this embodiment, the thickness of the monolithic sheet or film may be, for example, from 500 to 3000 μm or from 1000 to 2000 μm .

Optical reflectors in accordance with the present invention can be used in general LED lighting, automotive LED lighting, and LED backlit units for applications in handheld devices, notebooks, desktop monitors, LCD TVs, and the like. For example, the optical reflector is suitable for improving the light brightness and light uniformity in lighting sources like LED and cold cathode fluorescent lamp (CCFL). The white optical reflector can be located behind a light guide panel in a backlight unit and/or be used as a light bulb reflector. The optical reflector can be used in white LED lighting with improved brightness, light uniformity and energy savings.

Examples

Example 1.

- A high Tg Plexiglas® V825-100 resin (Tg=114°C) made at Arkema was compounded with a core-shell impact modifier having a particle size of 250-300nm, white R105 TiO₂ pigment from DuPont blended with VM grade acrylic polymer and Paraloid® EXL 5136 matting agent (having a particle size of 8 µm, from Dow Chemical) to form white acrylic resin compositions using a 27 mm twin-screw extruder (from Leistritz) at a die temperature of 240°C and a processing speed of 60 lbs/hour. UV stabilizer was also added into the formulation during the compounding.
- The compounded acrylic pellets were dried at 85°C overnight. The melt flow rate was measured at 1.6 g/ for 10 minutes under 3.8Kg at 230°C.

Formulation 1	Grams	%
Acrylic Polymer V825-100	2100	35.0
Core-Shell Impact Modifier	1400	23.3
EXL5136 Matting Agent	500	8.3
VM -100	900	15.0
R105 in conc. (TiO ₂ , 55% in VM)	1100	18.3
Subtotal	5500	100
UV Package	124.50	2.541%
Stearic acid	2.00	0.041%
Tinuvin® 234	71.05	1.450%
Irganox® 1010	34.30	0.700%
Irgafos® 126	17.15	0.350%
Total (g)	5624.50	

- A 15-mil thick white reflective layer of the above formulation was co-extruded over a 45-mil ABS substrate using a single manifold die with a B/B/A/A/A feed block (from Cloeren) at a temperature of 245°C. The melt flow rate of the ABS used (752 NAT from Ineos) was measured at 0.72 g for 10 minutes under 3.8Kg at 230°C. The width of the co-extruded white sheet sample was controlled at 11 inches. The chiller roll temperature was controlled at 80-90°C. The optical reflectance at 560

nm was measured at 97.1% using a Perkin Elmer Lambda 950 with 150 mm integrating sphere. The surface gloss was measured at 26-28 GU at the setting angle of 60°.

Example 2.

- 5 A high Tg Plexiglas® V825-100 resin (Tg=114°C) made at Arkema was compounded with a core-shell impact modifier having a particle size of 250-300 nm, white R105 TiO₂ pigment from DuPont blended with VM grade acrylic polymer and Altuglas® BS130 matting agent (having a particle size of 20 µm, from Arkema, France) to form white acrylic resins using a 27 mm twin-screw extruder (from
- 10 Leistritz) at a die temperature of 250°C and a processing speed of 60 lbs/hour. UV stabilizer was also added into the formulation during the compounding. The compounded acrylic pellets were dried at 85°C overnight. The melt flow rate was measured at 1.4 g/ for 10 minutes under 3.8Kg at 230°C.

Formulation 2	Grams	%
Acrylic Polymer V825-100	2100	42.0
Core-Shell Impact Modifier	1400	28.0
BS130 Matting Agent	500	10.0
VM-100	450	9.0
R105 in conc.(TiO ₂ , 55% in VM)	550	11.0
Subtotal	5000	100
UV Package	113.25	2.545%
Stearic acid (0%)	2.00	0.045%
Tinuvin® 234	64.53	1.450%
Irganox® 1010	31.15	0.700%
Irgafos® 126	15.58	0.350%
Total (g)	5113.25	

- 15 A 20-mil white reflective layer of above formulation 2 was co-extruded over a 40-mil ABS (752 NAT from Ineos) substrate using a single manifold die with a B/B/A/A/A feed block (from Cloeren) at a temperature of 245°C. The width of the co-extruded white sheet sample was controlled at 11 inches. The chiller roll temperature was controlled at 80-90°C. The optical reflectance at 560 nm was measured at 96.0%

using Perkin Elmer Lambda 950 with 150 mm integrating sphere. The surface gloss was measured at 15-16 GU at a setting angle of 60°.

Example 3.

A high Tg Plexiglas® HT121 resin (Tg=124°C) (from Arkema) was compounded with a core-shell impact modifier having a particle size of 250-300 nm, white R105 TiO₂ pigment from DuPont blended with VM grade acrylic polymer and Paraloid® EXL 5136 matting agent (having a particle size of 8 µm, from Dow Chemical) to form a white acrylic resin composition using a 27 mm twin-screw extruder (from Leistritz) at a die temperature of 245°C and a processing speed of 60 lbs/hour. UV stabilizer was also added into the formulation during the compounding. The compounded acrylic pellets were dried at 85°C overnight. The melt flow rate was measured at 1.4 g/ for 10 minutes under 3.8Kg at 230°C.

Formulation 3	Grams	%
Acrylic Polymer HT121	2100	35.0
Core-Shell Impact Modifier	1400	23.3
EXL5136 Matting Agent	500	8.3
VM -100	900	15.0
R105 in conc.(TiO ₂ , 55% in VM)	1100	18.3
Subtotal	5500	100
UV Package	124.50	2.541%
Stearic acid	2.00	0.041%
Tinuvin® 234	71.05	1.450%
Irganox® 1010	34.30	0.700%
Irgafos® 126	17.15	0.350%
Total (g)	5624.50	

A 15-mil (380 µm) white reflective layer of above formulation 3 was co-extruded over 1) a 45-mil ABS (752 NAT from Ineos plus 4% of #63Z1526 grey ABS concentrate from Penn Color) and 2) a 45-mil impact acrylic polymer (Plexiglas® DR101 from Altuglas) substrate using a single manifold die with a B/B/A/A/A feed block (from Cloeren) at a temperature of 240-250°C. The melt flow rate of the Plexiglas® DR101 was measured at 1.0 g for 10 minutes under 3.8Kg at 230°C. The

width of the co-extruded white sheet sample was controlled at 11 inches. The chiller roll temperature was controlled at 80-90°C. The optical reflectance at 560 nm was measured at 97.1% from acrylic/grey ABS samples (vs. 97.0% from acrylic/DR101) using Perkin Elmer Lambda 950 with 150 mm integrating sphere. The surface gloss was measured at 28 GU at a setting angle of 60°. No light leakage was detected from the backside of the co-extruded sheets with a grey ABS.

Example 4.

A high Tg Plexiglas® HT121NA resin (Tg=124°C) made at Arkema was compounded with a core-shell impact modifier with a particle size of 250-300nm, white R105 TiO₂ pigment from DuPont blended with VM grade acrylic polymer and Altuglas® BS130 matting agent (having a particle size of 20 µm, from Arkema, France) to form a white acrylic resin composition using a 27 mm twin-screw extruder (from Leistritz) at the die temperature of 245 °C at a processing speed of 60 lbs/hour. UV stabilizer was also added into the formulation during the compounding. The compounded acrylic pellets were dried at 85°C overnight. The melt flow rate was measured at 1.2 g/ for 10 minutes under 3.8Kg at 230°C.

Formulation 4	Grams	%
Acrylic Polymer HT121	2100	42.0
Core-Shell Impact Modifier	1400	28.0
BS130 Matting Agent	500	10.0
VM-100	450	9.0
R105 in conc.(TiO ₂ , 55% in VM)	550	11.0
Subtotal	5000	100
UV Package	113.25	2.545%
Stearic acid	2.00	0.045%
Tinuvin® 234	64.53	1.450%
Irganox® 1010	31.15	0.700%
Irgafos® 126	15.58	0.350%
Total (g)	5113.25	

A 20-mil white reflective layer of above formulation 4 was co-extruded over a 40-mil ABS (752 NAT from Ineos plus 4% of #63Z1526 grey ABS concentrate from

Penn Color) substrate using a single manifold die with a B/B/A/A/A feed block (from Cloeren) at a temperature of 240-250°C. The width of the co-extruded white sheet sample was controlled at 11 inches. The chiller roll temperature was controlled at 80-90°C. The optical reflectance at 560 nm was measured at 96.0% using Perkin Elmer
 5 Lambda 950 with 150 mm integrating sphere. The surface gloss was measured at 16 GU at a setting angle of 60°. No light leakage was detected from the backside of the co-extruded sheets with a grey ABS.

Example 5.

High Tg Plexiglas[®] V825-100 resin (Tg=114°C) made at Arkema was
 10 compounded with core-shell impact modifier having a particle size of 250-300nm, white R105 TiO₂ pigment from DuPont blended with VM grade acrylic polymer and Altuglas[®] BS130 matting agent (having a particle size of 20 µm, from Arkema, France) to form a white acrylic resin composition using a 27 mm twin-screw extruder at a die temperature of 242°C and a processing speed of 60 lbs/hour. UV stabilizer
 15 was also added into the formulation during the compounding. The compounded acrylic pellets were dried at 90°C overnight. The melt flow rate was measured at 0.9 g/ for 10 minutes under 3.8Kg at 230°C.

Formulation 5	Grams	%
Acrylic Polymer V825-100	2100	48.3
Core-Shell Impact Modifier	1400	32.2
BS130 Matting Agent	450	10.3
VM -100	180	4.1
R105 in conc.(TiO ₂ , 55% in VM)	220	5.1
Subtotal	4350	100
UV Package	105.25	2.548%
Stearic acid	2.00	0.048%
Tinuvin [®] 234	59.89	1.450%
Irganox [®] 1010	28.91	0.700%
Irgafos [®] 126	14.46	0.350%
Total (g)	4455.25	

A 65-mil white reflective monolithic sheet of the above formulation 5 was extruded using a single manifold die with an A/A/A/A/A feed block (from Cloeren) at a temperature of 240-248°C. The width of the extruded white sheet sample was controlled at 11.5 inches. The chiller roll temperature was controlled at 80-90°C. The optical reflectance at 560 nm was measured at 95.8% using a Perkin Elmer Lambda 950 with 150 mm integrating sphere. The surface gloss was measured at 18 GU at a setting angle of 60°.

Example 6.

A high Tg Plexiglas® V825-100 resin (Tg=114°C) made at Arkema was compounded with a core-shell impact modifier having a particle size of 250-300nm, white R105 TiO₂ pigment from DuPont blended with VM grade acrylic polymer and Altuglas® BS130 matting agent (having a particle size of 20 µm, from Arkema, France) to form a white acrylic resin composition using a 27 mm twin-screw extruder (from Leistritz) at a die temperature of 242°C and a processing speed of 60 lbs/hour. UV stabilizer was also added into the formulation during the compounding. The compounded acrylic pellets were dried at 85°C overnight. The melt flow rate was measured at 0.95 g/ for 10 minutes under 3.8Kg at 230°C.

Formulation 6	Grams	%
Acrylic Polymer V825-100	2100	46.2
Core-Shell Impact Modifier	1400	30.8
BS130 Matting Agent	450	9.9
VM -100	270	5.9
R105 in conc.(TiO ₂ , 55% in VM)	330	7.3
Subtotal	4550	100
UV Package	107.50	2.547%
Stearic acid	2.00	0.047%
Tinuvin® 234	61.19	1.450%
Irganox® 1010	29.54	0.700%
Irgafos® 126	14.77	0.350%
Total (g)	4657.50	

A 6"x6" white reflective plaque of above formulation 6 was injection molded at a thickness of 0.060" under a pressure of 100T using Engel at a die temperature of 230-240°C. In addition to a bulk lighting scattering, a textured-surface mold (with MT-11000, Mold-Tech® from Roehlen Industries) is required. The surface gloss is controlled at 10 GU. The optical reflectance was measured at 97.6% at 560 nm from the plaque using a Perkin Elmer Lambda 950 with 150 mm integrating sphere.

Example 7.

High Tg Plexiglas® HT121 resin (Tg=124°C) made at Arkema was compounded with core-shell impact modifier having a particle size of 250-300nm, white R105 TiO₂ pigment from DuPont blended with VM grade acrylic polymer and Altuglas® BS130 matting agent (having a particle size of 20 µm, from Arkema, France) to form a white acrylic resin composition using a 27 mm twin-screw extruder at a die temperature of 245°C and a processing speed of 60 lbs/hour. UV stabilizer was also added into the formulation during the compounding. The compounded acrylic pellets were dried at 85°C overnight. The melt flow rate was measured at 0.8 g/ for 10 minutes under 3.8Kg at 230°C.

Formulation 7	Grams	%
Acrylic Polymer HT121	2100	47.2
Core-Shell Impact Modifier	1400	31.5
BS130 Matting Agent	450	10.1
VM -100	225	5.1
R105 TiO ₂ in conc.	275	6.2
Subtotal	4450	100
UV Package	106.38	2.548%
Stearic acid	2.00	0.048%
Tinuvin® 234	60.54	1.450%
Irganox® 1010	29.23	0.700%
Irgafos® 126	14.61	0.350%
Total (g)	4556.38	

A 6"x6" white reflective plaque of above formulation 7 was injection molded at a thickness of 0.060" under pressure of 100T using Engel at a die temperature of

235-248°C. A textured-surface mold (with MT-11020, Mold-Tech® from Roehlen Industries) is required. The surface gloss is controlled at 5 GU. The optical reflectance at 560 nm was measured at 97.3% from the plaque using a Perkin Elmer Lambda 950 with 150 mm integrating sphere.

5 Example 8.

High Tg Plexiglas® HT121 resin (Tg=124°C) made at Arkema was compounded with core-shell impact modifier having a particle size of 250-300nm, white R105 TiO₂ pigment from DuPont blended with VM grade acrylic polymer and Altuglas® BS110 matting agent (having a particle size of 50 µm, from Arkema, France) to form a white acrylic resin composition using a 27 mm twin-screw extruder at a die temperature of 240-250°C and a processing speed of 50 lbs/hour. UV stabilizer was also added into the formulation during the compounding. The compounded acrylic pellets were dried at 85°C overnight. The melt flow rate was measured at 1.2 g/ for 10 minutes under 3.8Kg at 230°C.

15

Formulation 8	Grams	%
Acrylic Polymer HT121	2100	45.7%
Core-Shell Impact Modifier	1400	30.4%
BS110 Matting Agent	400	8.7%
VM -100	315	6.8%
R105 in conc.(TiO ₂ , 55% in VM)	385	8.4%
Subtotal	4600	100%
UV Package	107.38	2.547%
Stearic acid	2.00	0.047%
Tinuvin® 234	61.12	1.450%
Irganox® 1010	29.51	0.700%
Irgafos® 126	14.75	0.350%
Total (g)	4707.38	

A 6"x6" white reflective plaque of above formulation 8 was injection molded at a thickness of 0.060" under pressure of 100T using Engel at a die temperature of 235-240°C. A textured-surface mold (with MT-11040, Mold-Tech® from Roehlen Industries) is required. The surface gloss is controlled at 4 GU. The optical

reflectance at 560 nm was measured at 97.9% from the plaque using a Perkin Elmer Lambda 950 with 150 mm integrating sphere.

Example 9.

- High Tg Plexiglas® HT121 resin (Tg=124°C) made at Arkema was compounded with core-shell impact modifier having a particle size of 250-300nm, white R105 TiO₂ pigment from DuPont blended with VM grade acrylic polymer to form a white acrylic resin composition using a 27 mm twin-screw extruder at a die temperature of 240-250°C and a processing speed of 50 lbs/hour. UV stabilizer was also added into the formulation during the compounding. The compounded acrylic pellets were dried at 85°C overnight. The melt flow rate was measured at 1.4 g/ for 10 minutes under 3.8Kg at 230°C.

Formulation 9	Grams	%
Acrylic Polymer HT121	2100	52.5%
Core-Shell Impact Modifier	1400	35.0%
VM -100	225	5.6%
R105 in conc.(TiO ₂ , 55% in VM)	275	6.9%
Subtotal	4000	100%
UV Package	95.13	2.554%
Stearic acid	2.00	0.054%
Tinuvin® 234	54.01	1.450%
Irganox® 1010	26.08	0.700%
Irgafos® 126	13.04	0.350%
Total (g)	4095.13	

- A 6"x6" white reflective plaque of above formulation 9 was injection molded at a thickness of 0.060" under pressure of 100T using Engel at a die temperature of 235-240°C. A textured-surface mold (with MT-11010, Mold-Tech® from Roehlen Industries) is required. The surface gloss is controlled at 6 GU. The optical reflectance at 560 nm was measured at 98.0% from the plaque using a Perkin Elmer Lambda 950 with 150 mm integrating sphere.

Example 10.

High Tg Plexiglas® HT121NA resin (Tg=124°C) made at Arkema was compounded with core-shell impact modifier having a particle size of 250-300nm, white R103 TiO₂ pigment from DuPont blended with VM grade acrylic polymer and
 5 Altuglas® BS110 matting agent (having a particle size of 50 µm, from Arkema, France) to form a white acrylic resin composition using a 27 mm twin-screw extruder at a die temperature of 245°C and a processing speed of 50 lbs/hour. UV stabilizer was also added into the formulation during the compounding. The compounded acrylic pellets were dried at 85°C overnight. The melt flow rate was measured at 1.2
 10 g/ for 10 minutes under 3.8Kg at 230°C.

Formulation 10	Grams	%
Acrylic Polymer HT121	2100	42.0%
Core-Shell Impact Modifier	1400	28.0%
BS110 Matting Agent	500	10.0%
VM -100	450	9.0%
R103 TiO ₂	550	11.0%
Subtotal	5000	100%
UV Package	113.25	2.545%
Stearic acid	2.00	0.045%
Tinuvin® 234	64.53	1.450%
Irganox® 1010	31.15	0.700%
Irgafos® 126	15.58	0.350%
Total (g)	5113.25	

A 14/12-mil thick white reflective layer of the above formulation 10 was co-extruded on top of a 34-mil ABS substrate on both sides to form a A/B/A structured sheet using a a single manifold die with a B/A/A/A/C feed block (from Cloeren) at a
 15 temperature of 240-250°C. The melt flow rate of ABS (752 NAT from Ineos) was measured at 0.72 g/ for 10 minutes under 3.8Kg at 230C. The width of the co-extruded white sheet sample was controlled at 11.5 inches. The chiller roll temperature was controlled at 80-90°C. The optical reflectance was measured at 95% at 560 nm from the acrylic/ABS/acrylic sheet (at the thickness of 14/34/12mils) using

a Perkin Elmer Lambda 950 with 150 mm integrating sphere. The surface gloss was measured at 16-19 GU at the setting angle of 60°.

Example 11 (monolithic/BS110).

- High Tg Plexiglas[®] HT121 resin (Tg=124°C) made at Arkema was compounded with core-shell impact modifier having a particle size of 250-300nm, white R105 TiO₂ pigment from DuPont blended with VM grade acrylic polymer and Altuglas[®] BS110 matting agent (having a particle size of 50 µm, from Arkema, France) to form a white acrylic resin composition using a 27 mm twin-screw extruder at a die temperature of 242°C and a processing speed of 60 lbs/hour. UV stabilizer was also added into the formulation during the compounding. The compounded acrylic pellets were dried at 90°C overnight. The melt flow rate was measured at 0.9 g/ for 10 minutes under 3.8Kg at 230°C.

Formulation 11	Grams	%
Acrylic Polymer HT121	2100	45.7%
Core-Shell Impact Modifier	1400	30.4%
BS110 Matting Agent	600	13.0%
VM -100	225	4.9%
R105 in conc.(TiO ₂ , 55% in VM)	275	6.0%
Subtotal	4600	100%
UV Package	54.73	1.265%
Stearic acid	0.99	0.023%
Tinuvin [®] 234	31.17	0.721%
Irganox [®] 1010	15.05	0.348%
Irgafos [®] 126	7.52	0.174%
Total (g)	4654.73	

- A 65-mil white reflective monolithic sheet of the above formulation 11 was extruded using a single manifold die with an A/A/A/A/A feed block (from Cloeren) at a temperature of 240-248°C. The width of the extruded white sheet sample was controlled at 11.5 inches. The chiller roll temperature was controlled at 90°C. The optical reflectance at 560 nm was measured at 95.7% using a Perkin Elmer Lambda

950 with 150 mm integrating sphere. The surface gloss was measured at 11-13 GU at a setting angle of 60°.

Example 12 (high reflective/low gloss formulation/grey ABS)

A high Tg Plexiglas® HT121 resin (Tg=124°C) (from Arkema) was
 5 compounded with a core-shell impact modifier having a particle size of 250-300 nm, white R105 TiO₂ pigment from DuPont blended with VM-100 grade acrylic polymer and and Altuglas® BS130 matting agent (having a particle size of 20 µm, from Arkema, France) to form a white acrylic resin composition using a 27 mm twin-screw extruder (from Leistritz) at a die temperature of 245°C and a processing speed of 60
 10 lbs/hour. UV stabilizer was also added into the formulation during the compounding. The compounded acrylic pellets were dried at 90°C overnight. The melt flow rate was measured at 0.5 g/ for 10 minutes under 3.8Kg at 230°C.

Formulation 12	Grams	%
Acrylic Polymer HT121	2070	36.8%
Core-Shell Impact Modifier	1200	21.3%
BS130 Matting Agent	800	14.2%
VM-100	225	4.0%
R105 TiO ₂	1330	23.6%
Subtotal	5625	100%
UV Package	44.27	1.04%
Stearic acid	0	0.00%
Tinuvin® 234	25.65	0.60%
Irganox® 1010	12.35	0.29%
Irgafos® 168	6.27	0.15%
Total (g)	5672.27	

A 20-mil white reflective layer of above formulation 12 was co-extruded over
 15 a 40-mil ABS (752 NAT from Ineos plus 4% of #63Z1526 grey ABS concentrate from Penn Color) substrate using a single manifold die with a B/B/A/A/A feedblock (from Cloeren) at a temperature of 235-248°C. The width of the co-extruded white sheet sample was controlled at 11 inches. The chiller roll temperature was controlled at 90°C. The optical reflectance at 560 nm was measured at 97.4% from acrylic/grey

ABS samples using Perkin Elmer Lambda 950 with 150 mm integrating sphere. The surface gloss was measured at 8 GU at a setting angle of 60°. No light leakage was detected from the backside of the co-extruded sheets with a grey ABS.

Example 13 (high reflective/low gloss formulation/grey ABS plus film)

- 5 A high Tg Plexiglas® HT121 resin (Tg=124°C) (from Arkema) was compounded with a core-shell impact modifier having a particle size of 250-300 nm, white R105 TiO₂ pigment from DuPont blended with VS-100 grade acrylic polymer and Altuglas® BS130 matting agent (having a particle size of 20 µm, from Arkema, France) to form a white acrylic resin composition using a 27 mm twin-screw
10 extruder (from Leistritz) at a die temperature of 245°C and a processing speed of 60 lbs/hour. UV stabilizer was also added into the formulation during the compounding. The compounded acrylic pellets were dried at 85°C overnight. The melt flow rate was measured at 0.6 g/ for 10 minutes under 3.8Kg at 230°C.

Formulation 13	Grams	%
Acrylic Polymer HT121	1450	37.7
Core-Shell Impact Modifier	800	20.8
BS130 Matting Agent	550	14.3
VS-100	150	3.9
R105 TiO ₂	900	23.3
Subtotal	3850	100
UV Package	42.94	1.45%
Stearic acid	1	0.03%
Tinuvin® 234	24.3	0.82%
Irganox® 1010	11.7	0.40%
Irgafos® 168	5.94	0.20%
Total (g)	3892.94	

- 15 A 15-mil (380 µm) white reflective layer of above formulation 13 was co-extruded over a 45-mil ABS (752 NAT from Ineos plus 4% of #63Z1526 grey ABS concentrate from Penn Color) substrate using a single manifold die with a B/B/A/A/A feedblock (from Cloeren) at a temperature of 235-248°C. The width of the co-extruded white sheet sample was controlled at 11 inches. The chiller roll temperature

was controlled at 90°C. The optical reflectance at 560 nm was measured at 97.5% from acrylic/grey ABS samples using Perkin Elmer Lambda 950 with 150 mm integrating sphere (vs. 97.0% at 560 nm from a co-extruded acrylic/grey ABS film at the thickness of 250um/250um). The surface gloss was measured at 5-8 GU at a setting angle of 60°. No light leakage was detected from the backside of the co-extruded sheets with a grey ABS.

Example 14 (high reflective/high gloss formulation/grey ABS plus film)

A high Tg Plexiglas® HT121 resin (Tg=124°C) (from Arkema) was compounded with a core-shell impact modifier having a particle size of 250-300 nm, white R105 TiO₂ pigment from DuPont blended with VM-100 grade acrylic polymer to form a white acrylic resin composition using a 27 mm twin-screw extruder (from Leistritz) at a die temperature of 245°C and a processing speed of 60 lbs/hour. UV stabilizer was also added into the formulation during the compounding. The compounded acrylic pellets were dried at 85°C overnight. The melt flow rate was measured at 1.3 g/ for 10 minutes under 3.8Kg at 230°C.

Formulation 14	Grams	%
Acrylic Polymer HT121	3406.5	50.8%
Core-Shell Impact Modifier	1500	22.4%
VM-100	200	3.0%
R105 TiO ₂	1593.5	23.8%
Subtotal	6700	100%
UV Package	76.5	1.50%
Stearic acid	1.5	0.03%
Tinuvin® 234	43.5	0.85%
Irganox® 1010	21.0	0.41%
Irgafos® 168	10.5	0.21%
Total (g)	6776.5	

A 15-mil (380 µm) white reflective layer of above formulation 14 was co-extruded over a 45-mil ABS (752 NAT from Ineos plus 4% of #63Z1526 grey ABS concentrate from Penn Color) substrate using a single manifold die with a B/B/A/A/A feedblock (from Cloeren) at a temperature of 235-248°C. The width of the co-

extruded white sheet sample was controlled at 11 inches. The chiller roll temperature was controlled at 90°C. The optical reflectance at 560 nm was measured at 98.0% from acrylic/grey ABS samples using Perkin Elmer Lambda 950 with 150 mm integrating sphere (vs. 97.5% at 560 nm from a co-extruded acrylic/grey ABS film at the thickness of 250um/200um). The surface gloss was measured at 86-87 GU at a setting angle of 60°. No light leakage was detected from the backside of the co-extruded sheets with a grey ABS.

Example 15 (injection molding or monolithic/BaSO₄ BF formulation)

A high Tg Plexiglas® HT121 resin (Tg=124°C) (from Arkema) was compounded with a core-shell impact modifier having a particle size of 250-300 nm, white R105 TiO₂ pigment from DuPont blended with VS-100 grade acrylic polymer and and Cimbar® BF grade BaSO₄ (having a particle size of 0.8 µm, from Cimbar, US) to form a white acrylic resin composition using a 27 mm twin-screw extruder (from Leistritz) at a die temperature of 245°C and a processing speed of 50 lbs/hour. UV stabilizer was also added into the formulation during the compounding. The compounded acrylic pellets were dried at 85°C overnight. The melt flow rate was measured at 0.9 g/ for 10 minutes under 3.8Kg at 230°C.

Formulation 15	Grams	%
Acrylic Polymer HT121	2000	45.5%
Core-Shell Impact Modifier	1400	31.8%
BaSO ₄ BF grade (0.8um)	350	8.0%
VS-100	195	4.4%
R105 TiO ₂	455	10.3%
Subtotal	4400	100%
UV Package	45.92	1.28%
Stearic acid	1.0	0.03%
Tinuvin® 234	26.95	0.75%
Irganox® 1010	11.23	0.31%
Irgafos® 168	6.74	0.19%
Total (g)	4445.92	

- A 2"x 3" white reflective plaque of above formulation 15 was injection molded at a thickness of 0.125" under pressure of 100T using Engel at a die temperature of 230-240°C. The surface gloss is measured at 86 GU at a setting angle of 60°. The optical reflectance at 560 nm was measured at 98.2% from the plaque using a Perkin Elmer Lambda 950 with 150 mm integrating sphere.

The melt flow rate (index) of the compounded acrylic polymers was measured with a die of 2.0955 mm in diameter and 8.000 mm in length under 3.8Kg at 230°C using Tinus Olsen Model MP933.

- The representative parameters for injection molding using 100T Engel to prepare the 6"x6" plaques were as follows:

Feed temperature (°F)	460
Transition temperature (°F)	470
Metering temperature (°F)	480
Nozzle temperature (°F)	450
Mold temperature (°F)	165
Boost pressure (psi)	1400
Back pressure (psi)	100-120
Injection speed (in/second)	1.0

The optical reflectance of the optical reflection films was measured in a reflection mode using a Perkin Elmer Lambda 950 with a 150 mm integrating sphere. The instrument was calibrated with a certified reflectance standard (Spectralon with R%=99%).

- The surface gloss of the optical reflection films was measured at a measuring angle of 60 degrees using a BYK Spectro-Guide or a BYK Micro-Tri-Gloss Meter (20, 60 and 85 degrees).

What is claimed is:

1. A film or sheet or profile suitable for use as an optical reflector, comprising a layer of a melt-processable acrylic resin composition comprised of an acrylic polymer and a white pigment.
2. The film or sheet or profile of claim 1, additionally comprising a substrate layer comprised of a thermoplastic polymer, wherein the layer of melt-processable acrylic resin composition is coated on at least one side of the substrate layer.
3. The film or sheet or profile of claim 1, wherein the melt-processable acrylic resin composition is additionally comprised of a matting or diffusion agent.
4. The film or sheet or profile of claim 1, wherein the melt-processable acrylic resin composition is additionally comprised of a matting or diffusion agent selected from the group consisting of barium sulfate particles, aluminum oxide particles, silicon oxide particles, hollow particles, organic particles, and fluoropolymers.
5. The film or sheet or profile of claim 1, wherein the melt-processable acrylic resin composition is additionally comprised of up to 30 weight % of matting or diffusion agent.
6. The film or sheet or profile of claim 1, wherein the white pigment is selected from the group consisting of titanium dioxide, zinc oxide, PdS and barium sulfate.
7. The film or sheet or profile of claim 1, wherein the white pigment comprises from 1 to 60 weight % of the melt-processable acrylic resin composition.
8. The film or sheet or profile of claim 2, wherein a first layer of melt-processable acrylic resin composition is present on a first side of the substrate

layer and a second layer of melt-processable acrylic resin composition is present on a second side of the substrate layer, with the first layer of melt-processable acrylic resin composition and the second layer of melt-processable acrylic resin composition being the same as or different from each other.

9. The film or sheet or profile of claim 1, wherein the acrylic polymer is impact modified.
10. The film or sheet or profile of claim 1, wherein the acrylic polymer has a T_g of at least 80°C.
11. The film or sheet or profile of claim 1, wherein the acrylic polymer contains acid functional groups.
12. The film or sheet or profile of claim 2, wherein the substrate layer has a thickness of from 100 to 3000 μm.
13. The film or sheet or profile of claim 2, wherein the substrate layer and melt-processable acrylic resin composition are co-extruded.
14. The film or sheet or profile of claim 2, wherein the layer of melt-processable acrylic resin composition has a thickness of 100 to 1000 μm.
15. The film or sheet or profile of claim 2, wherein the substrate layer is comprised of a thermoplastic polymer selected from the group consisting of acrylics, ABS, ASA, SAN, PET, PEN, PET-co-PEN, PET-co-PETG, PC and PC/ABS blends.
16. The film or sheet or profile of claim 1, wherein the melt-processable acrylic resin composition is additionally comprised of a core-shell impact modifier.
17. The film or sheet or profile of claim 2, wherein the substrate layer is clear and a layer of melt-processable acrylic resin composition is present on both sides of the substrate layer.

18. The film or sheet or profile of claim 1, wherein the melt-processable acrylic resin composition is additionally comprised of one or more additives selected from the group consisting of UV stabilizers, antioxidants, and processing additives.
19. The film or sheet or profile of claim 1, wherein the film or sheet is monolithic.
20. The film or sheet or profile of claim 1, wherein the melt-processable acrylic resin composition has a melt flow rate of at least 0.4 grams for 10 minutes under 3.8Kg at 230°C.
21. A method of making a film or sheet or profile in accordance with claim 2, comprising extruding a layer of the melt-processable acrylic resin composition onto at least one side of a substrate film layer comprised of a thermoplastic polymer.
22. A method of making a film or sheet or profile in accordance with claim 2, comprising co-extruding the melt-processable acrylic resin composition and a composition comprised of the thermoplastic polymer.
23. A method of making a film or sheet or profile in accordance with claim 1, comprising extruding or injection molding the melt-processable acrylic resin composition to form a monolithic film or sheet.
24. An LED lighting unit in an LCD display back lighting, general lighting and automotive lighting comprising, as an optical reflector, a film or sheet or profile in accordance with claim 1.
25. A lighting device comprised of a light emitting diode, an organic light emitting diode or a CCFL, and a film or sheet or profile in accordance with claim 1.

INTERNATIONAL SEARCH REPORT

international application No.

PCT/US13/50589

A. CLASSIFICATION OF SUBJECT MATTER

IPC(8) - F21V 7/22; G02B 5/08; B29D 11/00 (2013.01)

USPC - 362/296.02, 615; 525/80

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)

IPC(8) - G02B 5/08; B29D 11/00; B29B 13/02; B29C 51/42; F21V 7/22; B32B 27/06 (2013.01)

USPC - 359/838; 362/296.01, 296.02, 296.1, 615, 627; 428/339; 525/78, 80

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)

MicroPatent (US-G, US-A, EP-A, EP-B, WO, JP-bib, DE-C,B, DE-A, DE-T, DE-U, GB-A, FR-A); Google; Google Scholar; ProQuest Dialog; American Chemical Society Publications; Acrylic, reflect, pigment, white, mirror, film, sheet, applied, scatterer, Jiaxin Jason Ge, Mark Aubart, 3M, Fuji, backlight

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	WO 2010/101811 A1 (GE, JJ et al.) September 10, 2010; abstract; page 1, lines 4-5, 11-13, 22-23; page 2, lines 21-22; page 2, line 32 to page 3, line 1; page 3, lines 26-32; page 5, line 28 to page 6, line 2; page 7, lines 25-28; page 8, lines 12-13; page 8 line 21 to page 9, line 8, lines 15-20; page 10, lines 7-12; page 11, lines 20-24; page 12, lines 11-21; page 14, lines 17-33; page 15, lines 4-10, 17-19, 23-25; page 16, lines 15-16; page 18, lines 4-8, 14-16; page 19, lines 6-8, 18-19; page 20, lines 2-4, 17-18, page 21, lines 3-9	1-12, 14-21, 23
X	US 2008/0080055 A1 (LIGHTFOOT, EJ et al.) April 3, 2008; abstract; paragraphs [0002], [0036], [0039], [0066], [0074], [0077], [0088], [0090], [0094], [0095], [0120]; claims 9, 10	1-2, 13, 22, 24-25
A	US 2011/0038140 A1 (MA, J et al.) February 17, 2011; abstract; paragraphs [0003], [0006], [0022], [0023], [0039], [0055], [0056], [0064], [0065], [0068]-[0072]; claim 2	1-25
A	US 2011/0242818 A1 (ARITA, M et al.) October 6, 2011; entire document	1-25
A	US 6607794 B1 (WILSON, JC et al.) August 19, 2003; entire document	1-25
A	US 2005/0030630 A1 (OHNISHI, A et al.) February 10, 2005; entire document	1-25

☐ Further documents are listed in the continuation of Box C.

* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance

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"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

10-December 2013 (10.12.2013)

Date of mailing of the international search report

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Name and mailing address of the ISA/US

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