



(22) **Date de dépôt/Filing Date:** 2012/04/20

(41) **Mise à la disp. pub./Open to Public Insp.:** 2012/10/27

(45) **Date de délivrance/Issue Date:** 2015/02/24

(30) **Priorité/Priority:** 2011/04/27 (US13/095,784)

(51) **Cl.Int./Int.Cl.** **C09D 11/38** (2014.01),
B41J 2/01 (2006.01), **C09D 11/34** (2014.01)

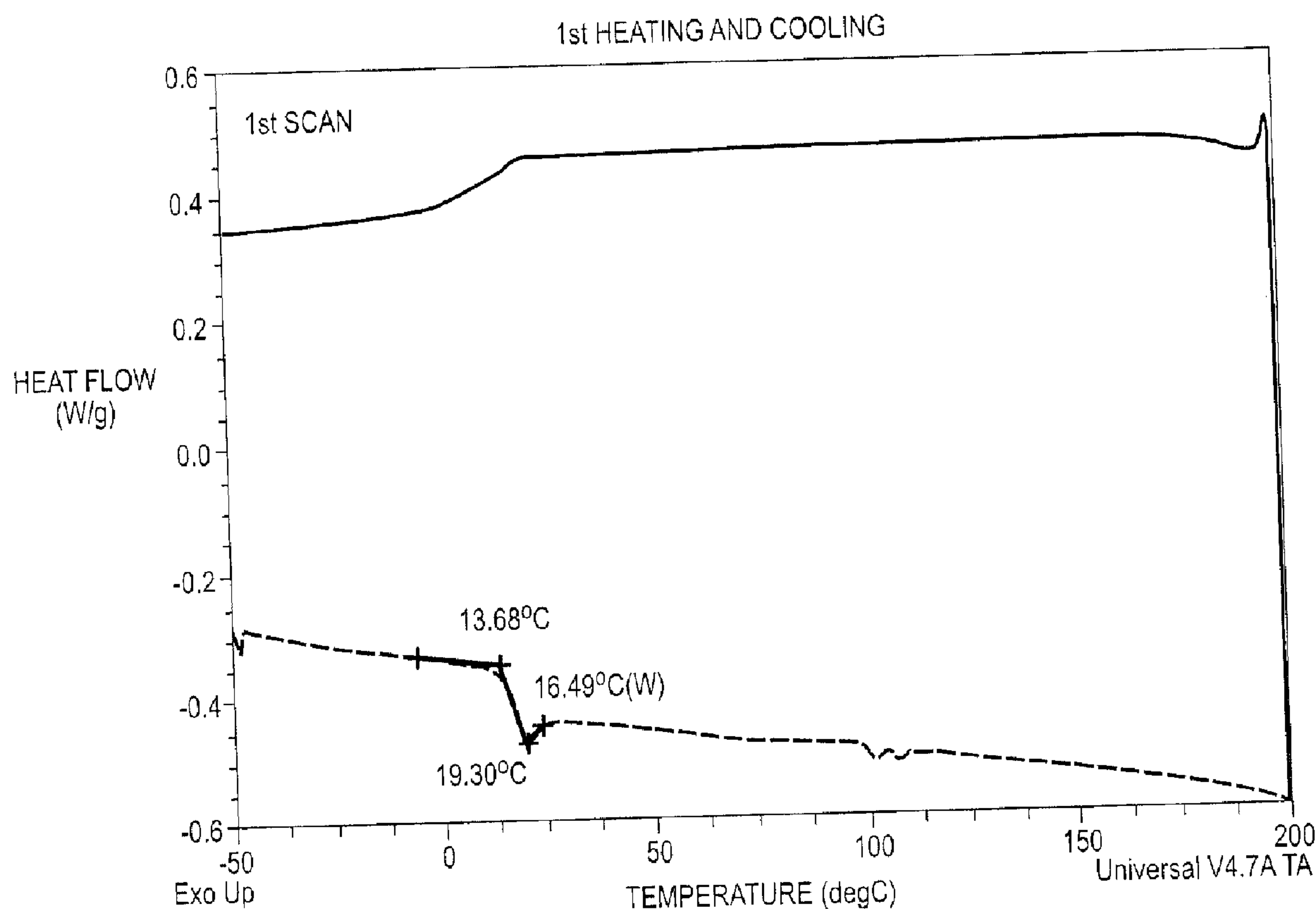
(72) **Inventeurs/Inventors:**
MORIMITSU, KENTARO, CA;
BELELIE, JENNIFER L., CA;
CHOPRA, NAVEEN, CA;
DRAPPEL, STEPHAN V., CA;
TRACY, COREY L., CA;
ODELL, PETER G., CA

(73) **Propriétaire/Owner:**
XEROX CORPORATION, US

(74) **Agent:** SIM & MCBURNEY

(54) **Titre : COMPOSITIONS D'ENCRE SOLIDES COMPRENANT DES ESTERS AMORPHES DE L'ACIDE TARTRIQUE**

(54) **Title: SOLID INK COMPOSITIONS COMPRISING AMORPHOUS ESTERS OF TARTARIC ACID**



(57) **Abrégé/Abstract:**

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

ABSTRACT

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

SOLID INK COMPOSITIONS COMPRISING AMORPHOUS ESTERS OF TARTARIC ACID

CROSS REFERENCE TO RELATED APPLICATIONS

[0001] Reference is made to commonly owned and co-pending, U.S. Patent Application Serial No. 13/095636 entitled "Solid Ink Compositions Comprising Crystalline-Amorphous Mixtures" to Jennifer Belelie et al; U.S. Patent Application Serial No. 13/095715 entitled "Solid Ink Compositions Comprising Crystalline Esters of Tartaric Acid" to Kentaro Morimitsu et al.; U.S. Patent Application Serial No. 13/095770 entitled "Phase Change Inks and Methods of Making the Same" to Kentaro Morimitsu et al.; U.S. Patent Application Serial No. 13/095591 entitled "Phase Change Ink Components and Methods of Making the Same" to Jennifer Belelie et al.; U.S. Patent Application Serial No. 13/095555 entitled "Phase Change Inks and Methods of Making the Same" to Naveen Chopra et al.; U.S. Patent Application Serial No. 13/095681 entitled "Solid Ink Compositions Comprising Crystalline-Amorphous Mixtures" to Jennifer Belelie et al.; and U.S. Patent No. 8287632 entitled "Solid Ink Compositions Comprising Amorphous Esters of Citric Acid" to Kentaro Morimitsu et al.; U.S. Patent Application Serial No. 13/095038 entitled "Print Process for Phase Separation Ink" to Paul McConville et al.; U.S. Patent Application Serial No. 13/095015 entitled "Solventless Reaction Process" to Thomas Edward Enright et al.; U.S. Patent Application Serial No. 13/095028 entitled "Phase Change Ink" to Kentaro Morimitsu et al.; U.S. Patent Application Serial No. 13/095174 entitled "Next-Generation Solid Inks From Novel Oxazoline Compnents, Developed for Robust Direct-to-Paper Printing" to Rina Carlini et al.; U.S. Patent Application Serial No. 13/095221 entitled "Novel Components for a Next-Generation Robust Solid Ink" to Rina Carlini et al.; and U.S. Patent Application Serial No. 13/095043 entitled "Phase Separation Ink" to Peter G. Odell et al.

BACKGROUND

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

[0003] Ink jet printing processes may employ inks that are solid at room temperature and liquid at elevated temperatures. Such inks may be referred to as solid inks, hot melt inks, phase change inks and the like. For example, U.S. Pat. No. 4,490,731, discloses an apparatus for dispensing solid ink for printing on a recording medium such as paper. In thermal ink jet printing processes employing hot melt inks, the solid ink is melted by the heater in the printing

apparatus and utilized (jetted) as a liquid in a manner similar to that of conventional thermal ink jet printing. Upon contact with the printing recording medium, the molten ink solidifies rapidly, enabling the colorant to substantially remain on the surface of the recording medium instead of being carried into the recording medium (for example, paper) by capillary action, thereby enabling higher print density than is generally obtained with liquid inks. Advantages of a phase change ink in ink jet printing are thus elimination of potential spillage of the ink during handling, a wide range of print density and quality, minimal paper cockle or distortion, and enablement of indefinite periods of nonprinting without the danger of nozzle clogging, even without capping the nozzles.

[0004] In general, phase change inks (sometimes referred to as “hot melt inks”) are in the solid phase at ambient temperature, but exist in the liquid phase at the elevated operating temperature of an ink jet printing device. At the jetting temperature, droplets of liquid ink are ejected from the printing device and, when the ink droplets contact the surface of the recording medium, either directly or via an intermediate heated transfer belt or drum, they quickly solidify to form a predetermined pattern of solidified ink drops.

[0005] Phase change inks for color printing typically comprise a phase change ink carrier composition which is combined with a phase change ink compatible colorant. In a specific embodiment, a series of colored phase change inks can be formed by combining ink carrier compositions with compatible subtractive primary colorants. The subtractive primary colored phase change inks can comprise four component dyes or pigments, namely, cyan, magenta, yellow and black, although the inks are not limited to these four colors. These subtractive primary colored inks can be formed by using a single dye or pigment or a mixture of dyes or pigments. For example, magenta can be obtained by using a mixture of Solvent Red Dyes or a composite black can be obtained by mixing several dyes. U.S. Pat. No. 4,889,560, U.S. Pat. No. 4,889,761, and U.S. Pat. No. 5,372,852, teach that the subtractive primary colorants employed can comprise dyes from the classes of Color Index (C.I.) Solvent Dyes, Disperse Dyes, modified Acid and Direct Dyes, and Basic Dyes. The colorants can also include

pigments, as disclosed in, for example, U.S. Pat. No. 5,221,335. U.S. Pat. No. 5,621,022, discloses the use of a specific class of polymeric dyes in phase change ink compositions.

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

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

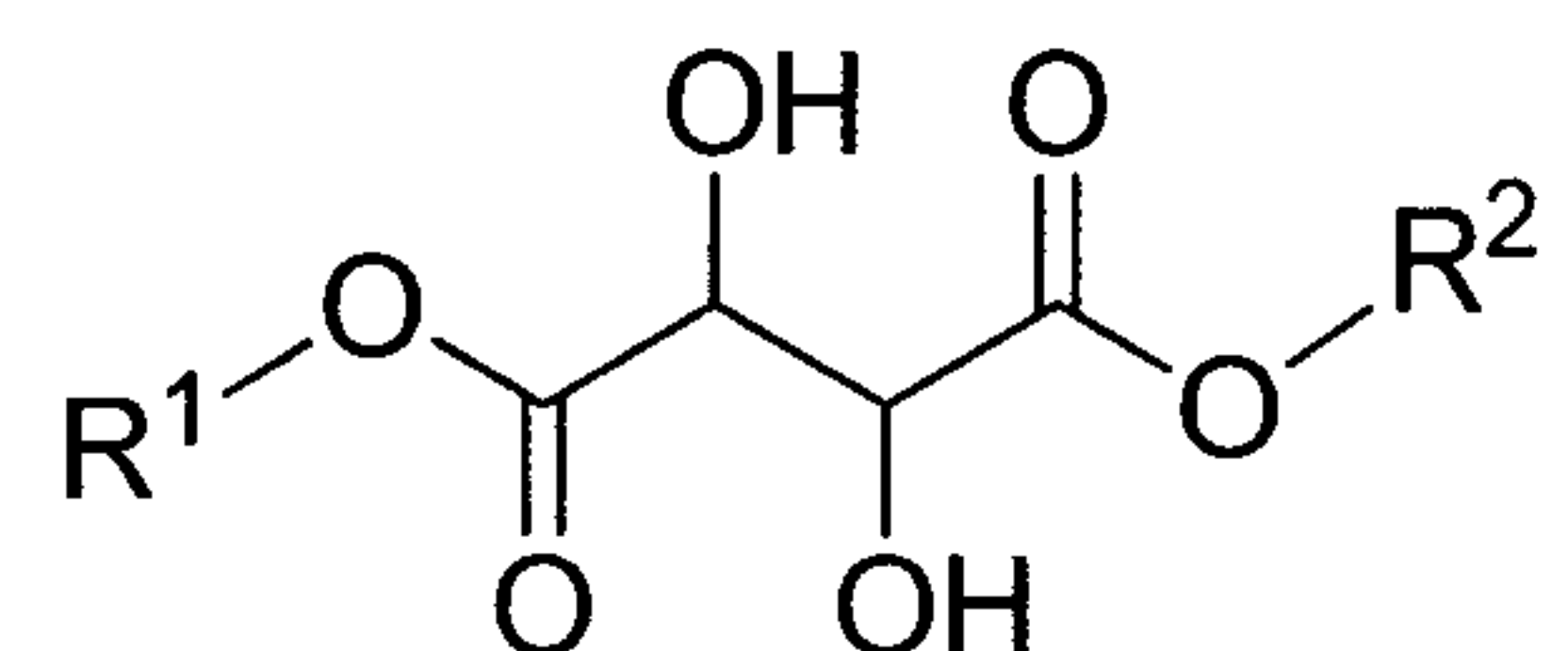
[0008]

SUMMARY

[0009] According to embodiments illustrated herein, there is provided novel solid ink compositions comprising both crystalline and amorphous components synthesized from tartaric acid suitable for ink jet printing,

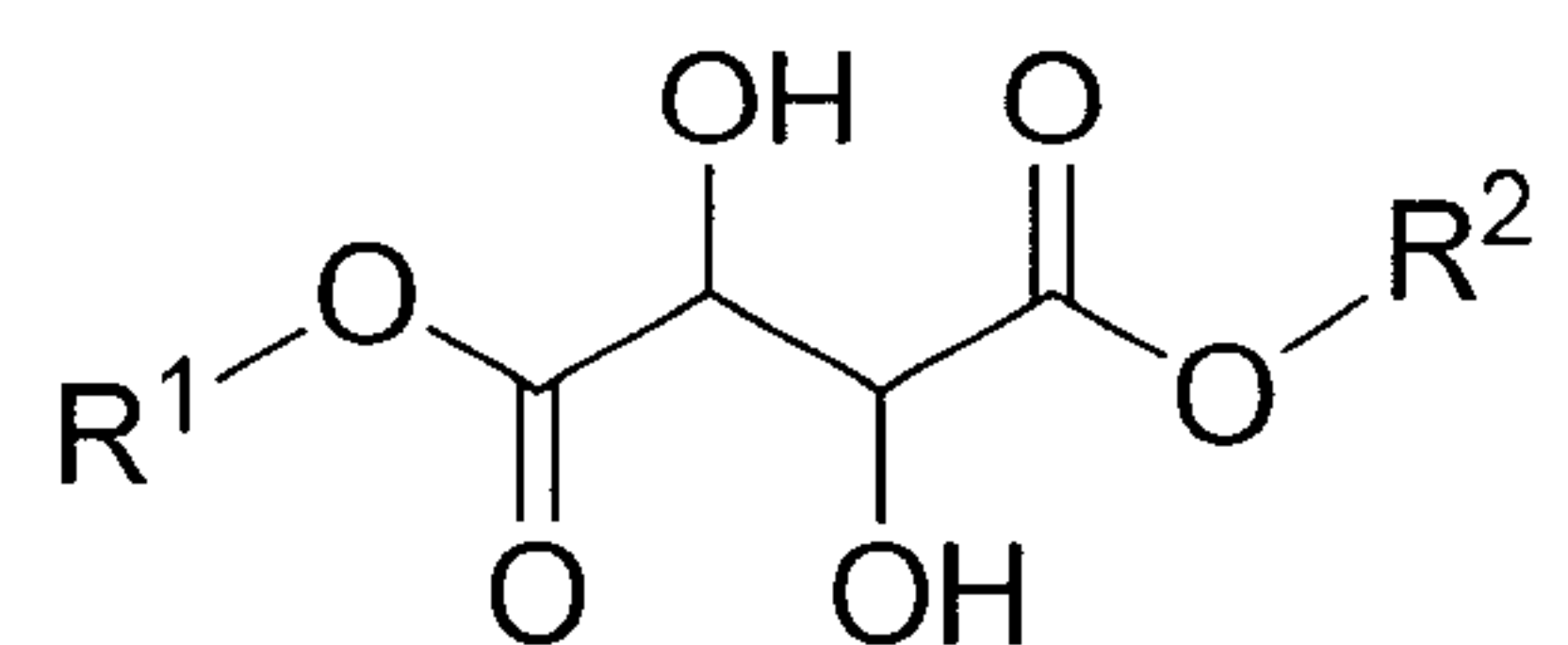
including printing on coated paper substrates. The crystalline and amorphous components can be both synthesized as esters of tartaric acid. However, the crystalline and amorphous components are synthesized from different ester reagents to achieve resulting products that are either crystalline or amorphous.

[0010] According to an aspect of the present invention there is provided, a phase change ink comprising: a crystalline component; and an amorphous component being an ester of tartaric acid and having a formula of



wherein R^1 and R^2 each, independently of the other or meaning that they can be the same or different, is selected from the group consisting of alkyl group, wherein the alkyl portion can be straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to 40 carbon atoms, or an substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof, and further wherein the tartaric acid backbone is selected from L-(+)-tartaric acid, D-(-)-tartaric acid, DL-tartaric acid, mesotartaric acid, and mixtures thereof.

[0011] According to a further aspect, there is provided a phase change ink comprising: a crystalline component; and an amorphous component being an ester of tartaric acid, wherein the crystalline component and the amorphous component each have the following structure:



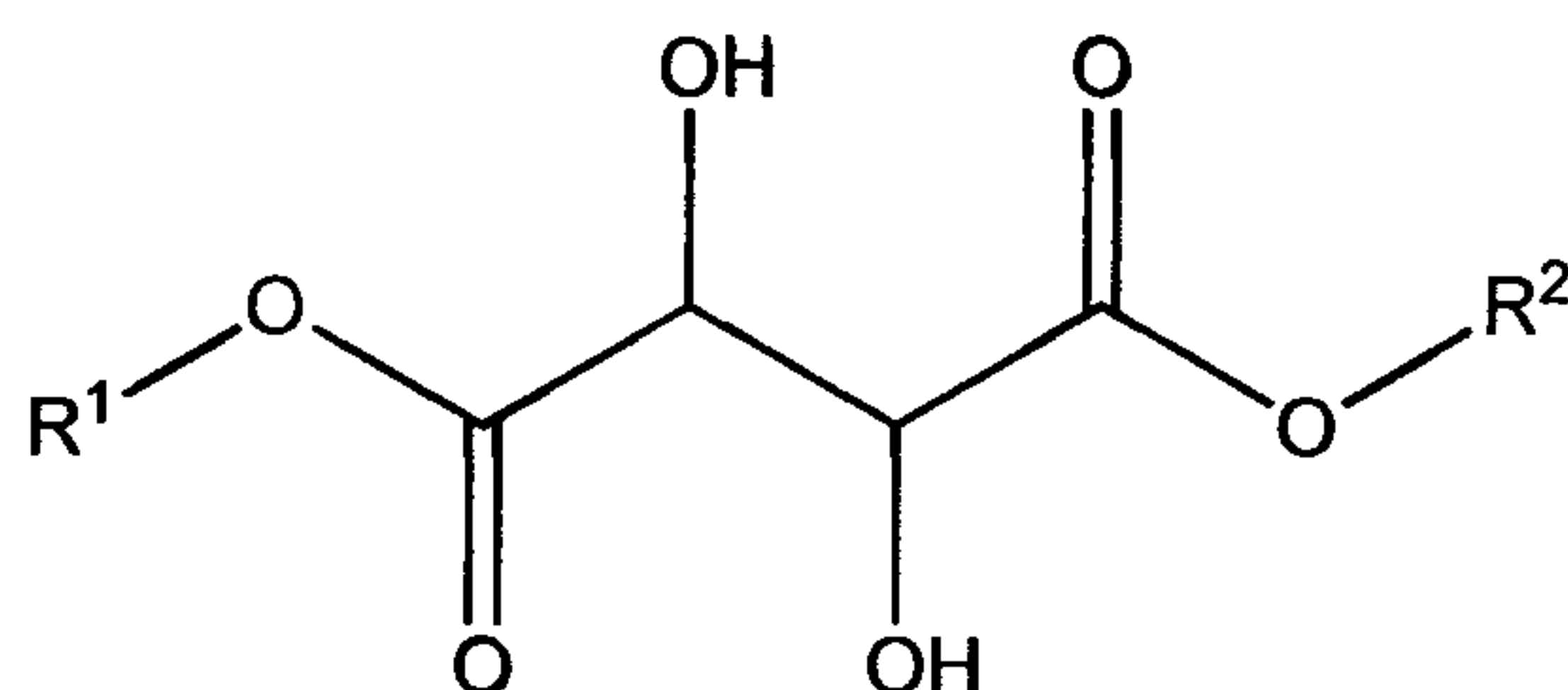
wherein R^1 and R^2 each, independently of the other or meaning that they can be the same or different, is selected from the group consisting of alkyl group, wherein the alkyl portion can be straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to 40 carbon atoms, or an substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof, and further wherein the tartaric acid backbone is selected from L-(+)-tartaric acid, D-(-)-tartaric acid, DL-tartaric acid, or

mesotartaric acid, and mixtures thereof, and wherein the crystalline and amorphous components are blended in a weight ratio of from about 1.5 to about 20.

[0011a] According to an aspect, there is provided a phase change ink comprising:

at least an amorphous component; and

at least a crystalline component, wherein the crystalline component is an ester of tartaric acid having a formula of



wherein R¹ and R² each, independently of the other, is selected from the group consisting of alkyl group, wherein the alkyl portion can be straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to 40 carbon atoms, or an substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof, and further wherein the tartaric acid backbone is selected from L-(+)-tartaric acid, D-(-)-tartaric acid, DL-tartaric acid, or mesotartaric acid, and mixtures thereof.

[0011b] According to another aspect, there is provided a phase change ink comprising:

an amorphous component; and

a crystalline component, wherein the crystalline component is an ester of tartaric acid synthesized by an esterification reaction with at least one alcohol.

[0012] In further aspects, there is provided a phase change ink comprising: a crystalline component; and an amorphous component, wherein the amorphous component is an ester of tartaric acid and is synthesized by an esterification reaction with at least one alcohol.

BRIEF DESCRIPTION OF THE DRAWINGS

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

[0014] Figure 1 is differential scanning calorimetry (DSC) data of di-L-menthyl DL-tartrate (DMT) confirming amorphous properties according to the present embodiments (the DSC data was obtained on a Q1000 Differential Scanning Calorimeter (TA Instruments) at a rate of 10°C/min from -50 to 200 to -50°C);

[0015] Figure 2 is a graph illustrating rheology data of DMT according to the present embodiments (all of the rheology measurements were made on a RFS3 controlled strain Rheometer (TA instruments) equipped with a Peltier heating plate and using a 25 mm parallel plate; the method used was a temperature sweep from high to low temperatures, in temperature decrements of 5 °C, a soak (equilibration) time of 120 seconds between each temperature and at a constant frequency of 1 Hz);

[0016] Figure 3 is DSC data of an ink sample comprising diphenethyl L-tartrate/DMT according to the present embodiments; and

[0017] Figure 4 is a graph illustrating rheology data of the ink samples comprising diphenethyl L-tartrate/DMT according to the present embodiments.

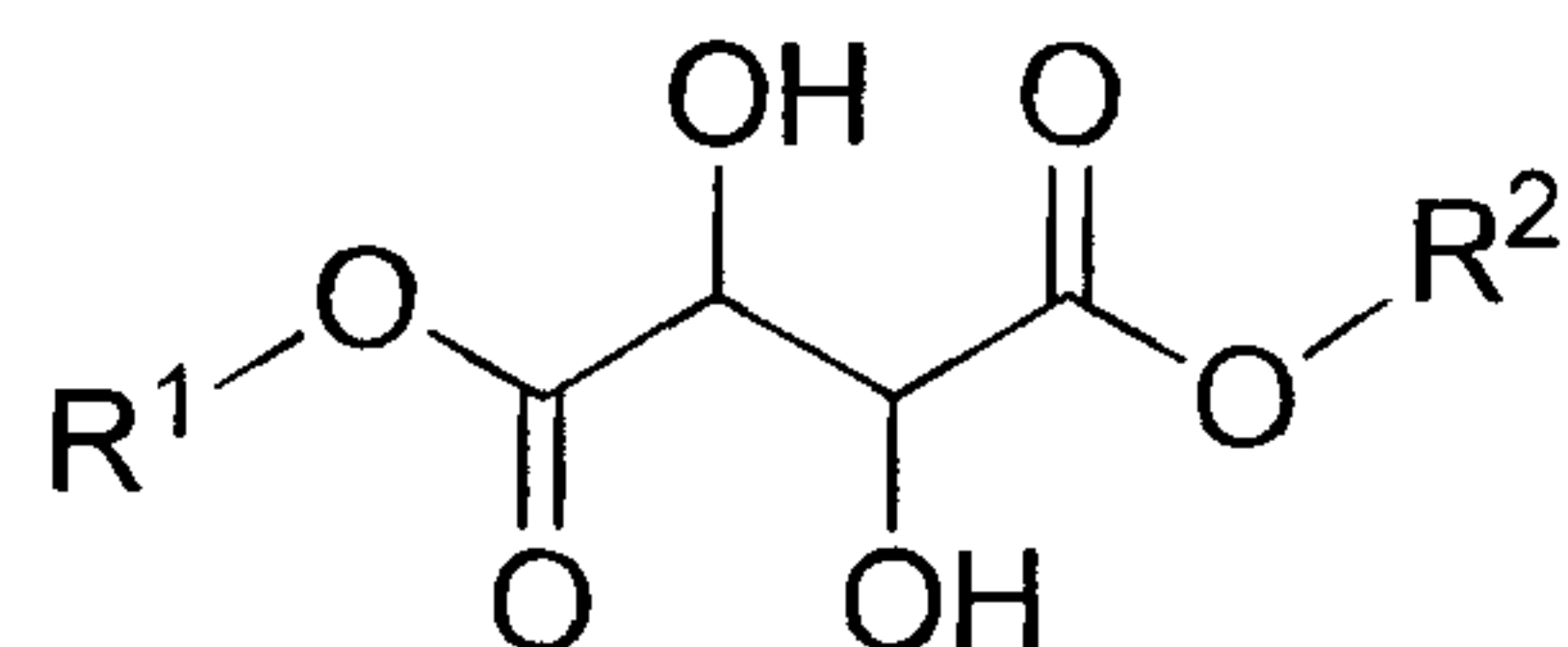
DETAILED DESCRIPTION

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

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

[0020] It has been discovered that using a mixture of crystalline and amorphous components in solid ink formulations provides robust inks, and in particular, solid inks which demonstrate robust images on uncoated and coated paper. For crystalline components, small molecules generally tend to crystallize when solidifying and low molecular weight organic solids are generally crystals. While crystalline components are generally harder and more resistant, such materials are also much more brittle, so that printed matter made using a mainly crystalline ink composition is fairly sensitive to damage. For amorphous components, high molecular weight amorphous components, such as polymers, become viscous and sticky liquids at high temperature, but do not show sufficiently low viscosity at high temperatures. As a result, the polymers cannot be jetted from print head nozzles at desirable jetting temperature ($\leq 140^{\circ}\text{C}$). In the present embodiments, however, it is discovered that a robust solid ink can be obtained through a blend of crystalline and amorphous components.

[0021] The present embodiments provide a new type of ink jet solid ink composition which comprises a blend of (1) crystalline and (2) amorphous components, generally in a weight ratio of from about 60:40 to about 95:5, respectively. In more specific embodiments, the weight ratio of the crystalline to amorphous component is from about 65:35 to about 95:5, or is from about 70:30 to about 90:10. In other embodiments, the crystalline and amorphous components are blended in a weight ratio of from about 1.5 to about 20 or from about 2.0 to about 10, respectively. Generally, the crystalline and amorphous components are esters of tartaric acid having the formula:



wherein R^1 and R^2 each, independently of the other or meaning that they can be the same or different, is selected from the group consisting of alkyl group, wherein the alkyl portion can be straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from about 1 to about 40 carbon atoms, or an substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof. Tartaric acid is selected from L-(+)-tartaric acid, D-(-)-tartaric acid, DL-tartaric acid, or mesotartaric acid, and mixtures thereof. Depending on the R groups and the stereochemistries of tartaric acid, the esters could form crystals or stable amorphous compounds.

[0022] In specific embodiments, the crystalline component is selected from the group consisting of dibenzyl L-tartrate, diphenethyl L-tartrate, bis(3-phenyl-1-propyl) L-tartrate, bis(2-phenoxyethyl) L-tartrate, diphenyl L-tartrate, bis(4-methylphenyl) L-tartrate, bis(4-methoxyphenyl) L-tartrate, bis(4-methylbenzyl) L-tartrate, bis(4-methoxybenzyl) L-tartrate, dicyclohexyl L-tartrate, bis(4-tert-butylcyclohexyl) L-tartrate, and any stereoisomers and mixtures thereof. In specific embodiments, the amorphous component is selected from the group consisting of di-L-menthyl L-tartrate, di-DL-menthyl L-tartrate, di-L-menthyl DL-tartrate, di-DL-menthyl DL-tartrate, and any stereoisomers and mixtures thereof. Each component imparts specific properties to the solid inks, and the blend of the components provide inks that exhibit excellent robustness on uncoated and coated substrates. The crystalline component in the ink formulation drives the phase change through rapid crystallization on cooling. The crystalline component also sets up the structure of the final ink film and creates a hard ink by reducing the tackiness of the amorphous component. The amorphous components provide tackiness and impart robustness to the printed ink.

[0023] The present embodiments provide amorphous components which are suitable for solid ink. The amorphous components are synthesized by an esterification reaction of tartaric acid. These materials show no crystallization, relatively low viscosity ($< 10^2$ centipoise (cps)), or from about 1

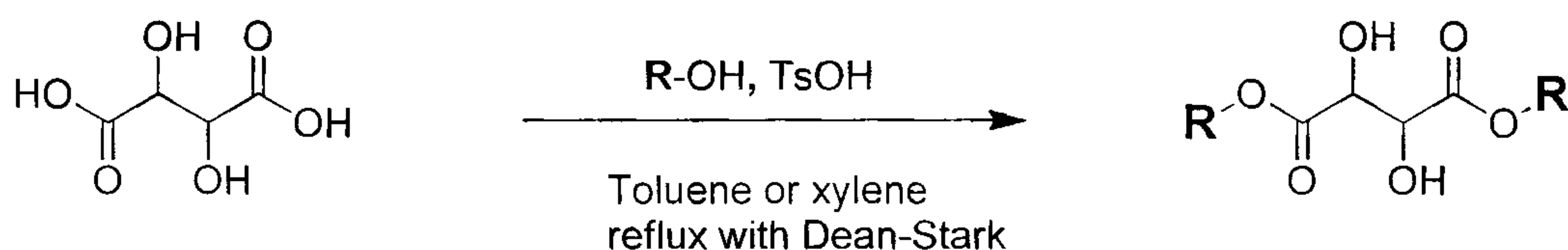
to about 100 cps, or from about 5 to about 95 cps) near the jetting temperature ($\leq 140^{\circ}\text{C}$, or from about 100 to about 140°C , or from about 105 to about 140°C) but very high viscosity ($> 10^6$ cps) at room temperature. In embodiments, the amorphous components are formulated with a crystalline component to form a solid ink composition. The ink compositions show good rheological profiles. Print samples created by the solid ink composition on coated paper by K-proof exhibit excellent robustness. Furthermore, using tartaric acid as an ester base has additional advantages of being low cost, and being obtained from a potential bio-derived ("green") source.

[0024] In embodiments, the solid ink composition is obtained by using novel amorphous components synthesized from tartaric acid and at least one alcohol in an esterification reaction. The solid ink composition comprises the amorphous component in combination with a crystalline component and a colorant. The present embodiments comprise a balance of amorphous and crystalline components to realize a sharp phase transition from liquid to solid and facilitate hard and robust printed images, while maintaining a desired level of viscosity. Prints made with this ink demonstrated advantages over commercially available inks, such as for example, better robustness against scratch. Thus, the present esters of tartaric acid, which provide amorphous components for the solid inks, have been discovered to produce robust inks having desirable rheological profiles and that meet the many requirements for inkjet printing.

[0025] The ink composition, in specific embodiments, further comprises a colorant, which may be a pigment or dye, present in the ink composition in an amount of at least from about 0.1 percent to about 50 percent by weight, or at least from about 0.2 percent to about 20 percent by weight of the total weight of the ink composition. The solid ink composition also comprises a crystalline component. The crystalline component is present an amount of from about 60 percent to about 95 percent by weight, or from about 65 percent to about 95 percent by weight of the total weight of the ink composition. The amorphous component is present an amount of from about 5 percent to about 40 percent by weight, or from about 5 percent to about 35 percent by weight of the total weight of the ink composition.

[0026] In embodiments, the resulting solid ink has a viscosity of from about 1 to about 14 cps, or from about 2 to about 13 cps, or from about 3 to about 12 cps, at a temperature of about 140°C. In embodiments, the solid ink has a viscosity of about $> 10^6$ cps, at room temperature. In embodiments, the solid ink has a T_{melt} of from about 65 to about 140°C, or from about 65 to about 135°C, from about 70 to about 130°C and a T_{crys} of from about 40 to about 140°C, or from about 45 to about 130°C, from about 50 to about 125°C, as determined by DSC at a rate of 10 °C/min.

[0027] The ink composition of the present embodiments comprise an amorphous component. Tartaric acid was reacted with a variety of alcohols to make di-esters as shown in the synthesis scheme below, which illustrates the preparation of a tartaric acid di-ester compound of the present embodiments. A variety of alcohols may be used in the esterification such as, for example, menthol, isomenthol, neomenthol, isoneomenthol, and any stereoisomers and mixtures thereof.



[0028] The esterification was conducted by a one-step reaction. Menthol was the alcohol selected for the experimental data. Both tartaric acid and menthol have stereoisomers, therefore there are many possible combinations in terms of chirality. Three combinations of tartaric acid and menthol (di-L-menthyl L-tartrate, di-DL-menthyl L-tartrate, di-L-menthyl DL-tartrate) were synthesized. Surprisingly, all combinations, even in the combination of optically pure L-menthol and L-tartaric acid, made amorphously setting materials which showed no crystallization. Suitable alcohols to be used with the present embodiments may be selected from the group consisting of alkyl alcohol, wherein the alkyl portion of the alcohol can be straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from about 1 to about 40 carbon atoms, or an substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof. In embodiments, two or more molar equivalents of alcohol may be

used in the reaction to produce the di-esters of tartaric acid. If one molar equivalent of alcohol is used, the result is mostly mono-esters.

[0029] In Figure 1, differential scanning calorimetry (DSC, 10°C/min from -50 to 200 to -50°C) data of di-L-menthyl DL-tartrate (DMT) showed glass transition and no crystallization peak, which indicates that the material was an amorphous solid. The DSC data indicate all the three DMTs showed very similar glass transition temperatures (T_g). The T_g s are 18 °C, 16 °C, and 10 °C for di-L-menthyl L-tartrate, di-L-menthyl DL-tartrate, and di-DL-menthyl L-tartrate, respectively. As shown in Figure 2, all the three DMTs have very similar rheology curves which are independent of chiralities of tartaric acid and menthol. These materials have relatively low viscosity ($< 10^2$ cps, or from about 1 to about 100 cps, or from about 5 to about 95 cps) near the jetting temperatures ($\leq 140^\circ\text{C}$, or from about 100 to about 140°C, or from about 105 to about 140°C), but very high viscosity ($> 10^6$ cps) at room temperature. The low viscosity in the jetting range (100-140°C) provides high formulation latitude. The high viscosity at room temperature imparts robustness. These characteristics make the materials good candidates for the amorphous component.

[0030] The ink of embodiments may further include conventional additives to take advantage of the known functionality associated with such conventional additives. Such additives may include, for example, at least one, antioxidant, defoamer, slip and leveling agents, clarifier, viscosity modifier, adhesive, plasticizer and the like.

[0031] The ink may optionally contain antioxidants to protect the images from oxidation and also may protect the ink components from oxidation while existing as a heated melt in the ink reservoir. Examples of suitable antioxidants include (1) N,N'-hexamethylene bis(3,5-di-tert-butyl-4-hydroxy hydrocinnamamide) (IRGANOX 1098, available from BASF), (2) 2,2-bis(4-(2-(3,5-di-tert-butyl-4-hydroxyhydrocinnamoyloxy))ethoxyphenyl)propane (TOPANOL-205, available from Vertellus), (3) tris(4-tert-butyl-3-hydroxy-2,6-dimethyl benzyl)isocyanurate (Aldrich D12,840-6), (4) 2,2'-ethylidene bis(4,6-di-tert-butylphenyl)fluoro phosphonite (ETHANOX-398, available from Albermarle Corporation), (5) tetrakis(2,4-di-tert-butylphenyl)-4,4'-biphenyl diphosphonite (ALDRICH 46,852-5;), (6) pentaerythritol

tetrastearate (TCI America), (7) tributylammonium hypophosphite (Aldrich 42,009-3), (8) 2,6-di-tert-butyl-4-methoxyphenol (Aldrich 25,106-2), (9) 2,4-di-tert-butyl-6-(4-methoxybenzyl)phenol (Aldrich 23,008-1), (10) 4-bromo-2,6-dimethylphenol (Aldrich 34,951-8), (11) 4-bromo-3,5-dimethylphenol (Aldrich B6,420-2), (12) 4-bromo-2-nitrophenol (Aldrich 30,987-7), (13) 4-(diethyl aminomethyl)-2,5-dimethylphenol (Aldrich 14,668-4), (14) 3-dimethylaminophenol (Aldrich ID14,400-2), (15) 2-amino-4-tert-amylphenol (Aldrich 41,258-9), (16) 2,6-bis(hydroxymethyl)-p-cresol (Aldrich 22,752-8), (17) 2,2'-methylenediphenol (Aldrich B4,680-8), (18) 5-(diethylamino)-2-nitrosophenol (Aldrich 26,951-4), (19) 2,6-dichloro-4-fluorophenol (Aldrich 28,435-1), (20) 2,6-dibromo fluoro phenol (Aldrich 26,003-7), (21) α -trifluoro-o-creso-1 (Aldrich 21,979-7), (22) 2-bromo-4-fluorophenol (Aldrich 30,246-5), (23) 4-fluorophenol (Aldrich F1,320-7), (24) 4-chlorophenyl-2-chloro-1,1,2-trifluoroethyl sulfone (Aldrich 13,823-1), (25) 3,4-difluoro phenylacetic acid (Aldrich 29,043-2), (26) 3-fluorophenylacetic acid (Aldrich 24,804-5), (27) 3,5-difluoro phenylacetic acid (Aldrich 29,044-0), (28) 2-fluorophenylacetic acid (Aldrich 20,894-9), (29) 2,5-bis (trifluoromethyl) benzoic acid (Aldrich 32,527-9), (30) ethyl-2-(4-(4-(trifluoromethyl)phenoxy)phenoxy)propionate (Aldrich 25,074-0), (31) tetrakis (2,4-di-tert-butyl phenyl)-4,4'-biphenyl diphosphonite (Aldrich 46,852-5), (32) 4-tert-amyl phenol (Aldrich 15,384-2), (33) 3-(2H-benzotriazol-2-yl)-4-hydroxy phenethylalcohol (Aldrich 43,071-4), NAUGARD 76, NAUGARD 445, NAUGARD 512, AND NAUGARD 524 (manufactured by Chemtura Corporation), and the like, as well as mixtures thereof. The antioxidant, when present, may be present in the ink in any desired or effective amount, such as from about 0.25 percent to about 10 percent by weight of the ink or from about 1 percent to about 5 percent by weight of the ink.

[0032] In embodiments, the phase change ink compositions described herein also include a colorant. Any desired or effective colorant can be employed in the phase change ink compositions, including dyes, pigments, mixtures thereof, and the like, provided that the colorant can be dissolved or dispersed in the ink carrier. Any dye or pigment may be chosen, provided that it is capable of being dispersed or dissolved in the ink carrier and is compatible with the other ink components. The phase change carrier

compositions can be used in combination with conventional phase change ink colorant materials, such as Color Index (C.I.) Solvent Dyes, Disperse Dyes, modified Acid and Direct Dyes, Basic Dyes, Sulphur Dyes, Vat Dyes, and the like. Examples of suitable dyes include Neozapon Red 492 (BASF); Orasol Red G (Pylam Products); Direct Brilliant Pink B (Oriental Giant Dyes); Direct Red 3BL (Classic Dyestuffs); Supranol Brilliant Red 3BW (Bayer AG); Lemon Yellow 6G (United Chemie); Light Fast Yellow 3G (Shaanxi); Aizen Spilon Yellow C-GNH (Hodogaya Chemical); Bemachrome Yellow GD Sub (Classic Dyestuffs); Cartasol Brilliant Yellow 4GF (Clariant); Cibanone Yellow 2G (Classic Dyestuffs); Orasol Black RLI (BASF); Orasol Black CN (Pylam Products); Savinyl Black RLSN (Clariant); Pyrazol Black BG (Clariant); Morfast Black 101 (Rohm & Haas); Diaazol Black RN (ICI); Thermoplast Blue 670 (BASF); Orasol Blue GN (Pylam Products); Savinyl Blue GLS (Clariant); Luxol Fast Blue MBSN (Pylam Products); Sevron Blue 5GMF (Classic Dyestuffs); Basacid Blue 750 (BASF); Keyplast Blue (Keystone Aniline Corporation); Neozapon Black X51 (BASF); Classic Solvent Black 7 (Classic Dyestuffs); Sudan Blue 670 (C.I. 61554) (BASF); Sudan Yellow 146 (C.I. 12700) (BASF); Sudan Red 462 (C.I. 26050) (BASF); C.I. Disperse Yellow 238; Neptune Red Base NB543 (BASF, C.I. Solvent Red 49); Neopen Blue FF-4012 (BASF); Lampronol Black BR (C.I. Solvent Black 35) (ICI); Morton Morplas Magenta 36 (C.I. Solvent Red 172); metal phthalocyanine colorants-such as those disclosed in U.S. Pat. No. 6,221,137. Polymeric dyes can also be used, such as those disclosed in, for example, U.S. Pat. No. 5,621,022 and U.S. Pat. No. 5,231,135, and commercially available from, for example, Milliken & Company as Milliken Ink Yellow 869, Milliken Ink Blue 92, Milliken Ink Red 357, Milliken Ink Yellow 1800, Milliken Ink Black 8915-67, uncut Reactint Orange X-38, uncut Reactint Blue X-17, Solvent Yellow 162, Acid Red 52, Solvent Blue 44, and uncut Reactint Violet X-80.

[0033] Pigments are also suitable colorants for the phase change inks. Examples of suitable pigments include PALIOGEN Violet 5100 (BASF); PALIOGEN Violet 5890 (BASF); HELIOGEN Green L8730 (BASF); LITHOL Scarlet D3700 (BASF); SUNFAST Blue 15:4 (Sun Chemical); Hostaperm Blue

B2G-D (Clariant); Hostaperm Blue B4G (Clariant); Permanent Red P-F7RK; Hostaperm Violet BL (Clariant); LITHOL Scarlet 4440 (BASF); Bon Red C (Dominion Color Company); ORACET Pink RF (BASF); PALIOGEN Red 3871 K (BASF); SUNFAST Blue 15:3 (Sun Chemical); PALIOGEN Red 3340 (BASF); SUNFAST Carbazole Violet 23 (Sun Chemical); LITHOL Fast Scarlet L4300 (BASF); SUNBRITE Yellow 17 (Sun Chemical); HELIOGEN Blue L6900, L7020 (BASF); SUNBRITE Yellow 74 (Sun Chemical); SPECTRA PAC C Orange 16 (Sun Chemical); HELIOGEN Blue K6902 7, K6910 (BASF); SUNFAST Magenta 122 (Sun Chemical); HELIOGEN Blue D6840, D7080 (BASF); Sudan Blue OS (BASF); NEOPEN Blue FF4012 (BASF); PV Fast Blue B2GO1 (Clariant); IRGALITE Blue GLO (BASF); PALIOGEN Blue 6470 (BASF); Sudan Orange G (Aldrich), Sudan Orange 220 (BASF); PALIOGEN Orange 3040 (BASF); PALIOGEN Yellow 152, 1560 (BASF); LITHOL Fast Yellow 0991 K (BASF); PALIOTOL Yellow 1840 (BASF); NOVOPERM Yellow FGL (Clariant); Ink Jet Yellow 4G VP2532 (Clariant); Toner Yellow HG (Clariant); Lumogen Yellow D0790 (BASF); Suco-Yellow L1250 (BASF); Suco-Yellow D1355 (BASF); Suco Fast Yellow D1355, D1351 (BASF); HOSTAPERM Pink E 02 (Clariant); Hansa Brilliant Yellow 5GX03 (Clariant); Permanent Yellow GRL 02 (Clariant); Permanent Rubine L6B 05 (Clariant); FANAL Pink D4830 (BASF); CINQUASIA Magenta (DU PONT); PALIOGEN Black L0084 (BASF); Pigment Black K801 (BASF); and carbon blacks such as REGAL 330™ (Cabot), Nipex 150 (Evonik) Carbon Black 5250 and Carbon Black 5750 (Columbia Chemical), and the like, as well as mixtures thereof.

[0034] Pigment dispersions in the ink base may be stabilized by synergists and dispersants. Generally, suitable pigments may be organic materials or inorganic. Magnetic material-based pigments are also suitable, for example, for the fabrication of robust Magnetic Ink Character Recognition (MICR) inks. Magnetic pigments include magnetic nanoparticles, such as for example, ferromagnetic nanoparticles.

[0035] Also suitable are the colorants disclosed in U.S. Pat. No. 6,472,523, U.S. Pat. No. 6,726,755, U.S. Pat. No. 6,476,219, U.S. Pat. No. 6,576,747, U.S. Pat. No. 6,713,614, U.S. Pat. No. 6,663,703, U.S. Pat. No. 6,755,902, U.S. Pat. No. 6,590,082, U.S. Pat. No. 6,696,552, U.S. Pat. No. 6,576,748, U.S. Pat. No. 6,646,111, U.S. Pat. No. 6,673,139, U.S. Pat. No.

6,958,406, U.S. Pat. No. 6,821,327, U.S. Pat. No. 7,053,227, U.S. Pat. No. 7,381,831 and U.S. Pat. No. 7,427,323.

[0036] In embodiments, solvent dyes are employed. An example of a solvent dye suitable for use herein may include spirit soluble dyes because of their compatibility with the ink carriers disclosed herein. Examples of suitable spirit solvent dyes include Neozapon Red 492 (BASF); Orasol Red G (Pylam Products); Direct Brilliant Pink B (Global Colors); Aizen Spilon Red C-BH (Hodogaya Chemical); Kayanol Red 3BL (Nippon Kayaku); Spirit Fast Yellow 3G; Aizen Spilon Yellow C-GNH (Hodogaya Chemical); Cartasol Brilliant Yellow 4GF (Clariant); Pergasol Yellow 5RA EX (Classic Dyestuffs); Orasol Black RLI (BASF); Orasol Blue GN (Pylam Products); Savinyl Black RLS (Clariant); Morfast Black 101 (Rohm and Haas); Thermoplast Blue 670 (BASF); Savinyl Blue GLS (Sandoz); Luxol Fast Blue MBSN (Pylam); Sevron Blue 5GMF (Classic Dyestuffs); Basacid Blue 750 (BASF); Keyplast Blue (Keystone Aniline Corporation); Neozapon Black X51 (C.I. Solvent Black, C.I. 12195) (BASF); Sudan Blue 670 (C.I. 61554) (BASF); Sudan Yellow 146 (C.I. 12700) (BASF); Sudan Red 462 (C.I. 260501) (BASF), mixtures thereof and the like.

[0037] The colorant may be present in the phase change ink in any desired or effective amount to obtain the desired color or hue such as, for example, at least from about 0.1 percent by weight of the ink to about 50 percent by weight of the ink, at least from about 0.2 percent by weight of the ink to about 20 percent by weight of the ink, and at least from about 0.5 percent by weight of the ink to about 10 percent by weight of the ink.

[0038] In embodiments, the ink carriers for the phase change inks may have melting points of from about 65 °C to about 150 °C, for example from about 70 °C to about 140 °C, from about 75 °C to about 135 °C, from about 80 °C to about 130 °C, or from about 85 °C to about 125 °C as determined by, for example, differential scanning calorimetry at a rate of 10°C/min.

Furthermore, these inks have a jetting viscosity of about 1 cps to about 13 cps, such as from about 2 cps to about 13 cps, or from about 4 cps to about 12 cps, at temperature of about 140 °C.

[0039] The ink compositions can be prepared by any desired or suitable method. For example, each of the components of the ink carrier can be mixed together, followed by heating, the mixture to at least its melting point, for example from about 60 °C to about 150 °C, 80 °C to about 145 °C and 85 °C to about 140 °C. The colorant may be added before the ink ingredients have been heated or after the ink ingredients have been heated. When pigments are the selected colorants, the molten mixture may be subjected to grinding in an attritor or ball mill apparatus or other high energy mixing equipment to affect dispersion of the pigment in the ink carrier. The heated mixture is then stirred for about 5 seconds to about 30 minutes or more, to obtain a substantially homogeneous, uniform melt, followed by cooling the ink to ambient temperature (typically from about 20 °C to about 25 °C). The inks are solid at ambient temperature. In a specific embodiment, during the formation process, the inks in their molten state are poured into molds and then allowed to cool and solidify to form ink sticks. Suitable ink preparation techniques are disclosed in U.S. Pat. No. 7,186,762.

[0040] The inks can be employed in apparatus for direct printing ink jet processes and in indirect (offset) printing ink jet applications. Another embodiment disclosed herein is directed to a process which comprises incorporating an ink as disclosed herein into an ink jet printing apparatus, melting the ink, and causing droplets of the melted ink to be ejected in an imagewise pattern onto a recording substrate. A direct printing process is also disclosed in, for example, U.S. Pat. No. 5,195,430. Yet another embodiment disclosed herein is directed to a process which comprises incorporating an ink as disclosed herein into an ink jet printing apparatus, melting the ink, causing droplets of the melted ink to be ejected in an imagewise pattern onto an intermediate transfer member, and transferring the ink in the imagewise pattern from the intermediate transfer member to a final recording substrate. In a specific embodiment, the intermediate transfer member is heated to a temperature above that of the final recording sheet and below that of the melted ink in the printing apparatus. In another specific embodiment, both the intermediate transfer member and the final recording sheet are heated; in this

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

[0041] Any suitable substrate or recording sheet can be employed, including plain papers such as XEROX 4200 papers, XEROX Image Series papers, Courtland 4024 DP paper, ruled notebook paper, bond paper, silica coated papers such as Sharp Company silica coated paper, JuJo paper, HAMMERMILL LASERPRINT paper, and the like, glossy coated papers such as XEROX Digital Color Elite Gloss, Sappi Warren Papers LUSTROGLOSS, specialty papers such as Xerox DURAPAPER, and the like, transparency materials, fabrics, textile products, plastics, polymeric films, inorganic recording mediums such as metals and wood, and the like, transparency materials, fabrics, textile products, plastics, polymeric films, inorganic substrates such as metals and wood, and the like.

[0042] The inks described herein are further illustrated in the following examples. All parts and percentages are by weight unless otherwise indicated.

[0043] It will be appreciated that various of the above-disclosed and other features and functions, or alternatives thereof, may be desirably combined into many other different systems or applications. Also, alternatives, modifications, variations or improvements therein may be subsequently made by those skilled in the art, and are also intended to be encompassed by the invention.

[0044] While the description above refers to particular embodiments, it will be understood that many modifications may be made without departing from the scope thereof.

[0045] The presently disclosed examples are, therefore, to be considered in all respects as illustrative and not restrictive. All changes that come within the meaning of and range of equivalency of the claims are intended to be embraced therein.

EXAMPLES

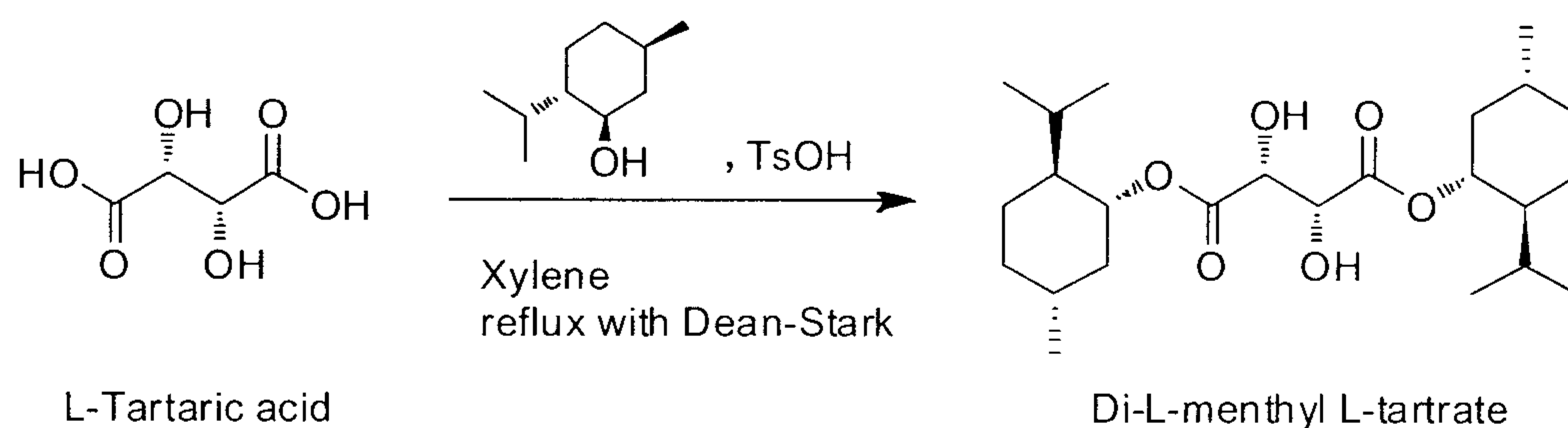
[0046] The examples set forth herein below and are illustrative of different compositions and conditions that can be used in practicing the present embodiments. All proportions are by weight unless otherwise indicated. It will be apparent, however, that the present embodiments can be practiced with many types of compositions and can have many different uses in accordance with the disclosure above and as pointed out hereinafter.

[0047] **Example 1**

[0048] **Synthesis of Materials**

[0049] In a typical synthesis of, for example, di-L-menthyl L-tartrate (DMT), L-tartaric acid (18.0 g, 120 mmol), L-menthol (37.5 g, 240 mmol), and xylene (240 ml) were added to a 500 mL flask, equipped with a Dean-Stark trap, to give a suspension. *p*-Toluenesulfonic acid monohydrate (0.29 g, 1.5 mmol) was added and the mixture was refluxed for 18 hours with azeotropic removal of water. The reaction mixture was cooled down to room temperature and washed with 10w% KOH aq. (1x) and brine (2x), then dried over MgSO₄. After filtration and removal of the solvent, the residue was dried under vacuum with stirring at 120 °C to obtain 34.9 g (yield: 68%) of

amorphous solid. The sample was characterized by ^1H NMR and acid number analysis (1.23 mgKOH/g). The synthesis scheme is illustrated below:



[0050] Preparation of the Solid Ink

[0051] Diphenethyl L-tartrate was selected for the phase changing material ($T_{\text{melt}} = 110\text{ }^{\circ}\text{C}$, $T_{\text{crys}} = 83\text{ }^{\circ}\text{C}$, η at $140\text{ }^{\circ}\text{C} = 4.7\text{ cps}$). This material was synthesized and used as the crystalline portion of the ink. DMT and the crystalline component were stirred in the molten state at 120°C , then cooled down to obtain the ink sample. The crystalline/amorphous ratio of the ink sample was 70/30 in weight percent. The two materials were well miscible in this mixing ratio.

[0052] As shown in Figure 3, DSC data of the prepared ink showed favorably sharp phase transitions. This data indicates that DMT amorphous does not interrupt crystallization of the crystalline component. Figure 4 shows rheology data of the prepared ink sample. The ink showed phase transition to $>10^6\text{ cps}$ at around $85\text{ }^{\circ}\text{C}$, but the phase transition temperature will be adjustable by changing the crystalline/amorphous ratio. The viscosity at around $130\text{ }^{\circ}\text{C}$ was below 12 cps.

[0053] Print Performance

[0054] To the ink sample was further added 3 weight percent of cyan dye (Ciba Orasol Blue GN) which showed good solubility in the ink. Then the ink was printed using a K Printing Proofer (manufactured by RK Print Coat Instrument Ltd., Litlington, Royston, Heris, SG8 0OZ, U.K.) onto Xerox digital Color Elite Gloss, 120gsm (DCEG). When a scratch/gouge finger with a curved tip at an angle of about 15° from vertical, with a weight of 528 g applied, was drawn across the image at a rate of approximately 13 mm/s no ink was visibly removed from the image. The scratch/gouge tip is similar to a lathe round nose cutting bit with radius of curvature of approximately 12mm.

[0055] Summary

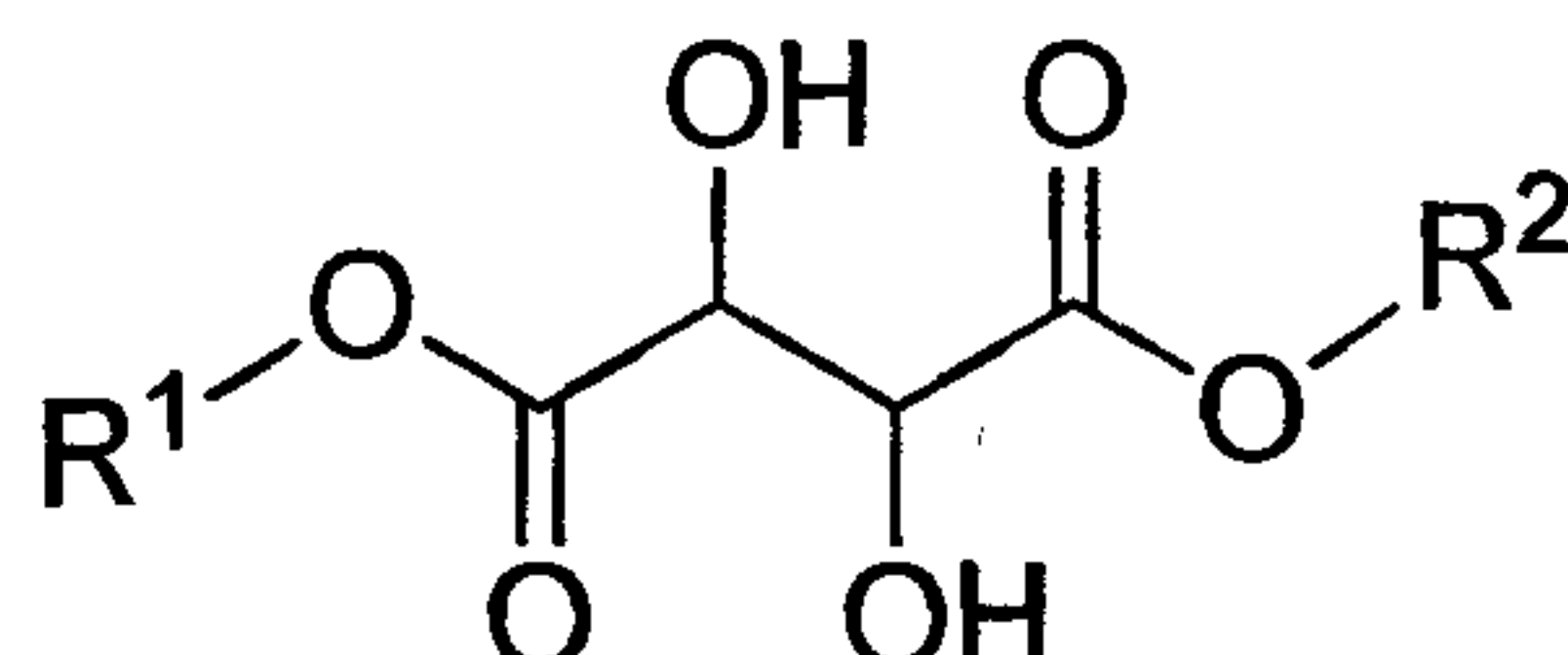
[0056] In summary, the present embodiments provide solid ink formulations developed for inkjet printing which contains at least one crystalline component and at least one amorphous component. The inks may also include a colorant, such as a pigment or dye. The novel amorphous components are synthesized from tartaric acid and at least one alcohol, such as menthol, by esterification reactions. The resulting amorphous components have desirable physical properties which provide for robust inks.

[0057] The invention encompasses variations, alternatives, modifications, improvements, equivalents, and substantial equivalents of the embodiments and teachings disclosed herein. Unless specifically recited in a claim, steps or components of claims should not be implied or imported from the specification or any other claims as to any particular order, number, position, size, shape, angle, color, or material.

CLAIMS

WHAT IS CLAIMED IS:

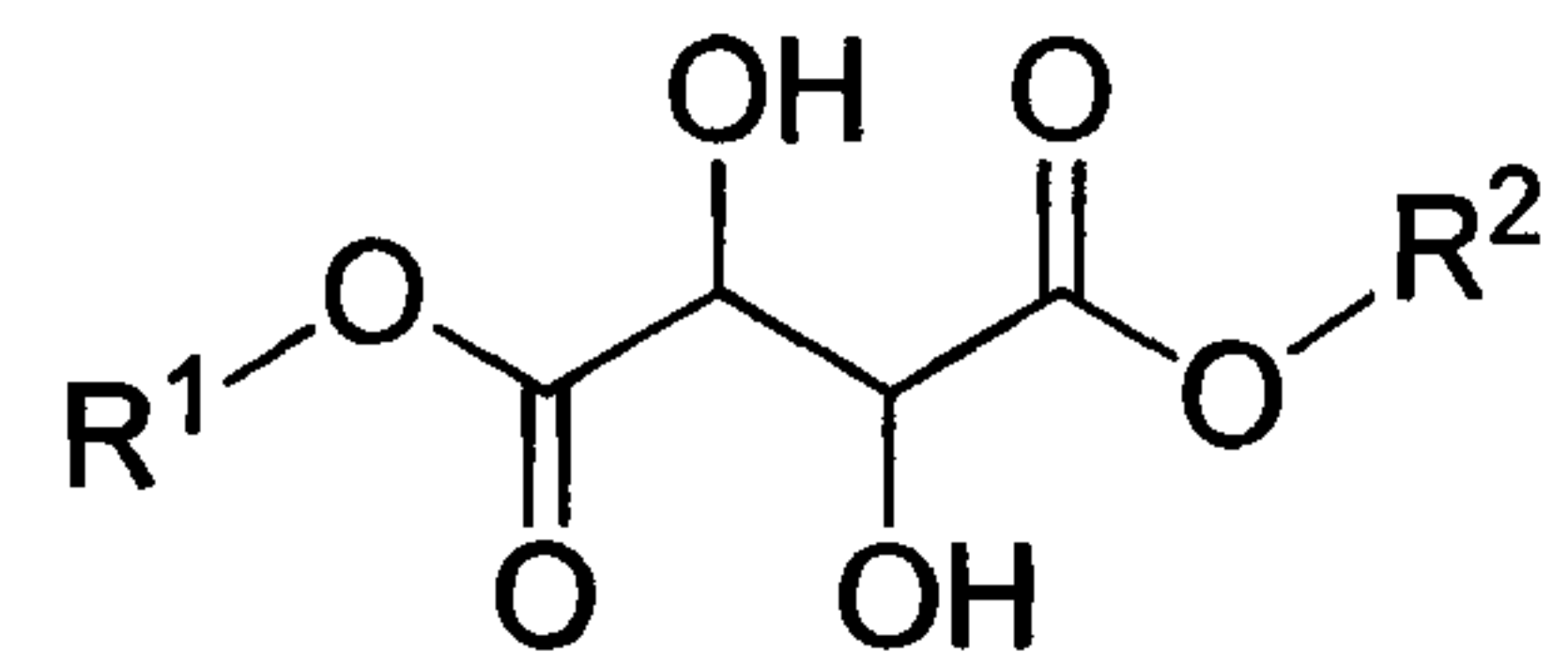
1. A phase change ink comprising:
a crystalline component; and
an amorphous component being esters of tartaric acid and having a formula of



wherein R¹ and R² each, independently of the other, is selected from the group consisting of alkyl group, wherein the alkyl portion can be straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to 40 carbon atoms, or an substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof, and further wherein the tartaric acid backbone is selected from L-(+)-tartaric acid, D-(-)-tartaric acid, DL-tartaric acid, mesotartaric acid, and mixtures thereof.

2. The phase change ink of claim 1, wherein the amorphous component is present in an amount of from about 5 percent to about 40 percent by weight of the total weight of the phase change ink.
3. The phase change ink of claim 2, wherein the amorphous component is present in an amount of from about 5 percent to about 35 percent by weight of the total weight of the phase change ink.
4. The phase change ink of claim 1, wherein the crystalline component is present in an amount of from about 60 percent to about 95 percent by weight of the total weight of the phase change ink.
5. The phase change ink of claim 4, wherein the crystalline component is present in an amount of from about 65 percent to about 95 percent by weight of the total weight of the phase change ink.
6. The phase change ink of claim 1, wherein the crystalline and amorphous components are blended in a weight ratio of from about 1.5 to about 20.
7. The phase change ink of claim 6, wherein the crystalline and amorphous components are blended in a weight ratio of from about 2 to about 10.

8. The phase change ink of claim 1, wherein the crystalline component is an ester of tartaric acid that is different than that of the amorphous component and has the following structure:



wherein R¹ and R² each, independently of the other, is selected from the group consisting of alkyl group, wherein the alkyl portion can be straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to 40 carbon atoms, or an substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof, and further wherein the tartaric acid backbone is selected from L-(+)-tartaric acid, D-(-)-tartaric acid, DL-tartaric acid, or mesotartaric acid, and mixtures thereof.

9. The phase change ink of claim 1, wherein the amorphous component is selected from the group consisting of di-L-menthyl L-tartrate, di-DL-menthyl L-tartrate, di-L-menthyl DL-tartrate, di-DL-menthyl DL-tartrate, stereoisomers and mixtures thereof.

10. The phase change ink of claim 1, wherein the crystalline component is selected from the group consisting of dibenzyl L-tartrate, diphenethyl L-tartrate, bis(3-phenyl-1-propyl) L-tartrate, bis(2-phenoxyethyl) L-tartrate, diphenyl L-tartrate, bis(4-methylphenyl) L-tartrate, bis(4-methoxyphenyl) L-tartrate, bis(4-methylbenzyl) L-tartrate, bis(4-methoxybenzyl) L-tartrate, dicyclohexyl L-tartrate, bis(4-tert-butylcyclohexyl) L-tartrate, stereoisomers and mixtures thereof.

11. The phase change ink of claim 1 further comprising a colorant selected from the group consisting of a pigment, dye and mixtures thereof.

12. The phase change ink of claim 1, wherein the amorphous component has a viscosity of from about 1 to about 100 cps at a temperature of about 140°C.

13. The phase change ink of claim 1, wherein the amorphous component has a viscosity of greater than about 10⁶ cps at room temperature.

14. The phase change ink of claim 1 having a viscosity of less than about 15 cps at a temperature of about 140°C.

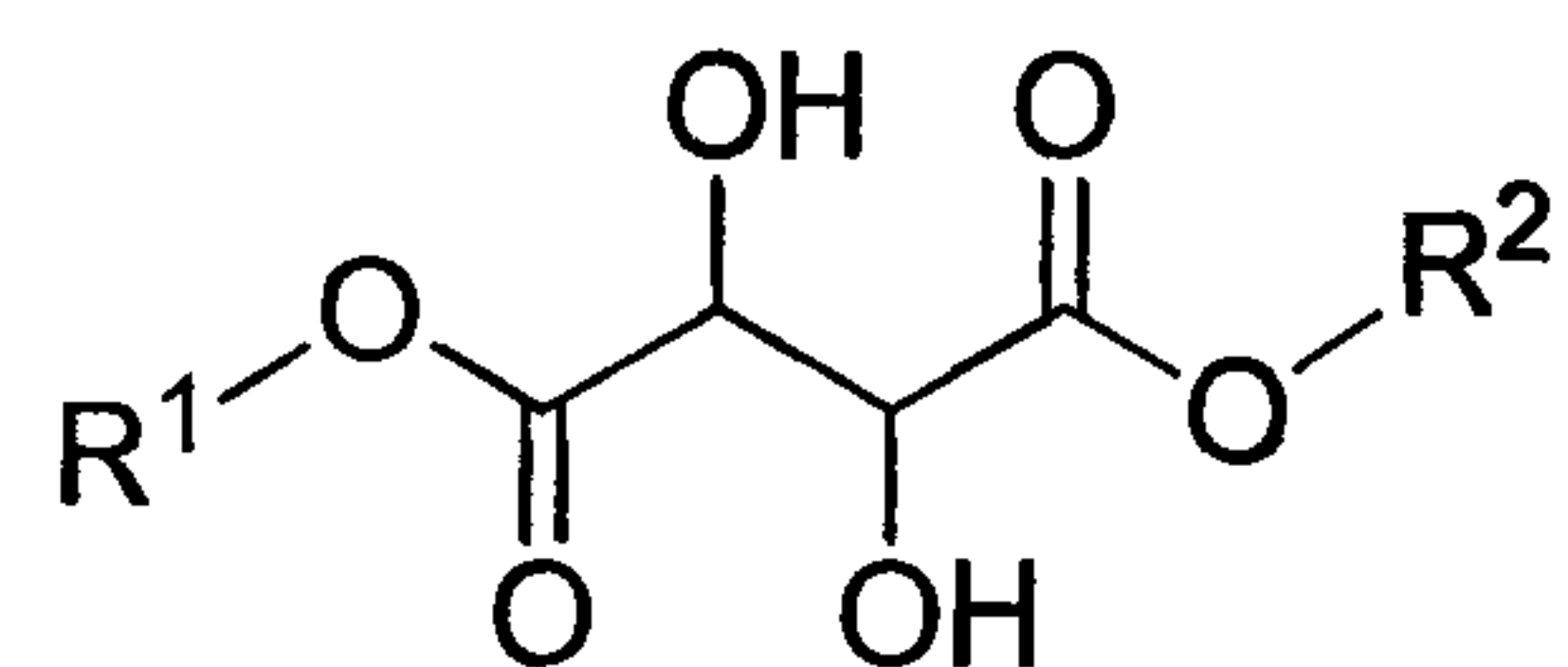
15. The phase change ink of claim 14 having a viscosity of from about 2 to about 15 cps at a temperature of about 140°C.

16. The phase change ink of claim 1 having a viscosity of greater than about 10^6 cps at room temperature.

17. A phase change ink comprising:

a crystalline component; and

an amorphous component being an ester of tartaric acid, wherein the crystalline component and the amorphous component each have the following structure:



wherein R^1 and R^2 each, independently of the other, is selected from the group consisting of alkyl group, wherein the alkyl portion can be straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to 40 carbon atoms, or an substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof, and further wherein the tartaric acid backbone is selected from L-(+)-tartaric acid, D-(-)-tartaric acid, DL-tartaric acid, or mesotartaric acid, and mixtures thereof, and wherein the crystalline and amorphous components are blended in a weight ratio of from about 1.5 to about 20.

18. The phase change ink of claim 17, wherein the amorphous component is synthesized by an esterification reaction with at least one alcohol.

19. A phase change ink comprising:

a crystalline component; and

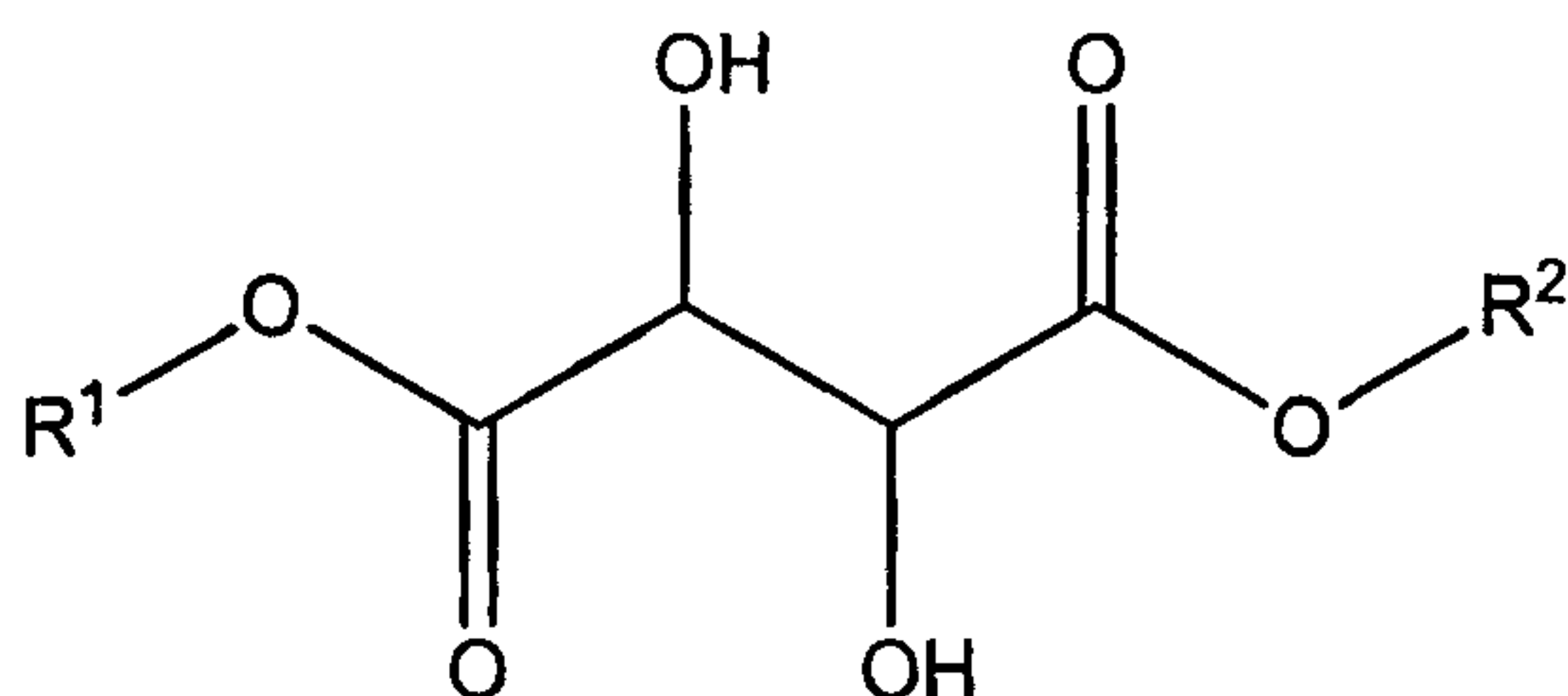
an amorphous component, wherein the amorphous component is an ester of tartaric acid and is synthesized by an esterification reaction with at least one alcohol.

20. The phase change ink of claim 19, wherein the alcohol is selected from the group consisting of menthol, isomenthol, neomenthol, isoneomenthol, stereoisomers and mixtures thereof.

21. A phase change ink comprising:

at least an amorphous component; and

at least a crystalline component, wherein the crystalline component is an ester of tartaric acid having a formula of



wherein R^1 and R^2 each, independently of the other, is selected from the group consisting of alkyl group, wherein the alkyl portion can be straight, branched or cyclic, saturated or unsaturated, substituted or unsubstituted, having from 1 to 40 carbon atoms, or an substituted or unsubstituted aromatic or heteroaromatic group, and mixtures thereof, and further wherein the tartaric acid backbone is selected from L-(+)-tartaric acid, D-(-)-tartaric acid, DL-tartaric acid, or mesotartaric acid, and mixtures thereof.

22. The phase change ink of claim 21, wherein the amorphous component is present in an amount of from about 5 percent to about 40 percent by weight of the total weight of the phase change ink.

23. The phase change ink of claim 22, wherein the amorphous component is present in an amount of from about 5 percent to about 35 percent by weight of the total weight of the phase change ink.

24. The phase change ink of claim 21, wherein the crystalline component is present in an amount of from about 60 percent to about 95 percent by weight of the total weight of the phase change ink.

25. The phase change ink of claim 24, wherein the crystalline component is present in an amount of from about 65 percent to about 95 percent by weight of the total weight of the phase change ink.

26. The phase change ink of claim 21, wherein the crystalline and amorphous components are blended in a weight ratio of from about 1.5 to about 20.

27. The phase change ink of claim 26, wherein the crystalline and amorphous components are blended in a weight ratio of from about 2 to about 10.

28. The phase change ink of claim 21, wherein the amorphous component is selected from the group consisting of di-L-menthyl L-tartrate, di-DL-menthyl L-tartrate, di-L-menthyl DL-tartrate, di-DL-menthyl DL-tartrate, stereoisomers and mixtures thereof.

29. The phase change ink of claim 21, wherein the crystalline component is selected from the group consisting of dibenzyl L-tartrate, diphenethyl L-tartrate, bis(3-phenyl-1-propyl) L-tartrate, bis(2-phenoxyethyl) L-tartrate, diphenyl L-tartrate, bis(4-methylphenyl) L-tartrate, bis(4-methoxyphenyl) L-tartrate, bis(4-methylbenzyl) L-tartrate, bis(4-methoxybenzyl) L-tartrate, dicyclohexyl L-tartrate, bis(4-tert-butylcyclohexyl) L-tartrate, stereoisomers and mixtures thereof.

30. The phase change ink of claim 21 further comprising a colorant selected from the group consisting of a pigment, dye or mixtures thereof.

31. The phase change ink of claim 21, wherein the crystalline component has a viscosity of from about 1 to about 10 cps at a temperature of about 140°C.

32. The phase change ink of claim 21, wherein the crystalline component is in crystallized form at room temperature.

33. The phase change ink of claim 21 having a viscosity of less than about 15 cps at a temperature of about 140°C.

34. The phase change ink of claim 33 having a viscosity of from about 2 to about 15 cps at a temperature of about 140°C.

35. The phase change ink of claim 21 having a viscosity of greater than about 10^6 cps at room temperature.

36. A phase change ink comprising:
an amorphous component; and
a crystalline component, wherein the crystalline component is an ester of tartaric acid synthesized by an esterification reaction with at least one alcohol.

1/4

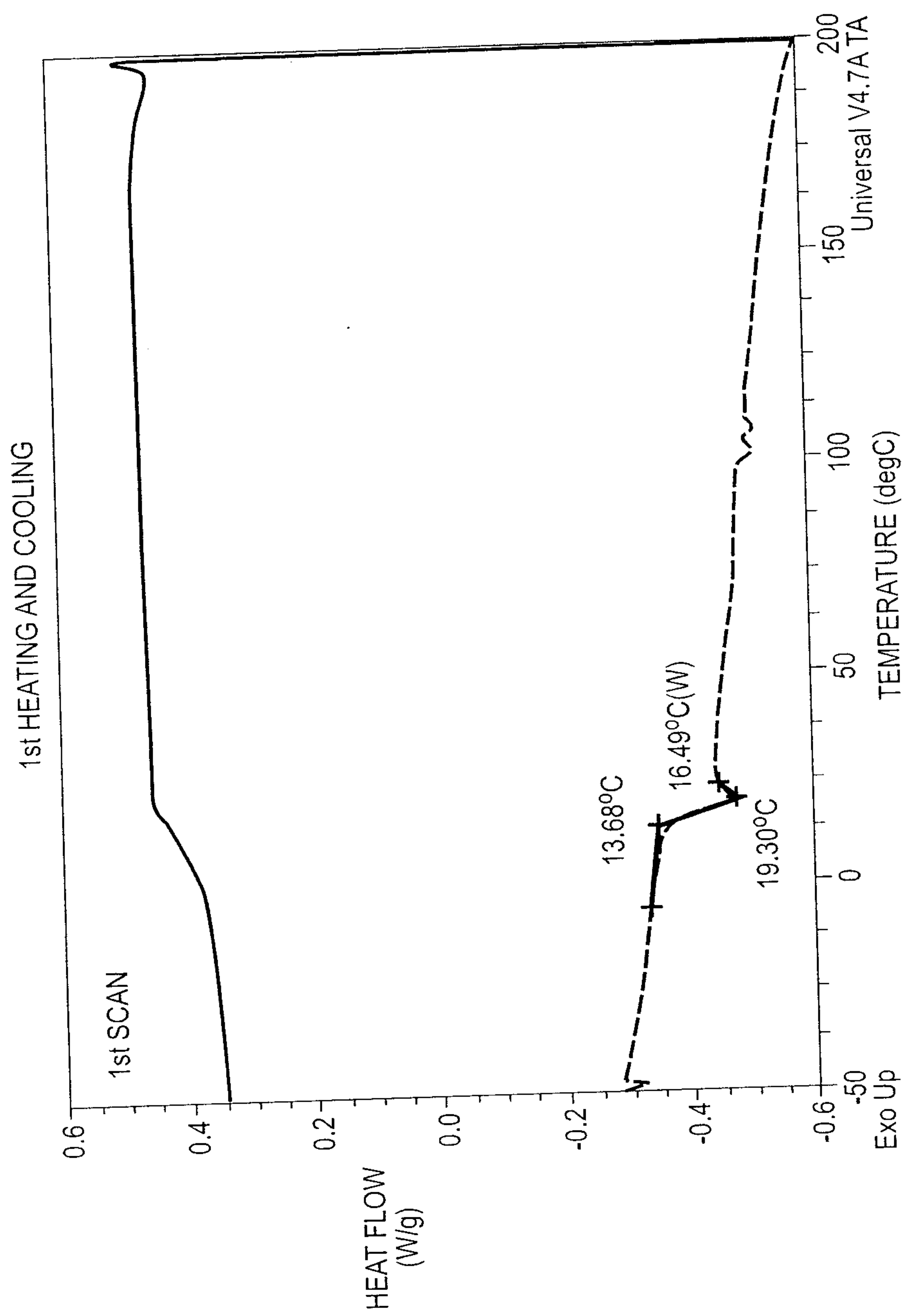
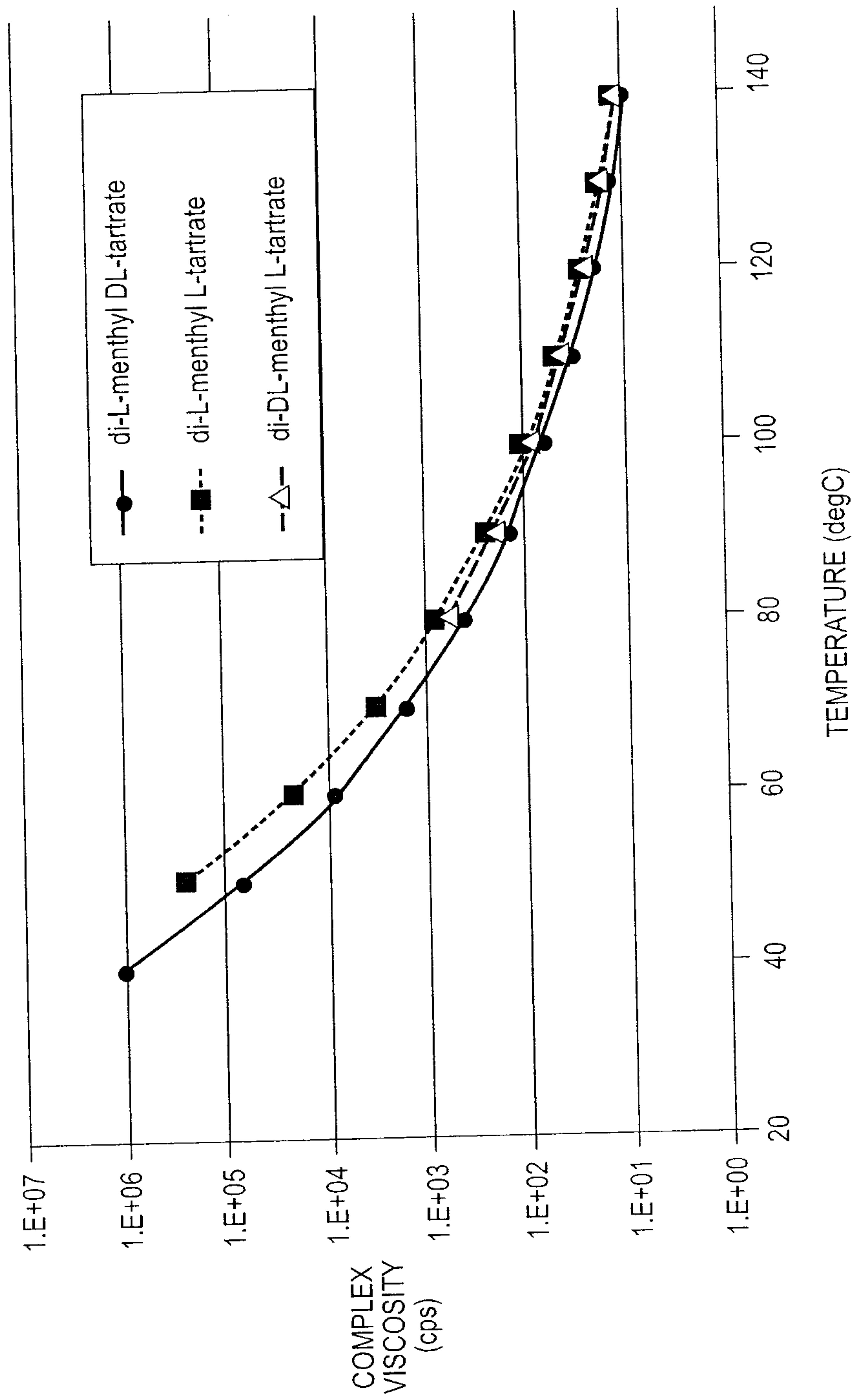


FIG. 1

2/4

**FIG. 2**

3/4

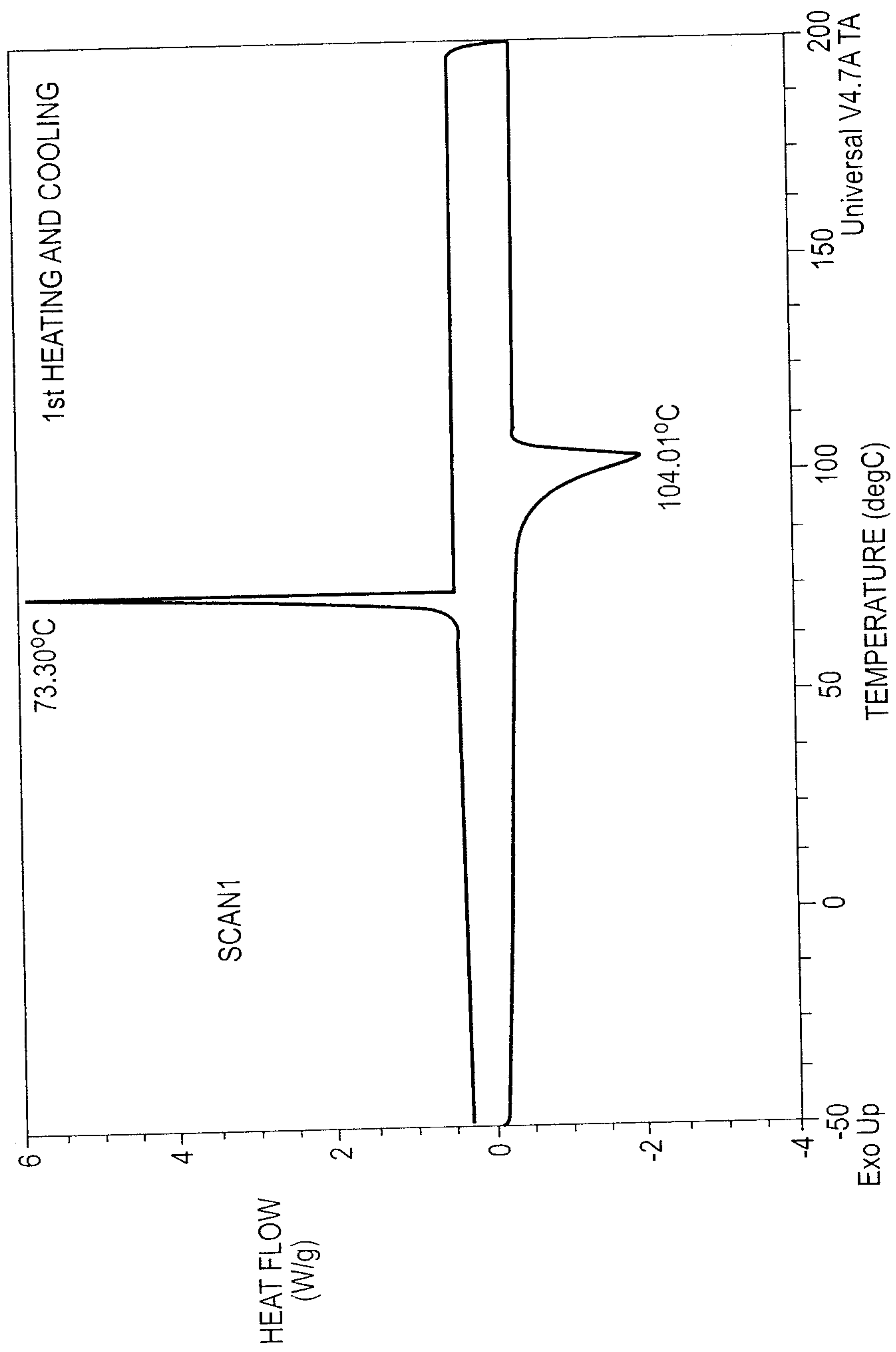


FIG. 3

4/4

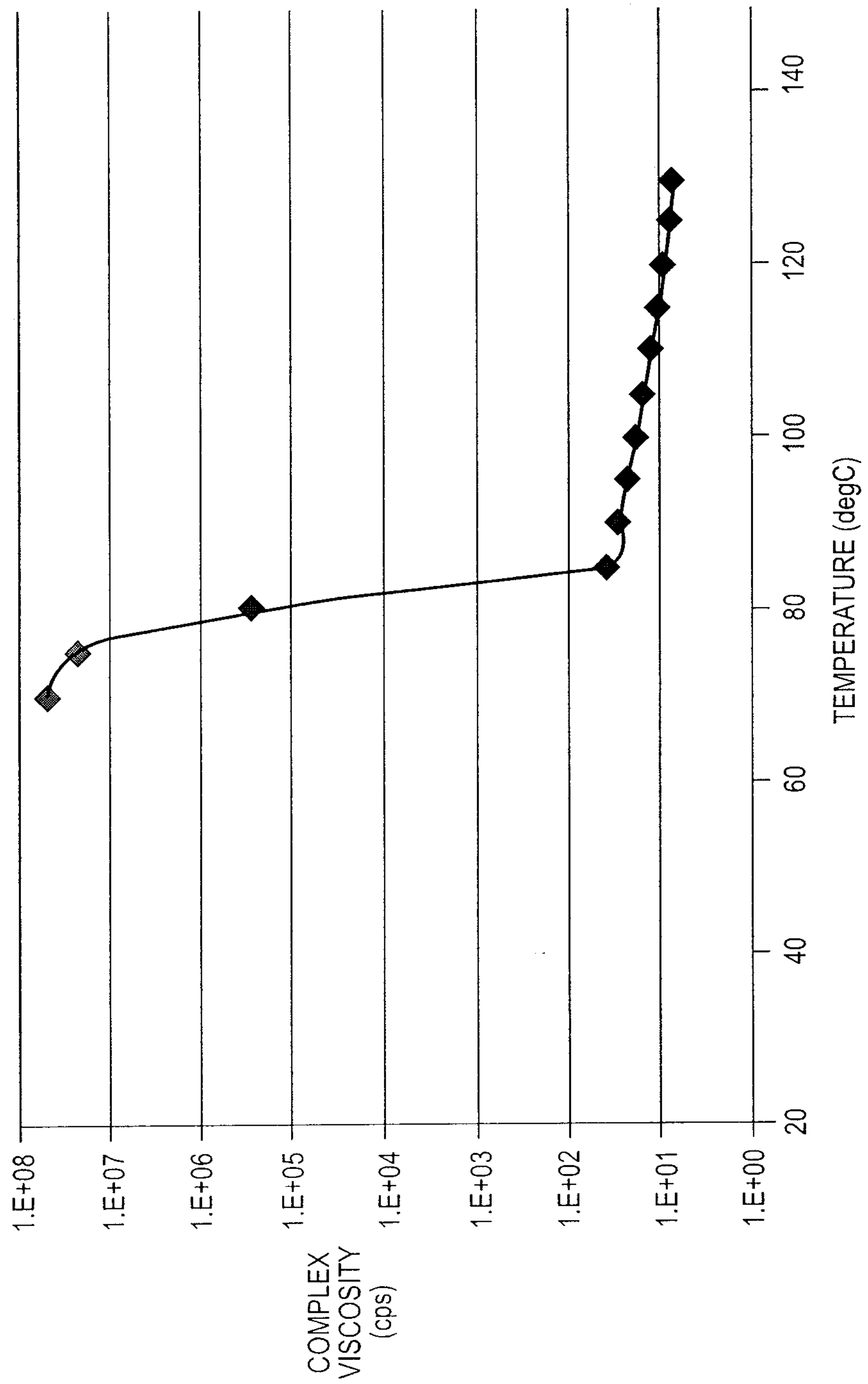


FIG. 4

1st HEATING AND COOLING

