

(19) World Intellectual Property Organization
International Bureau



(43) International Publication Date
8 November 2007 (08.11.2007)

PCT

(10) International Publication Number
WO 2007/125273 A1

(51) International Patent Classification:
C09D 11/10 (2006.01)

(74) Agent: ELKINGTON AND FIFE LLP; Prospect House,
Pembroke Road, Sevenoaks, Kent TN13 1XR (GB).

(21) International Application Number:
PCT/GB2007/001416

(81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BH, BR, BW, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KN, KP, KR, KZ, LA, LC, LK, LR, LS, LT, LU, LY, MA, MD, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RS, RU, SC, SD, SE, SG, SK, SL, SM, SV, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

(22) International Filing Date: 19 April 2007 (19.04.2007)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:
0608463.6 27 April 2006 (27.04.2006) GB

(71) Applicant (for all designated States except US): SERI-COL LIMITED [GB/GB]; Patricia Way, Pysons Road Industrial Estate, Broadstairs, Kent CT10 2LE (GB).

(84) Designated States (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IS, IT, LT, LU, LV, MC, MT, NL, PL, PT, RO, SE, SI, SK, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

(72) Inventors; and

Published:

— with international search report

(75) Inventors/Applicants (for US only): WARD, Jeremy [GB/GB]; Fujifilm Sericol Limited, Patricia Way, Pysons Road Industrial Estate, Broadstairs, Kent CT10 2LE (GB). GOULD, Nigel [GB/GB]; Fujifilm Sericol Limited, Patricia Way, Pysons Road Industrial Estate, Broadstairs, Kent CT10 2LE (GB).

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

WO 2007/125273 A1

(54) Title: A PRINTING INK

(57) Abstract: This invention relates to an ink-jet ink comprising at least one monofunctional (meth)acrylate monomer; at least one monofunctional N-vinyl amide monomer; at least one radical photoinitiator; and at least one colouring agent. The ink has a viscosity of less than 100 mPas at 25°C, and the molar ratio of the at least one monofunctional (meth)acrylate monomer to the at least one monofunctional N-vinyl amide monomer is from 1.0 to 6.0.

A printing ink

This invention concerns inks for use in ink-jet printers. In particular, this invention concerns inks for use in ink-jet printers that are cured using ultraviolet radiation.

5

In ink-jet printing, minute droplets of black, white or coloured ink are ejected in a controlled manner from one or more reservoirs or printing heads through narrow nozzles on to a substrate which is moving relative to the reservoirs. The ejected ink forms an image on the substrate. For high-speed printing, the inks must flow rapidly

10 from the printing heads, and, to ensure that this happens, they must have in use a low viscosity, typically below 100 mPas at 25°C although in most applications the viscosity should be below 50 mPas, and often below 25 mPas. Typically, when ejected through the nozzles, the ink has a viscosity of less than 25 mPas, preferably 5-

15 15 mPas and ideally 10.5 mPas at the jetting temperature which is often elevated to about 40°C (the ink might have a much higher viscosity at ambient temperature). The inks must also be resistant to drying or crusting in the reservoirs or nozzles. For these

reasons, ink-jet inks for application at or near ambient temperatures are commonly formulated to contain a large proportion of a mobile liquid vehicle or solvent. In one common type of ink-jet ink this liquid is water - see for example the paper by Henry R. Kang in the Journal of Imaging Science, 35(3), pp. 179-188 (1991). In those

20 systems, great effort must be made to ensure the inks do not dry in the head due to water evaporation. In another common type the liquid is a low-boiling solvent or mixture of solvents - see, for example, EP 0 314 403 and EP 0 424 714.

25 Unfortunately, ink-jet inks that include a large proportion of water or solvent cannot be handled after printing until the inks have dried, either by evaporation of the solvent or its absorption into the substrate. This drying process is often slow and in many cases (for example, when printing on to a heat-sensitive substrate such as paper) cannot be accelerated.

30 Another type of ink-jet ink contains unsaturated organic compounds, termed monomers, which polymerise by irradiation, commonly with ultraviolet light, in the presence of a photoinitiator. This type of ink has the advantage that it is not necessary to evaporate the liquid phase to dry the print; instead the print is exposed to radiation to cure or harden it, a process which is more rapid than evaporation of solvent at

moderate temperatures. In such ink-jet inks it is necessary to use monomers possessing a low viscosity.

However, ink-jet inks largely based on monomers suffer from significant draw-backs
5 compared to ink-jet inks containing solvent or more traditional inks such as screen or flexographic systems, where the higher viscosities allowed give greater formulation latitude. These types of ink can have significant amounts of the monomer content replaced with acrylate oligomers or inert thermoplastic resins whose higher molecular weight leads to a reduction in the number of bonds that must be formed during the
10 curing process. When each link is formed the bond length between the repeat units reduces leading to shrinkage of the cured film and unless this is controlled stress is imparted to the substrate. With plastic substrates this film shrinkage can lead to severe embrittlement of the printed article and post print finishing, such as guillotining, becomes problematic.

15

Traditionally UV ink-jet inks are formulated with difunctional acrylate monomers in order to achieve adequate cure speeds. Inks produced from these types of materials suffer badly from film shrinkage and consequent substrate embrittlement. Theoretically it should be possible to reduce shrinkage by use of wholly
20 monofunctional acrylate or vinyl monomer based systems, however this approach has generally been avoided due to very low cure speeds associated with monofunctional monomers.

There is therefore a requirement in the art for inks which achieve a balance between
25 cure speed and film shrinkage without compromising the low viscosity of the ink-jet ink.

Accordingly, the present invention provides an ink-jet ink comprising at least one monofunctional (meth)acrylate monomer; at least one monofunctional N-vinyl amide monomer; at least one radical photoinitiator; and at least one colouring agent; wherein
30 the ink has a viscosity of less than 100 mPas at 25°C, and wherein the molar ratio of the at least one monofunctional (meth)acrylate monomer to the at least one monofunctional N-vinyl amide monomer is from 1.0 to 6.0.

The present invention will now be described with reference to the accompanying drawings, in which:

Fig. 1 shows a graph of cure response against composition for three ink-jet inks of the present invention,

5 Fig. 2 shows a graph of cure response against composition for an ink-jet ink of the present invention containing NVP and IBOA.

The ink-jet ink of the present invention dries primarily by curing, i.e. by the polymerisation of the monomers present, as discussed hereinabove, and hence is a
10 curable ink. The ink does not, therefore, require the presence of water or a volatile organic solvent to effect drying of the ink, although the presence of such components may be tolerated. Preferably, however, the ink-jet ink of the present invention is substantially free of water and volatile organic solvents.

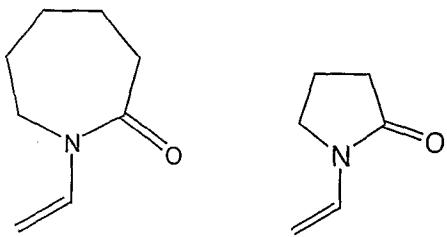
15 As explained hereinabove incorporating significant amounts of monofunctional monomers in inks has traditionally led to very poor UV cure response and hence multifunctional monomers have had to be added to boost cure. It has now been found that, at certain ratios, combinations of monofunctional (meth)acrylate monomers with an N-vinyl amide monomers provide a surprising synergistic effect, namely higher
20 cure speeds are observed than for either of the component monomers when taken alone. This effect is particularly beneficial in ink-jet inks formulated with monofunctional monomers allowing cure speeds which are similar or even better than those observed with difunctional and even trifunctional (meth)acrylate monomer-based inks.

25

N-Vinyl amides are well-known monomers in the art and a detailed description is therefore not required. N-Vinyl amides have a vinyl group attached to the nitrogen atom of an amide which may be further substituted in an analogous manner to the (meth)acrylate monomers.

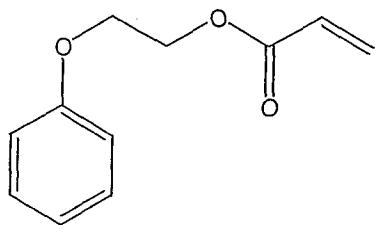
30

Preferred examples are N-vinyl caprolactam (NVC) and N-vinyl pyrrolidone (NVP):



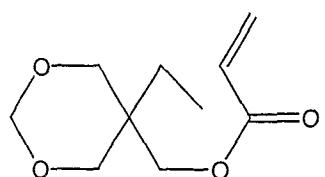
The monofunctional (meth)acrylate monomers are also well known in the art and are preferably the esters of acrylic acid. Preferred examples include:

5



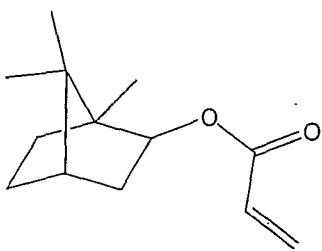
Phenoxyethyl acrylate (PEA)

mol wt 192 g/mol



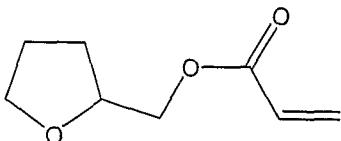
Cyclic TMP formal acrylate (CTFA)

mol wt 200 g/mol



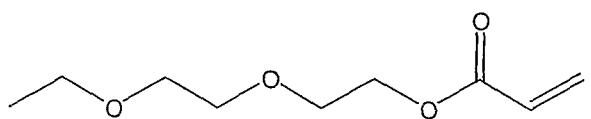
10 Isobornyl acrylate (IBOA)

mol wt 208 g/mol

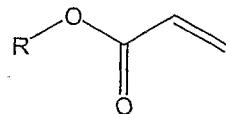


Tetrahydrofurfuryl acrylate (THFA)

mol wt 156 g/mol



2-(2-Ethoxyethoxy)ethyl acrylate mol wt 188 g/mol

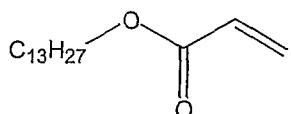


15

R = C₈H₁₇ / C₁₀H₂₁

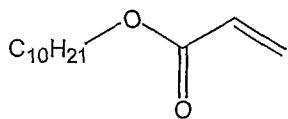
Octadecyl acrylate (ODA)

mol wt 200 g/mol

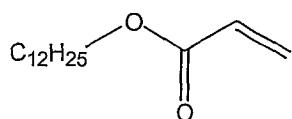


Tridecyl acrylate (TDA)

mol wt 254 g/mol



Isodecyl acrylate (IDA)
mol wt 212 g/mol



Lauryl acrylate
mol wt 240 g/mol

5 The substituents of the monofunctional monomers are not limited other than by the constraints imposed by the use in an ink-jet ink, such as viscosity, stability, toxicity etc. The substituents are typically alkyl, cycloalkyl, aryl and combinations thereof, any of which may be interrupted by heteroatoms. Non-limiting examples of substituents commonly used in the art include C₁₋₁₈ alkyl, C₃₋₁₈ cycloalkyl, C₆₋₁₀ aryl and combinations thereof, such as C₆₋₁₀ aryl- or C₃₋₁₈ cycloalkyl-substituted C₁₋₁₈ alkyl, any of which may be interrupted by 1-10 heteroatoms, such as oxygen or nitrogen, with nitrogen further substituted by any of the above described substituents.

10 The substituents may together also form a cyclic structure.

15 In a preferred embodiment, the monofunctional (meth)acrylate is a cyclic monofunctional (meth)acrylate. That is, the radical covalently bonded to the (meth)acrylate unit is cyclic. The cyclic radical may be saturated or unsaturated, including aromatic. Preferred cyclic monofunctional (meth)acrylates are phenoxyethyl acrylate (PEA), cyclic TMP formal acrylate (CTFA), isobornyl acrylate (IBOA), tetrahydrofurfuryl acrylate (THFA) or mixtures thereof. Most preferably, the monofunctional (meth)acrylates present are exclusively cyclic, i.e. they are the sole monofunctional (meth)acrylate(s) present.

20

25 The total amount of the at least one monofunctional (meth)acrylate monomer and the at least one monofunctional N-vinyl amide monomer in combination is preferably at least 60 wt%, more preferably at least 70 wt% and most preferably at least 80 wt%, based on the total weight of the ink.

30 The molar ratio of the at least one monofunctional (meth)acrylate monomer to the at least one monofunctional N-vinyl amide monomer is from 1.0 to 6.0. The upper limit to this ratio is preferably 4.0 or less, more preferably 3.5 or less, more preferably 2.0 or less and most preferably 1.6 or less. The lower limit to this ratio is preferably 1.1

or more, more preferably 1.2 or more, more preferably 1.3 or more and most preferably 1.5 or more. A particularly preferred range is 1.25 to 1.53.

Monofunctional acrylates and monofunctional N-vinyl amide, when combined, offer 5 significant improvements in cure response over the non-combined monomers. All of the combinations tested exhibited a minimum in the dose of UV light required for cure when cure response was plotted against monomer blend composition (further details are given in the examples hereinbelow). The depth of these minima are dependent on the individual cure speeds of the component monomers: the faster 10 curing the acrylate monomers when taken alone, the deeper the minimum in UV dose required.

Of those tested, many blends exhibited faster cure speeds than DPGDA (a difunctional acrylate) and in some cases speeds equivalent to TMPTA (a trifunctional 15 acrylate). These optimised blends provide significant advantages: high cure speeds can be achieved without compromising film properties such as flexibility, which is often sacrificed when multifunctional acrylates are employed.

It is possible to modify further the film properties of the ink-jet inks by inclusion of 20 multifunctional monomers, oligomers or inert resins, such as thermoplastic acrylics. However, it should be noted that in the case of oligomers and multifunctional monomers the flexibility may be adversely affected and also that some adjustments to stoichiometry may be required to retain optimum cure speed.

25 Examples of the multifunctional acrylate monomers which may be included in the ink-jet ink formulation include hexanediol diacrylate, trimethylolpropane triacrylate, pentaerythritol triacrylate, polyethyleneglycol diacrylate, for example, tetraethyleneglycol diacrylate), dipropyleneglycol diacrylate, tri(propylene glycol) triacrylate, neopentylglycol diacrylate, bis(pentaerythritol) hexa-acrylate, and the 30 acrylate esters of ethoxylated or propoxylated glycols and polyols, for example, propoxylated neopentyl glycol diacrylate, ethoxylated trimethylolpropane triacrylate, and mixtures thereof. Particularly preferred are difunctional acrylates with a molecular weight greater than 200.

In addition, suitable multifunctional acrylate monomers include esters of methacrylic acid (i.e. methacrylates), such as hexanediol dimethacrylate, trimethylolpropane trimethacrylate, triethyleneglycol dimethacrylate, diethyleneglycol dimethacrylate, ethyleneglycol dimethacrylate; 1,4-butanediol dimethacrylate.

5

Mixtures of (meth)acrylates may also be used.

In one embodiment the ink is substantially free of multifunctional monomer, meaning that only trace amounts will be present, for example as impurities in the 10 monofunctional material or as a component in a commercially available pigment dispersion. Where multifunctional monomer is included, the multifunctional monomer is present in an amount of no more than 30 wt%, preferably no more than 25 wt%, more preferably no more than 20 wt% and most preferably no more than 15 wt% based on the total weight of the ink. The multifunctional monomer which is 15 limited in amount may be any multifunctional monomer which could be involved in the curing reaction, such as a multifunctional (meth)acrylate monomer or a multifunctional vinyl ether.

In an embodiment the ink is substantially free of oligomeric and polymeric material 20 meaning that only trace amounts will be present. Where oligomeric or polymeric material is included, the oligomeric and polymeric material is present in an amount of no more than 20 wt%, more preferably no more than 10 wt%, most preferably no more than 5 wt% based on the total weight of the ink. Oligomeric and polymeric materials (e.g. acrylate oligomers and inert thermoplastic resins, respectively) are 25 known in the art and typically have a molecular weight above 500, more preferably above 1000.

In addition to the monomers described above, the compositions include a photoinitiator, which, under irradiation by, for example, ultraviolet light, initiates the 30 polymerisation of the monomers. Preferred are photoinitiators which produce free radicals on irradiation (free radical photoinitiators) such as, for example, benzophenone, 1-hydroxycyclohexyl phenyl ketone, 2-benzyl-2-dimethylamino-(4-morpholinophenyl)butan-1-one, benzil dimethylketal, bis(2,6-dimethylbenzoyl)-2,4,4-trimethylpentylphosphine oxide or mixtures thereof. Such photoinitiators are known

and commercially available such as, for example, under the trade names Irgacure, Darocur (from Ciba) and Lucerin (from BASF).

Preferably the photoinitiator is present from 1 to 20% by weight, preferably from 4 to

5 10% by weight, of the ink.

The ink-jet ink of the present invention also includes a colouring agent, which may be either dissolved or dispersed in the liquid medium of the ink. Preferably the colouring agent is a dispersible pigment, of the types known in the art and commercially available such as, for example, under the trade-names Paliotol (available from BASF plc), Cinquasia, Irgalite (both available from Ciba Speciality Chemicals) and Hostaperm (available from Clariant UK). The pigment may be of any desired colour such as, for example, Pigment Yellow 13, Pigment Yellow 83, Pigment Red 9, Pigment Red 184, Pigment Blue 15:3, Pigment Green 7, Pigment Violet 19, Pigment Black 7. Especially useful are black and the colours required for trichromatic process printing. Mixtures of pigments may be used.

The total proportion of pigment present is preferably from 0.5 to 15% by weight, more preferably from 1 to 5% by weight.

20

Although the ink of the present invention cures by a free radical mechanism, the ink of the present invention may also be a so-called "hybrid" ink which cures by a radical and cationic mechanism. The ink-jet ink of the present invention, in one embodiment, therefore further comprises at least one cationically curable monomer, such as a vinyl ether, and at least one cationic photoinitiator, such as an iodonium or sulfonium salt, e.g. diphenyliodonium fluoride and triphenylsulfonium hexafluophosphate. Suitable cationic photoinitiators include the Union Carbide UV1-69-series, Deuteron UV 1240 and IJY2257, Ciba Irgacure 250 and CGI 552, IGM-C440, Rhodia 2047 and UV9380c.

25 30

Other components of types known in the art may be present in the ink to improve the properties or performance. These components may be, for example, surfactants, defoamers, dispersants, synergists for the photoinitiator, stabilisers against

deterioration by heat or light, reodorants, flow or slip aids, biocides and identifying tracers.

The present invention also provides a method of ink-jet printing using the above-
5 described ink and a substrate having the cured ink thereon. Suitable substrates include styrene, PolyCarb (a polycarbonate), BannerPVC (a PVC) and VIVAK (a polyethylene terephthalate glycol modified). The ink of the present invention is preferably cured by ultraviolet irradiation and is suitable for application by ink-jet printing. The present invention further provides an ink-jet ink cartridge containing the
10 ink-jet ink as defined herein. The cartridge comprises an ink container and an ink delivery port which is suitable for connection with an ink-jet printer.

The ink-jet ink exhibits a desirable low viscosity (less than 100 mPas, preferably less than 50 mPas and most preferably less than 25 mPas at 25°C).

15 (Meth)acrylate is intended herein to have its standard meaning, i.e. acrylate and/or methacrylate. Mono and multifunctional are also intended to have their standard meanings, i.e. one and two or more groups, respectively, which take part in the polymerisation reaction on curing.

20 The inks of the invention may be prepared by known methods such as, for example, stirring with a high-speed water-cooled stirrer, or milling on a horizontal bead-mill.

Examples

25 The invention will now be described, by way of example, with reference to the following example (parts given are by weight).

Example 1 (Reference example)

30 Ink-jet ink formulations were prepared by varying the monomer composition whilst holding all the other components constant, as set out in Table 1.

Table 1. Cyan formulation used for all cure response testing.

Component	Percentage in formula
Colour concentrate	4.53
Monomer	81.86
UV stabilizer	0.8
Irgacure 184	1.88
Acyl phosphine oxide	8.01
Benzophenone	2.82
Silicone wetting agent	0.1

A series of monomers were evaluated in the above formula and compared for cure speed. Inks were drawn down onto to 220 micron gloss PVC using a 12 micron K bar applicator. The films were cured using a Svecia UV drier fitted with two independently switchable 80 W/cm lamps. In each case the UV dose required to cure the ink film to a tack-free state was measured.

The results are set out in Tables 2a and 2b which show samples cured with two lamps on full power and samples cured on half power, respectively.

Table 2a. Cure speeds of monomers in test formula.

Monomer	UV Dose required (mJ/cm ²)	No. of lamps & Power setting	Belt speed (m/min)
TMPTA	105	2 x half power	30
CTFA	220	2 x half power	16
DPGDA	400	2 x half power	>10
IBOA	480	2 x half power	7
PEA	>480	2 x half power	< 7

Table 2b. Cure speeds of monomers in test formula.

Monomer	UV Dose required (mJ/cm ²)	No. of lamps & Power setting	Belt speed (m/min)
THFA	500	2 x full power	14
EOEOEA	840	2 x full power	8
NVC	1000+	2 x full power	< 7
TDA	1000+	2 x full power	< 7
ODA	1000 ++	2 x full power	<< 7
IDA	1000++	2 x full power	<< 7
Lauryl acrylate	1000++	2 x full power	<< 7

Example 2

5 Further studies on blends of monofunctional acrylate highlighted a curiosity, that a blend of monofunctional acrylate with NVC showed a non linear cure speed response, a maximum in the cure response being observed, for example, at a NVC:PEA ratio of 1:1.7 by weight. Table 3 sets out the monomer compositions which provided the maximum cure speed for each monomer pair.

10

Table 3. Monomer composition at peak cure response.

Monomer	UV dose for cure (mJ/cm ²)	% NVC by weight	% monoacrylate by weight	Molar ratio Monoacrylate/ NVC
THFA	205	30	51.86	1.53
IBOA	140	30	51.86	1.15
EOEOEA	700	15	66.86	3.30
IDA	880	30	51.86	1.13
PEA	200	30	51.86	1.25
CTFA	120	37.5	44.36	1.47

The data from Tables 2 and 3 are summarised in Table 4:

Table 4. Minimum UV dose for individual acrylates and corresponding NVC/acrylate blends.

Monomer	UV dose for cure (mJ/cm ²)	
	Acrylate only	Acrylate + NVC
THFA	500	205
IBOA	480	140
EOEOEA	840	700
IDA	1000 ++	880
PEA	>480	200
CTFA	220	100
TMPTA	105	<60
NVC	1000+	1000+

Fig. 1 also shows a graphical representation of UV dose minima against the amount of NVC present. Where the amount of NVC is zero, the doses for cure are as set out in Reference Example 1. As the amount of NVC is increased the dose required for cure decreases showing that the addition of NVC advantageously increases cure speed. The increase in cure speed provides an improved ink with the maximum improvement in the cure speed being identified by the minima in Fig. 1. By way of a reference, the doses required for the cure of the di- and trifunctional acrylates DPGDA and TMPTA when taken alone are also shown in Fig. 1.

Example 3

During the evaluation it was noted that combinations of NVC and N-acryloylmorpholine (ACMO) only did not exhibit this trend. Although not wishing to be bound by theory, it is believed that this may be due to the similar nature of the unsaturation in the monomers, both having nitrogen close to the double bond.

Example 4

A formula containing a blend of NVP and IBOA was prepared and evaluated as described hereinabove with similar results which are set out in Fig. 2.

Example 5

Particularly preferred examples of ink-jet inks of the present invention are set out in

5 Table 5:

Table 5. Preferred blends of acrylate and amide

Monomer blend	Weight ratio	Comparative speed
THFA / NVC	51.86 / 30	Faster than DPGDA
IBOA / NVC	51.86 / 30	Faster than DPGDA
PEA / NVC	51.86 / 30	Faster than DPGDA
CTFA / NVC	44.36 / 37.5	Equivalent to TMPTA
IBOA / NVP	51.86 / 30	Equivalent to TMPTA

Example 6

10

A cyan ink-jet ink formulation of the present invention was prepared by combining the following components:

Pigment dispersion *	4.53
15 N Vinyl caprolactam	30.70
Phenoxyethyl acrylate	51.16
Firstcure ST-1	0.8
Irgacure 184	1.88
Acyl phosphine oxide	8.01
20 Benzophenone	2.82
Byk 307	0.1

*Pigment dispersion:

SOLSPERSE 32000	10.00
25 FIRSTCURE ST - 1	1.00
SARTOMERSR 9003	59.00 (propoxylated NPGDA - difunctional)
IRGALITE BLUE GLVO	30.00

Claims

1. An ink-jet ink comprising at least one monofunctional (meth)acrylate monomer; at least one monofunctional N-vinyl amide monomer; at least one radical photoinitiator; and at least one colouring agent; wherein the ink has a viscosity of less than 100 mPas at 25°C, and wherein the molar ratio of the at least one monofunctional (meth)acrylate monomer to the at least one monofunctional N-vinyl amide monomer is from 1.0 to 6.0.
5
2. An ink-jet ink as claimed in claim 1, wherein the total amount of the at least one monofunctional (meth)acrylate monomer and the at least one monofunctional N-vinyl amide monomer is at least 60 wt% based on the total weight of the ink.
10
3. An ink-jet ink as claimed in claim 2, wherein the total amount is at least 70 wt%.
4. An ink-jet ink as claimed in claim 3, wherein the total amount is at least 80 wt%.
5. An ink-jet ink as claimed in any preceding claim, wherein the upper limit in the molar ratio of the at least one monofunctional (meth)acrylate monomer to the at least one monofunctional N-vinyl amide monomer is 4.0 or less.
15
6. An ink-jet ink as claimed in claim 5, wherein the upper limit in the ratio is 3.5 or less.
7. An ink-jet ink as claimed in any preceding claim, wherein the lower limit in the molar ratio of the at least one monofunctional (meth)acrylate monomer to the at least one monofunctional N-vinyl amide monomer is 1.1 or more.
20
8. An ink-jet ink as claimed in any preceding claim, wherein the ink contains no more than 30 wt% of multifunctional monomers based on the total weight of the ink.
9. An ink-jet ink as claimed in any preceding claim, wherein the ink contains at least one multifunctional monomer and one or more of the multifunctional monomers a multifunctional (meth)acrylate monomer.
25

10. An ink-jet ink as claimed in any preceding claim, wherein the at least one monofunctional (meth)acrylate is selected from phenoxyethyl acrylate (PEA), cyclic TMP formal acrylate (CTFA), isobornyl acrylate (IBOA), tetrahydrofurfuryl acrylate (THFA), 2-(2-ethoxyethoxy)ethyl acrylate, octa/decyl acrylate (ODA), tridecyl acrylate (TDA), isodecyl acrylate (IDA) and lauryl acrylate.

5 11. An ink-jet ink as claimed in any of claims 1 to 9, wherein the at least one monofunctional (meth)acrylate is a cyclic monofunctional (meth)acrylate.

12. An ink-jet ink as claimed in claim 11, wherein the ink comprises at least one cyclic monofunctional (meth)acrylate as the sole monofunctional (meth)acrylate(s)

10 present.

13. An ink-jet ink as claimed in claim 11 or 12, wherein the cyclic monofunctional (meth)acrylate is phenoxyethyl acrylate (PEA), cyclic TMP formal acrylate (CTFA), isobornyl acrylate (IBOA), tetrahydrofurfuryl acrylate (THFA), or mixtures thereof.

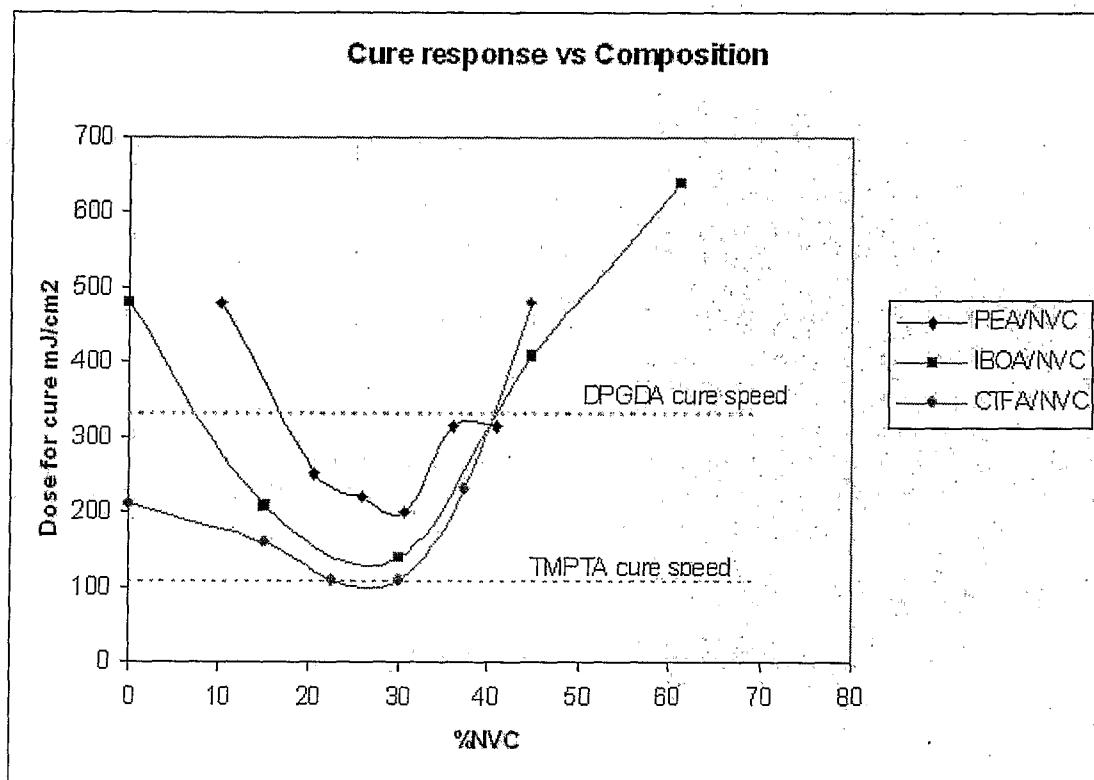
14. An ink-jet ink as claimed in any of claims 10 to 13, wherein the ink contains a combination of monomers selected from THFA/NVC, IBOA/NVC, PEA/NVC, CTFA/NVC, IBOA/ACMO and IBOA/NVP.

15 15. A method of ink-jet printing, comprising printing the ink-jet ink as claimed in any preceding claim on to a substrate and curing the ink.

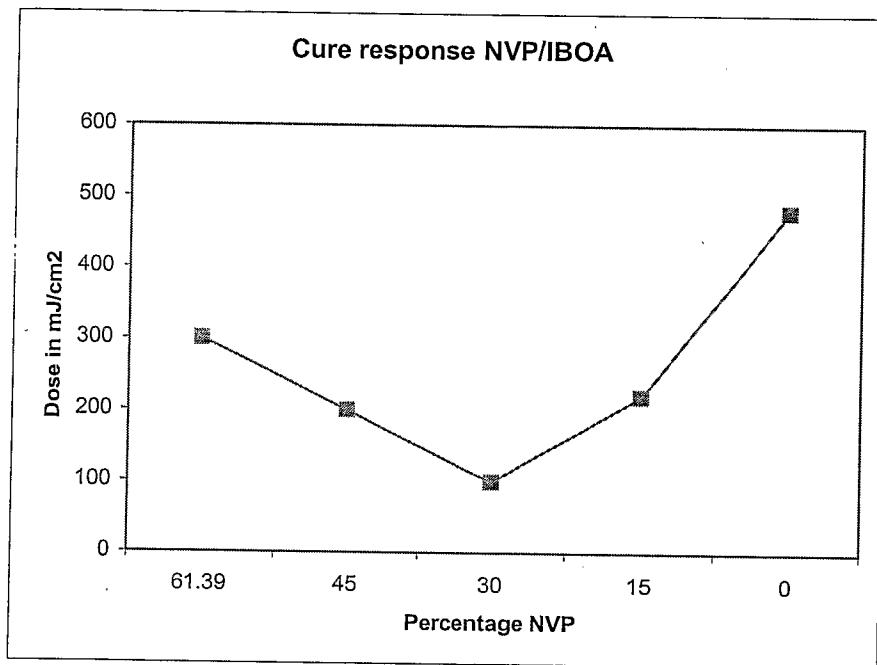
16. A substrate having the ink-jet ink as claimed in any of claims 1 to 14 printed 20 thereon.

17. An ink-jet ink cartridge containing the ink-jet ink as claimed in any of claims 1 to 14.

1/2

**Fig. 1**

2/2

**Fig. 2**

INTERNATIONAL SEARCH REPORT

International application No

PCT/GB2007/001416

A. CLASSIFICATION OF SUBJECT MATTER
INV. C09D11/10

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)
C09D

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 practical, search terms used)

EPO-Internal

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	WO 02/38687 A (3M INNOVATIVE PROPERTIES CO [US]) 16 May 2002 (2002-05-16) examples 1,3; table 7	1-17
X	WO 2005/026270 A (SUN CHEMICAL B V [NL]; SELMAN HARTLEY DAVID [GB]; CAIGER NIGEL ANTHONY) 24 March 2005 (2005-03-24) example 5	1-17
X	WO 03/010249 A (3M INNOVATIVE PROPERTIES CO [US]) 6 February 2003 (2003-02-06) examples 1-48	1-17
X	US 2004/006157 A1 (GLOSTER DANIEL F [US] ET AL) 8 January 2004 (2004-01-08) claim 10; example 3	1-17



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents :

- *A* document defining the general state of the art which is not considered to be of particular relevance
- *E* earlier document but published on or after the international filing date
- *L* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- *O* document referring to an oral disclosure, use, exhibition or other means
- *P* document published prior to the international filing date but later than the priority date claimed

T later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

X document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

Y document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

& document member of the same patent family

Date of the actual completion of the international search

3 July 2007

Date of mailing of the international search report

11/07/2007

Name and mailing address of the ISA/

European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl
Fax: (+31-70) 340-3016

Authorized officer

Ellrich, Klaus

INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/GB2007/001416

Patent document cited in search report	Publication date		Patent family member(s)		Publication date
WO 0238687	A 16-05-2002	AU EP JP US US	9698801 A 1332188 A1 2004522813 T 2003158283 A1 6558753 B1		21-05-2002 06-08-2003 29-07-2004 21-08-2003 06-05-2003
WO 2005026270	A 24-03-2005	BR CA EP GB JP KR US	PI0414302 A 2539369 A1 1668084 A1 2422612 A 2007505964 T 20060119981 A 2007042162 A1		07-11-2006 24-03-2005 14-06-2006 02-08-2006 15-03-2007 24-11-2006 22-02-2007
WO 03010249	A 06-02-2003	BR CA CN EP JP US	0211348 A 2453250 A1 1537149 A 1412438 A1 2004536925 T 2003083396 A1		21-09-2004 06-02-2003 13-10-2004 28-04-2004 09-12-2004 01-05-2003
US 2004006157	A1 08-01-2004		NONE		