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**DE-A- 3 231 820**                      **DE-A- 3 329 746**  
**US-A- 4 777 113**                      **US-A- 4 822 727**

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**Description****BACKGROUND OF THE INVENTION****FIELD OF THE INVENTION**

**[0001]** This invention relates to imaging elements and more particularly to photographic imaging elements.

**[0002]** Support materials for imaging elements often employ layers comprising glassy, hydrophobic polymers such as polyacrylates, polymethacrylates, polystyrenes, or cellulose esters, for example. One typical application is as a backing layer to provide resistance to scratches, abrasion, blocking, and ferrotyping. The latter two properties relate to the propensity of layers applied onto the support material or imaging element to stick together as a result of the adverse humidity, temperature, and pressure conditions that may occur during the manufacture and use of the imaging element.

**[0003]** These glassy polymers are typically coated from organic solvent-based solutions to yield a continuous film upon evaporation of the solvent. However, because of environmental considerations, it is desirable to replace organic solvent-based coating formulations with water-based coating formulations. The challenge has been to provide imaging elements containing layers having similar physical and chemical properties in the dried film to that obtained with organic solvent-based coatings, but which are the result of water-based coating compositions substantially free of organic solvents.

**[0004]** Water insoluble polymer particles contained in aqueous latexes and dispersions reported to be useful for coatings on photographic films typically have low glass transition temperatures (T<sub>g</sub>) to insure coalescence of the polymer particles into a strong, continuous film. Generally the T<sub>g</sub> of such polymers is less than 50°C., frequently the T<sub>g</sub> is no more than 30°C. Typically these polymers are used in priming or "subbing" layers which are applied onto the film support to act as adhesion promoting layers for photographic emulsion layers. Such low T<sub>g</sub> polymers, although useful when they underly an emulsion layer, are not suitable as, for example, backing layers since their blocking and ferrotyping resistance are poor. To fully coalesce a polymer latex with a higher T<sub>g</sub> requires significant concentrations of coalescing aids. This is undesirable for several reasons.

Volatilization of the coalescing aid as the coating dries is not desirable from an environmental standpoint. In addition, subsequent recondensation of the coalescing aid in the cooler areas of the coating machine may cause coating imperfections and conveyance problems. Coalescing aid which remains permanently in the dried coating will plasticize the polymer and adversely affect its resistance to blocking, ferrotyping, and abrasion. Thus, there is a need for imaging elements containing layers that perform various functions not having the disadvantages associated with layers applied from organic solutions.

**[0005]** US Patent No. 4,822,727 describes a silver halide photographic light-sensitive material having on a support at least one light-sensitive silver halide emulsion layer and at least one light-insensitive upper layer on the emulsion layer, in which at least one light-insensitive upper layer contains a polymer latex having a glass transition point of at least 20°C and said light-insensitive layer and/or at least one other light-insensitive layer contains a polymer latex having a glass transition point of lower than 20°C.

**SUMMARY OF THE INVENTION**

**[0006]** The invention provides an imaging element comprising a support, at least one light-sensitive layer e.g. a silver halide emulsion layer, and at least one coalesced layer coated from a continuous aqueous phase having dispersed therein a mixture of film-forming colloidal polymeric particles having an average particle size of from 10 to 500 nm and non-film-forming colloidal polymeric particles having an average particle size of from 10 to 500nm.

**[0007]** The coalesced layers are especially suitable for imaging elements due to their high transparency and toughness.

**DETAILED DESCRIPTION OF THE INVENTION**

**[0008]** While the invention is applicable to all types of imaging elements such as, thermal imaging elements, electrophotographic elements, vesicular elements and the like, the invention is particularly applicable for use in photographic elements which, for the purpose of simplicity of explanation, will be referred to hereinafter. The coalesced layers can be employed as subbing layers, overcoat layers, backing layers, receiving layers, barrier layers, timing layers, antihalation layers, antistatic layers, stripping layers, mordanting layers, scavenger layers, antikinking layers, transparent magnetic layers. The coalesced layers in accordance with this invention are particularly advantageous due to superior physical properties including transparency, toughness necessary for providing resistance to scratches, abrasion, blocking and ferrotyping, in addition to environmental considerations such as, the preparation of layers sub-

stantially free of solvents and general procedural advantages including ease of preparation together with short drying times.

**[0009]** The invention further provides an imaging element comprising a support having disposed thereon an antistat layer and an overlying protective layer of a coalesced layer of film-forming colloidal polymeric particles and non-film-forming colloidal polymeric particles.

**[0010]** The protective layer is coated from an aqueous composition comprising a mixture of film-forming, water dispersible polymeric particles and non-film-forming, water dispersible polymeric particles. The mixture of polymers with different film-forming characteristics yields an overcoat composition that readily forms a high quality, continuous transparent film that prevents the loss of antistatic properties during film processing and provides scratch and abrasion resistance.

**[0011]** The antistatic layer described in U.S. Patent 4,203,769 is prepared by coating an aqueous colloidal solution of vanadium pentoxide. Preferably, the vanadium pentoxide is doped with silver. A polymer binder, such as vinylidene chloride-containing terpolymer latex or a polyesterionomer dispersion, is preferably employed in the antistatic layer to improve the integrity of the layer and to improve adhesion to the undercoat layer. The weight ratio of polymer binder to vanadium pentoxide can range from about 1:5 to 200:1, but, preferably 1:1 to 10:1. The antistatic coating formulation may also contain a wetting aid to improve coatability. Typically, the antistat layer is coated at a dry coverage of from about 1 to 200 mg/m<sup>2</sup>.

**[0012]** Antistatic layers described in U.S. Patent No. 4,070,189 comprise a crosslinked vinylbenzene quaternary ammonium polymer in combination with a hydrophobic binder wherein the weight ratio of binder to antistatic crosslinked polymer is about 10:1 to 1:1.

**[0013]** The antistatic compositions described in U.S. Patents 4,237,194; 4,308,332; and 4,526,706 comprise a coalesced, cationically stabilized latex and a polyaniline acid addition salt semiconductor wherein the latex and semiconductor are chosen so that the semiconductor is associated with the latex before coalescing. Particularly preferred latex binders include cationically stabilized, coalesced, substantially linear, polyurethanes. The weight ratio of polymer latex particles to polyaniline in the antistatic coating composition can vary over a wide range. A useful range of this weight ratio is about 1:1 to 20:1. Typically, the dried coating weight of this antistatic layer is about 40 mg/m<sup>2</sup> or less.

**[0014]** Whether colloidal polymeric particles are film-forming or non-film-forming is determined by the following test:

**[0015]** An aqueous coating formulation of 3% by weight of colloidal polymeric particles free of organic solvent or coalescing aid, is applied to a sheet of polyethylene terephthalate in a wet coverage of 10 ml/m<sup>2</sup> and dried for 2 minutes at 75°C. Polymers that form clear, transparent continuous films under these conditions are film-forming, while those that do not form clear, transparent continuous films are non-film-forming, for the purpose of this invention.

**[0016]** The coalesced layers in accordance with this invention are formed from colloidal polymeric particles that are a discontinuous phase of solid, water-insoluble particles suspended in a continuous aqueous medium. The solid, water insoluble particles of both the film-forming and non-film-forming polymers have an average particle size of from 10 to 500 nm, preferably from 10 to 200 nm. The film forming polymer is present in the coalesced layer in an amount of from 20 to 70 percent by weight and preferably from 30 to 50 percent by weight based on the total weight of the layer.

**[0017]** The imaging elements in accordance with this invention comprise a support material having thereon at least one coalesced layer coated from an aqueous composition comprising a mixture of a film-forming, water dispersible polymer and a non-film-forming, water dispersible polymer. The support material may comprise various polymeric films including cellulose esters, such as cellulose acetate, cellulose diacetate, cellulose triacetate, cellulose acetate butyrate, cellulose propionate; polycarbonate, polystyrene, polyolefins, such as, polyethylene, polypropylene; polyesters, such as polyethylene terephthalate, polyethylene naphthalate; and paper or glass. Polyester film support is preferred. The thickness of the support is not critical. Support thickness of 50 µm to 254 µm (2 to 10 mil) can be employed, for example, with very satisfactory results. The polyester support typically employs an undercoat or primer layer well known in the art that comprise, for example, a vinylidene chloride/methyl acrylate/itaconic acid terpolymer or vinylidene chloride/acrylonitrile/acrylic acid terpolymer as described in U.S. Patent Nos. 2,627,088; 2,698,235; 2,698,240; 2,943,937; 3,143,421; 3,201,249; 3,271,178; and 3,501,301.

**[0018]** Coating compositions for preparing coalesced layers in accordance with the invention comprise a continuous aqueous phase having dispersed therein a mixture of film-forming polymeric particles (component A) and non-film-forming polymeric particles (component B). As in the coalesced layers, as indicated above, Component A comprises 20 to 70% of the total weight of components A and B of the coating composition. Other additional compounds may be added to the coating composition, depending on the function of the particular layer, including surfactants, emulsifiers, coating aids, matte particles, rheology modifiers, crosslinking agents, inorganic fillers such as metal oxide particles, pigments, magnetic particles e.g. cobalt doped gamma iron oxide and biocides. The coating composition may also include small amounts of organic solvents, preferably the concentration of organic solvent is less than 1 weight % of the total coating composition.

**[0019]** The non-film-forming polymer (B) comprises glassy polymers that provide resistance to blocking, ferrotyping, abrasion and scratches. Non-film-forming polymer B is present in the coating composition and in the photographic

layer in an amount of from 30 to 80 and preferably from 50 to 70 percent based on the total weight of film-forming polymer (A) and non-film-forming polymer (B). These polymers include addition-type polymers and interpolymers prepared from ethylenically unsaturated monomers such as acrylates including acrylic acid, methacrylates including methacrylic acid, acrylamides and methacrylamides, itaconic acid and its half esters and diesters, styrenes including substituted styrenes, acrylonitrile and methacrylonitrile, vinyl acetates, vinyl ethers, vinyl and vinylidene halides, and olefins. In addition, crosslinking and graft-linking monomers such as 1,4-butyleneglycol methacrylate, trimethylolpropane triacrylate, allyl methacrylate, diallyl phthalate, divinyl benzene may be used. Other polymers that may comprise component B include water-dispersible condensation polymers such as polyesters, polyurethanes, polyamides, and epoxies. Polymers suitable for component B do not give transparent, continuous films upon drying when the above-described test is applied.

**[0020]** The film-forming polymer (A) comprises polymers that form a continuous film under the extremely fast drying conditions typical of the photographic film manufacturing process. Polymers that are suitable for component A are those that give transparent, continuous films when the above-described test is applied and include addition-type polymers and interpolymers prepared from ethylenically unsaturated monomers such as acrylates including acrylic acid, methacrylates including methacrylic acid, acrylamides and methacrylamides, itaconic acid and its half esters and diesters, styrenes including substituted styrenes, acrylonitrile and methacrylonitrile, vinyl acetates, vinyl ethers, vinyl and vinylidene halides, and olefins. In addition, crosslinking and graft-linking monomers such as 1,4-butyleneglycol methacrylate, trimethylolpropane triacrylate, allyl methacrylate, diallyl phthalate, divinyl benzene may be used. Other suitable polymers useful as component A are film-forming dispersions of polyurethanes or polyesterionomers.

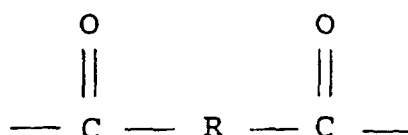
**[0021]** The colloidal polymeric particles can be prepared either by emulsion polymerization or by emulsifying pre-formed polymers in water with a proper dispersing agent. In both cases, chain transfer agents including mercaptans, polymercaptans, and halogen compounds can be used in the polymerization mixture to moderate the polymer molecular weight. The weight average molecular weight of prepared polymers may vary from 5,000 to 30,000,000 and preferably from 50,000 to 10,000,000.

**[0022]** Preparation of polyurethane dispersions is well-known in the art and involves chain extending an aqueous dispersion of a prepolymer containing terminal isocyanate groups by reaction with a diamine or diol. The prepolymer is prepared by reacting a polyester, polyether, polycarbonate, or polyacrylate having terminal hydroxyl groups with excess polyfunctional isocyanate. This product is then treated with a compound that has functional groups that are reactive with an isocyanate, for example, hydroxyl groups, and a group that is capable of forming an anion, typically this is a carboxylic acid group. The anionic groups are then neutralized with a tertiary amine to form the aqueous prepolymer dispersion.

**[0023]** The term polyesterionomer refers to polyesters that contain at least one ionic moiety. Such ionic moieties function to make the polymer water dispersible. These polyesters are prepared by reacting one or more dicarboxylic acids or their functional equivalents such as anhydrides, diesters, or diacid halides with one or more diols in melt phase polycondensation techniques as described in U.S. Patents 3,018,272; 3,929,489; 4,307,174; 4,419,437. Examples of this class of polymers include, for example, Eastman AQ polyesterionomers, manufactured by Eastman Chemical Co.

**[0024]** Typically the ionic moiety is provided by some of the dicarboxylic acid repeat units, the remainder of the dicarboxylic acid repeat units are nonionic in nature. Such ionic moieties can be anionic or cationic, but, anionic moieties are preferred for the present invention. Preferably, the ionic dicarboxylic acid contains a sulfonic acid group or its metal salt. Examples include the sodium, lithium, or potassium salt of sulfoterephthalic acid, sulfonaphthalene dicarboxylic acid, sulfophthalic acid, and sulfoisophthalic acid or their functional equivalent anhydride, diester, or diacid halide. Most preferably the ionic dicarboxylic acid repeat unit is provided by 5-sodiosulfoisophthalic acid or dimethyl 5-sodiosulfoisophthalate.

**[0025]** The nonionic dicarboxylic acid repeat units are provided by dicarboxylic acids or their functional equivalents represented by the formula:



where R is an aromatic or aliphatic hydrocarbon or contains both aromatic and aliphatic hydrocarbons. Exemplary compounds include isophthalic acid, terephthalic acid, succinic acid and adipic acid.

**[0026]** Suitable diols are represented by the formula: HO-R-OH, where R is aromatic or aliphatic or contains both aromatic and aliphatic hydrocarbons. Preferably the diol includes one or more of the following: ethylene glycol, diethylene glycol, or 1,4-cyclohexanedimethanol.

**[0027]** The polyesterionomer dispersions comprise from about 1 to about 25 mol %, based on the total moles of dicarboxylic acid repeat units, of the ionic dicarboxylic acid repeat units. The polyesterionomers have a glass transition temperature (T<sub>g</sub>) of about 60°C. or less to allow the formation of a continuous film.

**[0028]** The film-forming polymeric particles, the non-film-forming polymeric particles or both type particles may include reactive functional groups capable of forming covalent bonds by intermolecular crosslinking or by reaction with a crosslinking agent (i.e., a hardener). Suitable reactive functional groups include: hydroxyl, carboxyl, carbodiimide, epoxide, aziridine, vinyl sulfone, sulfinic acid, active methylene, amino, amide, allyl.

**[0029]** The coating compositions in accordance with the invention may also contain suitable crosslinking agents that may effectively be used in the coating compositions of the invention including aldehydes, epoxy compounds, polyfunctional aziridines, vinyl sulfones, methoxyalkyl melamines, triazines, polyisocyanates, dioxane derivatives such as dihydroxydioxane, carbodiimides, chrome alum, and zirconium sulfate. The crosslinking agents may react with functional groups present on either the film-forming polymers, the non-film-forming polymers or on both.

**[0030]** Matte particles well known in the art may be used in the coating composition of the invention, such matting agents have been described in Research Disclosure No. 308, published Dec 1989, pages 1008 to 1009. When polymeric matte particles are employed, the polymers may contain reactive functional groups capable of forming covalent bonds by intermolecular crosslinking or by reaction with a crosslinking agent (i.e., a hardener) in order to promote improved adherence to the film-forming and non-film-forming polymers of the invention. Suitable reactive functional groups include: hydroxyl, carboxyl, carbodiimide, epoxide, aziridine, vinyl sulfone, sulfinic acid, active methylene, amino, amide, allyl.

**[0031]** The coating compositions of the present invention may also include lubricants or combinations of lubricants to reduce sliding friction of the photographic elements in accordance with the invention. Virtually any type of water soluble or dispersible lubricants can be used. For example, (1) water soluble or dispersible paraffin or wax-like materials, including vegetable waxes, insect waxes, mineral waxes, petroleum waxes, synthetic waxes, carnauba wax, as well as wax-like components that occur individually in these waxes, (2) perfluoro- or fluoro- or fluorochloro-containing materials, which include poly(tetrafluoroethylene), poly(trifluorochloroethylene), poly(vinylidene fluoride), poly(trifluorochloroethylene-co-vinyl chloride), poly(meth)acrylates containing fluoro or perfluoroalkyl side groups, (3) poly(meth)acrylates or poly(meth)acrylamides containing long alkyl side groups, (4) silicone lubricants including siloxane containing various (cyclo)alkyl, aryl, epoxypropylalkyl, polyoxyethylene, and polyoxypropylene side groups.

**[0032]** The above lubricants also may contain reactive functional groups such as hydroxyl, carboxyl, carbodiimide, epoxide, aziridine, vinyl sulfone, sulfinic acid, active methylene, amino, and amide. The lubricants can be incorporated in the coating composition in an amount from 0.1 to 150 mg/m<sup>2</sup>, preferably from 0.1 to 90 mg/m<sup>2</sup>.

**[0033]** Any of the reactive functional groups of the polymers and any of the crosslinking agents described in U.S. Patent 5,057,407 and the patents cited therein may be used in accordance with this invention.

**[0034]** The compositions of the present invention may be applied as aqueous coating formulations containing up to about 50% total solids by coating methods well known in the art. For example, hopper coating, gravure coating, skim pan/air knife coating, spray coating, and other methods may be used with very satisfactory results. The coatings are dried at temperatures up to 150°C. to give dry coating weights of 20 mg/m<sup>2</sup> to 10 g/m<sup>2</sup>.

**[0035]** The invention is applicable to thermal imaging elements wherein the coalesced layer may be employed as supports, dye-donor elements, dye-image receiving layers, barrier layers, overcoats, binders as described in U.S. Patents 5,288,689; 5,283,225; 4,772,582; 5,166,128.

**[0036]** The invention is further illustrated by the following examples in which parts and percentages are by weight unless otherwise stated. Polymeric particles used in the example coatings together with the film-forming character of each are listed in Table 1. The film forming characteristic of each polymer is defined by the test set forth above.

TABLE 1

Polymer	Polymer Composition	T <sub>g</sub> , °C.	Description
P-1	Methyl methacrylate homopolymer	125	Non-film-forming
P-2	Methyl methacrylate/methacrylic acid 97/3	130	Non-film-forming
P-3	Methacrylonitrile homopolymer	115	Non-film-forming
P-4	Methacrylonitrile/methacrylic acid 97/3	115	Non-film-forming
P-5	Styrene/methacrylic acid 97/3	100	Non-film-forming
P-6	Butyl acrylate/acrylic acid 97/3	-40	Film-forming
P-7	Butyl acrylate/methyl methacrylate/acrylic acid 48.5/48.5/3	20	Film-forming
P-8	butyl acrylate/2-sulfo-1,1-dimethylethyl acrylamide/methyl 2-acrylamido-2-methoxyacetate 90/5/5	-20	Film-forming

TABLE 1 (continued)

Polymer	Polymer Composition	Tg, °C.	Description
P-9	Dow 620 latex (styrene-butadiene)	15	Film-forming
P-10	Dow 615 latex (styrene-butadiene)	10	Film-forming
P-11	ICI Neorez 960 polyurethane dispersion	10	Film-forming
P-12	Eastman Chemical Co. AQ29D polyesterionomer dispersion	29	Film-forming
P-13	Eastman Chemical Co. AQ55D polyesterionomer dispersion	55	Film-forming

#### Comparative Samples A-G and Examples 1-16

**[0037]** Aqueous coating solutions comprising 3 weight % total solids were coated with a doctor blade onto polyethylene terephthalate film support that had been subbed with a terpolymer latex of acrylonitrile vinylidene chloride, and acrylic acid. The coating was dried at 90°C. for one minute and the coating appearance recorded, the results are listed in Table 2. Transparent, high-quality films that are comparable in appearance to organic solvent applied coatings were obtained for the coating compositions of the invention.

TABLE 2

Coating	Polymer A Film Forming	Polymer B Non-film-forming	B/A	Appearance
Sample A	none	P-1	100/0	Powdery/non-continuous
Sample B	none	P-2	100/0	Powdery/non-continuous
Sample C	none	P-3	100/0	Powdery/non-continuous
Sample D	none	P-4	100/0	Powdery/non-continuous
Sample E	none	P-5	100/0	Powdery/non-continuous
Sample F	P-11	P-1	90/10	Very hazy/non-continuous
Sample G	P-11	P-1	80/20	Hazy
Example 1	P-11	P-1	72.5/27.5	Excellent
Example 2	P-11	P-1	70/30	Excellent
Example 3	P-11	P-2	70/30	Excellent
Example 4	P-11	P-3	70/30	Excellent
Example 5	P-11	P-4	70/30	Excellent
Example 6	P-11	P-5	70/30	Excellent
Example 7	P-6	P-2	70/30	Excellent
Example 8	P-6	P-2	70/30	Excellent
Example 9	P-7	P-2	70/30	Excellent
Example 10	P-8	P-2	70/30	Excellent
Example 11	P-9	P-1	70/30	Continuous film/slight haze
Example 12	P-10	P-1	70/30	Continuous film/slight haze
Example 13	P-12	P-2	70/30	Excellent
Example 14	P-13	P-2	70/30	Excellent
Example 15	P-11	P-2	50/50	Excellent
Example 16*	P-11	P-2	60/40	Excellent

\*- PFAZ® 322 polyfunctional aziridine, Sybron Chemicals Inc., added at 10 wt % of solids.

#### Comparative Samples H, I and Examples 17-25

**[0038]** The following examples demonstrate the excellent physical properties that are obtained with coating compositions of the invention. Aqueous formulations comprising 3 weight % total solids were applied onto subbed film support as in the previous examples and dried at 90°C. for one minute to give transparent films with a dry coating weight of

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750 mg/m<sup>2</sup>. Taber abrasion for the coatings were measured and compared with a 750 mg/m<sup>2</sup> coating of Elvacite 2041 (methyl methacrylate polymer sold by E.I. DuPont de Nemours and Co.) that had been coated from methylene chloride solution. The Taber abrasion tests were performed in accordance with the procedures set forth in ASTM D1044. The results are given in Table 3.

TABLE 3

Coating	Description	Taber Abr. (% haze)
Sample H	Solvent coated Elvacite 2041	7.0
Sample I	P-11	13.5
Example 17	P-2/P-11 70/30 ratio	7.0
Example 18	P-2/P-11 70/30 ratio, with aziridine *	7.0
Example 19	P-2/P-11 72.5/27.5 ratio, with aziridine*	7.0
Example 20	P-2/P-12 70/30 ratio	9.8
Example 21	P-2/P-13 70/30 ratio	11.0
Example 22	P-2/P-13 70/30 ratio, with aziridine*	8.4
Example 23	P-2/P-11 50/50 ratio with aziridine*	7.0
Example 24	P-2/P-11 40/60 ratio with aziridine*	11.0
Example 25	P-2/P-11/Ludox AM 35/32.5/32.5	7.5

\*- PFAZ® 322 polyfunctional aziridine, Sybron Chemicals Inc., added at 10 wt % of solids.

### Comparative Samples J-L and Examples 26-39

**[0039]** The following examples show that the coating compositions of the invention provide void-free, impermeable films that are comparable with organic solvent applied layers. A subbed polyester film support as previously described was coated with an aqueous antistatic formulation comprising 0.025 weight % of silver-doped vanadium pentoxide, 0.075 weight % of a terpolymer latex of methylacrylate, vinylidene chloride, and itaconic acid (15/83/2) and dried at 100°C. to yield an antistatic layer having a dry weight of about 8 mg/m<sup>2</sup>. Aqueous coating compositions of the invention containing 1 to 3 weight % solids were applied over the antistatic layer and dried for 90 seconds at 100°C. to yield transparent coatings having a dry weight of 250 to 750 mg/m<sup>2</sup>. It is known (described in U.S. Patents 5,006,451 and 5,221,598) that the antistatic properties of the vanadium pentoxide layer are destroyed after film processing if not protected by an impermeable barrier. Thus, the permeability of the example coatings could be evaluated by measuring the antistatic properties of the samples after processing in conventional film developing and fixing solutions.

**[0040]** The samples were soaked in high pH (11.3) developing and fixing solutions as described in U.S. Patent 4,269,929, at 38°C. for 60 seconds each and then rinsed in distilled water. The internal resistivity (using the salt bridge method) of the processed samples at 20% relative humidity was measured and compared with the internal resistivity before processing. The coating compositions and results are reported in Table 4. The results show that coating compositions of the invention give void-free coatings that are as impermeable as a solvent cast film (sample J) and are far superior to an aqueous coating composition comprising only the high Tg methyl methacrylate copolymer dispersion alone (sample K).

TABLE 4

Coating	Description	Coating Weight (mg/m <sup>2</sup> )	Resistivity Before Process log Ω/sq.	Resistivity After Process log Ω/sq.
Sample J	Solvent Coated Elvacite 2041	750	7.5	7.7
Sample K	P-2 without film-forming polymer	750	7.5	>14.0
Sample L	P-11 without non-film-forming polymer	750	9.3	10.3
Example 26	P-2/P-12 70/30 ratio	750	7.9	8.3
Example 27	P-2/P-13 70/30 ratio	750	8.0	8.1
Example 28	P-2/P-11 70/30 ratio	750	8.0	8.9

TABLE 4 (continued)

Coating	Description	Coating Weight (mg/m <sup>2</sup> )	Resistivity Before Process log $\Omega$ /sq.	Resistivity After Process log $\Omega$ /sq.
Example 29	P-2/P-11 70/30 ratio, with aziridine*	750	7.6	7.6
Example 30	P-2/P-7 70/30 ratio, with aziridine*	750	7.6	7.6
Example 31	P-5/P-11 70/30 ratio	750	7.6	7.7
Example 32	P-5/P-13 70/30 ratio	750	7.6	7.8
Example 33	P-3/P-11 70/30 ratio	750	8.0	8.0
Example 34	P-4/P-11 70/30 ratio, with aziridine*	750	7.8	7.9
Example 35	P-2/P-11 70/30 ratio, with aziridine*	250	8.5	8.7
Example 36	P-2/P-11 50/50 ratio	1000	7.3	7.2
Example 37	P-2/P-11 40/60 ratio	1000	7.3	7.9
Example 38	P-2/P-11 70/30 ratio with aziridine* and polymethylmethacrylate 2 $\mu$ m matte	750	7.2	7.3
Example 39	P-2/P-11 70/30 ratio with aziridine* and polymethylmethacrylate-co-methacrylic acid 2 $\mu$ m matte	750	7.4	7.5

\*- PFAZ® 322 polyfunctional aziridine, Sybron Chemicals Inc., added at 10 wt % of solids.

#### Examples 40-42

**[0041]** In addition to testing procedures already described, Paper Clip Friction (PCF) and Single Arm Scratch were measured for the following examples using the procedure set forth in ANSI IT 9.4-1992 and ANSI PH 1.37-1977, respectively. These examples serve to illustrate the excellent lubricity and scratch resistance that can be obtained with coating compositions of the invention upon incorporation of various lubricant materials. The coatings of the invention were applied over a conductive layer comprising vanadium pentoxide as described in previous examples.

TABLE 5

Coating	Description	Coating Weight (mg/m <sup>2</sup> )	Resistivity Before Process log $\Omega$ /sq.	Resistivity After Process log $\Omega$ /sq.	PCF	Single Arm Scratch (gms)
Example 40	P-2/P-11 70/30 ratio, with aziridine.* Michemlube** 160 at 7.5mg/m <sup>2</sup>	1000	8.2	7.6	0.20	--
Example 41	P-2/P-11/Teflon 30+ 62/35/3 ratio with aziridine*	750	7.6	7.6	0.15	70

<sup>+</sup> - Teflon 30 and Teflon 3170 aqueous dispersions available from DuPont de Nemours and Co.

<sup>\*\*</sup> Aqueous carnauba wax dispersion sold by Michelman Inc.

\*- PFAZ® 322 polyfunctional aziridine, Sybron Chemicals Inc., added at 10 wt % of solids.



TABLE 5 (continued)

Coating	Description	Coating Weight (mg/m <sup>2</sup> )	Resistivity Before Process log $\Omega$ /sq.	Resistivity After Process log $\Omega$ /sq.	PCF	Single Arm Scratch (gms)
Example 42	P-2/P-11/Teflon 3170 <sup>+</sup> 62/35/3 ratio with aziridine*	750	7.8	7.9	0.125	110

\* - Teflon 30 and Teflon 3170 aqueous dispersions available from DuPont de Nemours and Co.

\*- PFAZ® 322 polyfunctional aziridine, Sybron Chemicals Inc., added at 10 wt % of solids.

#### Example 43

[0042] This example illustrates the incorporation of a conductive metal oxide particle in the coatings used in the invention. A coating comprising a 15/35/50 weight ratio of polymer P-2/polymer P-11/conductive tin oxide particles was applied onto a subbed polyester support to give a transparent coating with a total dried weight of 1000 mg/m<sup>2</sup>. The conductive tin oxide was Keeling & Walker CPM375 antimony-doped tin oxide that had been milled to an average particle size of about 50nm. The surface resistivity of the coating measured at 20% RH before and after film processing using a two-point probe was 9.9 and 10.3 log  $\Omega$ /square, respectively.

#### Claims

1. An imaging element comprising a support, at least one light-sensitive layer and at least one coalesced layer obtainable from a continuous aqueous phase having dispersed therein a mixture of film-forming water insoluble colloidal polymeric particles having an average particle size of from 10 to 500 nm and non-film-forming water insoluble colloidal polymeric particles having an average particle size of from 10 to 500nm, said film-forming colloidal polymeric particles forming clear, transparent continuous films and said non-film-forming colloidal polymeric particles not forming clear, transparent continuous films when an aqueous coating formulation of 3% by weight of colloidal polymeric particles free of organic solvent or coalescing aid, is applied to a sheet of polyethylene terephthalate in a wet coverage of 10 ml/m<sup>2</sup> and dried for 2 minutes at 75°C.
2. An imaging element comprising a support, a light-sensitive layer and an antistat layer, the antistat layer being overcoated with a protective layer of a coalesced layer as defined in claim 1.
3. The imaging element of Claims 1 or 2 wherein the film-forming colloidal polymeric particles are present in the coalesced layer in an amount of from 20 to 70 percent by weight based on the total weight of the layer.
4. The imaging element of Claims 1 or 2 wherein the light-sensitive layer is a silver halide emulsion layer.
5. The imaging element of Claims 1 or 2 wherein the light-sensitive layer is a thermal imaging layer.
6. The imaging element of Claims 1 or 2 wherein the polymer of the film-forming colloidal particles is an addition polymer.
7. The imaging element of Claims 1 or 2 wherein the polymer of the film-forming colloidal particles is a condensation polymer.
8. The imaging element of Claim 1 wherein the coalesced layer contains metal oxide particles.
9. The imaging element of Claim 8 wherein the metal oxide particles are conductive metal oxides.
10. The imaging element of Claim 9 wherein the conductive metal oxide is tin oxide.

11. The imaging element of Claim 10 wherein the tin oxide is antimony doped.
12. The imaging element of Claim 1 wherein the coalesced layer contains magnetic particles.
- 5 13. The imaging element of Claim 12 wherein the magnetic particles are cobalt doped gamma iron oxide.
14. The imaging element of Claims 1 or 2 wherein the film-forming colloidal polymeric particles or the non-film-forming colloidal polymeric particles are crosslinked.
- 10 15. The imaging element of Claims 1 or 2 wherein the film-forming colloidal polymeric particles include addition-type polymers and interpolymers prepared from ethylenically unsaturated monomers.
16. The imaging element of Claims 1 or 2 wherein the film-forming colloidal polymeric particles include film-forming dispersions of polyurethane or polyesterionomers.

#### Patentansprüche

1. Abbildungselement mit einem Träger, mindestens einer lichtempfindlichen Schicht und mindestens einer zusammengeflochtenen Schicht, die aus einer stetigen wässrigen Phase erzeugbar ist, in der eine Mischung aus filmbildenden, nicht wasserlöslichen kolloidalen Polymerpartikeln mit einer mittleren Partikelgröße von 10 bis 500 nm und nicht filmbildenden, nicht wasserlöslichen, kolloidalen Polymerpartikeln mit einer mittleren Partikelgröße von 10 bis 500 nm dispergiert ist, wobei die filmbildenden, kolloidalen Polymerpartikel klare, transparente, durchgehende Filme bilden, und wobei die nicht filmbildenden, kolloidalen Polymerpartikel keine klaren, transparenten, durchgehenden Filme bilden, wenn eine wässrige Beschichtungsformulierung von 3 Gew.-% kolloidaler Polymerpartikel und ohne ein organisches Lösemittel oder eine Koaleszenzhilfe auf einen Bogen aus Polyethylenterephthalat in einem Nassauftrag von 10 ml/m<sup>2</sup> aufgetragen und für 2 Minuten bei 75°C getrocknet wird.
2. Abbildungselement mit einem Träger, einer lichtempfindlichen Schicht und einer Antistatikschiicht, wobei auf die Antistatikschiicht eine Schutzschicht einer zusammengeflochtenen Schicht aufgetragen ist, wie in Anspruch 1 dargestellt.
3. Abbildungselement nach Anspruch 1 oder 2, **dadurch gekennzeichnet, dass** die filmbildenden, kolloidalen Polymerpartikel in der zusammengeflochtenen Schicht in einer Menge von 20 bis 70 Gew.-%, bezogen auf das Gesamtgewicht der Schicht, vorliegen.
4. Abbildungselement nach Anspruch 1 oder 2, **dadurch gekennzeichnet, dass** die lichtempfindliche Schicht eine Silberhalogenid-Emulsionsschiicht ist.
5. Abbildungselement nach Anspruch 1 oder 2, **dadurch gekennzeichnet, dass** die lichtempfindliche Schicht eine thermische Abbildungsschiicht ist.
6. Abbildungselement nach Anspruch 1 oder 2, **dadurch gekennzeichnet, dass** das Polymer der filmbildenden, kolloidalen Partikel ein Additionspolymer ist.
7. Abbildungselement nach Anspruch 1 oder 2, **dadurch gekennzeichnet, dass** das Polymer der filmbildenden, kolloidalen Partikel ein Kondensationspolymer ist.
8. Abbildungselement nach Anspruch 1, **dadurch gekennzeichnet, dass** die zusammengeflochtene Schicht Metalloxidpartikel enthält.
9. Abbildungselement nach Anspruch 8, **dadurch gekennzeichnet, dass** die Metalloxidpartikel leitfähige Metalloxide sind.
10. Abbildungselement nach Anspruch 9, **dadurch gekennzeichnet, dass** das leitfähige Metalloxid Zinnoxid ist.
11. Abbildungselement nach Anspruch 10, **dadurch gekennzeichnet, dass** das Zinnoxid antimondotiert ist.

12. Abbildungselement nach Anspruch 1, **dadurch gekennzeichnet, dass** die zusammengefllossene Schicht Magnetpartikel enthält.

13. Abbildungselement nach Anspruch 12, **dadurch gekennzeichnet, dass** die Magnetpartikel kobaltdotiertes Gammaeisenoxid sind.

14. Abbildungselement nach Anspruch 1 oder 2, **dadurch gekennzeichnet, dass** die filmbildenden, kolloidalen Polymerpartikel oder die nicht filmbildenden, kolloidalen Polymerpartikel vernetzt sind.

15. Abbildungselement nach Anspruch 1 oder 2, **dadurch gekennzeichnet, dass** die filmbildenden, kolloidalen Polymerpartikel Additionspolymere und Interpolymere enthalten, die aus ethylenisch ungesättigten Monomeren hergestellt sind.

16. Abbildungselement nach Anspruch 1 oder 2, **dadurch gekennzeichnet, dass** die filmbildenden, kolloidalen Polymerpartikel filmbildende Dispersionen von Polyurethan oder Polyesterionomeren enthalten.

## Revendications

1. Élément formateur d'image comprenant un support, au moins une couche photosensible et au moins une couche coalescée pouvant être obtenue à partir d'une phase aqueuse continue dans laquelle est dispersé un mélange de particules colloïdales polymères filmogènes insolubles dans l'eau ayant une taille moyenne comprise entre 10 et 500 nm et de particules colloïdales polymères non filmogènes insolubles dans l'eau ayant une taille moyenne comprise entre 10 et 500 nm, lesdites particules colloïdales polymères filmogènes formant des films continus limpides et transparents et lesdites particules colloïdales polymères non filmogènes ne formant pas de films continus limpides et transparents, lorsqu'une formulation aqueuse de revêtement contenant 3 % en poids de particules colloïdales polymères, sans solvant organique, ni agent de coalescence, est appliquée sur une feuille de poly (éthylène téréphtalate) à une teneur à l'état humide de 10 ml/m<sup>2</sup>, puis séchée pendant 2 minutes à 75 °C.

2. Élément formateur d'image comprenant un support, une couche photosensible et une couche antistatique, la couche antistatique étant revêtue d'une couche de protection coalescée telle que définie dans la revendication 1.

3. Élément formateur d'image selon la revendication 1 ou 2, dans lequel les particules colloïdales polymères filmogènes sont présentes dans la couche coalescée en une quantité comprise entre 20 et 70 pourcent en poids par rapport au poids total de la couche.

4. Élément formateur d'image selon la revendication 1 ou 2, dans lequel la couche photosensible est une couche d'émulsion aux halogénures d'argent.

5. Élément formateur d'image selon la revendication 1 ou 2, dans lequel la couche photosensible est une couche de formation d'image thermique.

6. Élément formateur d'image selon la revendication 1 ou 2, dans lequel le polymère des particules colloïdales filmogènes est un polymère d'addition.

7. Élément formateur d'image selon la revendication 1 ou 2, dans lequel le polymère des particules colloïdales filmogènes est un polymère de condensation.

8. Élément formateur d'image selon la revendication 1, dans lequel la couche coalescée contient des particules d'oxyde métallique.

9. Élément formateur d'image selon la revendication 8, dans lequel les particules d'oxyde métallique sont des oxydes métalliques conducteurs.

10. Élément formateur d'image selon la revendication 9, dans lequel l'oxyde métallique conducteur est l'oxyde d'étain.

11. Élément formateur d'image selon la revendication 10, dans lequel l'oxyde d'étain est dopé à l'antimoine.

12. Élément formateur d'image selon la revendication 1, dans lequel la couche coalescée contient des particules magnétiques.

5 13. Élément formateur d'image selon la revendication 12, dans lequel les particules magnétiques sont des particules d'oxyde de fer gamma dopé au cobalt.

14. Élément formateur d'image selon la revendication 1 ou 2, dans lequel les particules colloïdales polymères filmogènes ou les particules colloïdales polymères non filmogènes sont réticulées.

10 15. Élément formateur d'image selon la revendication 1 ou 2, dans lequel les particules colloïdales polymères filmogènes comprennent des polymères d'addition et des interpolymères préparés à partir de monomères ayant une insaturation de type éthylénique.

15 16. Élément formateur d'image selon la revendication 1 ou 2, dans lequel les particules colloïdales polymères filmogènes comprennent des dispersions filmogènes de polyuréthane ou de polyesterionomères.

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