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(54) **BASECOAT COMPOSITION AND ASSOCIATED PAPERBOARD STRUCTURE**

GRUNDLACKZUSAMMENSETZUNG UND ZUGEHÖRIGE KARTONSTRUKTUR

COMPOSITION DE COUCHE DE FOND ET STRUCTURE DE CARTON CORRESPONDANTE

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Description

FIELD

5 **[0001]** This patent application is directed to coatings for paperboard and, more particularly, to basecoat compositions for forming smooth paperboard structures.

BACKGROUND

10 **[0002]** Paperboard is used in various packaging applications. For example, aseptic liquid packaging paperboard is used for packaging beverage cartons, boxers and the like. Therefore, customers often prefer paperboard having a generally smooth surface with few imperfections to facilitate the printing of high quality text and graphics, thereby increasing the visual appeal of products packaged in paperboard.

15 **[0003]** Manufacturers have attempted to smooth the surface of paperboard by coating the entire surface of the paperboard with a basecoat comprised of various pigments, such as clay, calcium carbonate, TiO₂ and the like, then overcoating this base with a second and sometimes even a third coating, which is generally referred to as a topcoat. It was discovered that high quantities of relatively fine pigment particles applied to the surface of paperboard provided a smoother surface without sacrificing bulk. Indeed, it has been understood that the more pigment particles applied to the surface of the paperboard the better the resulting smoothness. However, the use of relatively high quantities of pigments substantially increases the cost of preparing smooth and highly printable paperboard.

20 **[0004]** Accordingly, those skilled in the art continue with research and development efforts in the field of paperboard coating.

SUMMARY

25 **[0005]** According to a first aspect of the present invention there is provided a basecoat composition for paperboard, the composition comprising a carrier and a pigment component dispersed in the carrier, the pigment component comprising all pigments in the basecoat composition, wherein the pigment component has a median particle size between about 3 and about 8 micrometers, and wherein at most about 15 percent by weight of the pigment component has a particle size smaller than 1 micrometer.

30 **[0006]** Optionally, the median particle size is between about 3 and about 7 micrometers, preferably between about 3 and about 6 micrometers, more preferably between about 4 and about 5 micrometers.

35 **[0007]** Optionally, at most about 14 percent by weight of said pigment component has a particle size smaller than 1 micrometer, preferably at most about 13 percent by weight of said pigment component has a particle size smaller than 1 micrometer, more preferably at most about 12 percent by weight of said pigment component has a particle size smaller than 1 micrometer, most preferably at most about 11 percent by weight of said pigment component has a particle size smaller than 1 micrometer.

40 **[0008]** Optionally, at most about 20 percent by weight of said pigment component has a particle size greater than 8 micrometers, preferably at most about 15 percent by weight of said pigment component has a particle size greater than 8 micrometers, more preferably at most about 10 percent by weight of said pigment component has a particle size greater than 8 micrometers.

45 **[0009]** Optionally, the pigment component has a steepness index of at most about 1.3, preferably at most about 1.2, more preferably at most about 1.1, most preferably at most about 1.0, the steepness index (Ψ) being defined by the expression:

$$\Psi = \frac{D80 - D20}{D50}$$

50 where D50 is the median particle size, D80 is the particle size at which 80 percent (by weight) of the pigment particles are smaller and D20 is the particle size at which 20 percent (by weight) of the pigment particles are smaller.

[0010] Optionally, the pigment component comprises calcium carbonate.

[0011] Optionally, the pigment component comprises precipitated calcium carbonate.

55 **[0012]** Optionally, the precipitated calcium carbonate comprises at least 50 percent by weight of said pigment component, preferably at least 70 percent by weight of said pigment component, more preferably at least 80 percent by weight of said pigment component and most preferably said pigment component consists essentially of said precipitated calcium carbonate.

[0013] Optionally, the pigment component comprises a blend of pigments.

[0014] Optionally, the pigment component consists essentially of inorganic pigments.

[0015] Optionally, with the proviso that said pigment component is substantially free of platy pigments.

[0016] According to a second aspect of the present invention there is provided a paperboard structure comprising a paperboard substrate comprising a first major surface and a second major surface and a basecoat applied to at least one of the first major surface and the second major surface, the basecoat comprising a pigment component, the pigment component comprising all pigments in the basecoat, the pigment component being defined in any of the relevant preceding paragraphs.

[0017] Optionally, the paperboard substrate has a basis weight of at least 0.138kg/m² (85 pounds/3,000 ft²).

[0018] Optionally, the basecoat is applied at a coat weight of at most about 14.6 g/m² (9 pounds/3,000 ft²), preferably at most about 13.0 g/m² (8 pounds per 3000 square feet).

[0019] Optionally, the paperboard structure further comprises a top coat positioned over said basecoat to form a top-coated paperboard structure having an outermost coating surface, wherein said outermost coating surface preferably has a Parker Print Surf smoothness (PPS 10S) of at most about 3μm, more preferably at most about 2μm.

[0020] Other embodiments of the disclosed basecoat composition and associated paperboard structure will become apparent from the following description, the accompanying drawings and the appended claims.

BRIEF DESCRIPTION OF THE DRAWINGS

[0021]

Fig. 1 is a cross-sectional view of one embodiment of the disclosed paperboard structure;

Fig. 2 is a graphical representation of the mass percent particle size distribution of a pigment suitable for use as the pigment component of the disclosed pigment composition;

Fig. 3 is a graphical representation of the mass percent particle size distribution of various calcium carbonate pigments;

Fig. 4 is a graphical representation of the mass frequency particle size distribution of the calcium carbonate pigments of Fig. 3;

Fig. 5 is a graphical representation of the mass percent particle size distribution of blended calcium carbonate pigments;

Fig. 6 is a graphical representation of the mass frequency particle size distribution of the blended calcium carbonate pigments of Fig. 5;

Fig. 7 is a graphical representation of the mass percent particle size distribution of various blends of coarse narrow particle size calcium carbonate pigments with extra-coarse calcium carbonate pigments;

Fig. 8 is a graphical representation of the mass frequency particle size distribution of the pigment blends of Fig. 7;

Fig. 9 is a graphical representation of the mass percent particle size distribution of various blends of coarse narrow particle size calcium carbonate pigments with fine calcium carbonate pigments;

Fig. 10 is a graphical representation of the mass frequency particle size distribution of the pigment blends of Fig. 9;

Fig. 11 is a graphical representation of smoothness versus percent of particles greater than 8 micrometers for a blend of coarse narrow particle size calcium carbonate with extra-coarse calcium carbonate;

Fig. 12 is a graphical representation of smoothness versus percent of particles less than 1 micrometer for a blend of coarse narrow particle size calcium carbonate with fine ground calcium carbonate; and

Fig. 13 is a graphical representation of smoothness obtained using various pigment blends.

DETAILED DESCRIPTION

[0022] Paperboard structures having desired smoothness may be obtained by engineering the particle size distribution of the particles used in the associated basecoat composition. Specifically, it has now been discovered that the significant presence of excess fine particles, as well as excess coarse particles, has a detrimental effect on smoothness, and that smoothness can be enhanced by using particles having a relatively narrow particle size distribution within an optimized median particle size range.

[0023] Referring to Fig. 1, one embodiment of the disclosed paperboard structure, generally designated 10, may include a paperboard substrate 12, a basecoat 14 and, optionally, a top coat 16. The paperboard substrate 12 may include a first major surface 18 and a second major surface 20. The basecoat 14 may be applied only to the first major surface 18 (C1S) or to both the first major surface 18 and the second major surface 20 (C2S). The top coat 16 may be applied over the basecoat 14 to present an outermost coating surface 22. Additional coating layers (not shown) may be positioned between the basecoat 14 and the top coat 16 without departing from the scope of the present disclosure.

[0024] The paperboard substrate 12 may be any web of fibrous material that is capable of being coated with the disclosed basecoat 14. The paperboard substrate 12 may be bleached or unbleached, and may be paper or thicker and more rigid than paper. For example, the paperboard substrate 12 may have an uncoated basis weight of about 85 pounds per 3000 ft² or more. Examples of appropriate paperboard substrates 12 include corrugating medium, linerboard, solid bleached sulfate (SBS) and aseptic liquid packaging paperboard

[0025] In one particular implementation, the basecoat 14 may be applied to the first major surface 18 of the paperboard substrate 12 in a quantity sufficient to fill the pits and crevices in the first major surface 18 without the need for coating the entire first major surface 18 of the paperboard substrate 12, thereby forming a discontinuous film on the first major surface 18. For example, the basecoat 14 may be applied using a blade coater such that the blade coater urges the basecoat 14 into the pits and crevices in the first major surface 18 while removing the basecoat 14 from the first major surface 18. Specifically, the basecoat 14 may be applied in a manner that is akin to spackling, wherein substantially all of the basecoat 14 resides in the pits and crevices in the first major surface 18 of the paperboard substrate 12 rather than on the first major surface 18 of the paperboard substrate 12.

[0026] At this point, those skilled in the art will appreciate that when the basecoat 14 is used in a blade coater the spacing between the moving paperboard substrate 12 and the blade of the coater maybe minimized to facilitate filling the pits and crevices in the first major surface 18 without substantially depositing the basecoat 14 on the first major surface 18 of the paperboard substrate 12 (i.e., forming a discontinuous film on the first major surface 18 of the paperboard substrate 12). In other words, the blade of the coater maybe positioned sufficiently close to the first major surface 18 of the moving paperboard substrate 12 such that the blade of the coater urges the basecoat 14 into the pits and crevices in the first major surface 18 of the paperboard substrate 12, while removing excess basecoat 14 from the first major surface 18 of the paperboard substrate 12.

[0027] The top coat 16 may be any appropriate topcoat. For example, the topcoat 16 may include calcium carbonate, clay and various other components and may be applied over the basecoat 14 as a slurry. Top coats are well known by those skilled in the art and any conventional or non-conventional top coat composition may be used without departing from the scope of the present disclosure.

[0028] The outermost coating surface 22 of the disclosed paperboard structure 10 maybe relatively smooth. In one realization, the outermost coating surface 22 of the disclosed paperboard structure 10 may have a Parker Print Surface (PPS 10S) smoothness of at most about 5 micrometers. In another realization, the outermost coating surface 22 of the disclosed paperboard structure 10 may have a Parker Print Surface (PPS 10S) smoothness of at most about 4 micrometers. In another realization, the outermost coating surface 22 of the disclosed paperboard structure 10 may have a Parker Print Surface (PPS 10S) smoothness of at most about 3 micrometers. In another realization, the outermost coating surface 22 of the disclosed paperboard structure 10 may have a Parker Print Surface (PPS 10S) smoothness of at most about 2 micrometers.

[0029] The basecoat 14 may include a pigment component having an engineered particle size distribution, as discussed in greater detail herein. To facilitate application of the basecoat 14 (and its pigment component) to the paperboard substrate 12, the basecoat 14 may be initially prepared as a basecoat composition that includes a pigment component and a carrier component. The carrier component may include any suitable carrier, such as water. The pigment component may be dispersed in the carrier component to facilitate application of the basecoat 14 to the paperboard substrate 12. As an example, the basecoat composition may have a solids content of at most about 70 percent by weight, such as at most about 67 percent by weight, though those skilled in the art will appreciate that the appropriate solids content may depend on various factors, such as the technique being used to apply the basecoat composition to the paperboard substrate 12. Additional components, such as binders (e.g., latex, starch, etc.), thickeners, stabilizers, dispersing agents and the like, maybe included in the basecoat composition without departing from the scope of the present disclosure.

[0030] The pigment component of the basecoat 14 (or of the basecoat composition) refers to all of the pigments within the basecoat 14 (or the basecoat composition). The pigment component may include a single type of pigment or,

alternatively, maybe a blend of two or more different pigments.

[0031] Fig. 2 provides a graphical representation of the mass particle size distribution of VICALITY® Heavy precipitated calcium carbonate ("PCC"), which is commercially available from Minerals Technologies Inc. of New York, New York. The VICALITY® Heavy pigment has a median particle size of about 4.2 micrometers, a steepness parameter of about 1.0, and a fines content wherein at most about 10 percent by weight of the pigment particles have a particle size less than 1 micrometer.

[0032] As used herein, the "particle size" of a pigment refers to the equivalent spherical diameter of the pigment, which may be measured using a particle size analyzer regardless of whether the particles are spherical (or near spherical) or non-spherical. The data presented in Fig. 2 was collected using a SEDIGRAPH® 5120 particle size analyzer, which is commercially available from Micrometrics Instrument Corporation of Norcross, Georgia.

[0033] As used herein, "median particle size" refers to the particle size at which 50 percent (by weight) of the pigment particles are less than that particle size. Therefore, as shown in Fig. 2, the median particle size (D50) of VICALITY® Heavy pigment is about 4.2 micrometers.

[0034] As used herein, "steepness parameter" (Ψ) refers to the narrowness of the particle size distribution and is calculated as follows:

$$\Psi = \frac{D80 - D20}{D50}$$

where D50 is the median particle size, D80 is the particle size at which 80 percent (by weight) of the pigment particles are smaller and D20 is the particle size at which 20 percent (by weight) of the pigment particles are smaller. Therefore, as shown in Fig. 2, the steepness parameter of VICALITY® Heavy pigment is about 1.0 (i.e., $(6.05 - 1.93) / 4.23 = 0.97$).

[0035] The fines content can be expressed at various particle sizes. As one example, the fines content can be expressed as the percentage (by weight) of particles having a particle size less than 1 micrometer. Therefore, as shown in Fig. 2, VICALITY® Heavy pigment has a fines content wherein at most about 10 percent by weight of the pigment particles have a particle size less than 1 micrometer.

[0036] The median particle size of the disclosed pigment component maybe within a specific range. In one expression, the median particle size may range from about 3 micrometers to about 8 micrometers. In another expression, the median particle size may range from about 3 micrometers to about 7 micrometers. In another expression, the median particle size may range from about 3 micrometers to about 6 micrometers. In yet another expression, the median particle size may range from about 4 micrometers to about 5 micrometers.

[0037] The steepness parameter of the disclosed pigment component may be less than a threshold value, which may correspond to a relatively narrow particle size distribution. In one expression, the steepness parameter maybe at most about 1.3. In another expression, the steepness parameter may be at most about 1.2. In another expression, the steepness parameter may be at most about 1.1. In yet another expression, the steepness parameter may be at most about 1.0.

[0038] The fines content of the disclosed pigment component maybe relatively low. In one expression, at most about 15 percent by weight of the pigment particles of the pigment component may have a particle size less than 1 micrometer. In another expression, at most about 14 percent by weight of the pigment particles of the pigment component may have a particle size less than 1 micrometer. In another expression, at most about 13 percent by weight of the pigment particles of the pigment component may have a particle size less than 1 micrometer. In another expression, at most about 12 percent by weight of the pigment particles of the pigment component may have a particle size less than 1 micrometer. In another expression, at most about 11 percent by weight of the pigment particles of the pigment component may have a particle size less than 1 micrometer. In yet another expression, at most about 10 percent by weight of the pigment particles of the pigment component may have a particle size less than 1 micrometer.

[0039] The coarse content of the disclosed pigment component may also be relatively low. In one expression, at most about 20 percent by weight of the pigment particles of the pigment component may have a particle size greater than 8 micrometer. In another expression, at most about 15 percent by weight of the pigment particles of the pigment component may have a particle size greater than 8 micrometer. In yet another expression, at most about 10 percent by weight of the pigment particles of the pigment component may have a particle size greater than 8 micrometer.

[0040] The disclosed pigment component particle size distribution (combination of median particle size, fines content, steepness parameter and/or coarse content) may be obtained by selecting a single pigment for use as the entire pigment component, wherein the single pigment provides the desired particle size distribution. For example, VICALITY® Heavy precipitated calcium carbonate, a commercially available pigment, may have the desired particle size distribution, as shown in Fig. 2.

[0041] It is also contemplated that pigments and pigment blends may be engineered to have the disclosed pigment component particle size distribution. As one example, the disclosed particle size distribution may be achieved by mixing together various existing (e.g., commercially available) pigments in appropriate proportions. As another example, an

existing pigment or pigment blend may be processed (e.g., sifting and separating) to achieve the disclosed particle size distribution.

[0042] Thus, various pigments may be included in the disclosed pigment component. In one variation, the pigment component may be substantially entirely comprised of inorganic pigments. In another variation, the pigment component may include both inorganic and organic pigments. In yet another variation, the pigment component may be substantially free of platy pigments (e.g., platy clays), wherein "platy" refers to pigments having a shape factor greater than 60. Examples of pigments that may be used to design a pigment component having the disclosed particle size distribution include, but are not limited to, precipitated calcium carbonate, ground calcium carbonate, talc and clay (e.g., kaolin).

EXAMPLE 1

[0043] The particle size distributions of six calcium carbonate pigments were measured and evaluated using a SED-IGRAPH® 5120 particle size analyzer. Pigment 1 ("Fine Ground") was a fine ground calcium carbonate, HYDROCARB® 90, commercially available from Omya AG of Oftringen, Switzerland. Pigment 2 ("Coarse Ground") was a coarse ground calcium carbonate, HYDROCARB® 60, commercially available from Omya AG. Pigment 3 ("Extra-Coarse Ground") was an extra-coarse ground calcium carbonate, HYDROCARB® PG3, commercially available from Omya AG. Pigment 4 ("Fine Precipitated") was a fine prismatic precipitated calcium carbonate, ALBAGLOS® S, commercially available from Minerals Technologies Inc. Pigment 5 ("Coarse Precipitated") was a coarse rhombohedral precipitated calcium carbonate, VICALITY® Heavy, commercially available from Minerals Technologies Inc. Pigment 6 ("Extra-Coarse Precipitated") was an extra-coarse rhombohedral precipitated calcium carbonate, CALESSENCE® 1500, commercially available from Minerals Technologies Inc.

[0044] The results are graphically presented in Figs. 3 and 4, and specific data are presented in Table 1, below:

TABLE 1

	Fine Ground	Coarse Ground	Extra-Course Ground	Fine Precipitated	Coarse Precipitated	Extra-Course Precipitated
	Hydrocarb 90	Hydrocarb 60	Hydrocarb PG3	Albaglos S	Vicality Heavy	Calescence
Modal Diameter (μ)	0.89	2.00	4.22	0.79	5.01	11.89
Median Diameter (μ)	0.69	1.37	2.85	0.90	4.22	11.15
Mass % < 0.5 μ	38.3	19.2	10.8	8.3	3.4	0.6
Mass % < 1 μ	69.3	39.1	21.5	62.8	10.8	1.1
Mass % < 2 μ	93.6	67.7	39.0	84.2	20.8	1.8
Mass % > 8 μ	0.0	1.0	12.4	3.5	5.6	80.0
Mass % > 10 μ	0.0	0.8	6.1	1.6	2.0	59.2
Steepness (D80-D20/D50)	1.5	1.5	2.0	1.0	1.0	0.6

[0045] In addition to providing the median particle size (shown as "Median Diameter"), the steepness parameter, percent less than 1 micrometer and percent greater than 8 micrometers, Table 1 also provides the modal diameter (the particle diameter that represents the highest point of each curve in Fig. 4), percent less than 0.5 micrometers, percent less than 2 micrometers, and percent greater than 10 micrometers.

[0046] As shown in Figs. 3 and 4 and Table 1, Pigments 1-6 have a wide range of particle size distributions. Pigment 1 (Fine Ground) has a small average particle size, a relatively wide size distribution, the most fines, and the least coarse particles.

[0047] Pigment 2 (Coarse Ground) has substantially the same steepness parameter as Pigment 1, but a median particle size that is double. Pigment 2 has about half as many small particles as Pigment 1, but still virtually no particles larger than 8 micrometers.

[0048] Pigment 3 (Extra-Coarse Ground) is the coarsest ground carbonate evaluated-it has a median particle size that is about double the median particle size of Pigment 2 and four times as large as Pigment 1. Pigment 3 has the broadest distribution of all the pigments. It still has a relatively large amount of fine particles, but also has a significant amount of coarse particles.

[0049] Pigment 4 (Fine Precipitated) has a similar median particle size to Pigment 1, but a much narrower particle size distribution (steepness parameter of 1.0 versus 1.5). Pigment 4 has a much smaller amount of particles less than 0.5 micrometers, compared to Pigment 1, but a comparable amount less than 1 micrometer. Pigment 4 has very few coarse particles.

[0050] Pigment 5 (Coarse Precipitated) has an average particle size larger than the Pigment 3, but has very few fine or coarse particles, and has a narrow particle size distribution. Therefore, Pigment 5 may be used as the pigment component of the disclosed basecoat (and basecoat composition).

[0051] Pigment 6 (Extra-Coarse Precipitated) has a very large average particle size. The majority of its particles are greater than 8 microns. Pigment 6 has the lowest steepness index of any of the pigments evaluated in Example 1.

EXAMPLE 2

[0052] A solid bleached sulfate (SBS) paperboard was used to make double-coated board samples. The board had an average basis weight of about 125 pounds per 3000 ft² and an average roughness of 7.5 micrometers, as measured by Parker Print Surf (PPS 10S) smoothness. Three different basecoat compositions were applied to a continuous web of the SBS paperboard using a pilot coater. The basecoat compositions were applied at a coat weight of about 9 pounds per 3000 ft². A common top coat was applied to all three basecoated structures to give a top coat weight of about 6 pounds per 3000 ft². The topcoated structures were gloss calendered, under common conditions, to produce a 75 degree gloss of about 50.

[0053] The three basecoat compositions were prepared as follows: Basecoat Composition 1 included 100 parts Pigment 1 (HYDROCARB® 90) and 20 parts latex binder; Basecoat Composition 2 included 100 parts Pigment 2 (HYDROCARB® 60) and 20 parts latex binder; and Basecoat Composition 3 included 100 parts Pigment 5 (VICALITY® Heavy) and 20 parts latex binder. Water was used as the carrier component of Basecoat Compositions 1-3 to achieve the required solids content for coating. An alkali-swellable thickener was used to adjust the Brookfield 20 rpm viscosity of Basecoat Compositions 1-3 to about 2500 cP.

[0054] Basecoat Compositions 1-3 were each applied to a continuous web of the SBS paperboard using a pilot coater. The test data for the double coated board samples are presented in Table 2, below:

TABLE 2

	Hydrocarb 90	Hydrocarb 60	Vicality Heavy
Basecoat Weight (lb/3000 ft ²)	9	8.9	8.6
Topcoat Weight (lb/3000 ft ²)	6.2	6.2	6.1
Basecoated PPS Smoothness (μ)	4.79	5.46	4.82
Calendered Topcoated PPS (μ)	1.65	1.64	1.14
IGT Pick strength	119.5	139.5	148.2

[0055] Both HYDROCARB® 90 and VICALITY® Heavy produced substantially reduced basecoat-only roughness, but after topcoating, HYDROCARB® 90 and HYDROCARB® 60 gave equal roughness values, while VICALITY® Heavy produced substantially reduced PPS roughness values. The IGT pick test measures surface strength. The IGT results show HYDROCARB® 90 resulted in reduced coating strength, but VICALITY® Heavy and HYDROCARB® 60 were equivalent.

EXAMPLE 3

[0056] A solid bleached sulfate (SBS) paperboard was used to make double-coated board samples. The board had an average basis weight of about 120 pounds per 3000 ft² and an average roughness of 7.3 micrometers, as measured by Parker Print Surf (PPS 10S) smoothness. Four different basecoat compositions were applied to a continuous web of the SBS paperboard using a pilot coater. The basecoat compositions were applied at a coat weight of about 9 pounds per 3000 ft². A common top coat was applied to all four basecoated structures to give a top coat weight of about 6 pounds per 3000 ft². The topcoated structures were gloss calendered, under common conditions, to produce a 75 degree gloss of about 50.

[0057] The four basecoat compositions were prepared as follows: Basecoat Composition 4 included 100 parts Pigment 2 (HYDROCARB® 60) and 20 parts latex binder; Basecoat Composition 5 included 100 parts Pigment 5 (VICALITY® Heavy) and 20 parts latex binder; Basecoat Composition 6 included 100 parts Pigment 6 (CALESSENCE® 1500) and

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20 parts latex binder; and Basecoat Composition 7 included 100 parts Pigment 5 (HYDROCARB® PG3) and 20 parts latex binder. Water was used as the carrier component of Basecoat Compositions 4-7 to achieve the required solids content for coating. An alkali-swellable thickener was used to adjust the Brookfield 20 rpm viscosity of Basecoat Compositions 4-7 to about 2500 cP.

[0058] Basecoat Compositions 4-7 were each applied to a continuous web of the SBS paperboard using a pilot coater. The test data for the double coated board samples are presented in Table 3, below:

TABLE 3

	Hydrocarb 60	Vicality Heavy	Calessence	Hydrocarb PG3
Basecoat Weight (lb/3000 ft ²)	9.5	6.4	9.6	8.9
Topcoat Weight (lb/3000 ft ²)	7.3	5.9	6.2	5.5
Basecoated PPS Smoothness (μ)	5.06	4.66	7.50	6.36
Calendered Topcoated PPS (μ)	1.98	1.48	2.04	2.42
IGT Pick Strength	163	144	184	168

[0059] VICALITY® Heavy gave substantially improved roughness values compared to HYDROCARB® 60, for both basecoat-only and topcoated calendered Parker Print Surf Smoothness. CALESSENCE® 1500 gave very little improvement in basecoat-only smoothness of the uncoated board, but when topcoated, gave a topcoated smoothness comparable to HYDROCARB® 60. HYDROCARB® PG3 gave a substantially rougher surface than HYDROCARB® 60 for both basecoat-only and topcoated smoothness. IGT Pick results show a slightly lower coating strength for VICALITY® Heavy, compared to HYDROCARB® 60. CALESSENCE® 1500 was slightly stronger than HYDROCARB® 60, and HYDROCARB® PG3 was equal

EXAMPLE 4

[0060] The conditions and pigments of Example 4 were the same as Example 3, except for the weight and roughness of the uncoated board. Specifically, the uncoated board used for Example 4 had an average roughness of 7.3 micrometers, as measured by Parker Print Surf (PPS 10S) smoothness, and the basis weight was 104 pounds per 3000 ft². The test data for the double coated board samples are presented in Table 4, below:

TABLE 4

	Hydrocarb 60	Vicality Heavy	Calessence	Hydrocarb PG3
Basecoat Weight (lb/3000 ft ²)	10.0	9.0	9.9	9.4
Topcoat Weight (lb/3000 ft ²)	6.2	6.0	5.9	6.1
Basecoated PPS Smoothness (μ)	7.64	5.83	8.02	7.30
Calendered Topcoated PPS (μ)	2.98	1.94	2.44	3.00
IGT Pick Strength	154	97	142	118

[0061] VICALITY® Heavy gave a very large improvement in basecoat-only and topcoated smoothness, compared to HYDROCARB® 60. CALESSENCE® 1500 gave similar basecoat-only roughness values compared to HYDROCARB® 60, but gave a substantial improvement in topcoated smoothness compared to HYDROCARB® 60, but only about half of the benefit obtained by VICALITY® Heavy. HYDROCARB® PG3 gave equivalent results compared to HYDROCARB® 60.

EXAMPLE 5

[0062] A solid bleached sulfate (SBS) paperboard was used to make double-coated board samples. The board had an average basis weight of about 120 pounds per 3000 ft² and an average roughness of 7.3 micrometers, as measured by Parker Print Surf (PPS 10S) smoothness. Three different basecoat compositions were applied to a continuous web of the SBS paperboard using a pilot coater. The basecoat compositions were applied at a coat weight of about 9 pounds per 3000 ft². A common top coat was applied to all three basecoated structures to give a top coat weight of about 6

pounds per 3000 ft². The topcoated structures were gloss calendered, under common conditions, to produce a 75 degree gloss of about 50.

[0063] Blends of a coarse precipitated calcium carbonate (VICALITY® Heavy) with an ultrafine ground calcium carbonate (HYDROCARB® HG) and an extra-coarse precipitated calcium carbonate (CALESSANCE® 1500) were used to demonstrate the effect of increasing the percentage of fine or coarse particles in VICALITY® Heavy on final double coated sheet smoothness. Therefore, the three basecoat compositions were prepared as follows: Basecoat Composition 8 included 100 parts VICALITY® Heavy (Pigment 5) and 20 parts latex binder; Basecoat Composition 9 included 80 parts VICALITY® Heavy (Pigment 5), 20 parts CALESSANCE® 1500 (Pigment 6) and 20 parts latex binder; and Basecoat Composition 10 included 80 parts VICALITY® Heavy (Pigment 5), 20 parts HYDROCARB® HG (an ultrafine ground calcium carbonate commercially available from Omya AG) and 20 parts latex binder. Water was used as the carrier component of Basecoat Compositions 8-10 to achieve the required solids content for coating. An alkali-swellable thickener was used to adjust the Brookfield 20 rpm viscosity of Basecoat Compositions 8-10 to about 2500 cP.

[0064] The particle size distributions of the pigment components of Basecoat Compositions 8-10 were measured and evaluated using a SEDIGRAPH® 5120 particle size analyzer. The results are graphically presented in Figs. 5 and 6, and specific data are presented in Table 5, below:

TABLE 5

	Vicality Heavy	80 Parts Vicality Heavy 20 Parts Calessence	80 Parts Vicality Heavy 20 Parts Hydrocarb HG
Modal Diameter (μ)	5.31	4.73	5.01
Median Diameter (μ)	4.44	5.14	3.61
Mass % < 0.5μ	1.0	1.4	12.3
Mass % < 1μ	8.1	7.0	24.4
Mass % < 2μ	20.8	17.2	36.4
Mass % > 8μ	10.9	24.1	9.0
Mass % > 10μ	3.5	14.5	2.9
Steepness (D80-D20/D50)	1.1	1.3	1.5

[0065] Compared to VICALITY® Heavy, the blend with CALESSANCE® 1500 has twice as many particles greater than 8 micrometers and the blend with HYDROCARB® HG has three times as many particles less than 1 micrometers.

[0066] Basecoat Compositions 8-10 were each applied to a continuous web of the SBS paperboard using a pilot coater. The test data for the double coated board samples (as well as a sample prepared using all HYDROCARB® 60 as the pigment component) are presented in Table 6, below:

TABLE 6

			80-Vicality Heavy	80-Vicality Heavy
	Hydrocarb 60	Vicality Heavy	20-Hydrocarb HG	20-Calessence
Basecoat Weight (lb/3000 ft ²)	8.7	8.2	9.1	9.7
Topcoat Weight (lb/3000 ft ²)	5.8	7.2	6.2	7.2
Basecoated PPS Smoothness (μ)	5.56	4.50	5.96	5.05
Calendered Topcoated PPS (μ)	1.87	1.24	1.93	1.58
IGT Pick Strength	137	142	146	154

[0067] VICALITY® Heavy is shown to give a very large reduction in roughness compared to HYDROCARB® 60. Adding 20 parts CALESSANCE® 1500 to VICALITY® Heavy reduced by half the smoothness benefit, as compared to VICALITY® Heavy, but was still significantly better than HYDROCARB® 60. Adding 20 parts HYDROCARB® HG completely eliminated any smoothness benefit associated with using VICALITY® Heavy.

EXAMPLE 6

[0068] A solid bleached sulfate (SBS) paperboard was used to make double-coated board samples. The board had an average basis weight of about 125 pounds per 3000 ft² and an average roughness of 7.3 micrometers, as measured by Parker Print Surf (PPS 10S) smoothness. Three different basecoat compositions were applied to a continuous web of the SBS paperboard using a pilot coater. The basecoat compositions were applied at a coat weight of about 9 pounds per 3000 ft². A common top coat was applied to all three basecoated structures to give a top coat weight of about 6 pounds per 3000 ft². The topcoated structures were gloss calendered, under common conditions, to produce a 75 degree gloss of about 50.

[0069] The three basecoat compositions were prepared as follows: Basecoat Composition 11 included 100 parts HYDROCARB® 60 (Pigment 2 in Example 1) and 20 parts latex binder; Basecoat Composition 12 included 100 parts VICALITY® Heavy (Pigment 5 in Example 1) and 20 parts latex binder; and Basecoat Composition 13 included 100 parts ALBAGLOS® S (Pigment 4) and 20 parts latex binder. Water was used as the carrier component of Basecoat Compositions 11-13 to achieve the required solids content for coating. An alkali-swellable thickener was used to adjust the Brookfield 20 rpm viscosity of Basecoat Compositions 11-13 to about 2500 cP.

[0070] Basecoat Compositions 11-13 were each applied to a continuous web of the SBS paperboard using a pilot coater. The test data for the double coated board samples are presented in Table 7, below:

TABLE 7

	Hydrocarb 60	Vicality Heavy	Albaglos S
Basecoat Weight (lb/3000 ft ²)	9.5	9.0	9.2
Topcoat Weight (lb/3000 ft ²)	5.9	5.6	7.2
Basecoated PPS Smoothness (μ)	5.86	4.28	5.11
Calendered Topcoated PPS (μ)	2.18	1.34	2.11
IGT Pick Strength	148	152	160

[0071] The ALBAGLOS® S gave comparable results to HYDROCARB® 60, while the VICALITY® Heavy gave a very large reduction in roughness.

EXAMPLE 7

[0072] A series of pigment blends were formulated to produce a range of particle size distributions. The purpose of this series of pigments was to systematically add fine or coarse particles to a coarse narrow particle size calcium carbonate to ascertain the effect on coated smoothness.

[0073] CALESSENCE® 1500 was selected as an extra-coarse pigment, and was blended with VICALITY® Heavy to produce blends containing 14, 25 and 40 percent by weight CALESSENCE® 1500, respectively. Particle size distribution data for blends of VICALITY® Heavy with CALESSENCE® 1500 were collected using a SEDIGRAPH® 5120 particle size analyzer. The results are shown in Figs. 7 and 8.

[0074] HYDROCARB® 90 was selected as a fine pigment, and was blended with VICALITY® Heavy to produce blends with 7, 14 and 21 percent by weight HYDROCARB® 90, respectively. Particle size distribution data for blends of VICALITY® Heavy with HYDROCARB® 90 were collected using a SEDIGRAPH® 5120 particle size analyzer. The results are shown in Figs. 9 and 10.

[0075] Additionally, one pigment blend was prepared that included VICALITY® Heavy with 14 percent by weight KAObRITE® clay (a commercially available #2 kaolin clay) and another pigment blend was prepared that includes VICALITY® Heavy with 14 percent by weight HYDRAFINE® clay (a #1 kaolin clay commercially available from Kamin, LLC, of Macon, Georgia).

[0076] The particle size distribution data of the various pigment blends was collected using a SEDIGRAPH® 5120 particle size analyzer. The results are presented in Table 8, below:

TABLE 8

	Basecoat Pigment Properties				Coated Board Characteristics		
Basecoat Pigment	Median Particle Size	Percent Less Than 1 Micron	Percent Greater Than 8 Micron	Steepness Index	Basecoat Weight (lb/3000 ft³)	Topcoat weight (lb/ 3000 ft³)	Parker Print Smoothness (μ, 10kg-soft)
Hydrocarb 60	1.35	38.6	1.3	1.6	8.0	6.4	2.24
Hydrocarb 90	0.7	68.8	0	14	7.5	6.3	2.34
Albaglos 5	0.87	62.3	3.6	1	8.1	6.6	2.32
Vicality Heavy	4.32	10	6.4	1	7.7	5.5	1.34
Vicality Heavy with 7% Hydrocarb 90	3.96	14	5.4	1.1	8.5	6.3	1.92
Vicality Heavy with 14% Hydrocarb 90	3.78	18.4	5	1.2	7.7	6.1	2.09
Vicality Heavy with 21% Hydrocarb 90	3.45	22.1	4.7	1.4	7.9	5.9	2.12
Vicality Heavy with 14% Calessence 1500	4.58	9.2	15.6	1.1	7.2	6.2	1.47
Vicality Heavy with 25% Calessence 1500	5.03	7.5	24.4	1.3	8.3	6.2	1.53
Vicality Heavy with 40% Calessence 1500	5.9	6.8	35.9	1.4	7.8	5.5	1.71
Vicality Heavy with 14% Kaobrite	4.02	13.9	6	1.1	8.3	6.0	2.13
Vicality Heavy with 14% Kaofine 90	4.01	15.7	6.1	1.1	8.5	6.1	2.45

[0077] A solid bleached sulfate (SBS) paperboard was used to make double-coated board samples. The board had an average basis weight of about 125 pounds per 3000 ft² and an average roughness of 7.3 micrometers, as measured by Parker Print Surf (PPS 10S) smoothness.

[0078] The pigment blends described above (Table 8) were used to prepare basecoat compositions that were applied to a continuous web of the SBS paperboard using a pilot coater. The basecoat compositions included 100 parts (by weight) pigment/pigment blend and 20 parts by weight binder. Water was used as the carrier component of basecoat compositions to achieve the required solids content for coating. An alkali-swellable thickener was used to adjust the Brookfield 20 rpm viscosity of basecoat compositions to about 2500 cP.

[0079] The basecoat compositions were applied at the coat weights presented in Table 8, above. A common top coat was applied to all basecoated structures at the top coat weights presented in Table 8, above. The topcoated structures were gloss calendered, under common conditions, to produce a 75 degree gloss of about 50. Smoothness data are provided in Table 8, above.

[0080] Fig. 11 shows the effect of increasing coarse particles on calendered smoothness. VICALITY® Heavy has about

6 percent greater than 8 micrometers. The roughness of the outermost coating surface increases substantially linearly as additional coarse particles are added to the pigment blend.

[0081] Fig. 12 shows the effect of increasing the level of fine particles in the basecoat. VICALITY® Heavy has about 10 percent less than 1 micrometer. Increasing the percentage of fine particles significantly increases the roughness.

[0082] Fig. 13 contains data for VICALITY® Heavy with 14 parts of CALESSENC® 1500, HYDROCARB® 90, KA-OBRITE™ and HYDRAFINE®. The data show that adding fine clay particles has the same effect as adding fine calcium carbonate particles.

[0083] Table 8, above, also contains data for ALBAGLOS® S which was compared to VICALITY® Heavy to demonstrate that a fine narrow particle size calcium carbonate does not give smoothness benefits.

[0084] Although various embodiments of the disclosed basecoat composition and associated paperboard structure have been shown and described, modifications may occur to those skilled in the art upon reading the specification. The present patent application includes such modifications and is limited only by the scope of the claims.

Claims

1. A basecoat composition for paperboard, the composition comprising:

a carrier; and
a pigment component dispersed in said carrier, said pigment component comprising all pigments in said basecoat composition,

wherein said pigment component has a median particle size between about 3 and about 8 micrometers, and
wherein at most about 15 percent by weight of said pigment component has a particle size smaller than 1 micrometer.

2. The basecoat composition of Claim 1 wherein said median particle size is between about 3 and about 7 micrometers, preferably between about 3 and about 6 micrometers, more preferably between about 4 and about 5 micrometers.

3. The basecoat composition of Claim 1 wherein at most about 14 percent by weight of said pigment component has a particle size smaller than 1 micrometer, preferably at most about 13 percent by weight of said pigment component has a particle size smaller than 1 micrometer, more preferably at most about 12 percent by weight of said pigment component has a particle size smaller than 1 micrometer, most preferably at most about 10 percent by weight of said pigment component has a particle size smaller than 1 micrometer.

4. The basecoat composition of Claim 1 wherein at most about 20 percent by weight of said pigment component has a particle size greater than 8 micrometers, preferably at most about 15 percent by weight of said pigment component has a particle size greater than 8 micrometers, more preferably at most about 10 percent by weight of said pigment component has a particle size greater than 8 micrometers.

5. The basecoat composition of Claim 1 wherein said pigment component has a steepness index of at most about 1.3, preferably at most about 1.2, more preferably at most about 1.1, most preferably at most about 1.0, the steepness index (Ψ) being defined by the expression:

$$\Psi = \frac{D80 - D20}{D50}$$

where D50 is the median particle size, D80 is the particle size at which 80 percent (by weight) of the pigment particles are smaller and D20 is the particle size at which 20 percent (by weight) of the pigment particles are smaller.

6. The basecoat composition of Claim 1 wherein said pigment component comprises calcium carbonate.

7. The basecoat composition of Claim 1 wherein said pigment component comprises precipitated calcium carbonate.

8. The basecoat composition of Claim 7 wherein said precipitated calcium carbonate comprises at least 50 percent by weight of said pigment component, preferably at least 70 percent by weight of said pigment component, more preferably at least 80 percent by weight of said pigment component and most preferably said pigment component consists essentially of said precipitated calcium carbonate.

9. The basecoat composition of Claim 1 wherein said pigment component comprises a blend of pigments.

10. The basecoat composition of Claim 1 wherein said pigment component consists essentially of inorganic pigments.

11. The basecoat composition of Claim 1 with the proviso that said pigment component is substantially free of platy pigments.

12. A paperboard structure comprising:

a paperboard substrate comprising a first major surface and a second major surface; and
a basecoat applied to at least one of said first major surface and said second major surface, said basecoat comprising a pigment component, said pigment component comprising all pigments in said basecoat, wherein said pigment component is as defined in any of claims 1 to 11.

13. The paperboard structure of Claim 12 wherein said paperboard substrate has a basis weight of at least 0.138kg/m² (85 pounds/3,000 ft²).

14. The paperboard structure of Claim 12 wherein said basecoat is applied at a coat weight of at most about 14.6 g/m² (9 pounds/3,000 ft²), preferably at most about 13.0 g/m² (8 pounds per 3000 square feet).

15. The paperboard structure of Claim 12 further comprising a top coat positioned over said basecoat to form a top-coated paperboard structure having an outermost coating surface, wherein said outermost coating surface preferably has a Parker Print Surf smoothness (PPS 10S) of at most about 3μm, more preferably at most about 2μm.

Patentansprüche

1. Grundierungsbeschichtungszusammensetzung für Pappe, wobei die Zusammensetzung umfasst:

einen Träger; und
eine Pigmentkomponente, die in dem Träger dispergiert ist, wobei die Pigmentkomponente alle Pigmente in der Grundierungsbeschichtungszusammensetzung umfasst,

wobei die Pigmentkomponente eine mittlere Teilchengröße zwischen etwa 3 und etwa 8 Mikrometer aufweist, und
wobei höchstens etwa 15 Gewichtsprozent der Pigmentkomponente eine Teilchengröße von weniger als 1 Mikrometer aufweisen.

2. Grundierungsbeschichtungszusammensetzung nach Anspruch 1, wobei die mittlere Teilchengröße zwischen etwa 3 und etwa 7 Mikrometer, vorzugsweise zwischen etwa 3 und etwa 6 Mikrometer und noch bevorzugter zwischen etwa 4 und etwa 5 Mikrometer liegt.

3. Grundierungsbeschichtungszusammensetzung nach Anspruch 1, wobei höchstens etwa 14 Gewichtsprozent der Pigmentkomponente eine Teilchengröße von weniger als 1 Mikrometer aufweisen, vorzugsweise weisen höchstens etwa 13 Gewichtsprozent der Pigmentkomponente eine Teilchengröße von weniger als 1 Mikrometer auf, noch bevorzugter weisen höchstens etwa 12 Gewichtsprozent der Pigmentkomponente eine Teilchengröße von weniger als 1 Mikrometer auf, und besonders bevorzugt weisen höchstens etwa 10 Gewichtsprozent der Pigmentkomponente eine Teilchengröße von weniger als 1 Mikrometer auf.

4. Grundierungsbeschichtungszusammensetzung nach Anspruch 1, wobei höchstens etwa 20 Gewichtsprozent der Pigmentkomponente eine Teilchengröße von mehr als 8 Mikrometer auf, vorzugsweise weisen höchstens etwa 15 Gewichtsprozent der Pigmentkomponente eine Teilchengröße von mehr als 8 Mikrometer auf und noch bevorzugter

weisen höchstens etwa 10 Gewichtsprozent der Pigmentkomponente eine Teilchengröße von mehr als 8 Mikrometer auf.

5. Grundierungsbeschichtungszusammensetzung nach Anspruch 1, wobei die Pigmentkomponente einen Steilheit Index von höchstens etwa 1,3, vorzugsweise höchstens etwa 1,2, mehr bevorzugt höchstens etwa 1,1, besonders bevorzugt höchstens etwa 1,0 aufweist, wobei der Steilheit Index (Ψ) definiert ist durch:

$$\Psi = \frac{D80 - D20}{D50}$$

wobei D50 die mittlere Teilchengröße ist, D80 die Teilchengröße ist, bei welcher 80 Prozent (bezogen auf das Gewicht) der Pigmentteilchen kleiner sind und D20 die Teilchengröße ist, bei welcher 20 Prozent (bezogen auf das Gewicht) der Pigmentteilchen kleiner sind.

6. Grundierungsbeschichtungszusammensetzung nach Anspruch 1, wobei die Pigmentkomponente Calciumcarbonat enthält.

7. Grundierungsbeschichtungszusammensetzung nach Anspruch 1, wobei die Pigmentkomponente ausgefälltes Calciumcarbonat enthält.

8. Grundierungsbeschichtungszusammensetzung nach Anspruch 7, wobei das ausgefällte Calciumcarbonat wenigstens 50 Gewichtsprozent der Pigmentkomponente, vorzugsweise wenigstens 70 Gewichtsprozent der Pigmentkomponente und noch bevorzugter wenigstens 80 Gewichtsprozent der Pigmentkomponente umfasst, und besonders bevorzugt besteht die Pigmentkomponente im Wesentlichen aus dem ausgefällten Calciumcarbonat.

9. Grundierungsbeschichtungszusammensetzung nach Anspruch 1, wobei die Pigmentkomponente eine Mischung von Pigmenten umfasst.

10. Grundierungsbeschichtungszusammensetzung nach Anspruch 1, wobei die Pigmentkomponente im Wesentlichen aus anorganischen Pigmenten besteht.

11. Grundierungsbeschichtungszusammensetzung nach Anspruch 1 mit der Maßgabe, dass die Pigmentkomponente im Wesentlichen frei von plättchenförmigen Pigmenten ist.

12. Kartonstruktur, umfassend:

ein Pappsubstrat mit einer ersten Hauptfläche und einer zweiten Hauptfläche; und eine Grundierungsbeschichtung, die wenigstens auf entweder der ersten Hauptfläche oder der zweiten Hauptfläche aufgebracht ist, wobei die Grundierungsbeschichtung eine Pigmentkomponente umfasst, wobei die Pigmentkomponente alle Pigmente in der Grundierungsbeschichtung umfasst und wobei die Pigmentkomponente eine Pigmentkomponente gemäß einem der Ansprüche 1 bis 11 ist.

13. Kartonstruktur nach Anspruch 12, wobei das Pappsubstrat ein Flächengewicht von wenigstens 0,138 kg/m² (85 Pfund/3.000 ft²) aufweist.

14. Kartonstruktur nach Anspruch 12, wobei die Grundierungsbeschichtung bei einem Beschichtungsgewicht von höchstens etwa 14,6 g/m² (9 Pfund/3.000 ft²), vorzugsweise höchstens etwa 13,0 g/m² (8 Pfund pro 3000 Quadratfuß) aufgebracht wird.

15. Kartonstruktur nach Anspruch 12, ferner umfassend eine Deckschicht, die über der Grundierungsbeschichtung angeordnet ist, um eine beschichtete Kartonstruktur mit einer äußersten Beschichtungsfläche auszubilden, wobei die äußerste Beschichtungsfläche vorzugsweise eine Parker-Druck-Brandung-Glätte (PPS 10S) von höchstens etwa 3 µm, mehr bevorzugt von höchstens etwa 2 µm aufweist.

Revendications

1. Composition de couche de fond pour carton, la composition comprenant :

une substance de support ; et
un composant pigment dispersé dans ladite substance de support, ledit composant pigment comprenant tous les pigments dans ladite composition de couche de fond,

dans laquelle ledit composant pigment a une taille médiane de particule comprise entre environ 3 et environ 8 micromètres, et
dans laquelle au maximum environ 15 pour cent en poids dudit composant pigment ont une taille de particule inférieure à 1 micromètre.

2. Composition de couche de fond selon la revendication 1, dans laquelle ladite taille médiane de particule est comprise entre environ 3 et environ 7 micromètres, de préférence entre environ 3 et environ 6 micromètres, de façon plus particulièrement préférée entre environ 4 et environ 5 micromètres.

3. Composition de couche de fond selon la revendication 1, dans laquelle au maximum environ 14 pour cent en poids dudit composant pigment ont une taille de particule inférieure à 1 micromètre, de préférence au maximum environ 13 pour cent en poids dudit composant pigment ont une taille de particule inférieure à 1 micromètre, de façon plus particulièrement préférée au maximum environ 12 pour cent en poids dudit composant pigment ont une taille de particule inférieure à 1 micromètre, de façon plus particulièrement préférée au maximum environ 11 pour cent en poids dudit composant pigment ont une taille de particule inférieure à 1 micromètre, de façon tout particulièrement préférée au maximum environ 10 pour cent en poids dudit composant pigment ont une taille de particule inférieure à 1 micromètre.

4. Composition de couche de fond selon la revendication 1, dans laquelle au maximum environ 20 pour cent en poids dudit composant pigment ont une taille de particule supérieure à 8 micromètres, de préférence au maximum environ 15 pour cent en poids dudit composant pigment ont une taille de particule supérieure à 8 micromètres, de façon plus particulièrement préférée au maximum environ 10 pour cent en poids dudit composant pigment ont une taille de particule supérieure à 8 micromètres.

5. Composition de couche de fond selon la revendication 1, dans laquelle ledit composant pigment a un indice d'inclinaison d'au maximum environ 1,3, de préférence d'au maximum environ 1,2, de façon plus particulièrement préférée d'au maximum environ 1,1, de façon tout particulièrement préférée d'au maximum environ 1,0, l'indice d'inclinaison (Ψ) étant défini par l'expression

$$\Psi = \frac{D80 - D20}{D50}$$

où D50 est la taille médiane de particule, D80 est la taille de particule à laquelle 80 pour cent (en poids) des particules de pigment sont plus petites et D20 est la taille de particule à laquelle 20 pour cent (en poids) des particules de pigment sont plus petites.

6. Composition de couche de fond selon la revendication 1, dans laquelle ledit composant pigment comprend du carbonate de calcium.

7. Composition de couche de fond selon la revendication 1, dans laquelle ledit composant pigment comprend du carbonate de calcium précipité.

8. Composition de couche de fond selon la revendication 7, dans laquelle ledit carbonate de calcium précipité constitue au moins 50 pour cent en poids dudit composant pigment, de préférence au moins 70 pour cent en poids dudit composant pigment, de façon plus particulièrement préférée au moins 80 pour cent en poids dudit composant pigment et de façon tout particulièrement préférée ledit composant pigment consiste essentiellement en ledit carbonate de calcium précipité.

9. Composition de couche de fond selon la revendication 1, dans laquelle ledit composant pigment comprend un mélange de pigments.

10. Composition de couche de fond selon la revendication 1, dans laquelle ledit composant pigment consiste essentiellement en des pigments inorganiques.

11. Composition de couche de fond selon la revendication 1, étant entendu que ledit composant pigment est essentiellement exempt de pigments lamellaires.

12. Structure de carton comprenant :

un subjectile en carton comprenant une première surface principale et une seconde surface principale ;
une couche de fond appliquée sur au moins l'une de ladite première surface principale et de ladite seconde surface principale, ladite couche de fond comprenant un composant pigment, ledit composant pigment comprenant tous les pigments dans ladite couche de fond, ledit composant pigment étant tel que défini dans l'une quelconque des revendications 1 à 11.

13. Structure de carton selon la revendication 12, dans laquelle ledit subjectile en carton a un grammage d'au moins 0,138 kg/m² (85 livres/3 000 pieds²).

14. Structure de carton selon la revendication 12, dans laquelle ladite couche de fond est appliquée en un poids de couche d'au maximum environ 14,6 g/m² (9 livres/3 000 pieds²), de préférence d'au maximum environ 13,0 g/m² (8 livres pour 3 000 pieds carrés).

15. Structure de carton selon la revendication 12, comprenant en outre une couche de finition positionnée au-dessus de ladite couche de fond pour former une structure de carton revêtue d'une couche de finition, présentant une surface de revêtement externe, ladite surface de revêtement externe ayant de préférence un lissé Parker Print Surf (PPS 10S) d'au maximum environ 3 μm, de façon plus particulièrement préférée d'au maximum environ 2 μm.

FIG. 1

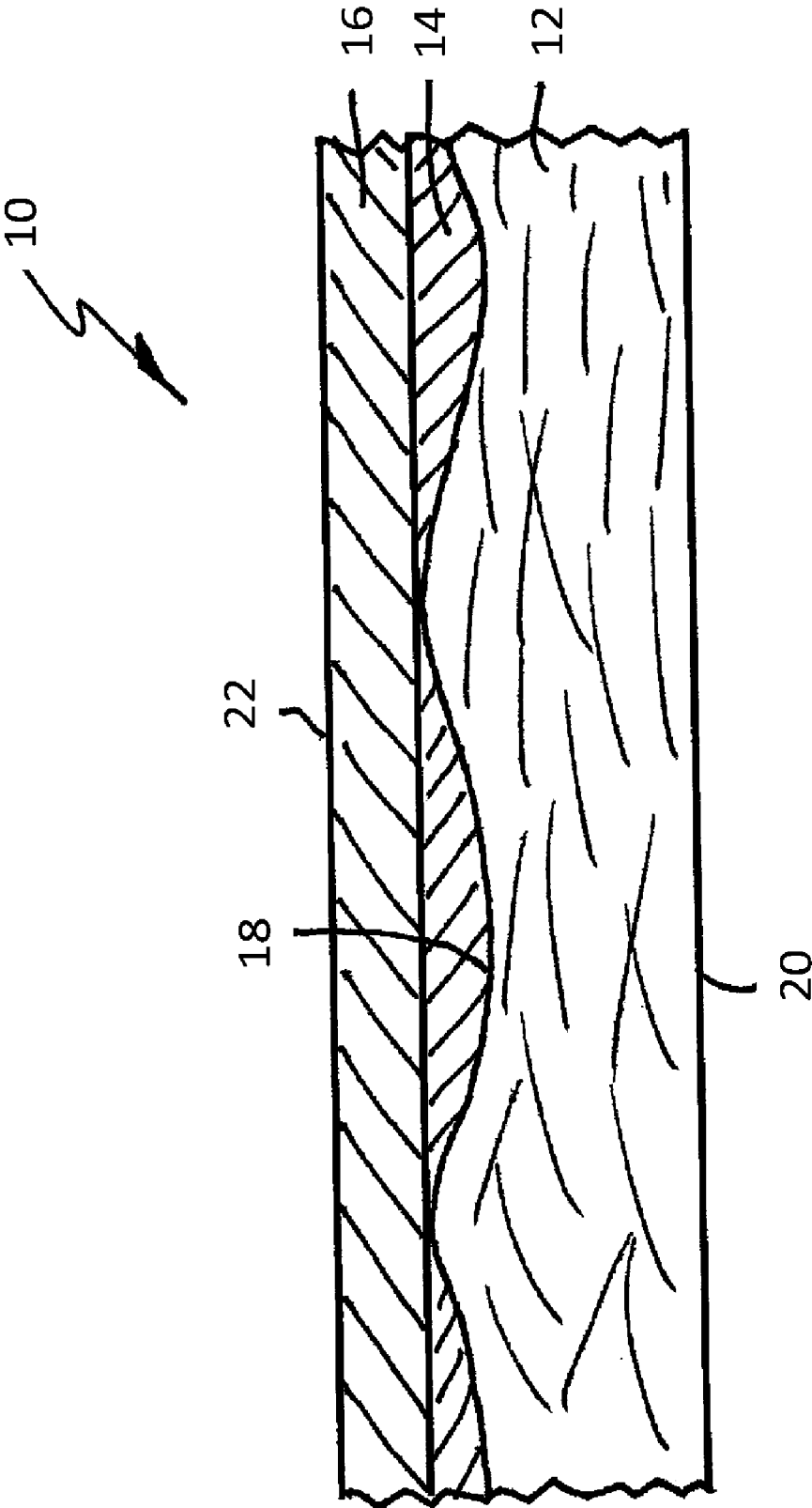


FIG. 2
Mass Percent Particle Size Distributions
For Vicality Heavy

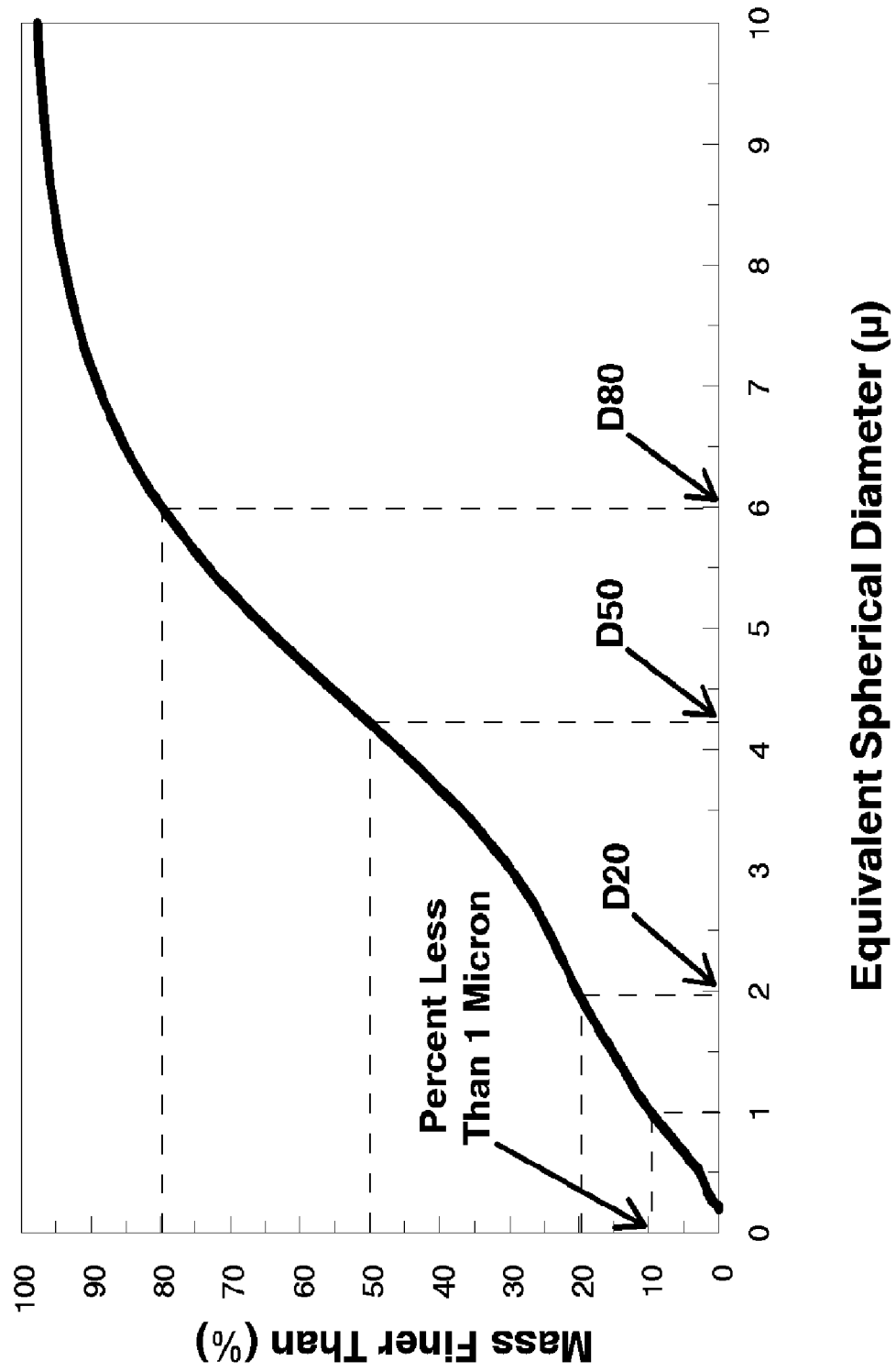


FIG. 3
Mass Particle Size Distributions
For Calcium Carbonate Pigments

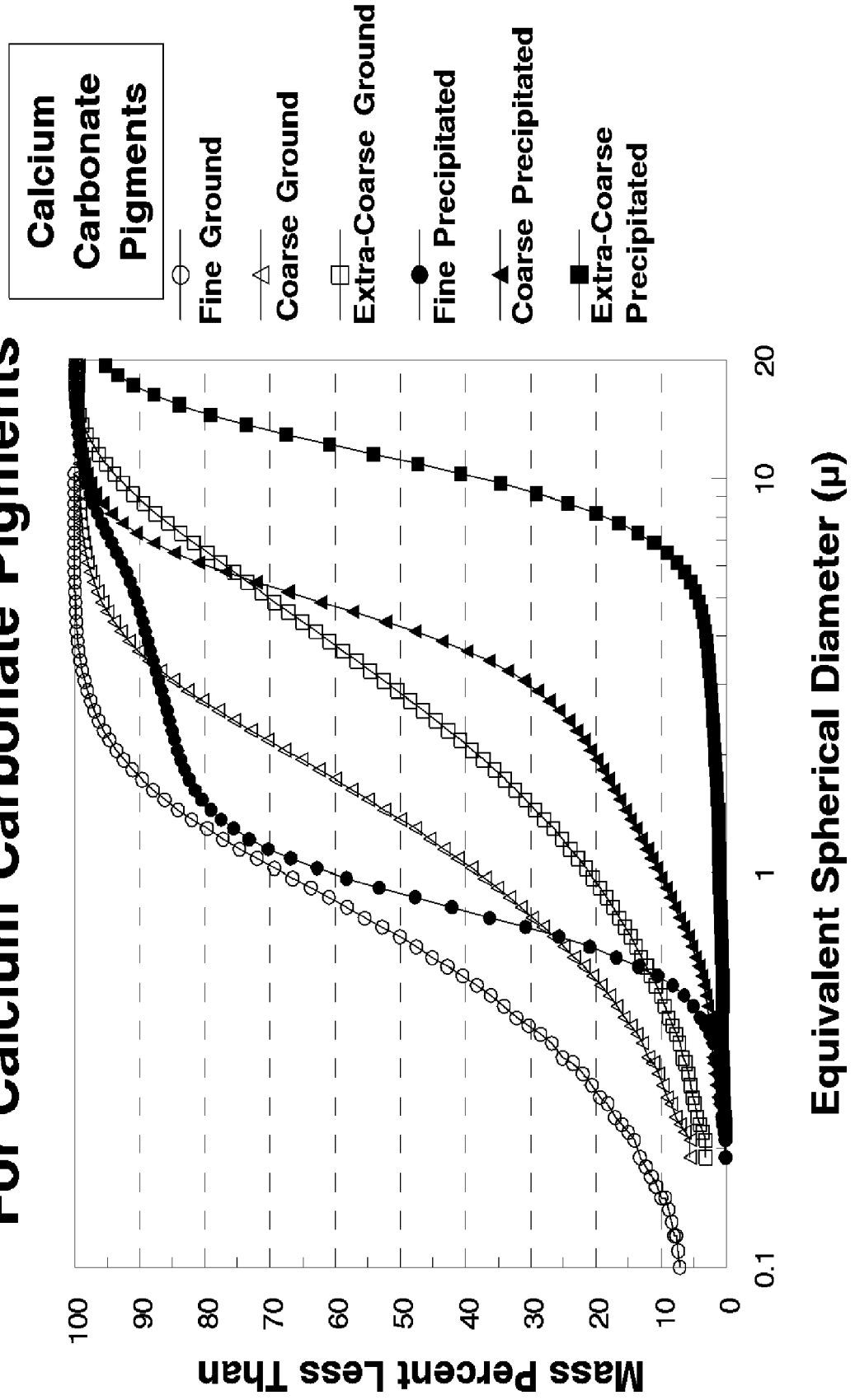


FIG. 4
Mass Frequency Particle Size Distributions
For Calcium Carbonate Pigments

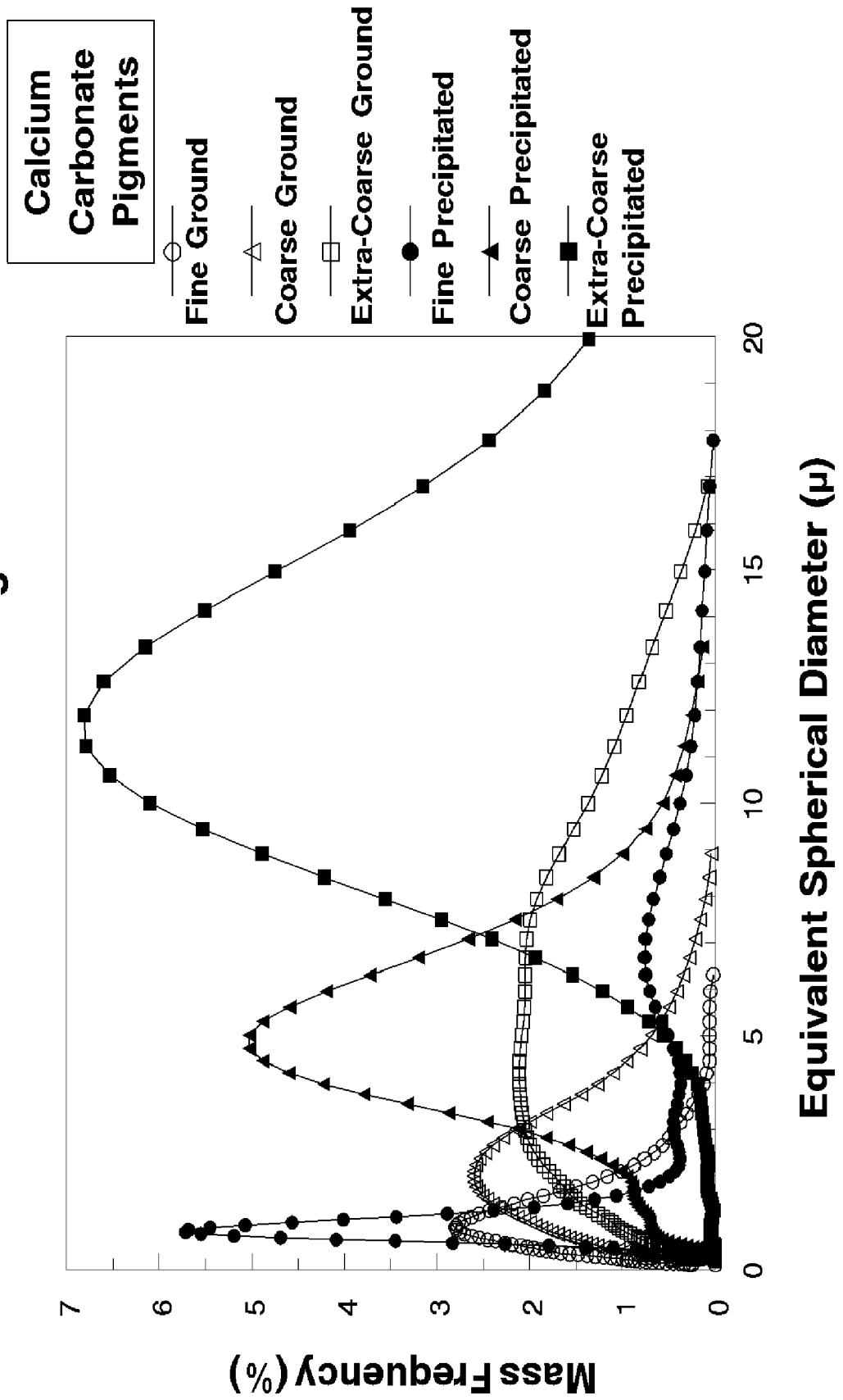


FIG. 5
Mass Particle Size Distributions
For Blended Calcium Carbonate Pigments

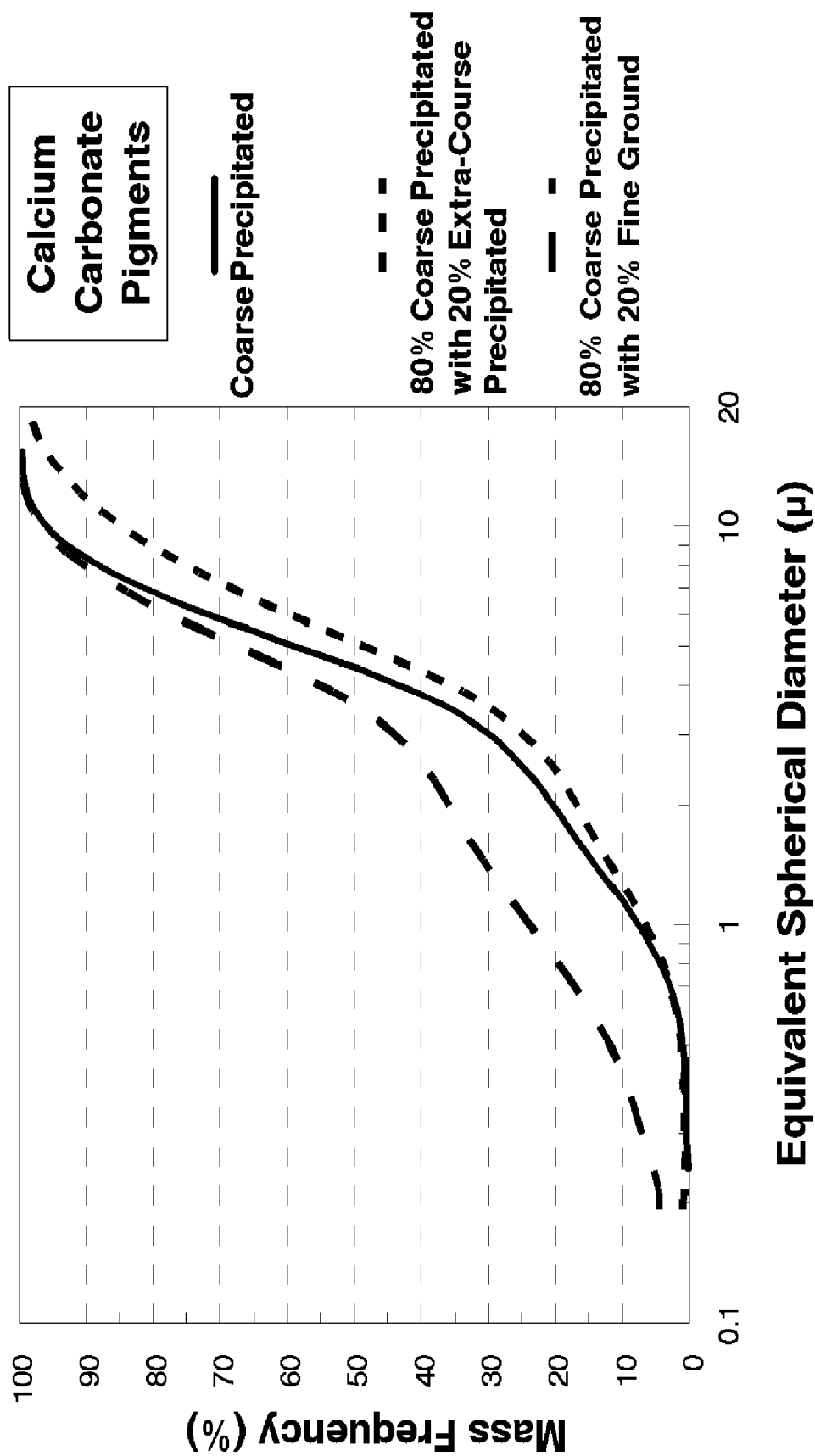


FIG. 6
Mass Frequency Particle Size Distributions
For Blended Calcium Carbonate Pigments

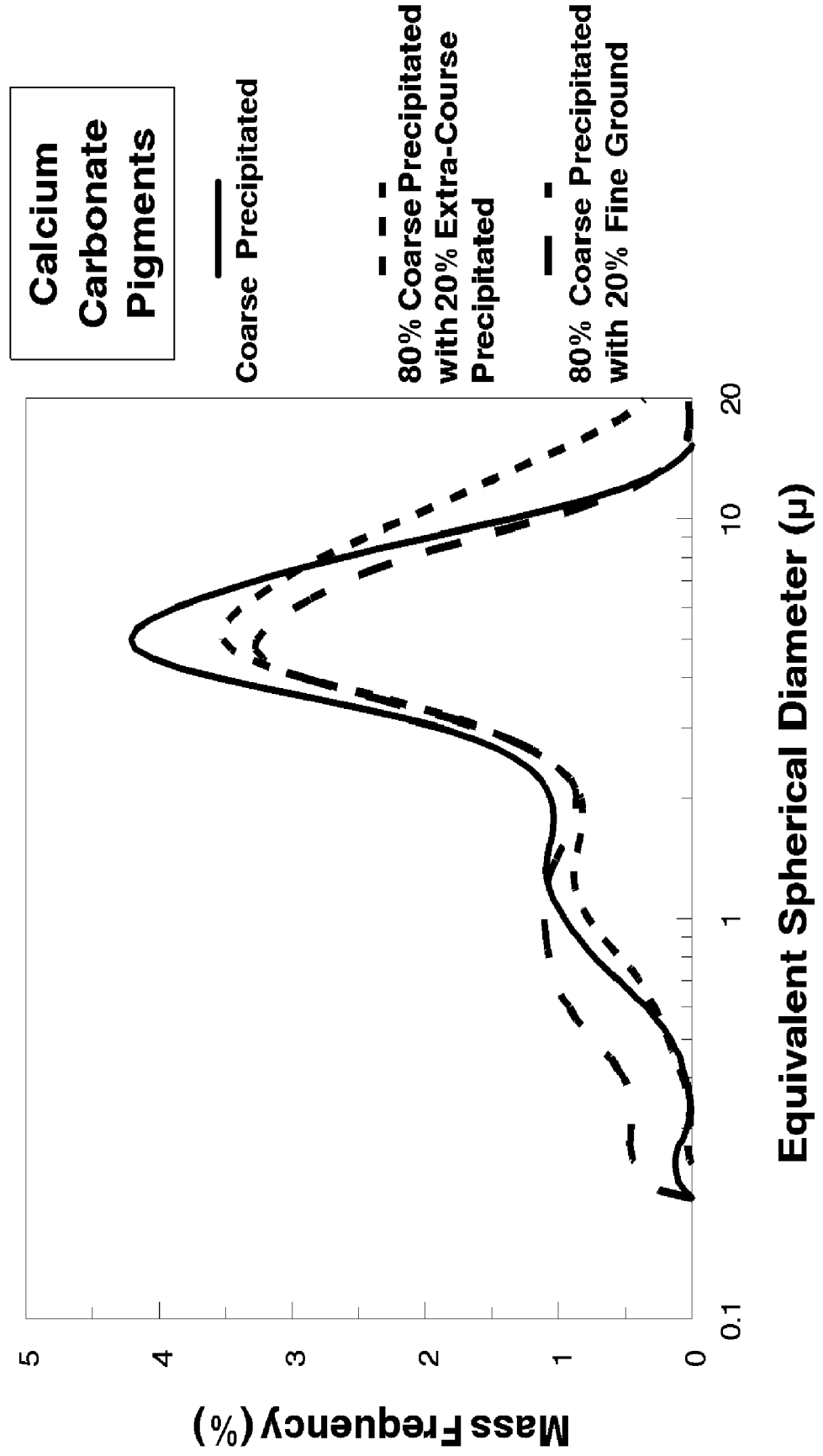


FIG. 7
Mass Percent Particle Size Distributions
For Vicality Heavy and Calescence 1500 Blends

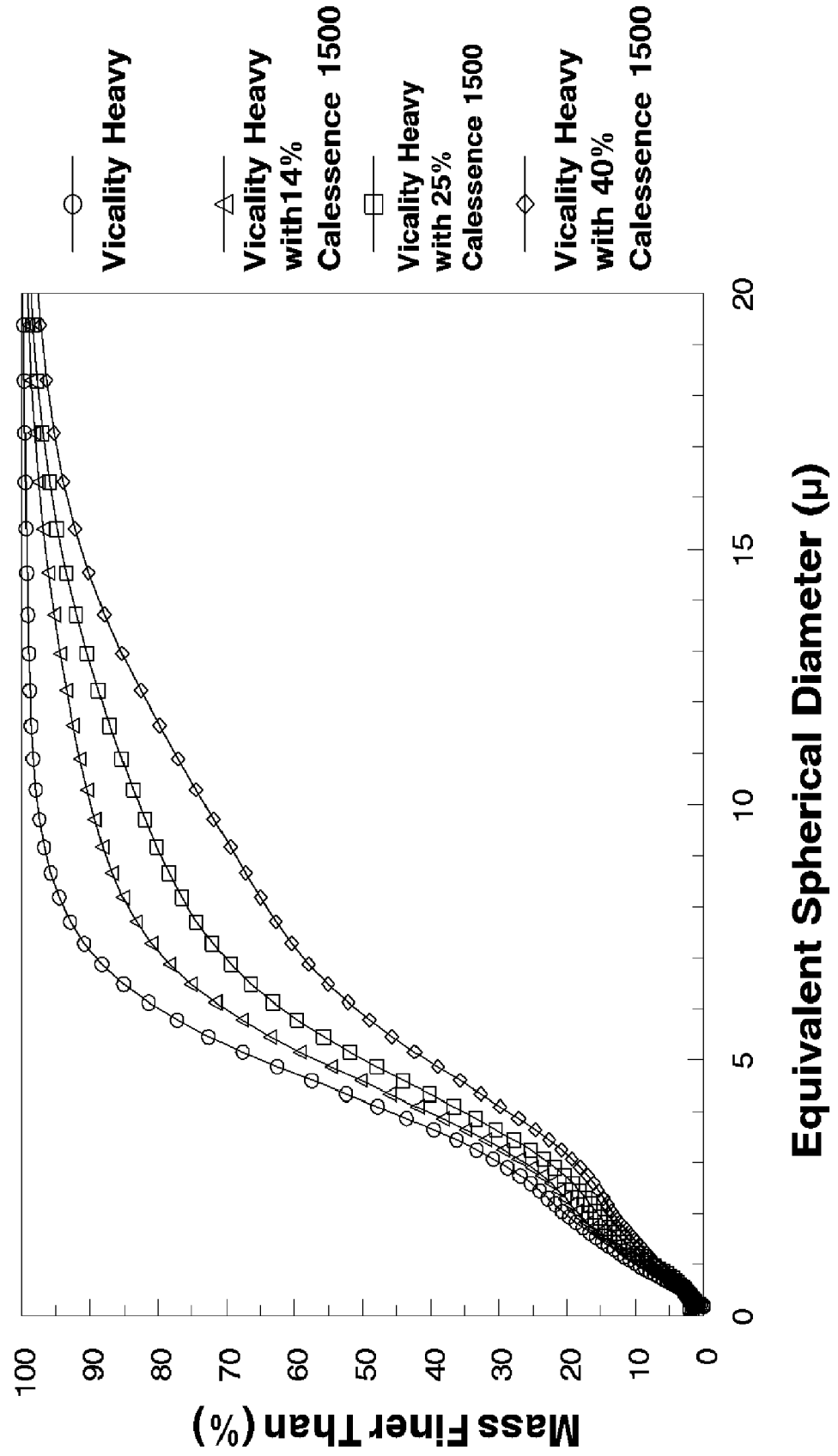


FIG. 8
Mass Frequency Particle Size Distributions
For Vicality Heavy and Calescence 1500 Blends

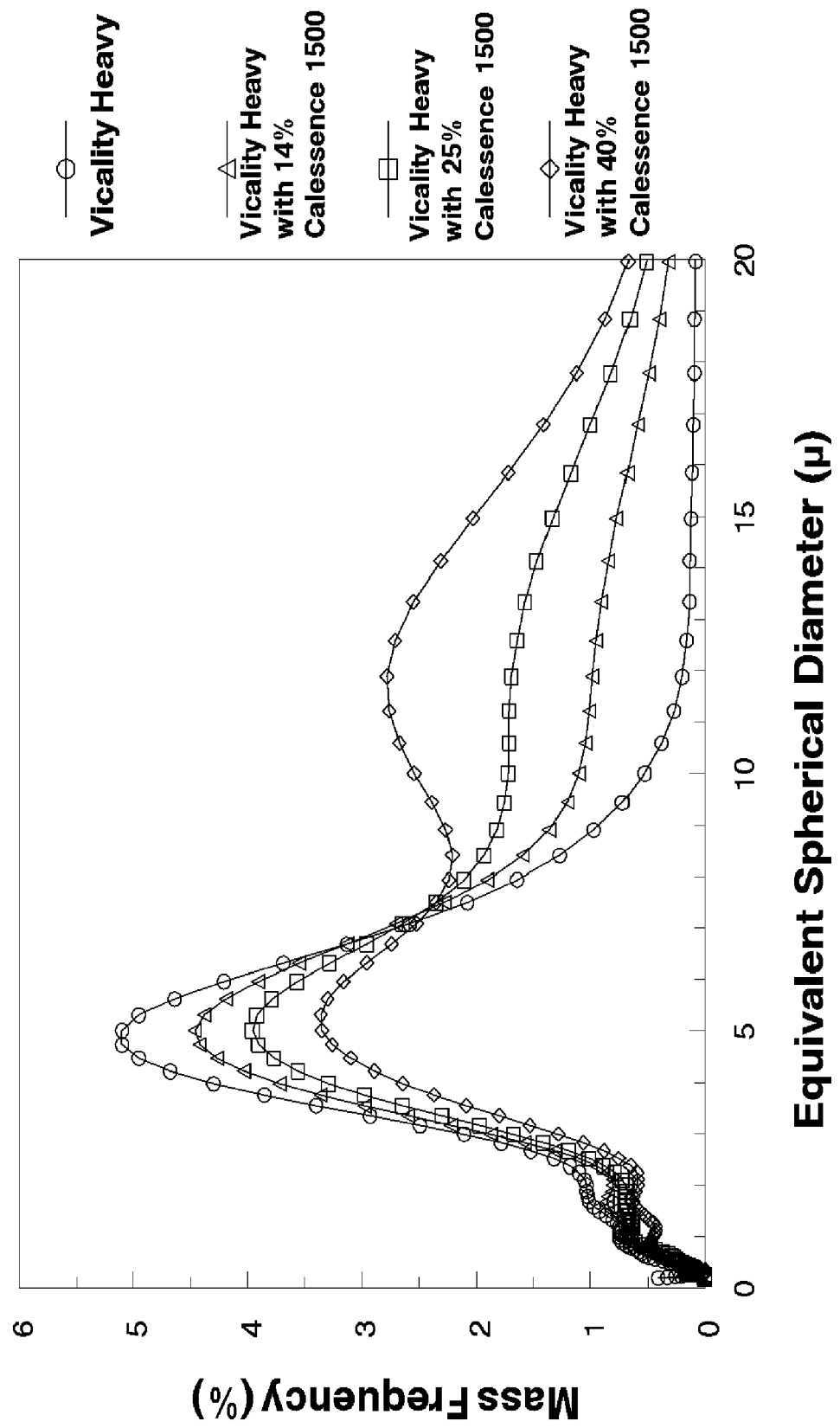


FIG. 9
Mass Percent Particle Size Distributions
For Vicality Heavy and Hydrocarb 90 Blends

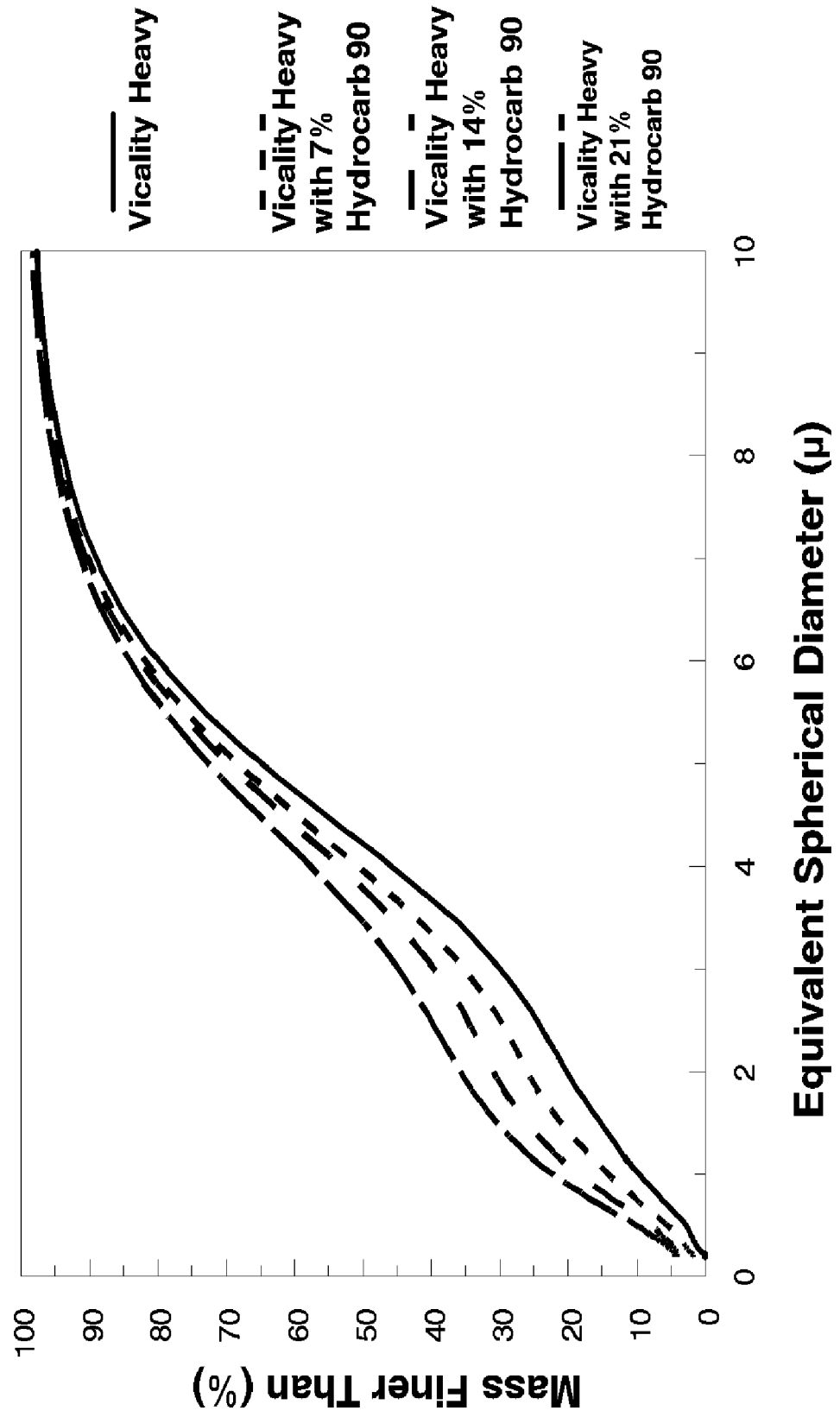


FIG. 10
Mass Frequency Particle Size Distributions
For Vicality Heavy and Hydrocarb 90 Blends

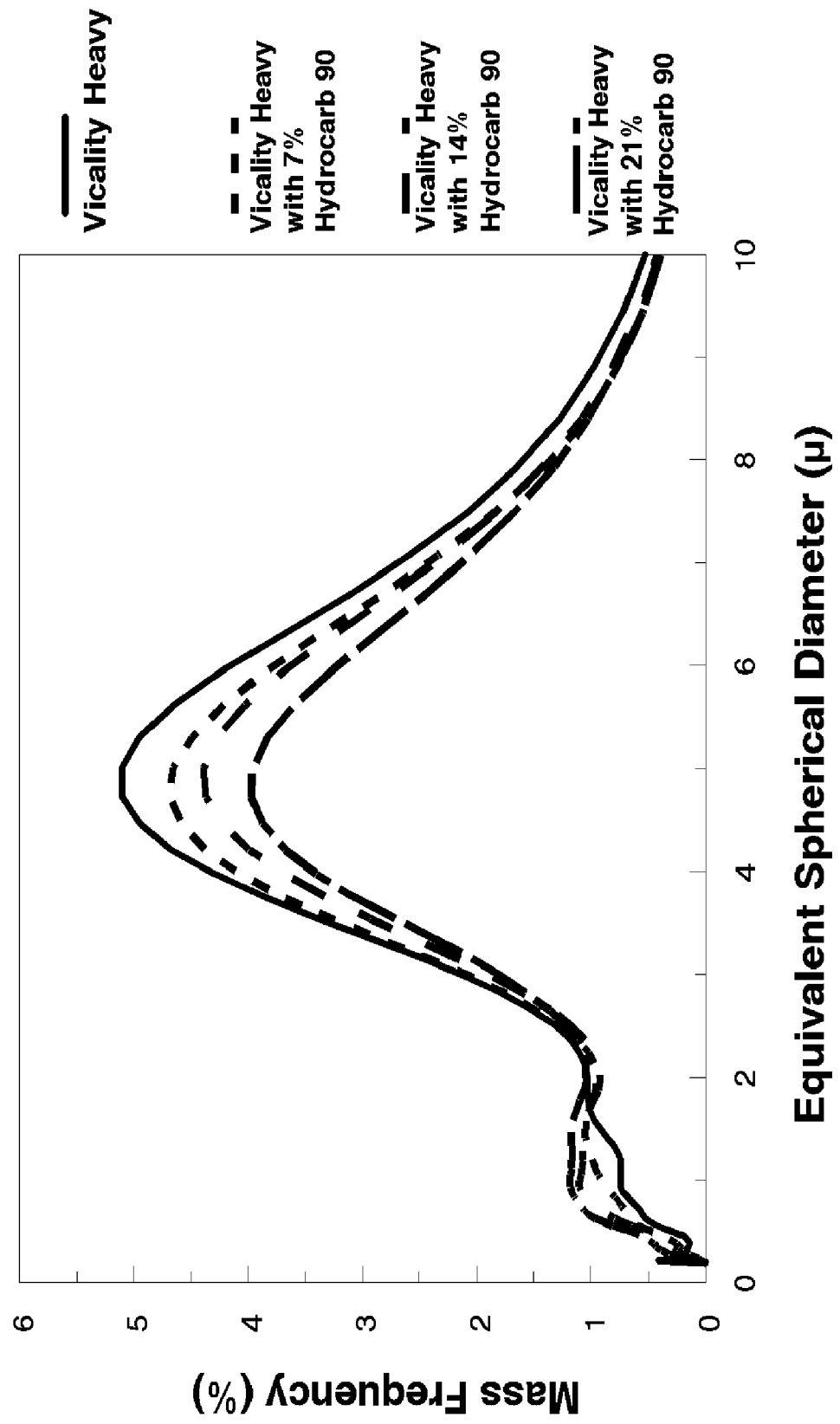


FIG. 11
Topcoated Calendered Smoothness Vs Percent Greater Than
8 μ For Blends of Vicality Heavy and Calescence 1500

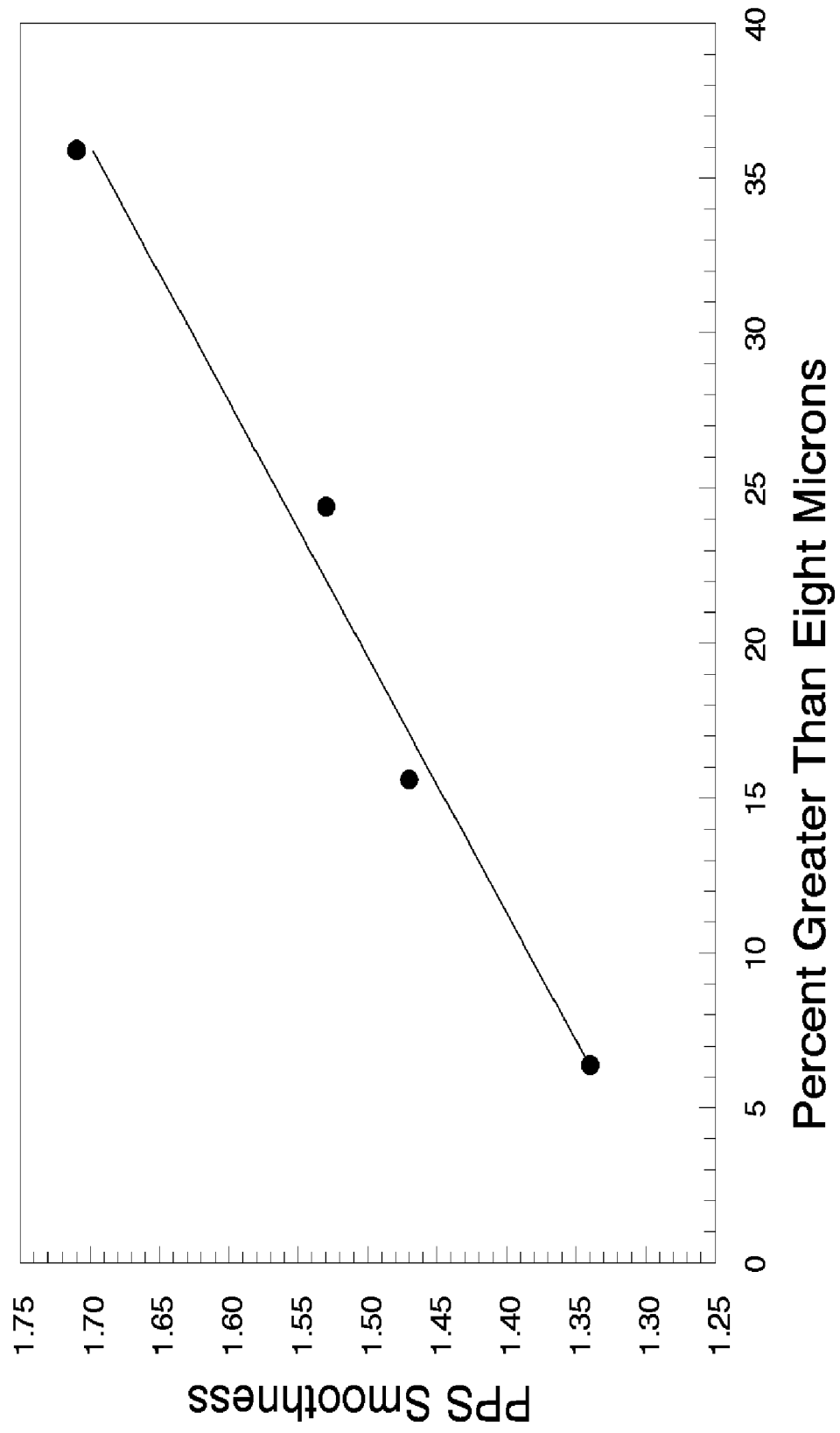


FIG. 12
Topcoated Calendered Smoothness Vs Percent Less
Than 1 μ For Blends of Vicality Heavy and Hydrocarb 90

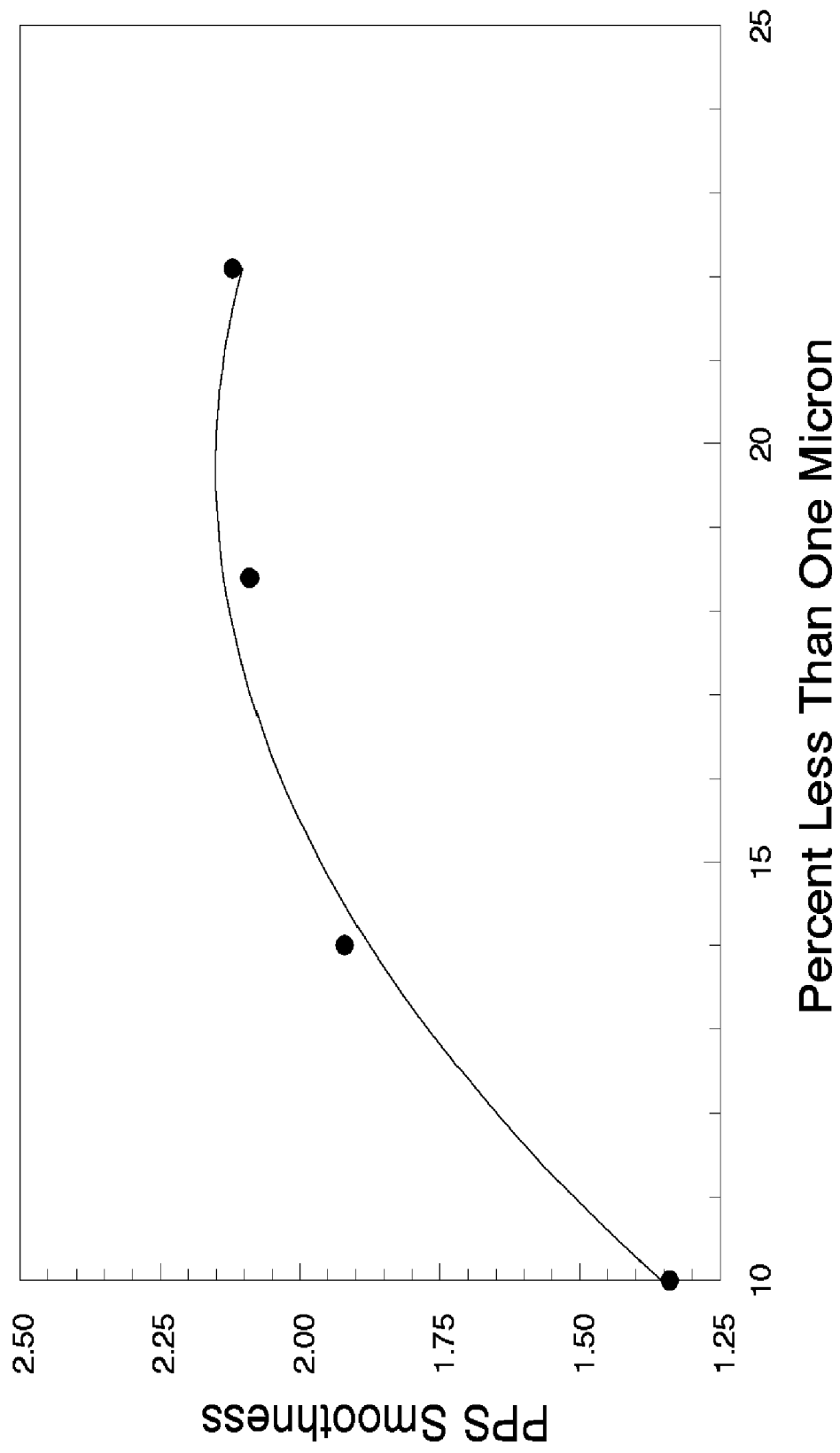


FIG. 13
Effect on Topcoated Calendered Smoothness of Adding 14% Fine or Coarse Pigment To a Coarse Narrow Particle Size Basecoat Pigment

