



US 20150218423A1

(19) **United States**(12) **Patent Application Publication**
Thebud et al.(10) **Pub. No.: US 2015/0218423 A1**(43) **Pub. Date: Aug. 6, 2015**(54) **STRUCTURED ADHESIVE LAYER****Publication Classification**(71) Applicant: **TESA SE**, Hamburg (DE)(51) **Int. Cl.**
C09J 7/02 (2006.01)(72) Inventors: **Nils Thebud**, Luneburg (DE); **Steffen Ebenau**, Hamburg (DE)**B29C 65/50** (2006.01)(52) **U.S. Cl.**
CPC **C09J 7/0289** (2013.01); **B29C 65/5085**
(2013.01); **C09J 7/025** (2013.01); **B29L**
2031/767 (2013.01)(73) Assignee: **TESA SE**, Hamburg (DE)(21) Appl. No.: **14/424,270**(57) **ABSTRACT**(22) PCT Filed: **Aug. 29, 2013**(86) PCT No.: **PCT/EP2013/067951**

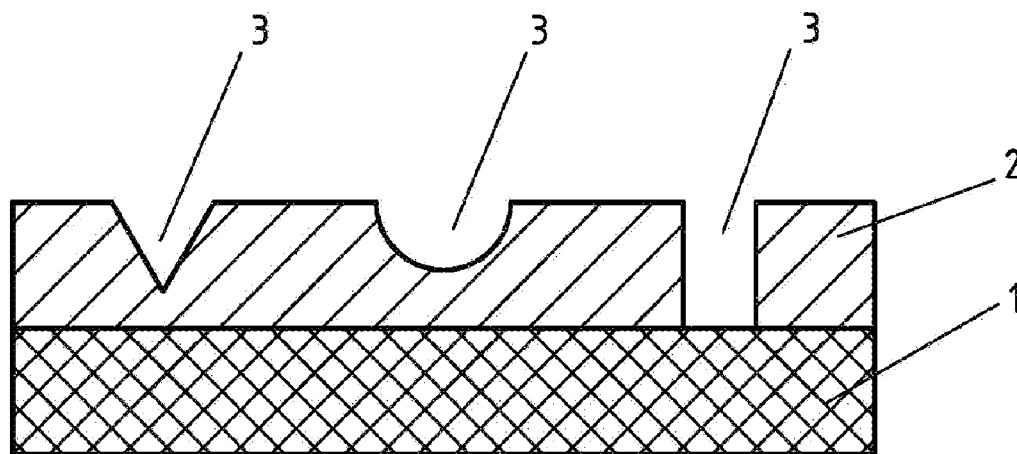
§ 371 (c)(1),

(2) Date: **Feb. 26, 2015**

The invention relates to the use of an adhesive tape to adhesively bond printing plates, during which the impairment of the adhesive bonds by air bubble inclusions between the adhesive tape and a substrate should be reduced. This is achieved by using an adhesive tape comprising at least one adhesive layer, wherein the adhesive layer has at least one groove that does not extend to one of the edges of the adhesive layer, and the portion of the entire groove volume of the adhesive layer that is associated with such grooves is more than 50%.

(30) **Foreign Application Priority Data**

Aug. 29, 2012 (DE) 10 2012 215 345.4



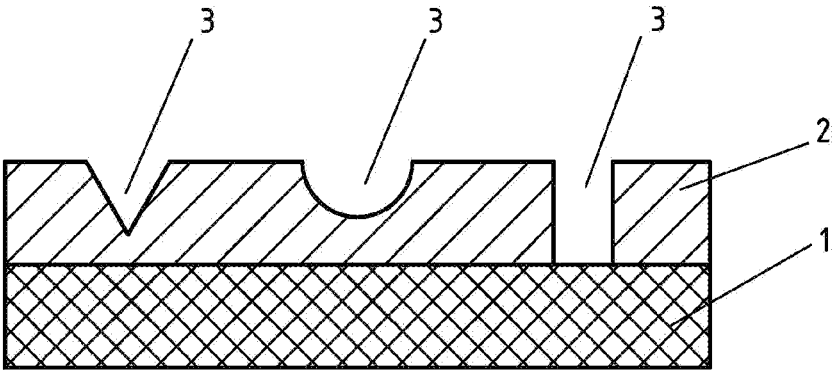


FIG.1

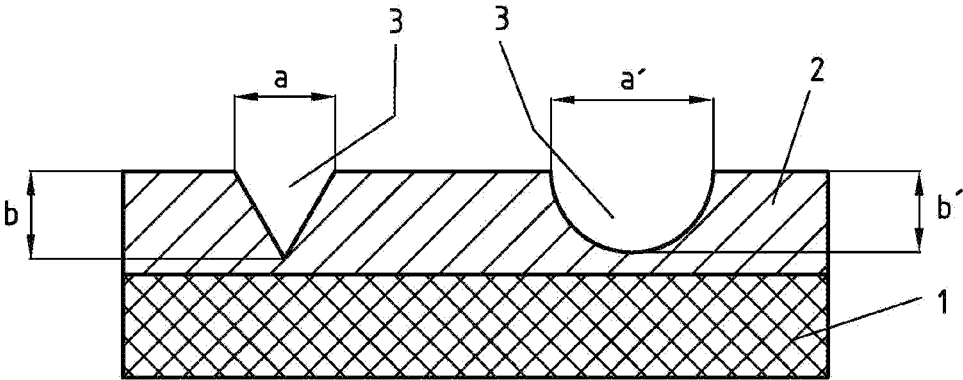
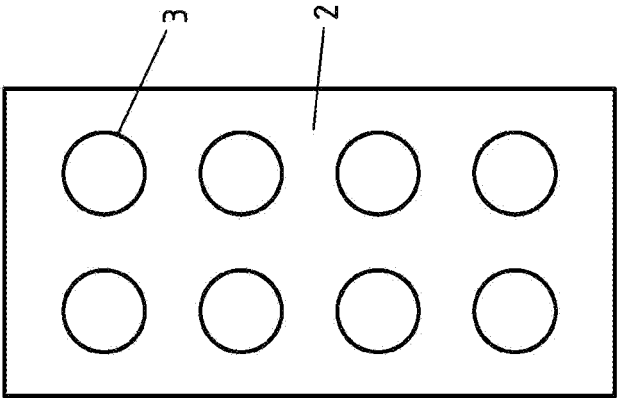
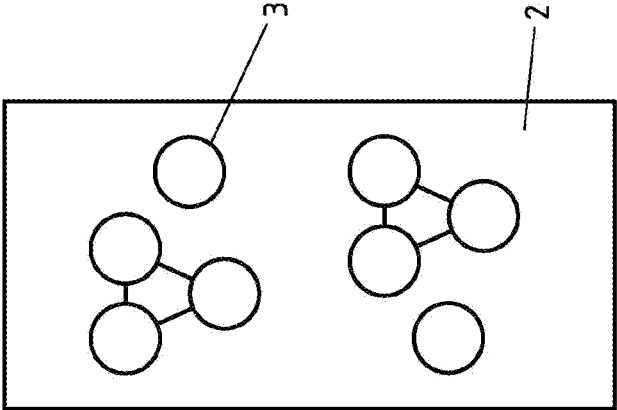
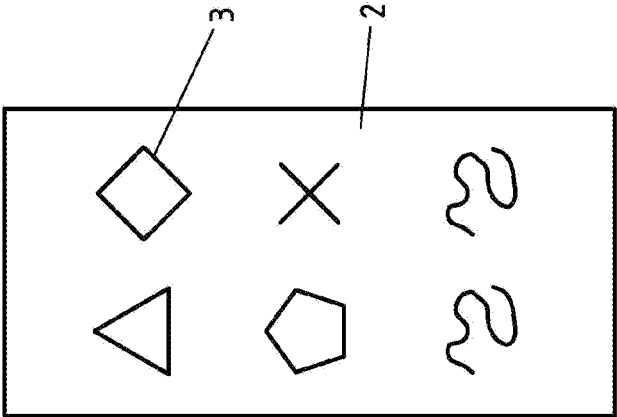


FIG.2



STRUCTURED ADHESIVE LAYER

[0001] This application is a 371 of International Patent Application No. PCT/EP2013/067951, filed Aug. 29, 2013, which claims foreign priority benefit under 35 U.S.C. §119 of the German Patent Application No. 10 2012 215 345.4, filed Aug. 29, 2012, the disclosures of which patent applications are incorporated herein by reference.

[0002] The invention is situated within the technical field of adhesive tapes. The invention relates in particular to adhesive tapes having a particular topography in the surface of an adhesive layer, and especially to the use thereof for the adhesive bonding of printing plates.

[0003] Adhesive tapes are used in a wide variety of ways to join substrates, but also, for example, as masking tapes or insulating tapes. An important role in the context of bonds with adhesive tapes is played by the nature of the contact area between adhesive and substrate. This contact area may be adversely affected by a variety of external influences, these influences leading in general to a reduction in the available contact area, in turn causing the quality of the target bond to drop. The contact area may be reduced, for example, by air inclusions between adhesive and substrate. This is frequently manifested in imprecise bonds and/or in bonds which lack strength and durability.

[0004] Precise positioning of substrates to be bonded is vital, for example, in flexographic printing processes. These are rotational printing processes where flexible printing plates made from photopolymer or rubber are utilized, the plates having a relief corresponding to the information to be applied by printing. These printing plates or printing formes are fastened on a printing cylinder. This is done using adhesive tapes which by virtue of their compressibility properties substantially influence the print quality.

[0005] In the printing process, the printing plate then passes through an ink reservoir, where the relief takes up the printing ink. The printing cylinder then transports the printing plate to a transfer station, where the surface containing printing ink comes into contact with the substrate to be printed. On removal of the printing plate from the substrate, the film of printing ink splits and leaves behind an imprint corresponding to the relief present on the printing plate surface. Ink transfer requires precise monitoring of the applied pressure when placing the printing plate onto the substrate, this pressure substantially determining the thickness of application and the uniformity of the printed image.

[0006] A double-sided adhesive tape is typically used for fastening the printing plate on the printing cylinder. In order to ensure high print quality, the printing plate must be very carefully mounted on the printing cylinder and precisely positioned. It is often times necessary for the position of the plate to have to be adjusted a number of times. In the course of the mounting of the plate on the printing cylinder, and in the course of possible repositioning, the inclusion of air occurs frequently at the interfaces between printing plate and adhesive tape and/or between adhesive tape and carrier or printing cylinder. Air bubbles of this kind lead to changes in the pressure applied when placing the printing plate onto the substrate, and constitute one of the most frequent sources of error in flexographic printing processes.

[0007] While it is possible in principle to remove the air inclusions using syringes or knives, these tools may also cause damage to the printing plates. Attempts have therefore been made to counter the inclusion of air bubbles by specific adhesive tape architectures. For instance, adhesive tapes with

adhesive in a parallel stripe or corrugated pattern have been used. Such adhesive tapes, however, have proven to lack sufficient reliability in terms of the bonding quality achieved. Although they did allow air to escape efficiently from the interfaces, the bonding effect between carrier and printing plate lack sufficient reliability, especially at high throughput rates. Adhesive tapes with an irregular relief of adhesive were also trialed, but likewise gave inadequate bonding strengths and, moreover, continued to have air inclusions in certain regions.

[0008] U.S. Pat. No. 5,296,277 describes an adhesive tape having a number of elevations in the adhesive layer, these elevations having flattened, adhesive tips whose area is less than 25% of the total area of the adhesive layer.

[0009] U.S. Pat. No. 5,362,516 describes the structuring of the surface of an adhesive layer by means of beads which are applied beforehand and over which the adhesive is then spread. A similar construction is subject matter of U.S. Pat. No. 5,141,790, in which case the structuring is achieved via particles which are incorporated into the adhesive layer and whose tips are substantially free of adhesive.

[0010] GB 1 511 060 describes an adhesive layer having at least one relatively long ridge or cutout, with at least one of these structures breaking through the outer edge of the adhesive layer.

[0011] U.S. Pat. No. 5,268,228 describes a double-sided adhesive tape having joints in the adhesive layer on one or both sides, the purpose of these joints being to divert the air during bonding, and their size being such that they very largely disappear after bonding.

[0012] WO 98/29516 A1 as well relates to adhesive layers with an embossed relief, and describes a method for controlling the topography of an adhesive surface, wherein the relief or topography of the adhesive layer controls the bonding performance.

[0013] WO 02/11985 A1 describes adhesive tapes for use in flexographic printing processes, the tapes having a regular pattern of permanent channels. Furthermore, the specification describes flexographic printing processes and other components of an apparatus for flexographic printing.

[0014] The measures known to date for preventing air inclusions during the adhesive bonding of printing plates provide for the air to be carried away outwardly. As a result, however, the problem of capillary effects—which may even cause air to be drawn in—arises frequently. There are often disadvantages in the distribution of the wetting area and/or of the bond strengths, owing to the air removal channels that are present in the adhesive layer, and this can lead to deficient bonds. It is possible, for example, that air is not taken off toward the outside at all, but instead is merely shifted within the adhesive layer into the next cavity. Here there may be substantial accumulations of air, which lower the accuracy of the bond and/or of the positioning of the substrate. Furthermore, the contact area actually achieved between adhesive and substrate is often heavily dependent on the pressure exerted.

[0015] Continuous grooves or channels which are made in the adhesive layers and are intended to allow air to flow away may also promote the penetration of liquids, as for example of printer ink, at least into the edge regions of the bonds, owing to the capillary effects described above. Such effects may weaken the adhesive bonds, possibly up to the point of substrate detachment.

[0016] It is an object of the invention, therefore, to provide an adhesive tape with which the above problems can be overcome. The adhesive tape is intended in particular to counteract the displacement of air bubbles within the adhesive tape as a result of the prevailing applied pressure, and to allow largely constant bond areas and bond strengths independently of the applied pressure. It is also intended that the penetration of air and also, in particular, of liquids into the edge regions of the bonds should be avoided.

[0017] The achievement of this object is based on the idea that substantial proportions or all of the included air should not be diverted to the outside, but should instead be diverted into and held in defined recesses within the adhesive layer. A first subject of the invention, therefore, is the use of an adhesive tape which comprises at least one pressure-sensitively adhesive layer, the adhesive layer having at least one groove that does not extend to one of the edges of the adhesive layer, and the proportion of the total groove volume of the adhesive layer that is accounted for by such grooves being more than 50%, for the adhesive bonding of printing plates. In the context of such use, the advantage of the significantly reduced or no longer present capillary effects in the edge regions of the adhesive bond comes to bear. Fluids and air are therefore drawn not at all, or at least to a reduced extent, into the bond area. The weakening of the bond and the formation of new air bubbles, under the influence of an applied pressure prevailing only at certain locations of the adhesive tape, is reduced or avoided completely.

BRIEF DESCRIPTION OF THE DRAWINGS

[0018] The invention will now be described in greater detail with reference to the drawings, wherein:

[0019] FIG. 1 is a schematic illustrating a number of variants of grooves in the adhesive layer.

[0020] FIG. 2 is a schematic of the adhesive layer, illustrating the meaning of the terms “groove depth” and “groove width”.

[0021] FIG. 3 is a plan view of a grooved adhesive layer and shows repeating shapes that are present separately from one another.

[0022] FIG. 4 is a plan view of a grooved adhesive layer and shows repeating groove shapes that are partly separate from one another and partly joined to one another.

[0023] FIG. 5 is a plan view of a grooved adhesive layer and shows different groove shapes present separately from one another.

[0024] With preference in accordance with the invention, the proportion of the total groove volume of the adhesive layer that is accounted for by grooves that do not extend to one of the edges of the adhesive layer is more than 70%, more preferably more than 80%, more particularly more than 90%, as for example more than 93%, very preferably more than 96%, and most preferably more than 99%.

[0025] By the “total groove volume of the adhesive layer” is meant the total volume occupied by grooves in the pressure-sensitively adhesive layer. Included here is both the volume occupied by grooves with edge contact and the volume occupied by grooves without edge contact.

[0026] By printing plates, which may also generally be referred to as printing formes, the invention refers to articles for the transfer of printing inks to a substrate suitable for receiving these inks. The printing plates may in principle be employed in all relevant printing processes such as relief printing, planographic printing, gravure printing and tem-

plate printing. With preference in accordance with the invention, the printing plates are printing plates for relief printing processes. More preferably the printing plates are flexographic printing plates. In flexographic printing, soft printing plates and highly fluid printing inks are employed. The printing plates typically consist either of a UV-sensitive photopolymer plate or of rubber. The photopolymeric printing plate is exposed with UV light through a negative mask, and the printing elements are developed in a washing operation. Laser engraving is used to manufacture the printing plates made from rubber material. Following their production, the printing plates are adhered to the printing cylinder of the flexographic printing machine using adhesive tapes.

[0027] A “pressure-sensitively adhesive layer” is a layer of a viscoelastic adhesive whose set film at room temperature in the dry state remains permanently tacky and adhesive. The pressure-sensitively adhesive layer may, possibly following the removal of an overlying release liner, come into direct contact with a substrate and adhere thereto. Bonding takes place by gentle applied pressure, immediately to virtually all substrates.

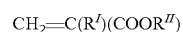
[0028] The at least one pressure-sensitively adhesive layer of the adhesive tape in the use according to the invention preferably comprises a polymer selected from the group consisting of natural rubbers, synthetic rubbers, polyacrylates, silicones, and mixtures of two or more of the above polymers. More preferably the at least one pressure-sensitively adhesive layer of the adhesive tape of the invention comprises to an extent of at least 30 wt %, more preferably at least 40 wt %, and more particularly at least 50 wt %, based on the total weight of the adhesive layer, a polymer selected from the group consisting of natural rubbers, synthetic rubbers, polyacrylates, silicones, and mixtures of two or more of the above polymers.

[0029] Synthetic rubbers preferably comprise styrene-butadiene copolymers, block copolymers such as, for example, styrene-isoprene-styrene, styrene-butadiene-styrene, styrene-ethylene/butylene-styrene, styrene-ethylene/propylene styrene, and combinations of the above copolymers. Synthetic rubbers and natural rubbers are commonly used together with at least one bond strength reinforcing resin. Examples of bond strength reinforcing resins contemplated include polymers of unsaturated C₅-C₉ hydrocarbons, terpene resins, and rosin.

[0030] By “polyacrylates” are meant polymers whose monomer base on an amount-of-substance basis is made up to an extent of at least 30% of acrylic acid, methacrylic acid, acrylate esters and/or methacrylic esters, with acrylic esters and/or methacrylic esters being present generally at least proportionally and preferably to an extent of at least 30%. More particularly a “polyacrylate” is a polymer obtainable by radical polymerization of acrylic and/or methylacrylic monomers and also, optionally, further, copolymerizable monomers.

[0031] Preference is given to using a polyacrylate which can be traced back to the following monomer composition:

[0032] a) acrylic esters and/or methacrylic esters of the following formula



[0033] where R^I is H or CH₃ and R^{II} is an alkyl radical having 4 to 14 C atoms,

[0034] b) olefinically unsaturated monomers having functional groups, which are reactive toward epoxide groups, for example,

[0035] c) optionally further acrylates and/or methacrylates and/or olefinically unsaturated monomers which are copolymerizable with component (a).

[0036] The proportions of the corresponding components (a), (b), and (c) are preferably selected such that the product of polymerization has in particular a glass transition temperature $\leq 15^\circ\text{C}$. (DMA at low frequencies).

[0037] It is advantageous to select the monomers of component (a) with a fraction of 45 to 99 wt %, the monomers of component (b) with a fraction of 1 to 15 wt %, and the monomers of component (c) with a fraction of 0 to 40 wt % (the figures are based on the monomer mixture for the "base polymer", in other words without additions of possible additives to the completed polymer, such as resins etc.).

[0038] In particular, the monomers of component (a) are plasticizing and/or nonpolar monomers. Preferred for use as monomers (a) are acrylic and methacrylic esters with alkyl groups consisting of 4 to 14 C atoms, more preferably 4 to 9 C atoms. Examples of such monomers are n-butyl acrylate, n-butyl methacrylate, n-pentyl acrylate, n-pentyl methacrylate, n-amyl acrylate, n-hexyl acrylate, hexyl methacrylate, n-heptyl acrylate, n-octyl acrylate, n-octyl methacrylate, n-nonyl acrylate, isobutyl acrylate, isooctyl acrylate, isooctyl methacrylate, and their branched isomers, such as 2-ethylhexyl acrylate or 2-ethylhexyl methacrylate, for example.

[0039] In particular, the monomers of component (b) are olefinically unsaturated monomers having functional groups, in particular having functional groups which are able to enter into a reaction with epoxide groups.

[0040] For component (b), preference is given to using monomers with functional groups which are selected from the group encompassing the following: hydroxyl, carboxyl, sulfonic acid or phosphonic acid groups, acid anhydrides, epoxides, amines.

[0041] Particularly preferred examples of monomers of component (b) are acrylic acid, methacrylic acid, itaconic acid, maleic acid, fumaric acid, crotonic acid, aconitic acid, dimethylacrylic acid, β -acryloyloxypropionic acid, trichloroacrylic acid, vinylacetic acid, vinylphosphonic acid, itaconic acid, maleic anhydride, hydroxyethyl acrylate, hydroxypropyl acrylate, hydroxyethyl methacrylate, hydroxypropyl methacrylate, 6-hydroxyhexyl methacrylate, allyl alcohol, glycidyl acrylate, glycidyl methacrylate.

[0042] In principle it is possible as component (c) to use all vinylically functionalized compounds which are copolymerizable with component (a) and/or with component (b). The monomers of component (c) may serve to adjust the properties of the resultant pressure-sensitive adhesive.

Exemplary monomers of component (c) are as follows:

[0043] methyl acrylate, ethyl acrylate, propyl acrylate, methyl methacrylate, ethyl methacrylate, benzyl acrylate, benzyl methacrylate, sec-butyl acrylate, tert-butyl acrylate, phenyl acrylate, phenyl methacrylate, isobornyl acrylate, isobornyl methacrylate, tert-butyl phenyl acrylate, tert-butylphenyl methacrylate, dodecyl methacrylate, isodecyl acrylate, lauryl acrylate, n-undecyl acrylate, stearyl acrylate, tridecyl acrylate, behenyl acrylate, cyclohexyl methacrylate, cyclopentyl methacrylate, phenoxyethyl acrylate, phenoxyethyl methacrylate, 2-butoxyethyl methacrylate, 2-butoxyethyl acrylate, 3,3,5-trimethyl-cyclohexyl acrylate, 3,5-dimethyladamantyl acrylate, 4-cumylphenyl methacrylate, cyanoethyl acrylate, cyanoethyl methacrylate, 4-biphenyl acrylate, 4-biphenyl methacrylate, 2-naphthyl acrylate, 2-naphthyl methacrylate, tetrahydrofurfuryl acrylate, diethy-

laminoethyl acrylate, diethylaminoethyl methacrylate, dimethylaminoethyl acrylate, dimethylaminoethyl methacrylate, 2-butoxyethyl acrylate, 2-butoxyethyl methacrylate, methyl 3-methoxy acrylate, 3-methoxybutyl acrylate, phenoxyethyl acrylate, phenoxyethyl methacrylate, 2-phenoxyethyl methacrylate, butyldiglycol methacrylate, ethylene glycol acrylate, ethylene glycol monomethyl acrylate, methoxy polyethylene glycol methacrylate 350, methoxy polyethylene glycol methacrylate 500, propylene glycol monomethacrylate, butoxydiethylene glycol methacrylate, ethoxytriethylene glycol methacrylate, octafluoropentyl acrylate, octafluoropentyl methacrylate, 2,2,2-trifluoroethyl methacrylate, 1,1,1,3,3,3-hexafluoroisopropyl acrylate, 1,1,1,3,3,3-hexafluoroisopropyl methacrylate, 2,2,3,3,3-pentafluoropropyl methacrylate, 2,2,3,4,4,4-heptafluorobutyl methacrylate, 2,2,3,3,4,4,4-heptafluorobutyl acrylate, 2,2,3,3,4,4,4-heptafluorobutyl methacrylate, 2,2,3,3,4,4,5,5,6,6,7,7,8,8,8-pentafluorooctyl methacrylate, dimethylaminopropylacrylamide, dimethylaminopropylmethacrylamide, N-(1-methylundecyl)acrylamide, N-(n-butoxymethyl)acrylamide, N-(butoxymethyl)methacrylamide, N-(ethoxymethyl)acrylamide, N-(n-octadecyl)acrylamide, and also N,N-dialkyl-substituted amides, such as, for example, N, N-dimethylacrylamide, N, N-dimethylmethacrylamide, N-benzylacrylamides, N-isopropylacrylamide, N-tert-butylacrylamide, N-tert-octylacrylamide, N-methylolacrylamide, N-methylolmethacrylamide, acrylonitrile, methacrylonitrile, vinyl ethers, such as vinyl methyl ether, ethyl vinyl ether, vinyl isobutyl ether, vinyl esters, such as vinyl acetate, vinyl chloride, vinyl halides, vinylidene chloride, vinylidene halides, vinylpyridine, 4-vinylpyridine, N-vinylphthalimide, N-vinyl lactam, N-vinylpyrrolidone, styrene, α - and p-methylstyrene, α -butylstyrene, 4-n-butylstyrene, 4-n-decylstyrene, 3,4-dimethoxystyrene. Macromonomers such as 2-polystyreneethyl methacrylate (molecular weight M_w of 4000 to 13 000 g/mol), poly(methyl methacrylate)ethyl methacrylate (M_w of 2000 to 8000 g/mol).

[0044] Monomers of component (c) may advantageously also be selected such that they contain functional groups which support subsequent radiation crosslinking (for example by electron beams, UV). Suitable copolymerizable photoinitiators are, for example, benzoin acrylate and acrylate-functionalized benzophenone derivatives. Monomers which support crosslinking by electron beam bombardment are, for example, tetrahydrofurfuryl acrylate, N-tert-butylacrylamide, and allyl acrylate.

[0045] The polyacrylates may be prepared by methods familiar to the skilled person, especially advantageously by conventional radical polymerizations or controlled radical polymerizations. The polyacrylates may be prepared by copolymerizing the monomeric components, using the customary polymerization initiators and also, optionally, chain transfer agents, with polymerization taking place at the customary temperatures in bulk, in emulsion, in water or liquid hydrocarbons for example, or in solution.

[0046] The weight-average molecular weights M_w of the polyacrylates are preferably in a range from 20 000 to 2 000 000 g/mol, very preferably in a range from 100 000 to 1 000 000 g/mol, extremely preferably in a range from 150 000 to 500 000 g/mol; the figures for the average molecular weight M_w and for the polydispersity PD in this specification relate to the determination by gel permeation chromatography. To this end it may be advantageous to conduct the polymerization in

the presence of suitable chain transfer agents such as thiols, halogen compounds and/or alcohols, in order to set the desired average molecular weight.

[0047] Silicones are preferably polydiorganosiloxanes having a number-average molecular weight of about 5000 to about 10 000 000, more particularly of about 50 000 to about 1 000 000, and/or copolymeric silicone resins, also designated as MQ resins, with a number-average molecular weight of about 100 to about 1 000 000, more particularly of about 500 to about 50 000. The MQ resins contain triorganosilyloxy units and also $\text{SiO}_{4/2}$ units. Silicone-based pressure-sensitive adhesives customarily comprise 20 to 60 parts by weight of polydiorganosiloxanes and 40 to 80 parts by weight of one or more MQ resins. The aim is usually for a reaction of the polydiorganosiloxanes with the MQ resins, in order for adhesive properties to be developed. A reaction of this kind may be, for example, a condensation reaction between silanol functionalities present in the MQ resin and terminal silanol groups of the diorganopolysiloxanes. A further possible reaction pathway is formed by addition reactions between alkenyl functionalities of the polydiorganosiloxanes and SiH , alkenyl and/or silanol functionalities of the MQ resins.

[0048] The at least one pressure-sensitively adhesive layer of the adhesive tape of the inventive use may comprise additives which may contribute to the emphasis of particular properties of the adhesive layer. These additives may be, for example, pigments, plasticizers, fillers, stabilizers, antioxidants, etc. The proportion of the additives in the adhesive layer is preferably from 0.1 to 50 wt %, based on the total weight of the adhesive layer.

[0049] The weight per unit area of the nongrooved regions of the adhesive layer is preferably not more than 200 g/m^2 , more preferably not more than 100 g/m^2 , and more particularly 40 to 100 g/m^2 , as for example 60 to 100 g/m^2 . The stated weight per unit area relates to the fully embossed regions of the adhesive layer, and hence not to the grooves provided in accordance with the invention.

[0050] Likewise preferably, the adhesive layer is a coherent adhesive layer. This means an adhesive layer which parallel to its non-grooved surface, has a plane with an adhesive layer which is present continuously, i.e., is unbroken at any location. A coherent adhesive layer will of course have the groove or grooves provided in accordance with the invention, but in the case of a coherent adhesive layer, these grooves must not be so deep that the pressure-sensitive adhesive layer is interrupted. Provided that the surface of the adhesive layer lies substantially in the x-y plane, accordingly, in the case of a coherent adhesive layer, a section parallel to the x-y plane in a defined depth z must result in pressure-sensitive adhesive being present at every point in the sectional plane. The non-grooved surface of the adhesive layer is regarded as being the nongrooved boundary with the surrounding medium on the side of the pressure-sensitive adhesive layer that faces the substrate to be bonded.

[0051] The adhesive tape of the inventive use may be either a single-sided or a double-sided adhesive tape.

[0052] A “groove” means a macroscopically perceptible recess within the pressure-sensitively adhesive layer, beginning in the surface of the adhesive layer, and able in principle to have any desired shape and depth. Using the representation of a cut made through an adhesive tape of the invention, in the direction of the layer sequence of an angle of 90° to the running direction of the grooves, FIG. 1 illustrates a number

of variants of grooves in the adhesive layer. The reference numerals in the figure have the following meanings:

[0053] 1—carrier

[0054] 2—pressure-sensitively adhesive layer

[0055] 3—grooves.

[0056] With preference in accordance with the invention, the depth of the groove or grooves that do not extend to one of the edges of the adhesive layer is 10 to $200 \mu\text{m}$, more preferably 10 to $100 \mu\text{m}$, more particularly 20 to $60 \mu\text{m}$, as for example 25 to $50 \mu\text{m}$, very preferably 25 to $30 \mu\text{m}$. The “groove depth” means the maximum extent of a groove perpendicular to the plane in which the nongrooved surface of the adhesive layer is situated. The nongrooved surface of the adhesive layer is situated on the substrate-facing side of the adhesive layer.

[0057] Furthermore, the depth of all grooves that do not extend to one of the edges of the adhesive layer varies preferably by not more than 20%. The uniform topography that is achieved in this way ensures consistent bonding properties over the full extent of the adhesive tape.

[0058] With preference in accordance with the invention, the width of the groove or grooves that do not extend to one of the edges of the adhesive layer is 10 to $200 \mu\text{m}$. The “groove width” means the maximum distance of the groove edges from one another at an angle of 90° to the running direction of the groove, at any desired location of the groove.

[0059] Using the representation of a cut made through an adhesive tape of the invention parallel to the layer sequence and at an angle of 90° to the running direction of the grooves, FIG. 2 illustrates the meaning of the terms “groove depth” and “groove width”. The meaning of the reference numerals in the figure is as follows:

[0060] 1—carrier

[0061] 2—pressure-sensitively adhesive layer

[0062] 3—grooves

[0063] a, a'—groove width

[0064] b, b'—groove depth.

[0065] In accordance with the invention the pressure-sensitively adhesive layer has at least one groove which does not extend to one of the edges of the adhesive layer. This means that the groove in question has no contact with an outer boundary of the surface of the adhesive layer or with any area of the adhesive layer that is situated beneath the surface and parallel to the plane of the surface. Instead, there is always at least a minimum amount of pressure-sensitive adhesive between such a groove and the edge of the adhesive layer.

[0066] A groove extends to one of the edges of the adhesive layer when a fluid is able to reach an edge of the adhesive layer on an uninterrupted path from an inner region of the groove, and to emerge from the groove at that point. This means that even a groove which extends only up to another groove arm and opens into that arm is regarded as a groove which extends to one of the edges of the adhesive layer, provided a fluid, starting from the first groove, which opens out into the other groove arm, is able to reach an edge of the adhesive layer and to emerge from the adhesive layer at that point.

[0067] The architecture of the groove structure of the adhesive tape of the inventive use therefore differs from conventional topographies, which frequently provide continuous channels, in contact with the edges, for transporting air away. In the case of adhesive tapes for the bonding of printing plates, particularly of printing plates for flexographic printing, such channels, suitable for the removal of air to the

outside, are standard in the adhesive layer, since it is assumed that air must be removed from the bonding interface in order reliably to obtain a uniform printed image. With the adhesive tape of the inventive use, the disadvantages of such designs that have already been listed can be avoided, without air inclusions influencing the quality of bonding. The distance between any point on the edge of the adhesive layer and any point in a groove which does not extend to one of the edges of the adhesive layer is preferably at least 1 mm.

[0068] The air volume enclosed by the adhesive tape of the inventive use, and the achievable substrate wetting area, are preferably in a ratio to one another such that pressure stresses and shear stresses that occur in the assembly operation and during the service of the adhesive tape are unable to displace the air. The nongrooved surface of the pressure-sensitively adhesive layer is preferably 50% to 99%, more particularly 70% to 95%, and very preferably 75% to 90% of the total surface area of the adhesive layer.

[0069] The grooves in the adhesive tape of the inventive use are preferably permanent grooves. This means that the rheological properties of the adhesive layer are set in such a way that the adhesive layer topography determined by the groove or grooves is durably retained in its essential extent during the intended utilization of the adhesive tape. More preferably, “permanent grooves” means that the topography is retained in its substantial extent even after multiple utilization of the adhesive tape or after utilization over a relatively long time, as for example over several hours at 20 to 80° C. This permanence of the groove or grooves ensures that even if the adhesive tape comes under multiple or relatively long-lasting stress, air can be accommodated in the recesses intended for that purpose, and hence exact adhesive bonds are possible.

[0070] The geometric form of the profile of the grooves that do not extend to one of the edges of the pressure-sensitively adhesive layer is in principle freely selectable and may comprise, for example, lines, circles, polygons and/or amorphous structures. Also possible are indicia, logos, or the like. Repeating patterns may join one another or be present separately from one another. FIGS. 3 to 5 show in each case a plan view of the grooved, pressure-sensitively adhesive layer of an adhesive tape of the invention, and illustrate possible groove shapes. FIG. 3 shows repeating shapes that are present separately from one another. FIG. 4 shows repeating groove shapes that are partly separate from one another are partly joined to one another. FIG. 5 shows different groove shapes present separately from one another. The meanings of the reference numerals in each case are as follows:

[0071] 2—pressure-sensitively adhesive layer

[0072] 3—grooves.

[0073] The grooves may, furthermore, in a section in the direction of the layer sequence of the adhesive tape and at an angle of 90° to the running direction of the respective groove, likewise have in principle any desired form, comprising—for example—triangular, rectangular, or semicircular variants. Some of these forms are already evident from FIG. 1.

[0074] The higher regions of the pressure-sensitively adhesive layer are preferably macroscopically planar. This means in particular that there may be a sharp transition to a groove, which can be specified by the statement of an angle between planar, nongrooved region of the adhesive layer and groove wall. The counterpart to higher regions of the adhesive layer that are macroscopically planar are approximately corrugated higher regions. With a grooved adhesive layer whose higher regions are of planar design, it is possible with advantage to

obtain a bonding area that is largely independent of the applied pressure, whereas the bonding area in the case of more corrugated structures is much more heavily dependent on the applied pressure.

[0075] A further subject of the invention is a double-sided adhesive tape which comprises a pressure-sensitively adhesive layer on each of its top and bottom sides and which further comprises a polymer film and/or a polymer foam, and which is characterized in that at least one of the pressure-sensitively adhesive layers has at least one groove that does not extend to one of the edges of the adhesive layer, and in that the proportion of the total groove volume of the adhesive layer that is accounted for by such grooves is more than 50%. The polymer film is preferably a stabilizing film, such as a PET film. More preferably the adhesive tape of the invention comprises a polymer foam, and the polymer foam is a polyolefin foam, very preferably a closed-cell polyethylene foam.

[0076] The stabilizing film advantageously increases the pulling resistance of the adhesive tape of the invention, and therefore simplifies its demounting. The foam layer increases print quality. For the fixing of the stabilizing film on the foam, a laminated adhesive may be introduced between them.

[0077] The adhesive tape of the invention includes, for example, the following layers in the stated sequence:

[0078] grooved pressure-sensitive adhesive

[0079] polymer film (stabilizing film)

[0080] laminating adhesive

[0081] polymer foam

[0082] pressure-sensitive adhesive (grooved or nongrooved).

[0083] Also possible is an above construction where there is no laminating adhesive, where the stabilizing film is nevertheless surrounded on both sides by a layer of polyethylene, which has been applied in the form of a liquid composition, for example, to the stabilizing film.

[0084] A further subject of the invention is a release liner which comprises a polyolefin film or a paper carrier and which further comprises a silicone release layer, and which is characterized in that the silicone release layer has at least one ridge that does not extend to one of the edges of the silicone release layer, and the proportion of the total ridge volume of the silicone release layer that is accounted for by such ridges is more than 50%. With a release layer of this kind, the structure determined by the ridges can be easily embossed into the pressure-sensitively adhesive layer of an adhesive tape, and so the groove pattern described above can be produced there. With particular preference, the release liner of the invention comprises a polyolefin film, and the polyolefin film is a polypropylene film. More particularly the polyolefin film is based on monoaxially or biaxially oriented polypropylene.

[0085] In the context of the inventive use, the grooves and the pressure-sensitively adhesive layer have been obtained preferably by embossing, using a release liner having a complementary surface structure.

[0086] A release liner—also referred to below simply as a liner—is a lining material which has a nonstick (adhesive) surface and which is applied directly to an adhesive for temporary protection of the adhesive, and which can generally be removed by simple peeling immediately prior to application of the adhesive. Among other things, a release liner ensures that the adhesive is not soiled prior to use. In addition, release liners may be adjusted, by the nature and composition of the release materials, in such a way that the adhesive tape can be

unwound with the desired force (easily or with difficulty). Moreover, in the case of adhesive tapes coated with adhesive on both sides, the release liner ensures that the correct side of the adhesive is exposed first on unwind.

[0087] A liner is not part of an adhesive tape, but instead is just an aid to its production, storage, or for further processing. Furthermore, unlike an adhesive tape carrier, a liner is not joined permanently to a layer of adhesive; instead, the assembly is only temporary and not lasting.

[0088] A “ridge” means a macroscopically perceptible elevation that begins in the surface of the liner and that may in principle have any desired shape and height within the context of the invention. For possible forms and patterns of arrangement of the ridges in the liner, the comments made above concerning the grooves and the groove pattern of the pressure-sensitively adhesive layer apply correspondingly. The geometric form of the profile of the ridges is therefore in principle likewise freely selectable and may include, for example, lines, circles, polygons and/or amorphous structures. Also possible are indicia, logos, or the like. Repeating patterns may be joined to one another or be present separately from one another. In cross section, for example, the ridges comprise triangular, rectangular, or semicircular variants.

[0089] A “surface” of the liner is considered to mean the respective boundary of the two sides of the liner with the surrounding medium. With preference in accordance with the invention, the proportion of the surface of the silicone release layer that is formed by ridges is 1% to 50%, more preferably 5% to 30%, and more particularly 10% to 25%.

[0090] In accordance with the invention, the silicone release layer has at least one ridge that does not extend to one of the edges of the silicone release layer. This means, in a sense corresponding to the groove pattern of the adhesive tape of the inventive use, that the ridge in question has no contact with an outer border of the surface of the silicone release layer.

[0091] The ridge height of the release liner of the invention is preferably 10 to 200 μm , more preferably 20 to 100 μm , more particularly 25 to 60 μm , as for example 30 to 50 μm . The “ridge height” means the maximum extent of a ridge perpendicular to the plane in which the surface of the silicone release layer that is not occupied by ridges is located.

[0092] The ridge width at the foot of the ridge is preferably 10 to 200 μm . The “ridge width” means the maximum distance between two points at the foot of the ridge from one another at an angle of 90° to the running direction of the ridge at any desired location on the ridge.

[0093] Measurement of the extent of the ridges in the liner of the invention and of the grooves of the adhesive tape of the inventive use, particularly the measurement of the ridge heights and groove depths, is accomplished by means of scanning electron microscopy (SEM).

[0094] The liner of the invention may comprise at least one ridge on one side or else on both sides.

[0095] The silicone release layer of the liner of the invention preferably comprises a crosslinked silicone systems. These include silicone systems which have been produced from mixtures of crosslinking catalysts and what are called thermally curable condensation-crosslinking or addition-crosslinking organopolysiloxanes. For condensation-crosslinking silicone systems, tin compounds such as dibutyltin diacetate are frequently present as crosslinking catalysts in the composition.

[0096] The thickness of the liner of the invention, disregarding the ridges, is preferably 20 to 200 μm .

[0097] The ridge topography on the surface of the liner of the invention may be obtained, for example, by shaping (embossing methods), primary forming (cast film), or by printing.

[0098] A further subject of the invention is an assembly which comprises a release liner of the invention and a double-sided adhesive tape of the invention, and which is characterized in that the silicone release layer with at least one ridge of the release liner is in direct contact with the pressure-sensitively adhesive layer having at least one groove of the adhesive tape, and the pressure-sensitively adhesive layer has a topography which is essentially the inverse of the topography of the surface having at least one ridge of the silicone release layer of the release liner.

EXAMPLES

[0099] Adhesive tapes with the following construction were used:

[0100] 60 μm pressure-sensitive polyacrylate adhesive

[0101] 460 μm closed-cell polyethylene foam

[0102] 20 μm laminating adhesive

[0103] 12 μm PET film

[0104] 35 μm pressure-sensitively adhesive layer

[0105] With the aid of a correspondingly structured liner (2 μm silicone coating both sides on 110 μm polypropylene film), the structures set out below were embossed into the 35 μm pressure-sensitively adhesive layer of these adhesive tapes.

Example 1

[0106] Circles having an inner diameter of 2 mm and an outer diameter of 2.2 mm; groove width consequently 100 μm ; approximately rectangular groove cross section; groove depth 25 μm ; distance between the circles 1 mm; minimum distance to the edge of the adhesive layer 2 mm;

Example 2

[0107] Irregularly arranged structures with corrugated cross section (particularly of the higher regions of the adhesive layer) and with a depth of 25 μm ;

Example 3 (Comparative Example)

[0108] commercially available tape with continuous channels (3M 1320E).

Investigations Performed

1. Air Permeability

[0109] In this test, a measurement is made of the air permeability (air bleed) between the substrate and the surface of the adhesive. The adhesive tape is applied to a test plate, using a pressing weight of 7 kg. An air pressure of 0.3 bar is then applied for 10 seconds. After this time has expired, a measurement is made of the amount of air in standard liters (sl/h) which has flowed out between adhesive and test plate over a defined distance. Three individual tests are carried out per adhesive, and the average is formed from the results.

TABLE 1

Results	
Example No.	Standard liters (sl/h)
1	0
2	0
3 (comparative example)	9

2. Bonding Area

[0110] A toner layer is printed onto a siliconized paper, and the adhesive tape for measurement, with the structured adhesive, is placed thereon. The adhesive tape is pressed on with the weight indicated in table 2. The adhesive tape is then peeled from the siliconized paper provided with the toner layer. The imprint is scanned in gray scales, and the gray scale image is converted by image processing software into a one bit file. The bit file is converted back into gray stages, and the percentage black and white components are measured by means of appropriate software.

TABLE 2

Results		
Example No.	Pressing weight (kg)	Bonding area (%)
1	1	96
1	2	95
1	4	98
2	1	82
2	2	92
2	4	99

[0111] The results show that with sharply delimited groove structures (approximately rectangular groove cross section in example 1), in comparison to structures with a corrugated cross section (example 2), the bonding area achieved is constant and largely independent of the pressing weight.

1. A method comprising bonding a printing plate to a substrate with an adhesive tape, wherein the adhesive tape comprises at least one pressure-sensitively adhesive layer, the adhesive layer having at least one groove that does not extend to one of the edges of the adhesive layer, and

the proportion of the total groove volume of the adhesive layer that is accounted for by such grooves being more than 50%.

2. The method as claimed in claim 1, wherein the proportion of the total groove volume of the adhesive layer that is accounted for by such grooves is more than 70%.

3. The method as claimed in claim 1, wherein the printing plates are flexographic printing plates.

4. The method as claimed in claim 1, wherein the non-grooved surface area of the adhesive layer is 50% to 99% of the total surface area of the adhesive layer.

5. The method as claimed in claim 1, wherein the depth of the grooves that do not extend to one of the edges of the adhesive layer is 10 to 100 μm .

6. The method as claimed in claim 1, wherein the width of the grooves that do not extend to one of the edges of the adhesive layer is 10 to 200 μm .

7. The method as claimed in claim 1, wherein the grooves are permanent grooves.

8. The method as claimed in claim 1, wherein the grooves of the adhesive layer have been obtained by embossing using a release liner having a complementary surface structure.

9. A double-sided adhesive tape, comprising a pressure-sensitively adhesive layer on each of its top and bottom sides and further comprising a polymer film and/or a polymer foam, wherein at least one of the adhesive layers has at least one groove that does not extend to one of the edges of the adhesive layer, and

the proportion of the total groove volume of the adhesive layer that is accounted for by such grooves is more than 50%.

10. The double-sided adhesive tape as claimed in claim 9, wherein the adhesive tape comprises a polymer foam and the polymer foam is a polyolefin foam.

11. A release liner comprising a polyolefin film or a paper carrier and further comprising a silicone release layer, wherein the silicone release layer has at least one ridge that does not extend to one of the lateral edges of the silicone release layer, and

the proportion of the total ridge volume of the silicone release layer that is accounted for by such ridges is more than 50%.

12. The release liner as claimed in claim 11, wherein the release liner comprises a polyolefin film and the polyolefin film is a polypropylene film.

* * * * *