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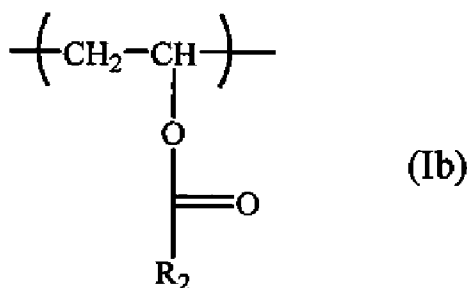
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(54) Title: METHODS OF PROCESSING USING SILICATE-FREE DEVELOPER COMPOSITIONS



(57) Abstract: A method is used to prepare lithographic printing plates by developing positive-working lithographic printing plate precursor that has a single imageable layer that comprises a polymer binder having recurring units represented by Structure (Ib) below: wherein the recurring units of Structure (Ib) are present in an amount of at least 25 and up to and including 60 mol %, all based on total recurring units in the polymer binder, and R<sub>2</sub> is a substituted or unsubstituted hydroxyaryl group in which the hydroxyl group is ortho to the ester linkage, to form exposed and non-exposed regions in the imageable layer. The resulting imaged lithographic printing plate is developed using a silicate-free developer composition having a pH of at least 12 and comprising at least 0.001 gram-atom/kg of a metal cation M<sup>2+</sup> selected from the group consisting of barium, calcium, strontium, and zinc cations.

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## METHODS OF PROCESSING USING SILICATE-FREE DEVELOPER COMPOSITIONS

### FIELD OF THE INVENTION

5           This invention relates to methods for using silicate-free, alkaline developer compositions to process imaged positive-working lithographic printing plate precursors. Particularly, this invention relates to methods of using these silicate-free developer compositions for process lithographic printing plate precursors that have imageable layers containing vinyl hydroxyaryl ester recurring  
10 units in which the hydroxyl group is *ortho* to the ester linkage.

### BACKGROUND OF THE INVENTION

          In conventional or "wet" lithographic printing, ink receptive regions, known as image areas, are generated on a hydrophilic surface. When the  
15 surface is moistened with water and lithographic printing ink is applied, the hydrophilic regions retain the water and repel the ink, and the ink receptive regions accept the ink and repel the water. The ink is eventually transferred to the surface of a material upon which the image is to be reproduced.

          Lithographic printing precursors useful for preparing lithographic  
20 printing plates or sleeves typically comprise one or more imageable layers applied over the hydrophilic surface of a substrate. The imageable layers include one or more radiation-sensitive components that can be dispersed in a suitable binder. Alternatively, the radiation-sensitive component can also be the binder material. Following imaging, either the imaged regions or the non-imaged regions of the  
25 imageable layer are removed by a suitable developer, revealing the underlying hydrophilic surface of the substrate. If the imaged regions are removed, the precursor is considered as positive-working. Conversely, if the non-imaged regions are removed, the precursor is considered as negative-working. In each instance, the regions of the imageable layer (that is, the image areas) that remain  
30 are ink-receptive, and the regions of the hydrophilic surface revealed by the developing process accept water and aqueous solutions, typically a fountain solution, and repel ink.

Direct digital imaging has become increasingly important in the printing industry. Lithographic printing precursors for the preparation of lithographic printing plates have been developed for use with infrared lasers that image in a platesetter in response to signals from a digital copy of the image in a computer. This "computer-to-plate" technology has generally replaced the former technology where masking films were used to image the precursors.

Early lithographic printing plate precursors for use with infrared lasers typically involve an ablation process, which selectively remove ink receptive or ink repellent surface materials and thereby revealing surfaces of complementary ink affinity. Some examples of such ablative lithographic printing plate precursors are described in U.S. Patent 5,339,737 (Lewis et al.). These lithographic plate precursors typically require a relatively high amount of energy input and thereby have limited productivity when the available infrared laser power is limited. Another drawback of ablative lithographic printing plate precursors is the need to remove debris during imaging, adding to the cost of the imaging equipment and more noise during the operation of such equipment. The first commercial non-ablative lithographic printing plate precursors for use with infrared lasers required a preheat step between infrared laser imaging and image development. Some examples of such lithographic printing plate precursors requiring a preheat step are described in U.S. Patent 5,372,907 (Corbiere et al.). Due to the extra equipment and energy consumption required by the preheat step, lithographic printing plate precursors that do not require a preheat step were designed, as described for example in U.S. Patents 6,280,899 (Parsons et al.) and 6,326,122 (Nagasaka et al.). Such lithographic printing plate precursors are typically positive-working and contain an infrared laser imageable layer comprising novolac resins as the primary binders. These lithographic printing plate precursors typically have limited durability on press and limited resistance to press chemicals, unless such plates are baked at high temperature after image development. The baking step adds to equipment cost and energy consumption.

Various attempts have been made to improve the run length on press and chemical resistance of the no-preheat plates, but each attempt has one or more limitations. For example, no-preheat lithographic printing plate precursors

containing some acrylic binders, described in U.S. Patent 6,143,464 (Kawauchi) typically suffer from inadequate differentiation in the solubility in alkaline developers between the IR laser exposed areas and non-exposed areas and from such problems like poor scratch resistance. This inadequate image differentiation often leads to excessive coating loss in the non-IR exposed areas or incomplete removal of the coatings from the IR exposed areas. To avoid such problems, the image development conditions such as developer strength, developing time, temperature, and brush pressure should to be tightly controlled. Therefore, such lithographic printing plate precursors are considered to have narrow development latitude.

To overcome these problems, two-layer no-preheat lithographic plate precursor have been designed, as described for example in U.S. Patent 6,294,311 (Shimazu et al.). These lithographic printing plate precursors require manufacturing lines capable of providing two coated layers. Therefore, there is an ongoing desire to develop single-layer, no-preheat, positive-working lithographic plate precursors that exhibit good run length on press and good resistance to press chemicals.

In search of such precursors, it was found that single-layer positive-working lithographic printing plate precursors containing a poly(vinyl acetal) have excellent run length on press and excellent development latitudes. Some examples of such printing plate precursors are described in U.S. Patents 7,399,576 (Levanon et al.) and 7,544,462 (Levanon et al.) and U.S. Patent Application Publications 2006/0154187 (Wilson et al.) and 2009/0162783 (Levanon et al.). However, there is a continuing need to improve their resistance to certain press chemicals and solvents.

It was found that solvent resistance could be improved using a poly(vinyl acetal) that also includes recurring units having hydroxyaryl ester groups, as described for example, in copending and commonly assigned U.S. Serial No. 12/555,040 (filed September 9, 2009 by Levanon, Bylina, Kampel, Rubin, Postel, Kurtser, and Nakash). While good run length and solvent resistance were obtained with these plates, there is a continuing need to improve the development latitude when using developer compositions. Thus, there is a

need for a method that improves the development latitudes for the lithographic printing plate precursors containing polyvinyl acetal polymers that also have hydroxyaryl ester groups.

Specific developer compositions are often optimized for  
5 developing a particular positive-working lithographic printing plate precursor. There have been attempts to do this by including coating protecting agents in the developer to reduce the solubility of the imageable coating in the non-exposed areas more effectively than the imageable coating in the exposed areas. The use of various coating protecting agents such as non-ionic, cationic, or betaine  
10 surfactants have provided only limited success.

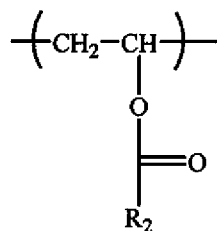
There is also a need to find a developer that not only provides good image differentiation for such lithographic printing plate precursors, but that also allows for processing a large quantity of such printing plate precursors in one processing cycle of fresh developer loaded in an automatic plate processor without  
15 drifting of image quality on the processed plates or excessive difficulty in cleaning the automatic processor after the processing cycle.

One cause of shortened development cycle and excessive difficulty in cleaning the automatic processor relates to partial dissolution of aluminum oxide film on the substrates of typical lithographic printing plate precursors. The  
20 use of an alkali silicate or lithium salt can reduce or eliminate such aluminum oxide attacks. However, the use of silicates adds to the dirtiness of the processor bath. It was found that developers containing lithium chloride are very slow in dissolving the infrared laser exposed coating containing polyvinyl acetal that also has hydroxyaryl ester groups and are therefore considered unsuitable for  
25 processing. Even with optimization of the lithium chloride amount, it has not been possible to find a satisfactory developer that dissolves the exposed coating without attacking the aluminum oxide film on the substrate. There is a need to solve these development problems.

### 30 SUMMARY OF THE INVENTION

This invention provides a method of providing a lithographic printing plate comprises:

A) imagewise exposing a positive-working lithographic printing plate precursor that has a substrate and an outermost imageable layer that comprises a polymer binder comprising recurring units represented by Structures (Ib) below:



5

(Ib)

wherein the recurring units of Structure (Ib) are present in an amount of at least 25 and up to and including 60 mol %, all based on total recurring units in the polymer binder, and R<sub>2</sub> is a substituted or unsubstituted hydroxyaryl group in which the hydroxyl group is *ortho* to the ester linkage, to form exposed and non-exposed regions in the imageable layer, and

B) developing the resulting imaged lithographic printing plate precursor to remove the exposed regions of the imageable layer, the development being carried out using a silicate-free developer composition having a pH of at least 12 and comprising at least 0.001 gram-atom/kg of a metal cation M<sup>2+</sup> selected from the group consisting of barium, calcium, strontium, and zinc cations.

Imaged lithographic printing plates are provided using the method of this invention.

This invention also provides a kit useful for providing lithographic printing plates, the kit comprising:

- a) one or more positive-working lithographic printing plate precursors as described above, and
- b) a silicate-free developer composition having a pH of at least 12 and comprising at least 0.001 gram-atom/kg of a metal cation M<sup>2+</sup> selected from the group consisting of barium, calcium, strontium, and zinc cations.

This kit includes a combination of the lithographic printing plate precursors that can be supplied in any number (usually in the hundreds) in suitable

cartons or packages, and the noted developer composition that is generally supplied in suitable containers. The components of the kit can be separately ordered and supplied from a single or multiple sources or distributors, or they can be ordered and supplied together from the same source or distributor.

5           The method of this invention provides a number of advantages. Lithographic printing plates having long run length are obtained in single-layer positive-working lithographic printing plate precursors because of the presence of a poly(vinyl acetal) as a binder in the single imageable layer. Moreover, these lithographic printing plates can also exhibit desired solvent resistance when the  
10 poly(vinyl acetal) also contains recurring units with hydroxyaryl ester groups such as those polymeric binder used in the lithographic printing plate precursors described in U.S. Serial No. 12/555,040 (noted above).

In addition, image discrimination is improved with such elements by processing the imaged precursor with a developer composition having a pH of  
15 at least 12 and comprising at least 0.001 gram-atom/kg of a metal cation  $M^{2+}$  selected from the group consisting of barium, calcium, strontium, and zinc cations. The presence of the  $M^{2+}$  metal cations improves image discrimination better than merely the presence of cationic or betaine surfactants.

Without being limited to a particular mechanism or technical  
20 understanding of the reasons for the advantages of this invention, it is possible that the differences in behavior of Precursors 1 and 2 described in the Examples below could originate from differences in the polymeric structure of the binder used in the imageable layer. In Precursor 2, the polymer binder is based on an acetal polymer wherein all of the hydroxyaromatic groups are acetal pendant groups.  
25 However, in Precursor 1 has a binder polymer that is an acetal/ester copolymer wherein some of the hydroxyaryl groups are acetals and some of the hydroxyaryl groups are esters (salicylate) of polyvinyl alcohol.

The effect of the addition of the calcium ion to the developer could be explained by the hypothesis that the dissolution of the imageable layer coatings  
30 in the Precursor 1 and 2 lithographic printing plates occurs when the exposed precursors are exposed to the developer. Since the developer used in the practice of this invention is highly alkaline, the hydroxyaryl groups in the binder polymer

in the imageable layer are deprotonated, and as a result, the imageable layer coating becomes more soluble in the developer and thus removed. When the developer contains calcium ions or other noted  $M^{+2}$  cations, similar deprotonation of the hydroxyaryl groups occurs, but in addition, in Precursor 1, the calcium cations appear to coordinate the deprotonated salicylate residue

As a result of such coordination, less soluble salicylate derivative is formed and solubility of the coating is reduced or even totally eliminated depending upon the amount of calcium ion). Such coordination is impossible with the binder polymer in Precursor 2 because no salicylate is present. Only hydroxyaryl acetal residues are present in the polymer binder and the presence of calcium ions in the developer are incapable of providing the desired effect.

The developer compositions used in this invention are also free of silicates and metasilicates meaning that none are purposely added or incorporated by any means. Although silicates are effective for inhibiting dissolution of aluminum oxide films on the substrates, the presence of a silicate in a developer composition causes precipitation of water-insoluble aluminosilicates that contaminate the processing bath and complicate the cleaning of the processing apparatus.

Thus, in the embodiments of this invention, the addition of the noted  $M^{2+}$  metal cations, especially calcium ions, to the developer composition has been found to provide several benefits, including inhibiting dissolution of aluminum oxide films into the developer composition.

## DETAILED DESCRIPTION OF THE INVENTION

As used herein, the terms “lithographic printing plate precursor”, “printing plate precursor”, and “precursor” refer to the positive-working imageable elements that can be used in the practice of this invention.

### Developer Compositions

There are various embodiments of developer compositions that can be used to advantage in the practice of this invention. All of the developer compositions have a pH of at least 12 and typically at least 12 and up to and



including 13.5, or more likely at least 12.5 and up to and including 13.5. This highly alkaline pH is generally provided using one or more alkali agents, as long as silicates and metasilicates are not present (not purposely added). Sugars and sugar alcohols are not purposely present in the developer compositions. Useful  
5 alkali agents include alkali metal hydroxides such as sodium hydroxide and potassium hydroxide. In some embodiments, both sodium and potassium ions are present as part of the alkali agents. Where this is true, it can be desirable that the potassium ions be more prevalent than the sodium ions, for example at a molar ratio of potassium to sodium ions of greater than 1:1. The total amount of the  
10 alkali metal ions is generally at least 0.3 and up to and including 1 gram-atom/kg.

The developer compositions include one or more metal cations ( $M^{2+}$ ) that are generally selected from the group consisting of barium, calcium, strontium, and zinc cation. Calcium, strontium, and zinc cations are particularly useful, and in some embodiments, calcium is particularly advantageous to protect  
15 the surface of the imageable layer containing polymeric binders comprising recurring units defined by Structure (Ib) noted below.

The metal cations  $M^{2+}$  are generally present in the developer compositions in an amount of at least 0.001 gram-atom/kg, and typically at least 0.001 and up to and including 0.01 gram-atom/kg. The  $M^{2+}$  metal cations can be  
20 introduced into the developer composition using corresponding salts.

The developer compositions used in this invention also includes one or more chelating agents, each of which has a complex formation constant ( $\log K$ ) for the  $M^{2+}$  metal cation of at least 3.5 and less than or equal to 4.5, and a  $\log K$  for aluminum ion that is 7 or less. In many embodiments, the  $M^{2+}$  metal  
25 cation that is used with the chelating agent is either calcium or strontium, and calcium is the most likely metal cation in this instance.

Useful chelating agents with these properties include but are not limited to, phosphono-polycarboxylic acids such as phosphonoalkyl polycarboxylic acids, such as 2-phosphonobutane-1,2,4-tricarboxylic acid, which  
30 is particularly useful with calcium metal cations.

The described chelating agents can be present in an amount of at least 0.01 and up to and including 0.1 mol/liter, or typically at least 0.03 and up to and including 0.1 mol/liter.

An optional but desirable component of some of the developer compositions used in this invention is a cationic surfactant or a betaine. Two or more cationic surfactants can also be used, and the total amount is generally at least 0.01 weight % and typically at least 0.1 and up to and including 3 weight %. The cationic surfactant can help moderate the developer composition aggressiveness (further improve image discrimination) in the non-imaged areas (areas not to be removed) of the imaged lithographic printing precursor, especially those having recurring units represented by Structure (Ia) below. Suitable cationic surfactants for use in the present invention include, but are not limited to, quaternary ammonium halides of fatty acids such as a fatty acid quaternary ammonium chloride. One example of such cationic surfactants is provided in Hydromax 300 (Chemax Performance Products, Greenville, SC) that is described for example, in U.S. Patent Application Publication 2006/0154187 (Wilson et al.).

The developer composition used in this invention can also comprise one or more surfactants to achieve the best wetting, stabilizing, solubilizing, protecting, dispersing, and rinsing properties. Such surfactants are generally anionic or nonionic in nature. Both types can be present. Useful anionic surfactants are of the alkylaryl sulfonates class, such as an alkylaryl sulfonate, for example, alkyl diphenyl oxide disulfonate that is available as Dowfax<sup>®</sup> 2A1 from Dow Chemical Co. The anionic and nonionic surfactants can be present in an amount of at least 0.1 and up to and including 2 weight %.

The developer compositions can further comprise hydrotropes, biocides, antifoaming agents, and gumming materials that provide protection of the developed printing plate, all in known quantities.

Some embodiments of the method of this invention include the use of a developer composition that has a pH of at least 12 and up to and including 13.5, wherein the  $M^{2+}$  is calcium or strontium metal cation, and the developer composition further comprises:

a sodium or potassium hydroxide, and

2-phosphonobutane-1,2,4-tricarboxylic acid.

In still other embodiments of the method include the use of a developer composition that has a pH of at least 12 and up to and including 13.5, wherein  $M^{2+}$  is calcium metal cation, and the developer composition further  
5 comprises:

an alkali metal hydroxide,  
2-phosphonobutane-1,2,4-tricarboxylic acid, and  
a cationic surfactant, and

the polymer binder in the outermost imageable layer comprises  
10 recurring units represented by either or both of Structures (Ia) and (Ib) described herein, in random fashion.

The developer composition used in this invention can be prepared by dissolving the components in water. It can be supplied in a form ready to use, or it can also be provided in a form of a concentrate, which is diluted up to 2.5  
15 times with water or an aqueous alkaline solution prior to use (for example in step B of the method of this invention).

Although each developer composition can also be used as its own replenisher, more likely, a specially formulated replenisher can be used. In the replenisher composition, the concentration of alkali agent is generally higher than  
20 the concentration of the alkali agent in the developer composition, to compensate for the consumption of the alkali agent during the development process. There is often a correlation between the value of the ionic conductivity and the value of alkalinity of the total developer composition bath.

In some embodiments, the replenisher composition not only has  
25 more alkali agent (such as hydroxide), but it can also have an increased level of the  $M^{2+}$  cation and increased amounts of cationic surfactant or other components.

### **Positive-working Lithographic Printing Plate Precursors**

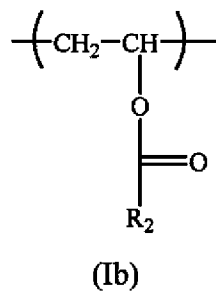
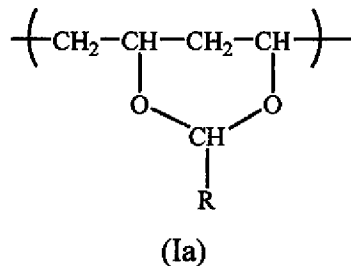
The present invention can be used to process imaged positive-  
30 working imageable element comprising a substrate having thereon an imageable layer comprising a water-insoluble polymeric binder, and a radiation absorbing compound,

wherein the polymeric binder comprises recurring units comprising aromatic ester (such as hydroxyaryl ester) groups, or in random fashion:

- 5 a) vinyl acetal recurring units comprising pendant hydroxyaryl groups, and  
b) recurring units comprising aromatic ester (such as hydroxyaryl ester) groups.

For purposes of this disclosure, the polymeric binder defined as comprising at least recurring units of Structure (Ib) or recurring units of both  
10 Structures (Ia) and (Ib), are considered as “primary” polymeric binders. As noted below, the primary polymeric binders must be present in the imageable layer, but they are not necessarily the only polymeric binders in the imageable layer.

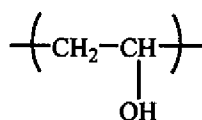
In some embodiments, the polymeric binder comprises recurring units represented by each of the following Structures (Ia) and (Ib), in random  
15 fashion:



that are described in more detail below, wherein the recurring units of Structure (Ia) are present in an amount of at least 10 and up to and including 35 mol % (or  
25 at least 10 and up to an including 30 mol %), the recurring units of Structure (Ib)

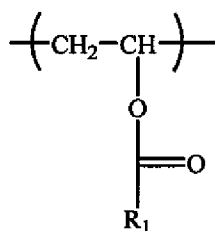
are present in an amount of at least 25 and up to and including 60 mol % (or at least 25 and up to and including 50 mol %), all based on the total recurring units in the polymeric binder.

5 Still other embodiments include the use of a polymeric binder that comprises, in random fashion, in addition to the recurring units from Structures (Ia) and (Ib), at least 25 and up to and including 60 mol % of recurring units represented by the following Structure (Ic), in random fashion:



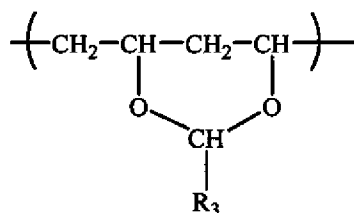
(Ic),

10 and optionally up to 25 mol % of recurring units represented by the following Structure (Id), optionally up to 10 mol % of recurring units represented by the following Structure (Ie), and optionally up to 20 mol % of recurring units represented by the following Structure (If), all based on the total recurring units in the polymeric binder, in random fashion:



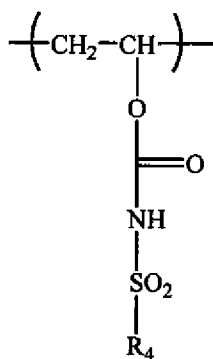
15

(Id)



(Ie)

20



(If)

which Structures (Ic) through (If) are described in more detail below.

5                    In Structure (Ia), R is a substituted or unsubstituted hydroxyaryl group such as a substituted or unsubstituted hydroxyphenyl or hydroxynaphthyl group wherein the aryl group has 1 to 3 hydroxyl groups on the ring. Typically, there is only 1 hydroxyl group on the aryl ring. Other substituents that can optionally be present on the aryl group include but are not limited to, alkyl, 10                    alkoxy, halogen, and any other group that does not adversely affect the performance of the polymeric binder in the imageable element.

                      In Structure (Ib), R<sub>2</sub> is a substituted or unsubstituted hydroxyaryl group in which the hydroxyl group is *ortho* to the ester linkage. Some of the R<sub>2</sub> groups are substituted with a cyclic imide group, for example a substituted or 15                    unsubstituted hydroxyphenyl or hydroxynaphthyl group that has a cyclic imide substituent such as an aliphatic or aromatic imide group, including but not limited to, maleimide, phthalimide, tetrachlorophthalimide, hydroxyphthalimide, carboxyphthalimide, and naphthalimide groups. Further optional substituents on R<sub>2</sub> include but are not limited to, hydroxyl, alkyl, alkoxy, halogen, and other groups 20                    that do not adversely affect the properties of the cyclic imide group or the polymeric binder in the imageable element. A hydroxyphenyl group, with a cyclic imide substituent and no other substituents, is useful in the polymeric binder.

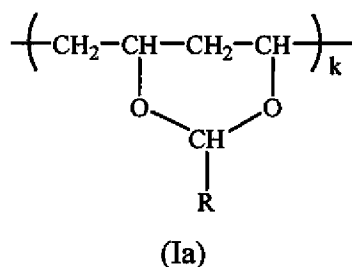
                      In Structure (Id), R<sub>1</sub> is hydrogen or a substituted or unsubstituted linear or branched alkyl group having 1 to 12 carbon atoms (such as methyl, ethyl, 25                    *n*-propyl, *n*-butyl, *n*-pentyl, *n*-hexyl, chloromethyl, trichloromethyl, *iso*-propyl, *iso*-butyl, *t*-butyl, *iso*-pentyl, *neo*-pentyl, 1-methylbutyl, *iso*-hexyl, and dodecyl

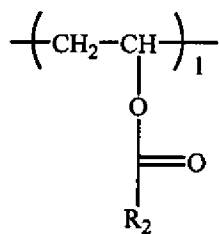
groups), a substituted or unsubstituted cycloalkyl having 5 to 10 carbon atoms in the carbocyclic ring (such as cyclopentyl, cyclohexyl, 4-methylcyclohexyl, and 4-chlorocyclohexyl), or a substituted or unsubstituted aryl group having 6 or 10 carbon atoms in the aromatic ring (such as phenyl, naphthyl, *p*-methylphenyl, and *p*-chlorophenyl). Such groups can be substituted with one or more substituents such as alkyl, alkoxy, and halogen, or any other substituent that a skilled worker would readily contemplate that would not adversely affect the performance of the polymeric binder in the imageable element.

In Structure (Ie), R<sub>3</sub> is an aryl group (such as phenyl or naphthyl group) that is substituted with an -O<sub>x</sub>-(CH<sub>2</sub>)<sub>y</sub>-COOH group wherein x is 0 or 1 and y is 0, 1, or 2. Typically, x is 1 and y is 1, and the aryl group is a phenyl group. This aryl group can have further substituents such as alkyl, alkoxy, or halogen that do not adversely affect the performance of the polymeric binder in the imageable element.

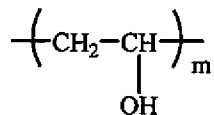
In Structure (If), R<sub>4</sub> is a substituted or unsubstituted aryl group having 6 or 10 carbon atoms in the aromatic ring (such as phenyl or naphthyl) and that can have one or more substituents such as alkyl, alkoxy, and others that a skilled worker would readily contemplate as not adversely affecting the properties of the polymeric binder in the imageable element.

In some embodiments, the polymeric binder comprises recurring units represented by each of Structures (Ia) through (If), all in random fashion:

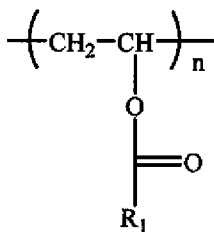




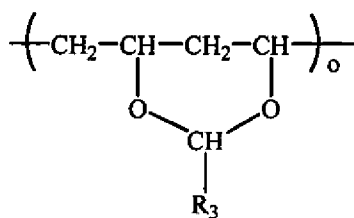
(Ib)



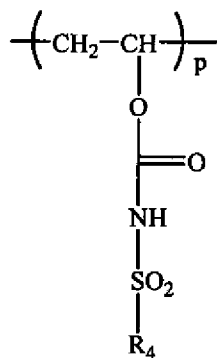
(Ic),



(Id)



(Ie)



(If)

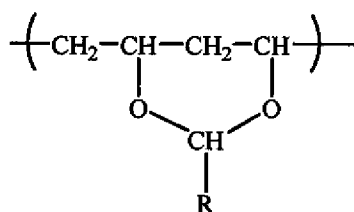
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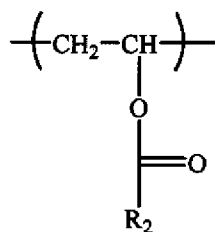
wherein R, R<sub>1</sub>, R<sub>2</sub>, R<sub>3</sub>, R<sub>4</sub>, x and y are as defined above, k is at least 15 and up to and including 25 mol %, l is at least 25 and up to and including 45 mol %, m is at least 30 and up to and including 55 mol %, n is 0 or up to and including 15 mol %, o is 0 or up to and including 8 mol %, and p is 0 or up to and including 10 mol %, all based on total recurring units in the polymeric binder.

In yet other embodiments, the polymeric binder comprises recurring units represented by each of Structures (Ia) through (Id), in random fashion:

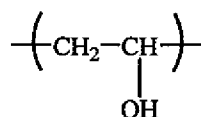


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(Ia)

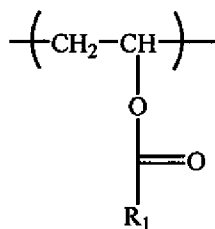


(Ib)



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(Ic),



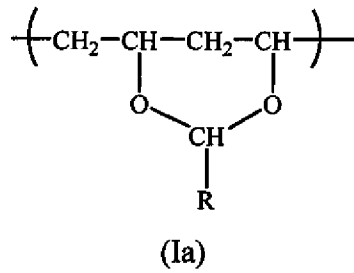
(Id)

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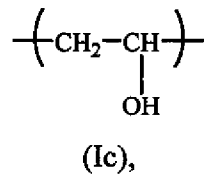
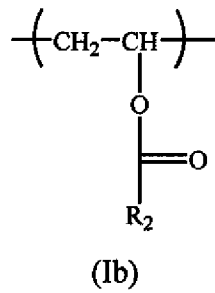
wherein R, R<sub>1</sub>, and R<sub>2</sub> are as defined above.

Further, other embodiments include the use of the polymeric binder that comprises recurring units represented by each of Structures (Ia) through (Ie), in random fashion:

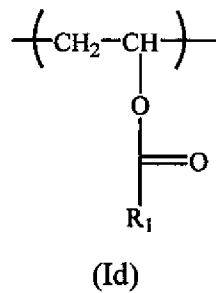
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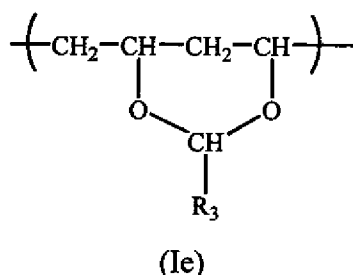


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wherein R, R<sub>1</sub>, R<sub>2</sub>, R<sub>3</sub>, x, and y are as defined above.

- 5                   A primary polymeric binder comprising recurring units that are represented by Structures (Ia) or (Ib), or both Structures (Ia) and (Ib) and optionally (Ic), (Id), (Ie), or (If) can contain recurring units other than those defined by the illustrated recurring units, all in random fashion, and such additional recurring units would be readily apparent to a skilled worker in the art.
- 10               Thus, the polymeric binders useful in this invention are not limited specifically to the recurring units defined by Structures (Ia) through (If). Where two or more types of recurring units are present in the primary binder, the recurring units are present in a random fashion. If blocks of recurring units are present, they exist inadvertently because there is no intent to intentionally cause the formation of
- 15               blocks of recurring units.

                  There also can be multiple types of recurring units from any of the defined classes of recurring units in Structures (Ia), (Ib), (Id), (Ie), and (If) with different substituents. For example, there can be multiple types of recurring units with different R groups, there can be multiple types of recurring units with

20               different R<sub>1</sub> groups, there can be multiple types of recurring units with different R<sub>2</sub> groups, there can be multiple types of recurring units with different R<sub>3</sub> groups, or there can be multiple types of recurring units with different R<sub>4</sub> groups.

                  The primary polymeric binder is generally present in an amount of at 40 and up to and including 95 weight % (typically at least 50 and up to and

25               including 80 weight %) based on the total dry weight of the imageable layer.

                  The primary polymer binders used in the positive-working lithographic printing plates used in this invention can be prepared by transesterification of alkyl or aryl esters of hydroxy-substituted aromatic acids with polyvinyl alcohol in the presence of basic catalysts such as metal hydroxides,

metal alkoxides, and cyclic amines in dimethylsulfoxide (DMSO) or N-methylpyrrolidone (NMP) or mixtures of these solvents with  $\gamma$ -butyrolactone (BLO).

Some embodiments of the primary polymeric binders have pendant  
5 hydroxyaryl groups that are substituted with a cyclic imide (such as a phthalimide group) on the aromatic ring. Such polymers can be prepared by trans-esterification of cyclic imide derivatives of alkyl or aryl esters of hydroxyl-substituted aromatic acids with polyvinyl alcohol in the presence of basic catalysts such as metal hydroxides, metal alkoxides or cyclic amines in DMSO or NMP, or  
10 mixtures of these solvents with BLO or by trans-esterification of mixtures of cyclic imide derivatives of alkyl and aryl esters of hydroxyl-substituted aromatic acids with polyvinyl alcohol in the presence of basic catalysts such as metal hydroxides, metal alkoxides or cyclic amines in DMSO or NMP or mixtures of these solvents with BLO.

15 The primary polymeric binders described herein can be used alone or in admixture with other alkali soluble polymeric binders, identified herein as "secondary polymeric binders". These additional polymeric binders include other poly(vinyl acetal)s, for example, the poly(vinyl acetal)s described in U.S. Patents 6,255,033 and 6,541,181 (noted above), WO 04/081662 (also noted above), and in  
20 U.S. Patent Application Publication 2008/0206678 (Levanon et al.).

The type of the secondary polymeric binder that can be used together with the primary polymeric binder is not particularly restricted. In general, from a viewpoint of not diminishing the positive radiation-sensitivity of the imageable element, the secondary polymeric binder is generally an alkali-  
25 soluble polymer.

Other useful secondary polymeric binders include phenolic resins, including novolak and resole resins such as condensation polymers of phenol and formaldehyde, condensation polymers of *m*-cresol and formaldehyde, condensation polymers of *p*-cresol and formaldehyde, condensation polymers of  
30 *m*-/*p*-mixed cresol and formaldehyde, condensation polymers of phenol, cresol (*m*-, *p*-, or *m*-/*p*-mixture) and formaldehyde, and condensation copolymers of pyrogallol and acetone. Further, copolymers obtained by copolymerizing

compound comprising phenol groups in the side chains can be used. Mixtures of such polymeric binders can also be used.

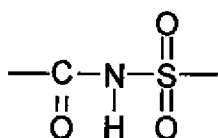
5 Examples of other useful secondary polymeric binders include the following classes of polymers having an acidic group in (1) through (5) shown below on a main chain and/or side chain (pendant group).

- (1) sulfone amide (-SO<sub>2</sub>NH-R'),
- (2) substituted sulfonamido based acid group (hereinafter, referred to as active imido group) [such as -SO<sub>2</sub>NHCOR', SO<sub>2</sub>NHSO<sub>2</sub>R', -CONHSO<sub>2</sub>R'],
- (3) carboxylic acid group (-CO<sub>2</sub>H),
- 10 (4) sulfonic acid group (-SO<sub>3</sub>H), and
- (5) phosphoric acid group (-OPO<sub>3</sub>H<sub>2</sub>).

R' in the above-mentioned groups (1)-(5) represents hydrogen or a hydrocarbon group.

Representative secondary polymeric binders having the group (1) sulfone amide group are for instance, polymers that are constituted of a minimum constituent unit as a main component derived from a compound having a sulfone amide group. Thus, examples of such a compound include a compound having, in a molecule thereof, at least one sulfone amide group in which at least one hydrogen atom is bound to a nitrogen atom and at least one polymerizable unsaturated group. Among these compounds are *m*-aminosulfonylphenyl methacrylate, N-(*p*-aminosulfonylphenyl)methacrylamide, and N-(*p*-aminosulfonylphenyl)acrylamide. Thus, a homopolymer or a copolymer of polymerizing monomers having a sulfonamide group such as *m*-aminosulfonylphenyl methacrylate, N-(*p*-aminosulfonylphenyl) methacrylamide, or N-(*p*-aminosulfonylphenyl) acrylamide can be used.

Examples of secondary polymeric binders with group (2) activated imido group are polymers comprising recurring units derived from compounds having activated imido group as the main constituent component. Examples of such compounds include polymerizable unsaturated compounds having a moiety defined by the following structural formula.



N-(*p*-toluenesulfonyl) methacrylamide and N-(*p*-toluenesulfonyl) acrylamide are examples of such polymerizable compounds.

5 Secondary polymeric binders having any of the groups (3) through (5) include those readily prepared by reacting ethylenically unsaturated polymerizable monomers having the desired acidic groups, or groups that can be converted to such acidic groups after polymerization.

The secondary polymeric binder can have a weight average molecular weight of at least 2,000 and a number average molecular weight of at least 500. Typically, the weight average molecular weight is at least 5,000 and up to and including 300,000, the number average molecular weight is at least 800 and up to and including 250,000, and the degree of dispersion (weight average molecular weight/number average molecular weight) is at least 1.1 and up to and including 10.

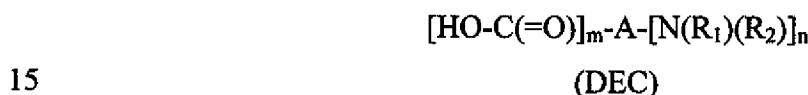
15 Mixtures of the secondary polymeric binders can be used with the one or more primary polymeric binders. The secondary polymeric binder(s) can be present in an amount of at least 1 weight % and up to and including 50 weight %, and typically from at least 5 and up to and including 30 weight %, based on the dry weight of the total polymeric binders in the radiation-sensitive composition or imageable layer.

The imageable layer in the lithographic printing plate precursors can also include one or more developability-enhancing compounds. WO 2004/081662 (Memetea et al.) describes the use of various developability-enhancing compounds of acidic nature to enhance the sensitivity of positive-working compositions and elements so that required imaging energy is reduced. Acidic Developability-Enhancing Compounds (ADEC), such as carboxylic acids or cyclic acid anhydrides, sulfonic acids, sulfinic acids, alkylsulfuric acids, phosphonic acids, phosphinic acids, phosphonic acid esters, phenols, sulfonamides, or sulfonimides can permit further improved developing latitude and printing durability. Representative examples of such compounds are provided

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in [0030] to [0036] of U.S. Patent Application Publication 2005/0214677 (noted above) that is cited herein by reference with respect to these acid developability-enhancing compounds.

The imageable layer can also include a developability-enhancing composition containing one or more basic developability-enhancing compounds (BDEC) as described in U.S. Patent 7,544,462 (Levanon et al.) and one or more developability enhancing compounds (DEC) as described in U.S. Patent Publication No. 2009/0162783 (Levanon et al.). For example, the DEC compounds are organic compounds having at least one amino group and at least one carboxylic acid group, particularly if at least one amino group is directly linked to an aryl group. The DEC compounds can be represented by the following Structure (DEC):



wherein R<sub>1</sub> and R<sub>2</sub> are independently hydrogen or substituted or unsubstituted alkyl, substituted or unsubstituted cycloalkyl, or substituted or unsubstituted aryl groups, A is a substituted or unsubstituted organic linking group having at least one carbon, nitrogen, sulfur, or oxygen atom in the chain, wherein A also comprises a substituted or unsubstituted arylene group directly connected to - [N(R<sub>1</sub>)(R<sub>2</sub>)]<sub>n</sub>, m is an integer of 1 to 4, and n is an integer of 1 to 4.

The lithographic printing plate precursors are positive-working and the primary polymeric binders described herein are present in a single surface imageable layer.

This surface imageable layer can also contain hydroxymandelic acid in an amount of at least 0.1 and up to and including 1 weight % based on the total imageable layer dry weight.

The lithographic printing plate precursors are positive-working and the primary polymeric binders described herein are generally present as polymeric binders in a single imageable layer.

In general, the lithographic printing plate precursors are formed by suitable application of a formulation of the imageable layer composition that

contains one or more primary polymeric binders, a radiation absorbing compound (described below), optionally a developability-enhancing composition, and other optional addenda, to a suitable substrate to form an imageable layer. This substrate is usually treated or coated in various ways as described below prior to application of the formulation. For example, the substrate can be treated to provide an "interlayer" for improved adhesion or hydrophilicity, and the imageable layer is applied over the interlayer.

The substrate generally has a hydrophilic surface, or a surface that is more hydrophilic than the applied imageable layer formulation on the imaging side. The substrate comprises a support that can be composed of any material that is conventionally used to prepare lithographic printing plate precursors. It is usually in the form of a sheet, film, or foil, and is strong, stable, and flexible and resistant to dimensional change under conditions of use so that color records will register a full-color image. Typically, the support can be any self-supporting material including polymeric films (such as polyester, polyethylene, polycarbonate, cellulose ester polymer, and polystyrene films), glass, ceramics, metal sheets or foils, or stiff papers (including resin-coated and metallized papers), or a lamination of any of these materials (such as a lamination of an aluminum foil onto a polyester film). Metal supports include sheets or foils of aluminum, copper, zinc, titanium, and alloys thereof.

Polymeric film supports can be modified on one or both surfaces with a "subbing" layer to enhance hydrophilicity, or paper supports can be similarly coated to enhance planarity. Examples of subbing layer materials include but are not limited to, alkoxysilanes, amino-propyltriethoxysilanes, glycidioxypropyl-triethoxysilanes, and epoxy functional polymers, as well as conventional hydrophilic subbing materials used in silver halide photographic films (such as gelatin and other naturally occurring and synthetic hydrophilic colloids and vinyl polymers including vinylidene chloride copolymers).

One substrate is composed of an aluminum support that can be coated or treated using physical graining, electrochemical graining and chemical graining, followed by anodizing. The aluminum sheet is mechanically or



electrochemically grained and anodized using phosphoric acid or sulfuric acid and conventional procedures.

An optional interlayer can be formed by treatment of the aluminum support with, for example, a silicate, dextrin, calcium zirconium fluoride, 5 hexafluorosilicic acid, phosphate/sodium fluoride, poly(vinyl phosphonic acid) (PVPA), vinyl phosphonic acid copolymer, poly(acrylic acid), or acrylic acid copolymer solution, or an alkali salt of a condensed aryl sulfonic acid as described in GB 2,098,627 and Japanese Kokai 57-195697A (both Herting et al.). The grained and anodized aluminum support can be treated with a solution of a 10 phosphate (such as  $\text{NaH}_2\text{PO}_4$ ) and sodium fluoride to improve surface hydrophilicity.

The thickness of the substrate can be varied but should be sufficient to sustain the wear from printing and thin enough to wrap around a printing form. Some embodiments include a treated aluminum foil having a 15 thickness of from at least 100 and up to and including 600  $\mu\text{m}$ .

The backside (non-imaging side) of the substrate can be coated with a slipping or matte layer to improve handling and “feel” of the imageable element.

The substrate can also be a cylindrical surface having the 20 imageable layer composition applied thereon, and thus be an integral part of the printing press. The use of such imaged cylinders is described for example in U.S. Patent 5,713,287 (Gelbart).

The imageable layer (and radiation-sensitive composition) typically also comprises one or more radiation absorbing compounds that are typically 25 sensitive to infrared radiation and thus, the radiation absorbing compounds are known as infrared radiation absorbing compounds (“IR absorbing compounds”) that generally absorb radiation of at least 700 and up to and including 1400 nm and typically of at least 750 and up to and including 1250 nm.

Examples of suitable IR dyes include but are not limited to, azo 30 dyes, squarylium dyes, croconate dyes, triarylamine dyes, thioazolium dyes, indolium dyes, oxonol dyes, oxazolium dyes, cyanine dyes, merocyanine dyes, phthalocyanine dyes, indocyanine dyes, indotricarbocyanine dyes, hemicyanine

dyes, streptocyanine dyes, oxatricarbocyanine dyes, thiocyanine dyes, thiatricarbocyanine dyes, merocyanine dyes, cryptocyanine dyes, naphthalocyanine dyes, polyaniline dyes, polypyrrole dyes, polythiophene dyes, chalcogenopyrroloarylidene and bi(chalcogenopyrrolo)- polymethine dyes, 5 oxyindolizine dyes, pyrylium dyes, pyrazoline azo dyes, oxazine dyes, naphthoquinone dyes, anthraquinone dyes, quinoneimine dyes, methine dyes, arylmethine dyes, polymethine dyes, squarine dyes, oxazole dyes, croconine dyes, porphyrin dyes, and any substituted or ionic form of the preceding dye classes. Suitable dyes are described for example, in U.S. Patents 4,973,572 (DeBoer), 10 5,208,135 (Patel et al.), 5,244,771 (Jandrue Sr. et al.), and 5,401,618 (Chapman et al.), and EP 0 823 327A1 (Nagasaka et al.).

Cyanine dyes having an anionic chromophore are also useful. For example, the cyanine dye can have a chromophore having two heterocyclic groups. In another embodiment, the cyanine dye can have from about two 15 sulfonic acid groups, such as two sulfonic acid groups and two indolenine groups as described for example in U.S Patent Application Publication 2005-0130059 (Tao).

A general description of a useful class of suitable cyanine dyes is shown by the formula in [0026] of WO 2004/101280 (Munnely et al.).

20 In addition to low molecular weight IR-absorbing dyes, IR dye moieties bonded to polymers can be used. Moreover, IR dye cations can be used as well, that is, the cation is the IR absorbing portion of the dye salt that ionically interacts with a polymer comprising carboxy, sulfo, phospho, or phosphono groups in the side chains.

25 Near infrared absorbing cyanine dyes are also useful and are described for example in U.S. Patents 6,309,792 (Hauck et al.), 6,264,920 (Achilefu et al.), 6,153,356 (Urano et al.), and 5,496,903 (Watanabe et al.). Suitable dyes can be formed using conventional methods and starting materials or obtained from various commercial sources including American Dye Source (Baie 30 D'Urfe, Quebec, Canada) and FEW Chemicals (Germany). Other useful dyes for near infrared diode laser beams are described, for example, in U.S Patent 4,973,572 (noted above).

Useful IR absorbing compounds can also be pigments including carbon blacks such as carbon blacks that are surface-functionalized with solubilizing groups. Carbon blacks that are grafted to hydrophilic, nonionic polymers, such as FX-GE-003 (manufactured by Nippon Shokubai), or which are surface-functionalized with anionic groups, such as CAB-O-JET<sup>®</sup> 200 or CAB-O-JET<sup>®</sup> 300 (manufactured by the Cabot Corporation) are also useful. Other useful pigments include, but are not limited to, Heliogen Green, Nigrosine Base, iron (III) oxides, manganese oxide, Prussian Blue, and Paris Blue. The size of the pigment particles should not be more than the thickness of the imageable layer and preferably the pigment particle size will be less than half the thickness of the imageable layer.

In the lithographic printing plate precursors, the radiation absorbing compound is generally present at a dry coverage of at least 0.1 and up to and including 30 weight %, or it is an IR dye that is present in an amount of at least 0.5 and up to and including 15 weight %. The particular amount needed for this purpose would be readily apparent to one skilled in the art, depending upon the specific compound used.

Alternatively, the radiation absorbing compounds can be included in a separate layer that is in thermal contact with the imageable layer. Thus, during imaging, the action of the radiation absorbing compound in the separate layer can be transferred to the imageable layer without the compound originally being incorporated into it.

The imageable layer (and radiation-sensitive composition) can also include one or more additional compounds that are colorant pigments or dyes, or UV or visible light-sensitive components. Pigment colorants can be organic colorants that are generally insoluble in less than 0.1 g/liter of coating solvents that are generally used to apply the radiation-sensitive imageable layer to a substrate. Such coating solvents generally have hydroxyl, ester, ether, carbonyl, carboxy, amide, or nitrile groups and having a boiling point of at least 30° and up to and including 250°C. Classes of useful pigment colorants include but are not limited to, phthalocyanines, perylenes, and azo pigments. Colorant dyes that are soluble in an alkaline developer are also useful. Useful colorant dyes include

triarylmethane dyes such as ethyl violet, crystal violet, malachite green, brilliant green, Victoria blue B, Victoria blue R, and Victoria pure blue BO, BASONYL<sup>®</sup> Violet 610 and D11 (PCAS, Longjumeau, France). These compounds can act as contrast dyes that distinguish the non-exposed (non-imaged) regions from the exposed (imaged) regions in the developed lithographic printing plate.

The imageable layer (and radiation-sensitive composition) can further include a variety of additives including dispersing agents, humectants, biocides, plasticizers, surfactants for coatability or other properties, viscosity builders, fillers and extenders, pH adjusters, drying agents, defoamers, preservatives, antioxidants, development aids, rheology modifiers or combinations thereof, or any other addenda commonly used in the lithographic art, in conventional amounts.

The positive-working lithographic printing plate precursors can be prepared by applying the imageable layer (radiation-sensitive composition) formulation over the surface of the substrate (and any other hydrophilic layers provided thereon) using conventional coating or lamination methods. Thus, the formulation can be applied by dispersing or dissolving the desired ingredients in a suitable coating solvent, and the resulting formulation is applied to the substrate using suitable equipment and procedures, such as spin coating, knife coating, gravure coating, die coating, slot coating, bar coating, wire rod coating, roller coating, or extrusion hopper coating. The formulation can also be applied by spraying onto a suitable support (such as an on-press printing cylinder).

The coating weight for the imageable layer is at least 0.5 and up to and including 3.5 g/m<sup>2</sup> and typically at least 1 and up to and including 3 g/m<sup>2</sup>.

The selection of solvents used to coat the layer formulation(s) depends upon the nature of the polymeric binders and other polymeric materials and non-polymeric components in the formulations. Generally, the imageable layer formulation is coated out of acetone, methyl ethyl ketone, or another ketone, tetrahydrofuran, 1-methoxy-2-propanol, N-methyl pyrrolidone, 1-methoxy-2-propyl acetate,  $\gamma$ -butyrolactone, and mixtures thereof.

Intermediate drying steps can be used between applications of the various layer formulations to remove solvent(s) before coating other formulations. Drying steps can also help in preventing the mixing of the various layers.

Representative methods for preparing positive-working lithographic printing plate precursors are described below in the examples.

After the imageable layer formulation is dried on the substrate (that is, the coating is self-supporting and dry to the touch), the lithographic printing plate precursor can be heat treated at a temperature of at least 40 and up to and including 90°C (typically at from at least 50 and up to and including 70°C) for at least 4 hours and typically at least 20 hours, or for at least 24 hours. The maximum heat treatment time can be several days, but the optimal time and temperature for the heat treatment can be readily determined by routine experimentation. This heat treatment can also be known as a “conditioning” step. Such treatments are described for example, in EP 823,327 (Nagaska et al.) and EP 1,024,958 (McCullough et al.).

It is also desirable that during the heat treatment, the lithographic printing plate precursor is wrapped or encased in a water-impermeable sheet material to represent an effective barrier to moisture removal from the precursor. More details of this process are provided in U.S. Patent 7,175,969 (Ray et al.).

### **Imaging and Development**

The lithographic printing plate precursors used in this invention can have any useful form. The precursors can be of any useful size and shape (for example, square or rectangular) having the requisite single positive-working imageable layer disposed on a suitable substrate.

During use, the lithographic printing plate precursors are exposed to a suitable source of infrared radiation at a wavelength using an infrared laser at a wavelength of at least 700 and up to and including 1400 nm. The laser used to expose the imaging member is can be a diode laser, because of the reliability and low maintenance of diode laser systems, but other lasers such as gas or solid-state lasers can also be used. The combination of power, intensity and exposure time

for laser imaging would be readily apparent to one skilled in the art. Presently, high performance lasers or laser diodes used in commercially available imagesetters emit infrared radiation at one or more wavelengths with the range of from at least 750 and up to and including 1250 nm.

5           The imaging apparatus can function solely as a platesetter or it can be incorporated directly into a lithographic printing press. In the latter case, printing can commence immediately after imaging, thereby reducing press set-up time considerably. The imaging apparatus can be configured as a flatbed recorder or as a drum recorder, with the lithographic printing plate precursor mounted to  
10 the interior or exterior cylindrical surface of the drum. A useful imaging apparatus is available as models of Kodak Trendsetter imagesetters available from Eastman Kodak Company (Burnaby, British Columbia, Canada) that contain laser diodes that emit near infrared radiation at a wavelength of 830 nm. Other suitable imaging sources include the Crescent 42T Platesetter that operates at a wavelength  
15 of 1064 nm (available from Gerber Scientific, Chicago, IL) and the Screen PlateRite 4300 series or 8600 series platesetter (available from Screen, Chicago, IL). Additional useful sources of radiation include direct imaging presses that can be used to image a lithographic printing plate precursor while it is attached to the printing plate cylinder. An example of a suitable direct imaging printing press  
20 includes the Heidelberg SM74-DI press (available from Heidelberg, Dayton, OH).

IR Imaging speeds can be at least 30 and up to and including 1500 mJ/cm<sup>2</sup> or typically at least 40 and up to and including 300 mJ/cm<sup>2</sup>.

While laser imaging is usually practiced, imaging can be provided by any other means that provides thermal energy in an imagewise fashion. For  
25 example, imaging can be accomplished using a thermoresistive head (thermal printing head) in what is known as "thermal printing", described for example in U.S. Patent 5,488,025 (Martin et al.). Thermal print heads are commercially available (for example, as Fujitsu Thermal Head FTP-040 MCS001 and TDK Thermal Head F415 HH7-1089).

30           Imaging is generally carried out using direct digital imaging. The image signals are stored as a bitmap data file on a computer. Such data files can be generated by a raster image processor (RIP) or other suitable means. The

bitmaps are constructed to define the hue of the color as well as screen frequencies and angles.

Imaging of the lithographic printing plate precursor produces an imaged precursor that comprises a latent image of imaged (exposed) and non-  
5 imaged (non-exposed) regions. Developing the imaged precursor with the developer composition described herein removes predominantly only the exposed regions of the imageable layer and any layers underneath it, and exposing the hydrophilic surface of the substrate (that generally contains aluminum). Development is carried out for a time sufficient to remove the imaged (exposed)  
10 regions of the imageable layer, but not long enough to remove the non-imaged (non-exposed) regions of the imageable layer. The imaged (exposed) regions of the imageable layer are described as being “soluble” or “removable” in the developer composition because they are removed, dissolved, or dispersed within the developer more readily than the non-imaged (non-exposed) regions of the  
15 imageable layer. Thus, the term “soluble” also means “dispersible”.

Generally, the developer composition described herein is applied to the imaged precursor by rubbing or wiping it with an applicator containing the developer composition. Alternatively, the imaged precursor can be brushed with  
20 the developer composition, or the developer composition can be applied by spraying the imaged precursor with sufficient force to remove the exposed regions. Still again, the imaged precursor can be immersed in the developer composition. In all instances, a developed image is produced in a lithographic printing plate. Development can be carried out in suitable apparatus containing suitable rollers, brushes, tanks, and plumbing for delivery, disposal, or  
25 recirculation of solutions if desired. Development using dip tanks are particularly useful.

The developer composition can be added as a “working strength” solution, or it can be added as a “concentrate” that is diluted at least 1.5 times and up to and including 2.5 times with water or an aqueous alkaline solution. The  
30 concentrated form of the developer compositions would then have appropriate concentrations of the various components so that, upon dilution with water or an

aqueous alkaline solution, or both, the resulting working strength developer composition then has the desired amounts of each component.

During development, the developer composition can be replenished with fresh amounts of the same solution, or it can be replenished with a developer composition replenisher that has similar or different concentrations of various components. For example, the developer replenisher composition can have a higher concentration of alkali agent,  $M^{2+}$  metal cation as well as other components such as a cationic surfactant or a chelating agent. The higher concentration can be as little as 5% higher and up to and including 20% higher concentrations of the desired components.

The rate of replenishment would be readily determined by routine experimentation based on the area of precursors being processed. In most instances, the rate of replenishment can be monitored and controlled by measuring the conductivity of the developer composition in the processing tank, to maintain the conductivity as close to a target conductivity as possible. If the conductivity becomes too high during replenishment, a diluent such as plain water can also be added to the processing tank.

Following development, the lithographic printing plate can be rinsed with water and dried in a suitable fashion. It can also be treated with a conventional gumming solution (preferably gum arabic).

The resulting lithographic printing plate can also be baked in a post-exposure bake operation that can be carried out to increase run length. Baking can be carried out at a temperature of at least 220°C and up to and including 260°C for from at least 0.5 and up to and including 10 minutes, or at 120°C for 30 minutes.

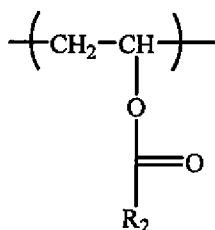
Printing can be carried out by applying a lithographic ink and fountain solution to the printing surface of the lithographic printing plate. The ink is taken up by the non-imaged (non-exposed or non-removed) regions of the imageable layer and the fountain solution is taken up by the hydrophilic surface of the substrate revealed by the imaging and development process. The ink is then transferred to a suitable receiving material (such as cloth, paper, metal, glass, or plastic) to provide a desired impression of the image thereon. If desired, an



intermediate “blanket” roller can be used to transfer the ink from the printing plate to the receiving material. The lithographic printing plates can be cleaned between impressions, if desired, using conventional cleaning means and chemicals.

The present invention provides at least the following embodiments and combinations thereof, but other combinations of features are considered to be within the present invention as a skilled artisan would appreciate from the teaching of this disclosure:

1. A method of providing a lithographic printing plate comprising:
  - 10 A) imagewise exposing a positive-working lithographic printing plate precursor that has a substrate and an outermost imageable layer that comprises a polymer binder comprising recurring units represented by Structure (Ib) below:



15

(Ib)

wherein the recurring units of Structure (Ib) are present in an amount of at least 25 and up to and including 60 mol %, all based on total recurring units in the polymer binder, and R<sub>2</sub> is a substituted or unsubstituted hydroxyaryl group in which the hydroxyl group is *ortho* to the ester linkage, to form exposed and non-exposed regions in the imageable layer, and

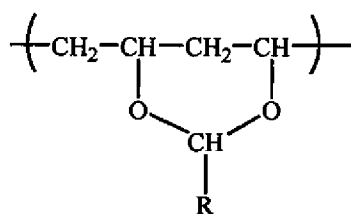
- 20 B) developing the resulting imaged lithographic printing plate precursor to remove the exposed regions of the imageable layer, the development being carried out using a silicate-free developer composition having a pH of at least 12 and comprising at least 0.001 gram-atom/kg of a metal cation M<sup>2+</sup> selected from the group consisting of barium, calcium, strontium, and zinc cations.

25

2. The method of embodiment 1 wherein the metal cation  $M^{2+}$  is one or more of calcium, strontium, and zinc cations.

3. The method of embodiment 1 or 2 wherein the metal cation  $M^{2+}$  is present in the developer composition in an amount of at least 0.001 and up to and including 0.01 gram-atom/kg.

4. The method of any of embodiments 1 to 3 wherein the polymer binder further comprises recurring units defined by the following Structure (Ia), and all recurring units are present in the polymer binder in random order:



10

(Ia)

wherein the Structure (Ia) recurring units are present in an amount of at least 10 and up to and including 35 mol %, based on the total recurring units, and R is a substituted or unsubstituted hydroxyaryl group.

5. The method of any of embodiments 1 to 4 wherein  $R_2$  is a hydroxyphenyl or hydroxynaphthyl group that is substituted with a cyclic imide group.

6. The method of embodiment 4 or 5 wherein the polymer binder comprises recurring units represented by Structure (Ia) in an amount of at least 10 and up to and including 35 mol %, and recurring units represented by Structure (Ib) in an amount of at least 25 and up to and including 50 mol %.

7. The method of any of embodiments 1 to 6 wherein the developer composition further comprises a chelating agent that has a complex formation constant ( $\log K$ ) for the calcium or strontium  $M^{2+}$  metal cation of at least 3.5 and less than or equal to 4.5, and a  $\log K$  for aluminum ion that is 7 or less.

8. The method of any of embodiments 1 to 7 wherein the developer composition further comprises a chelating agent that is a phosphonopolycarboxylic acid.

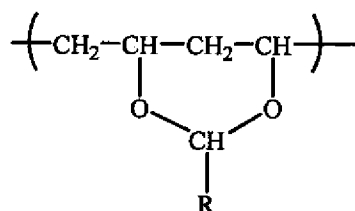
9. The method of any of embodiments 1 to 8 wherein the developer composition further comprises 2-phosphonobutane-1,2,4-tricarboxylic acid.
10. The method of any of embodiments 1 to 9 wherein the  
5 developer composition further comprises a chelating agent that has a complex formation constant (log K) for the calcium or strontium  $M^{2+}$  metal cation of at least 3.5 and less than or equal to 4.5, and a log K for aluminum ion that is 7 or less, the chelating agent being present in an amount of at least 0.01 and up to and including 0.1 mol/liter.
11. The method of embodiment 10 wherein the  $M^{2+}$  metal  
10 cation is calcium cation and the chelating agent is 2-phosphonobutane-1,2,4-tricarboxylic acid.
12. The method of any of embodiments 1 to 11 wherein the lithographic printing plate precursor further comprises an infrared radiation  
15 absorbing compound in the imageable layer, and the precursor is imagewise exposed to infrared radiation.
13. The method of any of embodiments 1 to 12 wherein the outermost imageable layer is the only imageable layer in the lithographic printing plate precursor that is disposed on an aluminum-containing substrate.
14. The method of any of embodiments 1 to 13 wherein the  
20 developer composition has a pH of at least 12 and up to and including 13.5.
15. The method of any of embodiments 1 to 14 wherein the developer composition further comprises an alkali metal hydroxide as an alkali agent.
16. The method of any of embodiments 1 to 15 wherein the  
25 developer composition further comprises a cationic surfactant.
17. The method of any of embodiments 1 to 16 wherein the developer composition has a pH of at least 12 and up to and including 13.5, the developer composition wherein  $M^{2+}$  is calcium or strontium metal cation and the  
30 developer composition further comprises:  
a sodium or potassium hydroxide, and  
2-phosphonobutane-1,2,4-tricarboxylic acid.

18. The method of embodiment 17 wherein  $M^{2+}$  is calcium metal cation.

19. The method of any of embodiments 1 to 16 wherein the developer composition has a pH of at least 12 and up to and including 13.5, the developer composition wherein  $M^{2+}$  is calcium metal cation and the developer composition further comprises:

an alkali metal hydroxide,  
2-phosphonobutane-1,2,4-tricarboxylic acid, and  
a cationic surfactant, and

10 the polymer binder in the outermost imageable layer comprises recurring units represented by both Structures (Ia) and (Ib), in random fashion, wherein the recurring units of Structure (Ia) are as follows:



(Ia)

15 wherein the recurring units of Structure (Ia) are present in an amount of at least 10 and up to and including 35 mol %, based on the total recurring units, and R is a substituted or unsubstituted hydroxyaryl group.

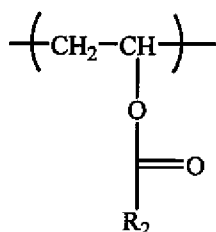
20 20. The method of any of embodiments 1 to 19 that is carried out in a processing apparatus to which the developer composition is supplied as a concentrate that is diluted at least 1.5 times with an aqueous solution for use in step B.

25 21. The method of any of embodiments 1 to 20 wherein the positive-working lithographic printing plate precursor has a surface imageable layer containing hydroxymandelic acid, an organic compound having at least one amino group and at least one carboxylic acid group directly linked to an aryl group, or both hydroxymandelic acid and at least one of the organic compounds.

22. A lithographic printing plate prepared according to the method of any of embodiments 1 to 21.

23. A kit useful for providing lithographic printing plates, the kit comprising:

- a) one or more positive-working lithographic printing plate precursors, each precursor having a substrate and an outermost imageable layer that comprises a polymer binder comprising recurring units represented by Structure (Ib) below:



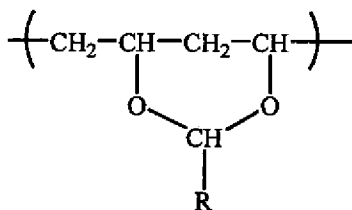
(Ib)

10

wherein the recurring units of Structure (Ib) are present in an amount of at least 25 and up to and including 60 mol %, all based on total recurring units in the polymer binder, and R<sub>2</sub> is a substituted or unsubstituted hydroxyaryl group in which the hydroxyl group is *ortho* to the ester linkage, and

- b) a silicate-free developer composition having a pH of at least 12 and comprising at least 0.001 gram-atom/kg of a metal cation M<sup>2+</sup> selected from the group consisting of barium, calcium, strontium, and zinc cations.

24. The kit of embodiment 23 wherein the polymeric binder further comprises recurring units represented by the following Structure (Ia), in random order with the recurring units of Structure (Ib):



(Ia)

wherein the recurring units of Structure (Ia), when present, are present in an amount of at least 10 and up to and including 35 mol %, the recurring units of Structure (Ib), when present, are present in an amount of at least 25 and up to and

including 60 mol %, all based on total recurring units in the polymer binder, and R is a substituted or unsubstituted hydroxyaryl group.

25. The kit of embodiment 23 or 24 wherein the silicate-free developer composition also comprises a chelating agent that is a phosphono-  
5 polycarboxylic acid, a cationic surfactant, or both.

The following Examples are provided to illustrate the practice of this invention and they are not meant to be limiting to the scope of the invention in any manner.

10 The following materials were used in the preparation and use of the examples. Unless otherwise indicated, the materials were obtained from Aldrich Chemical Company (Milwaukee, WI).

ABA represents 4-aminobenzoic acid.

15 Bayhibit<sup>®</sup> AM is a 50% aqueous solution of 2-phosphonobutane-1,2,4-tricarboxylic acid, "PBTC" (Bayer AG).

BLO represents  $\gamma$ -butyrolactone.

BPA 1100 is a resole resin that was obtained from AZEM  
(Wiesbaden).

Dextrin was corn dextrin, Type I, powder.

20 Dowfax<sup>®</sup> 2A1 is an anionic alkyldiphenyloxide disulfonate (Dow Chemical Company).

Dioxalane is 1,3-dioxalane.

DMABA represents 4-(dimethylamino)benzoic acid.

25 Hydromax 300 is a 40% aqueous solution of an organic fatty acid quaternary ammonium chloride mixture (Chemax Performance Products, Greenville, SC).

MEK represents methyl ethyl ketone.

NMP represents N-methyl pyrrolidone.

30 PM represents 1-methoxy-2-propanol that can be obtained as Arcosolve<sup>®</sup> PM from LyondellBasell Industries (the Netherlands).

Polyfox<sup>®</sup> PF 652 is a surfactant (Omnova).

PVP represents poly(vinyl pyrrolidone), average Mw of 58,000, K29-32 (ACROS Organics, New Jersey, USA).

S0094 is an infrared radiation absorbing dye ( $\lambda_{\text{max}} = 813 \text{ nm}$ ) that was obtained from FEW Chemicals (Germany).

5 d-Sorbitol is d-glucitol.

Sudan Black B is a neutral diazo dye (C.U. 26150).

Victoria Blue R is a triarylmethane dye (Basic Blue 11, C.I. 44040).

Zinc nitrate was present as zinc nitrate hexahydrate.

10

**Precursor 1:**

A lithographic printing plate precursor was prepared according to Example 12 of copending and commonly assigned U.S. Serial No. 12/555,040 (noted above) that is cited herein, with the exception that instead of Polymer I, 15 Polymer H (described therein) was used. The imageable layer was prepared from a coating solution containing the following components:

	Polymer H	0.762 g
	BPA 1100	0.12 g
	S 0094 IR Dye	0.026 g
20	Victoria Blue R	0.011 g
	Sudan Black B	0.021 g
	ABA	0.11 g
	Polyfox <sup>®</sup> PF 652 surfactant (10% in PM)	0.031 g
	BLO	2.69 g
25	Dioxalane	3.24 g
	PM	3.50 g
	MEK	3.24 g

This coating solution was filtered and applied to an 30 electrochemically roughened and anodized aluminum substrate that had been subjected to a treatment using an aqueous solution of sodium phosphate and sodium fluoride. The resulting imageable layer coating was dried for 30 seconds

at 130°C in Glunz&Jensen “Unigraph Quartz” oven. The dry coating weight of the resulting positive-working imageable layer was 1.5 g/m<sup>2</sup>. The resulting lithographic printing plate precursor was further treated in an oven at 62°C and 28% relative humidity for 24 hours.

5

**Precursor 2:**

Precursor 2 was prepared according to Example 2 of U.S. Patent Application Publication 2009/0162783 A1 (Levanon et al.) having the positive-working imageable layer formulation shown in [0213] and containing DMABA as the developability enhancing compound.

10

**Invention Example 1:**

Samples of Precursor 1 were exposed using the Kodak<sup>®</sup> Magnus 400 Quantum imager at a range of energies, 50 mJ/cm<sup>2</sup> to 200 mJ/cm<sup>2</sup> and processed in a Mercury Mark VI processor using Developer 1 (shown below) at 23°C for 20 seconds.

15

Developer 1

Component	Concentration (%)
KOH	2.40
PVP	0.10
Dextrin	0.50
Zn(NO <sub>3</sub> ) <sub>2</sub> x 6H <sub>2</sub> O	0.15
d-Sorbitol	5.50
Water	91.4

20

The resulting lithographic printing plates were evaluated in various tests. The results are shown as follows.



Precursor	Corrosion, Weight Loss ( $\Delta m/S$ , g/m <sup>2</sup> )	CDL %	Clearing Point (mJ/cm <sup>2</sup> )	Linearity Point (mJ/cm <sup>2</sup> )
1	0.08	0.4	50	90

These results show that developing the samples of imaged Precursor 1 in a silicate-free developer containing M<sup>+2</sup> metal cation (Zn<sup>2+</sup>) provided very good performing lithographic printing plates, characterized with very low corrosion of the aluminum-containing substrate.

Clearing Point is the lowest imaging energy at which the exposed regions were completely removed by the developer at a given temperature and time. Linearity Point is the energy at which the 50% dots at 200 lpi screen are reproduced as 50%  $\pm$  0.2% dots. Cyan Density Loss (CDL %) provides a measure of the resistance of the non-exposed regions on the lithographic printing plate to the developer. CDL % is calculated using the following formula.

$$\text{CDL \%} = (\text{OD}_b - \text{OD}_a) / \text{OD}_b \times 100$$

wherein OD<sub>a</sub> is the optical density of the non-exposed coating after development and OD<sub>b</sub> is the optical density of the non-exposed coating before development. The optical densities were measured using an X-Rite 500 Series spectrodensitometer having a cyan filter.

The corrosion weight loss data provide a measure of the resistance of the substrate under the imageable layer to the developer. It was measured on a 16 cm x 16 cm square of the uncoated substrate. The weight loss was measured by comparing the initial weight of the aluminum square with the weight of the aluminum square after it had been treated in the developer for 30 seconds at 23°C, rinsed with water, and dried.

## 25 Invention Example 2:

Invention Example 1 was repeated except that Developer 1 was replaced during processing with Developer 2 shown below.

## Developer 2

Component	Concentration (%)
KOH	3.20
Bayhibit <sup>®</sup> AM	0.50
CaCl <sub>2</sub> X 2H <sub>2</sub> O	0.04
DowFax <sup>®</sup> 2A1	0.50
Hydromax 300	0.10
Water	95.7

The resulting lithographic printing plates were evaluated for several properties and the results are shown as follows:

Precursor	Corrosion, Weight loss ( $\Delta m/S$ , g/m <sup>2</sup> )	CDL %	Clearing Point (mJ/cm <sup>2</sup> )	Linearity Point (mJ/cm <sup>2</sup> )
2	0.03	0.2	60	90

5

These results show that developing the samples of imaged Precursor 1 in a silicate-free developer containing M<sup>2+</sup> metal cation (Ca<sup>2+</sup>) provided very good performing lithographic printing plates, characterized with very low corrosion of the aluminum-containing substrate. In addition, the developer containing the calcium metal cations is a more environmentally acceptable developer.

10

**Comparative Examples 1-4:**

Invention Example 1 was repeated except that Developer 1 was replaced with Kodak<sup>®</sup> commercial developers Goldstar Premium and KT 300, and the developing soaking time for KT 300 was set to 25 seconds instead of 20 seconds. Samples of Precursor 2 were also prepared, imaged, and processed also.

15

The results are listed as follows.

Comparative Examples	Precursor	Developer	Corrosion, Weight loss (g/m <sup>2</sup> )	CDL %	Clearing Point (mJ/cm <sup>2</sup> )	Linearity Point (mJ/cm <sup>2</sup> )
1	1	Goldstar Premium	0.11	22.8	90	140
2	1	KT 300	0.13	36.1	90	140
3	2	Goldstar Premium	0.10	2.80	60	125
4	2	KT 300	0.14	4.60	50	105

5 These results show that Precursor 1 suffered from excessive coating loss in the non-exposed regions and exhibited slow imaging speeds (higher clearing point and linearity point) when developed in developers not containing M<sup>2+</sup> metal cations. The corrosion data also showed more attack of the aluminum-containing substrate by the developers not containing the M<sup>2+</sup> metal cations.

10 These results also show that Precursor 2, which did not contain a poly(vinyl acetal) binder that also had hydroxylaryl ester groups, showed fairly good resistance to the commercial developers and good imaging speeds, but poor solvent resistance that is described in U.S. Serial No. 12/555,040 (noted above).

15 **Comparative Example 5:**

Invention Example 2 was repeated except that the CaCl<sub>2</sub> in Developer 2 was omitted. During processing with the resulting developer, both the infrared laser exposed and non-exposed regions on Precursor 1 were completely dissolved. These results show that the use of cationic surfactants such as Hydromax 300 in Developer 2 is not adequate to protect the non-exposed coatings in positive-working lithographic printing plate precursors having poly(vinyl acetal) polymer binders that also have hydroxylaryl ester groups.

20

**Invention Example 3:**

Invention Example 2 was repeated except that the  $\text{CaCl}_2 \times 2\text{H}_2\text{O}$  was increased to show the effect of its concentration in the developer on the image quality of Precursor 1. These following results show how the amount of  $\text{Ca}^{2+}$  cations in the developer affects the dissolution of the non-imaged regions of the imageable layer, and the optimal amount of calcium cation that is practical to fully inhibit imageable layer dissolution in Developer 2.

<b><math>\text{CaCl}_2 \times 2\text{H}_2\text{O}</math> (weight %)</b>	<b>CDL%</b>	<b>50% dot reading at 100 mJ/cm<sup>2</sup> exposure</b>
0.005	43.8	No dots left
0.010	8.90	47.6
0.020	1.90	48.5
0.040	0.20	49.8

10

**Invention Example 4:**

Invention Example 2 was repeated except that the cationic surfactant Hydromax 300 was omitted from the developer. Using the resulting developer, the imaged and processed Precursor 1 showed a CDL of 7.5%. The dot reading of 50% dots at 200 lpi was 49.7%. These results show that a developer not having a cationic surfactant such as Hydromax 300 as a coating protecting agent still worked reasonably well with positive-working lithographic printing plate precursors containing poly(vinyl acetal) polymer binders that also have hydroxyl aryl ester groups, while the presence of cationic surfactants in Developer 2 does provide some additional benefits. Therefore, Developer 2 that was used in Invention Example 2 is more useful than the developer used in this example.

15

20

**Invention Example 5:**

Invention Example 2 was repeated except that the amount of Hydromax 300 was increased to show the effects of its concentration in the developer on the image quality of Precursor 1. The results are provided as follows.

25

<b>Hydromax 300 (weight %)</b>	<b>CDL%</b>	<b>50% dot reading at 100 mJ/cm<sup>2</sup> exposure</b>
0.010	7.5	49.7
0.025	7.5	49.3
0.050	5.9	49.4
0.100	2.1	49.5

5 These results show that the concentration of the cationic surfactant in Hydromax 300 as a secondary coating protecting agent in Developer 2 had less pronounced effects on the image quality of Precursor 1 than the concentration of CaCl<sub>2</sub> x 2H<sub>2</sub>O, which is the primary coating protecting agent used in the present invention.

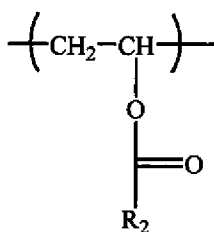
**Comparative Example 6:**

10 Invention Example 4 was repeated except that Precursor 2 was used instead of Precursor 1. After imaging and processing, both infrared laser exposed and non-exposed regions were completely dissolved by the developer. This result shows that lithographic printing plate precursors containing polyvinyl acetal polymer binders having no hydroxylaryl ester groups are not protected by  
15 Ca<sup>2+</sup> cations in the developer.

**CLAIMS:**

1. A method of providing a lithographic printing plate comprising:

- 5 A) imagewise exposing a positive-working lithographic printing plate precursor that has a substrate and an outermost imageable layer that comprises a polymer binder comprising recurring units represented by Structure (Ib) below:



(Ib)

10

wherein the recurring units of Structure (Ib) are present in an amount of at least 25 and up to and including 60 mol %, all based on total recurring units in the polymer binder, and R<sub>2</sub> is a substituted or unsubstituted hydroxyaryl group in which the hydroxyl group is *ortho* to the ester linkage, to form exposed and non-exposed regions in the imageable layer, and

15

B) developing the resulting imaged lithographic printing plate precursor to remove the exposed regions of the imageable layer, the development being carried out using a silicate-free developer composition having a pH of at least 12 and comprising at least 0.001 gram-atom/kg of a metal cation M<sup>2+</sup> selected from the group consisting of barium, calcium, strontium, and zinc cations.

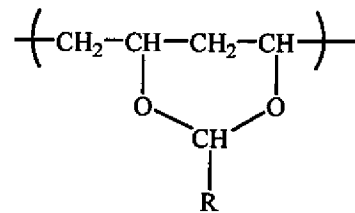
20

2. The method of claim 1 wherein the metal cation M<sup>2+</sup> is one or more of calcium, strontium, and zinc cations.

25

3. The method of claim 1 or 2 wherein the metal cation M<sup>2+</sup> is present in the developer composition in an amount of at least 0.001 and up to and including 0.01 gram-atom/kg.

4. The method of any of claims 1 to 3 wherein the polymer binder further comprises recurring units defined by the following Structure (Ia), and all recurring units are present in the polymer binder in random order:



5

(Ia)

wherein the Structure (Ia) recurring units are present in an amount of at least 10 and up to and including 35 mol %, based on the total recurring units, and R is a substituted or unsubstituted hydroxyaryl group.

10

5. The method of any of claims 1 to 4 wherein R<sub>2</sub> is a hydroxyphenyl or hydroxynaphthyl group that is substituted with a cyclic imide group.

15

6. The method of any of claims 1 to 5 wherein the developer composition further comprises a chelating agent that has a complex formation constant (log K) for the calcium or strontium M<sup>2+</sup> metal cation of at least 3.5 and less than or equal to 4.5, and a log K for aluminum ion that is 7 or less.

20

7. The method of any of claims 1 to 6 wherein the developer composition further comprises a chelating agent that is a phosphonopolycarboxylic acid.

25

8. The method of any of claims 1 to 7 wherein the developer composition further comprises a chelating agent that has a complex formation constant (log K) for the calcium or strontium M<sup>2+</sup> metal cation of at least 3.5 and less than or equal to 4.5, and a log K for aluminum ion that is 7 or less, the chelating agent being present in an amount of at least 0.01 and up to and including 0.1 mol/liter.

9. The method of any of claims 1 to 8 wherein the developer composition further comprises a cationic surfactant.

5 10. The method of any of claims 1 to 9 wherein the developer composition has a pH of at least 12 and up to and including 13.5, the developer composition wherein  $M^{2+}$  is calcium or strontium metal cation and the developer composition further comprises:

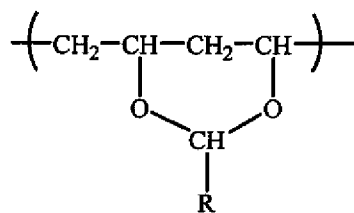
10 a sodium or potassium hydroxide, and  
2-phosphonobutane-1,2,4-tricarboxylic acid.

11. The method of claim 10 wherein  $M^{2+}$  is calcium metal cation.

15 12. The method of any of claims 1 to 11 wherein the developer composition has a pH of at least 12 and up to and including 13.5, the developer composition wherein  $M^{2+}$  is calcium metal cation and the developer composition further comprises:

20 an alkali metal hydroxide,  
2-phosphonobutane-1,2,4-tricarboxylic acid, and  
a cationic surfactant, and

the polymer binder in the outermost imageable layer comprises recurring units represented by both Structures (Ia) and (Ib), in random fashion, wherein the recurring units of Structure (Ia) are as follows:



25

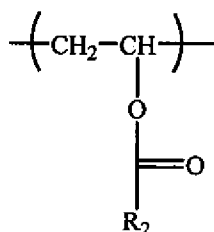
(Ia)

wherein the recurring units of Structure (Ia) are present in an amount of at least 10 and up to and including 35 mol %, based on the total recurring units, and R is a substituted or unsubstituted hydroxyaryl group.



13. A kit useful for providing lithographic printing plates, the kit comprising:

- a) one or more positive-working lithographic printing plate precursors, each precursor having a substrate and an outermost imageable layer that comprises a polymer binder comprising recurring units represented by Structure (Ib) below:

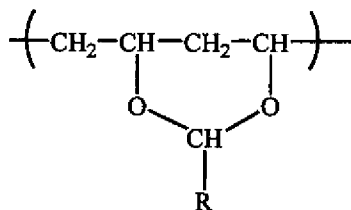


(Ib)

wherein the recurring units of Structure (Ib) are present in an amount of at least 25 and up to and including 60 mol %, all based on total recurring units in the polymer binder, and R<sub>2</sub> is a substituted or unsubstituted hydroxyaryl group in which the hydroxyl group is *ortho* to the ester linkage, and

- b) a silicate-free developer composition having a pH of at least 12 and comprising at least 0.001 gram-atom/kg of a metal cation M<sup>2+</sup> selected from the group consisting of barium, calcium, strontium, and zinc cations.

14. The kit of claim 13 wherein the polymeric binder further comprises recurring units represented by the following Structure (Ia), in random order with the recurring units of Structure (Ib):



(Ia)

wherein the recurring units of Structure (Ia), when present, are present in an amount of at least 10 and up to and including 35 mol %, the recurring units of Structure (Ib), when present, are present in an amount of at least 25 and up to and

including 60 mol %, all based on total recurring units in the polymer binder, and R is a substituted or unsubstituted hydroxyaryl group.

15. The kit of claim 13 or 14 wherein the silicate-free developer  
5 composition also comprises a chelating agent that is a phosphono-polycarboxylic acid, a cationic surfactant, or both.

## INTERNATIONAL SEARCH REPORT

International application No  
PCT/US2011/058697

A. CLASSIFICATION OF SUBJECT MATTER INV. B41C1/10 B41N3/08 G03F7/32 B41M5/36 ADD.		
According to International Patent Classification (IPC) or to both national classification and IPC		
B. FIELDS SEARCHED		
Minimum documentation searched (classification system followed by classification symbols) B41C B41N G03F B41M		
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched		
Electronic data base consulted during the international search (name of data base and, where practical, search terms used) EPO-Internal, WPI Data		
C. DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 6 162 575 A (FUJIOKA HAJIME [JP] ET AL) 19 December 2000 (2000-12-19) column 3, lines 17-21 column 13, lines 11-13 column 15, lines 20-24 column 17, lines 12-16	1-15
A	EP 1 715 386 A1 (FUJI PHOTO FILM CO LTD [JP]) 25 October 2006 (2006-10-25) claims 1,2 paragraph [0027]	1-15
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