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(54) **DRY PAINT TRANSFER LAMINATE**

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(57) **ABSTRACT**

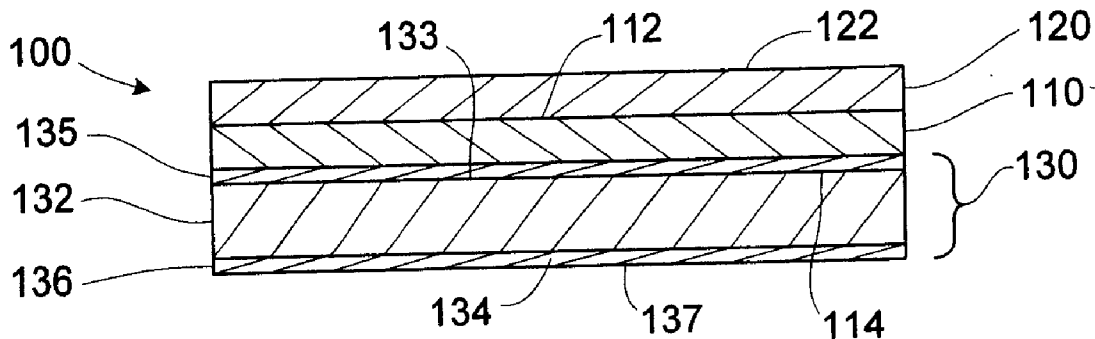
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Related U.S. Application Data

(63) Continuation of application No. 10/367,611, filed on Feb. 14, 2003.

This disclosed invention relates to a dry paint transfer laminate, comprising: a dry paint film layer comprising a binder and a pigment, the dry paint film layer having an upper surface and a lower surface; an adhesive layer overlying the upper surface of the dry paint film layer; and a release liner overlying the lower surface of the dry paint film layer.



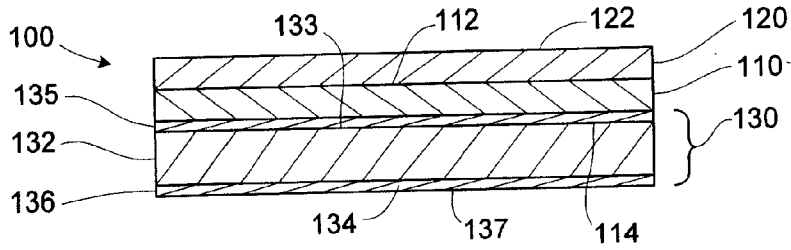


FIG. 1

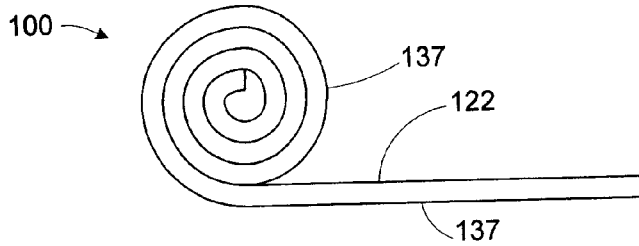


FIG. 2

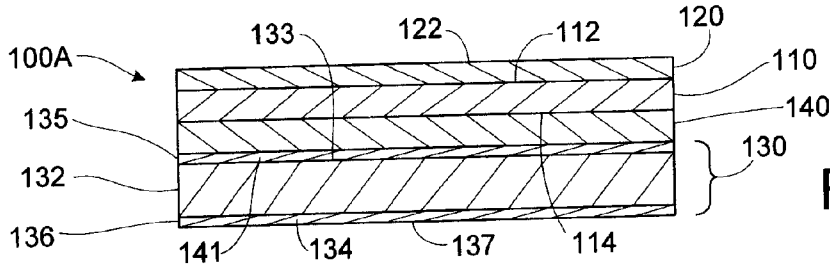


FIG. 3

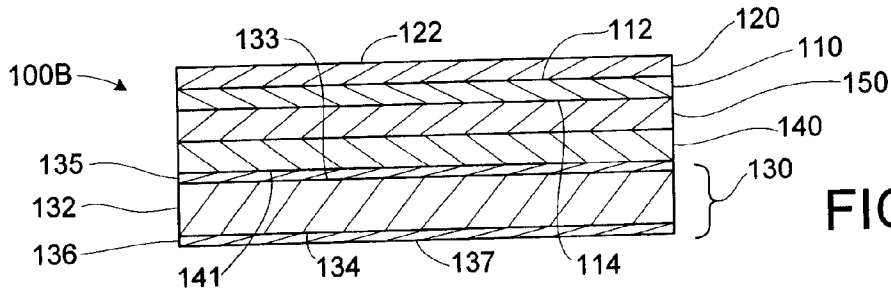


FIG. 4

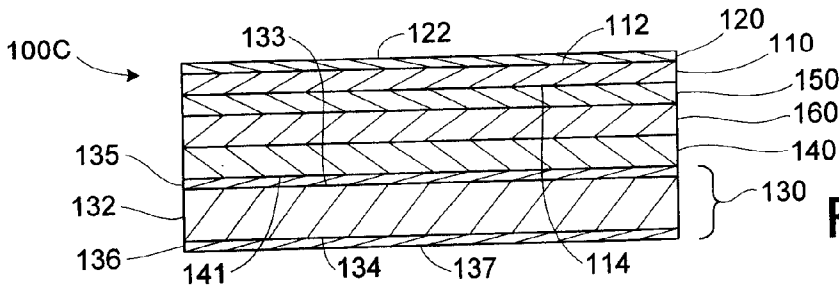


FIG. 5

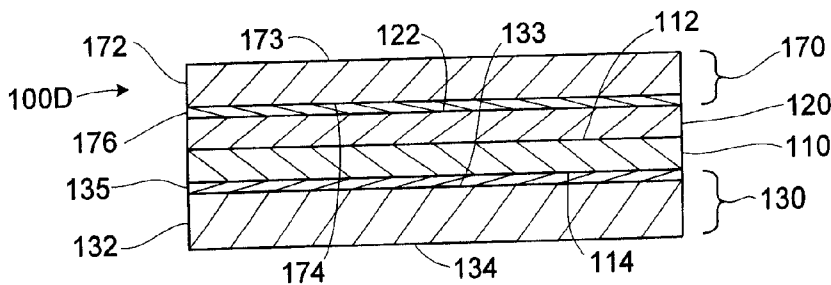


FIG. 6

DRY PAINT TRANSFER LAMINATE

[0001] This application is a continuation of U.S. application Ser. No. 10/367,611, filed Feb. 14, 2003, which is incorporated herein by reference in its entirety

TECHNICAL FIELD

[0002] This invention relates to dry paint transfer laminates. These laminates comprise a dry paint film layer, an adhesive layer overlying one side of the dry paint film layer, and a release liner overlying the other side of the dry paint film layer.

BACKGROUND OF THE INVENTION

[0003] Conventional painting using liquid paint requires set up steps involving masking off areas not to be painted and the spreading of drop cloths. Conventional painting also requires messy clean up of brushes, rollers, and the like, the problem of spills, exposure to fumes, and delays while the paint dries. When special effects such as faux finishes are desired, additional time and effort is required to apply additional coats.

[0004] The present invention provides a solution to these problems. With the present invention it is not necessary to mask off areas that are not to be painted and it is not necessary to use drop cloths. The messy clean up of brushes, rollers, and the like is avoided. Spills and exposure to fumes are avoided. Delays waiting for paint to dry are avoided. Special effects such as faux finishes can be accomplished with a single application.

SUMMARY OF THE INVENTION

[0005] This invention relates to a dry paint transfer laminate, comprising: a dry paint film layer comprising a binder and a pigment, the dry paint film layer having an upper surface and a lower surface; an adhesive layer overlying the upper surface of the dry paint film layer; and a release liner overlying the lower surface of the dry paint film layer.

[0006] In one embodiment, the release liner comprises: a backing liner which has an upper surface and a lower surface; a first release coating layer overlying the upper surface of the backing liner; and a second release coating layer overlying the lower surface of the backing liner.

[0007] In one embodiment, a transparent film layer is positioned between the lower surface of the dry paint film layer and the release liner.

[0008] In one embodiment, a printed decorative layer is positioned between the lower surface of the dry paint film layer and the release liner.

[0009] In one embodiment, a transparent film layer is positioned between the printed decorative layer and the release liner.

[0010] In one embodiment, a second printed decorative layer is positioned between the second dry paint film layer and the release liner.

[0011] In one embodiment, a transparent film layer is positioned between the second printed decorative layer and the release liner.

[0012] In one embodiment, another release liner overlies the adhesive layer.

[0013] This invention relates to a method of coating a substrate, comprising: placing the above-indicated laminate over the substrate with the adhesive layer in contact with the substrate and adhering the laminate to the substrate; and separating the release liner from the laminate leaving the dry paint film layer adhered to the substrate.

[0014] This invention relates to a method of making a dry paint transfer laminate, comprising: coating one side of a release liner with a paint film layer and drying or curing the paint film layer, the paint film layer comprising a binder and a pigment, the paint film layer having an upper surface and a lower surface, the release liner having a release surface, the lower surface of the paint film layer being adhered to the release surface of the release liner; and applying an adhesive over the upper surface of the paint film layer.

BRIEF DESCRIPTION OF THE DRAWINGS

[0015] In the annexed drawings, like references indicate like parts or features.

[0016] FIG. 1 is a schematic illustration of the side view of a dry paint transfer laminate embodying the present invention in a particular form.

[0017] FIG. 2 is a schematic illustration of the dry paint transfer laminate illustrated in FIG. 1, the laminate being partially wound into a roll.

[0018] FIG. 3 is a schematic illustration of the side view of another embodiment of the dry paint transfer laminate of the present invention.

[0019] FIG. 4 is a schematic illustration of the side view of still another embodiment of the dry paint transfer laminate of the present invention.

[0020] FIG. 5 is a schematic illustration of the side view of still another embodiment of the dry paint transfer laminate of the present invention.

[0021] FIG. 6 is a schematic illustration of the side view of still another embodiment of the dry paint transfer laminate of the present invention.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

[0022] The term "overlies" and cognate terms such as "overlying" and the like, when referring to the relationship of one or a first layer relative to another or a second layer, refers to the fact that the first layer partially or completely lies over the second layer. The first layer overlying the second layer may or may not be in contact with the second layer. For example, one or more additional layers may be positioned between the first layer and the second layer. The term "underlies" and cognate terms such as "underlying" and the like have similar meanings except that the first layer partially or completely lies under, rather than over, the second layer.

[0023] The term "dry paint" refers to a paint composition containing one or more volatile components (e.g., organic solvent, water, etc.) that has been applied to a substrate and allowed to dry to the extent that the volatile components have been removed completely or sufficiently to permit the

paint to adhere to the substrate and not smear when touched by the end user. The term "volatile" is used herein to refer to materials that are volatile at the drying temperature and atmospheric pressure.

[0024] The term "transparent" when referring to the transparent film layer overlying one or more of the dry paint film layers of the inventive dry paint transfer laminate means that the one or more dry paint film layers can be seen through the transparent film layer. The transparent film layer may be translucent.

[0025] Referring to FIG. 1, the inventive dry paint transfer laminate, in one of its illustrated embodiments, is generally indicated by the reference numeral 100, and comprises: a dry paint film layer 110 which has an upper surface 112 and a lower surface 114; an adhesive layer 120 overlying and adhered to upper surface 112; and a release liner 130 overlying and adhered to the lower surface 114. The release liner 130 comprises: a backing liner 132 which has an upper surface 133 and a lower surface 134; a first release coating layer 135 overlying and adhered to the upper surface 133; and a second release coating layer 136 overlying and adhered to the lower surface 134. The first release layer 135 is positioned between the upper surface 133 of backing liner 132 and the lower surface 114 of dry paint film layer 110, and preferentially adheres to the upper surface 133 of backing liner 132. Thus, when the release liner 130 is peeled away from the dry paint film layer 110, the release coating layer 135 separates from the dry paint film layer 110 and remains adhered to the backing liner 132. The lower surface 137 of release layer 136 is adapted for contacting the upper surface 122 of adhesive layer 120 when the laminate 100 is wound into roll form as illustrated in FIG. 2.

[0026] Referring to FIG. 2, the dry paint transfer laminate 100 is wound into roll form with the lower surface 137 of release coating layer 136 in contact with the upper surface 122 of adhesive layer 120. The release coating layer 136 preferentially adheres to backing liner 132. Thus, when the dry paint transfer laminate 100 illustrated in FIG. 2 is unwound, the release coating layer 136 separates from adhesive layer 120 and remains adhered to backing liner 132.

[0027] The dry paint transfer laminate 100A illustrated in FIG. 3 is identical to the dry paint transfer laminate 100 illustrated in FIG. 1 except that transparent film layer 140 is positioned between dry paint film layer 110 and release coating layer 135. The release coating layer 135 is adhered to transparent film layer 140 on one side and to backing liner 132 on the other side, and is preferentially adhered to backing liner 132. Thus, when the release liner 130 is peeled away from the transparent film layer 140, the release coating layer 135 separates from the transparent film layer 140 and remains adhered to the backing liner 132.

[0028] The dry paint transfer laminate 100B illustrated in FIG. 4 is identical to the dry paint transfer laminate 100A illustrated in FIG. 3 except that printed decorative layer 150 is positioned between dry paint film layer 110 and transparent film layer 140.

[0029] The dry paint transfer laminate 100C illustrated in FIG. 5 is identical to the dry paint transfer laminate 100B illustrated in FIG. 4 except that second printed decorative layer 160 is positioned between printed decorative layer 150 and transparent film layer 140.

[0030] Additional printed decorative layers beyond layers 150 and 160 may be used. For example, the inventive laminates may contain up to about 5 or more, and in one embodiment about 3 or about 4, printed decorative layers overlying one another. The printed decorative layers may provide a desired print or design and may be applied using conventional printing methods such as gravure, flexography, silk screen ink jet, etc.

[0031] The dry paint transfer laminate 100D illustrated in FIG. 6 is identical to the laminate 100 illustrated in FIG. 1 except that release coating layer 136 is not present, and additional release liner 170 has been added to overlie adhesive layer 120. Release liner 170 comprises: a backing liner 172 which has an upper surface 173 and a lower surface 174; and a release coating layer 176 overlying and adhered to the lower surface 174. The release layer 176 is positioned between the lower surface 174 of backing liner 172 and the upper surface 122 of adhesive layer 120, and preferentially adheres to the lower surface 174 of backing liner 172. Thus, when the release liner 170 is peeled away from the adhesive layer 120, the release coating layer 176 separates from the adhesive layer 120 and remains adhered to the backing liner 172.

[0032] The dry paint film layer 110 may have a thickness of about 0.5 to about 1.5 mils, and in one embodiment about 0.5 to about 1.2 mils, and in one embodiment about 0.5 to about 0.9 mil, and in one embodiment about 0.7 mil. The thickness of the adhesive layer 120 may range from about 0.4 to about 1 mil, and in one embodiment about 0.4 to about 0.8 mil, and in one embodiment about 0.4 to about 0.6 mil. The thickness of the backing liner 132 may range from about 0.5 to about 2 mils, and in one embodiment about 0.5 to about 1.5 mils, and in one embodiment about 0.85 to about 1.05 mils. The thickness of the first release coating layer 135 may range from about 0.05 to about 0.3 mil, and in one embodiment about 0.1 to about 0.2 mil. The thickness of the second release coating layer 136 may range from about 0.04 to about 0.2 mil, and in one embodiment about 0.04 to about 0.15 mil, and in one embodiment about 0.04 to about 0.08 mil. The thickness of the transparent film layer 140 may range from about 0.05 to about 0.4 mil, and in one embodiment about 0.05 to about 0.3 mil, and in one embodiment about 0.2 mil. The thickness of the printed decorative layer 150 may range from about 0.02 to about 0.15 mil, and in one embodiment about 0.02 to about 0.08 mils. The thickness of the second printed decorative layer 160 may range from about 0.02 to about 0.15 mil, and in one embodiment about 0.02 to about 0.1 mil. The thickness of the backing liner 172 may range from about 0.5 to about 2 mils, and in one embodiment about 0.5 to about 1.5 mils, and in one embodiment about 0.85 to about 1.05 mils. The thickness of the release coating layer 176 may range from about 0.04 to about 0.2 mil, and in one embodiment about 0.04 to about 0.15 mil, and in one embodiment about 0.04 to about 0.08 ml. Each of the foregoing thicknesses are dry film thicknesses. The laminates 100, 100A, 100B and 100C may have any width and length that is suitable for facilitated use by the end user. For example, the width may range from about 1 to about 200 cm, and in one embodiment 10 to 100 cm, and in one embodiment about 30 to about 40 cm. The length may range from about 10 to about 6500 meters, and in one embodiment about 15 to about 1000 meters. In one embodiment, the length may range from about 19 to about 6500 meters. In one embodiment, the length may range from

about 17 to about 20 meters. In one embodiment, the laminate may have a width of about 10 to about 20 cm, and a length of about 10 to about 30 cm. The laminates may be provided in the form of flat sheets or in roll form as illustrated in FIG. 2.

[0033] The layers **110**, **150** and **160** may comprise one or more binders or resins, and one or more pigments. These layers may be made from liquid coating or paint compositions comprising the one or more binders or resins, the one or more pigments, one or more solvents, and optionally one or more additional additives for controlling properties such as rheological properties and the like.

[0034] The binder or resin may be any binder or resin conventionally used in coating or paint formulations. The binder may comprise a thermoplastic or a thermosetting resin. The binder may be a synthetic resin or a natural resin. Examples of useful resins include acrylic resins, vinyl resins, polyester resins, alkyd resins, butadiene resins, styrene resins, phthalic acid or anhydride resins, urethane resins, epoxy resins, and the like. The binder may comprise vinyl and vinylidene polymers or copolymers containing units such as vinyl acetate, vinyl chloride, vinylidene chloride, and the like; hydrocarbon polymers and copolymers containing ethylene or propylene units and oxygenated or halogenated derivatives of ether, butadiene, oxygenated butadiene, isoprene, oxygenated isoprene, butadiene-styrene, butadiene vinyl toluene, isoprene-styrene and the like; polymers or copolymers containing units of acrylic acid, methacrylic acid, their esters, or acrylonitrile; vinylic hydrocarbon monomers reacted with unsaturated materials such as the reaction product of maleic acid or anhydride with styrene; and, broadly, various other resinous rubber-like elastomeric latex polymers and copolymers of ethylenically unsaturated monomers and polymers obtainable in stable aqueous latex form. The binder may comprise a copolymer of vinyl chloride and vinyl acetate. The binder may comprise diphenylmethane diisocyanate, methylene diethyl diisocyanate, isocyanurate, urea-formaldehyde, phenolformaldehyde, phenolic glue, animal hide glues, and the like. Other examples of binders or resins which may be used include fluorine resins, silicone resins, and fibrin resins.

[0035] The pigment may be any pigment used in making decorative coatings. These include opacifying pigments, such as titanium dioxide and zinc oxide, as well as tinting pigments such as carbon black, yellow oxides, brown oxides, tan oxides, raw and burnt sienna or umber, chromium oxide green, phthalocyanine green, phthalocyanine blue, ultramarine blue, cadmium pigments, chromium pigments, and the like. The pigments include organic reds such as azo reds, quinacridone red and perylene red as well as organic yellows such as diarylide yellow. Mixed metal oxide pigments may be used. Filler pigments such as clay, silica, talc, mica, wolloastonite wood flour, barium sulfate, calcium carbonate, aluminum silicate, and the like can be added as well in conventional amounts traditionally used in coating and paint formulations.

[0036] The solvent may either be aqueous or non-aqueous. Aqueous-based solvents include water, and water-based solutions such as water-alcohol mixtures and the like. Non-aqueous solvents include organic-based solvents, such as ketones, esters, aliphatics, aromatics, alcohols, glycols, glycol ethers, etc. These include methylethyl ketone, methyl-

isobutyl ketone, ethyl acetate, white spirits, alkanes, cycloalkanes, benzene, hydrocarbon substituted aromatic compounds (e.g., toluene, the xylenes, etc.), isoparaffinic solvents, and combinations of two or more thereof. The solvent is volatile in nature so that when applied to a substrate, the solvent evaporates leaving behind the binder, pigment and any other additional non-volatile ingredients.

[0037] Additional ingredients that may be used include wetting agents; plasticizers; suspension aids; thixotropic agents such as silica; water repellent additives such as polysiloxane compounds; fire retardant additives; biocides; defoamers; flow agents; and the like.

[0038] The pigment concentration for the liquid paint or coating composition used to provide the layers **110**, **150** and **160** may range from about 10 to about 30% by weight, and in one embodiment about 13 to about 27% by weight. The binder concentration may range from about 20 to about 40% by weight, and in one embodiment about 22 to about 37% by weight. The solvent concentration may range from about 30 to about 70% by weight, and in one embodiment about 40 to about 60% by weight. The additional ingredients such as wetting agents, suspension agents, etc., may be provided at concentrations known in the art, for example, up to about 5% by weight, and in one embodiment from about 0.1 to about 5% by weight. These coating or paint compositions may have a pigment volume concentration (PVC) in the range of about 5 to about 35%, and in one embodiment 10 to about 30%. The liquid paint or coating compositions used for making the film layers **110**, **150** and **160** may be mixed using known techniques.

[0039] The dry paint film layer **110** may comprise a single coat or multiple coats of paint and is typically in the form of a continuous layer, while the printed decorative layers **150** and **160** may independently be in the form of continuous or discontinuous layers. When multiple coats for the layer **110** are used, each coat may have the same or a different formulation. The layers **150** and/or **160** may have the same color or a different color than the layer **110**. The layers **150** and **160** may have the same color, or they may have colors that are different from each other. The layer **110** may be used to provide background color while the layers **150** and/or **160** may be used to provide a pattern or design. For example, the layers **150** and/or **160** may be used to provide a faux finish or a "ragging" or "sponging" look. The layers **150** and/or **160** may be used to provide a desired print or design image (e.g., a flowered design) having one or multiple colors. The designs may be in the form of repeat designs or random non-repeat designs.

[0040] The transparent film layer **140** may comprise a single coating layer or multiple coats, and may comprise any of the resin materials described above as being useful for making the dry paint film layer **110**. When multiple coats are used, each coat may have the same or a different formulation. Specific examples include polyvinyl chloride, and copolymers of vinyl chloride and acrylic or methacrylic acid. The transparent film layer **140** is primarily distinguishable from the dry paint film layer **110** by the fact that it is transparent or translucent. The transparent film layer **140**, in one embodiment, provides enhanced scuff resistance, stain resistance and/or recoatability to the dry paint film layer or layers underlying it. Enhanced recoatability refers to the fact that the presence of the transparent film layer **140** facilitates

the subsequent application of another dry paint film layer or printed decorative layer over it, or the application of conventional paint or wall coverings (e.g., wall paper) over it.

[0041] The adhesive layer **120** may be a pressure sensitive adhesive layer, a moisture activatable adhesive layer or a heat activatable adhesive layer. The adhesive may comprise any pressure sensitive, moisture activatable or heat activatable adhesive known in the art for use with film substrates. The adhesive layer **120** may be in the form of a continuous or discontinuous layer, and may comprise one or a mixture of two or more adhesives. The adhesive layer may be in the form of a patterned adhesive layer with a relatively strong adhesive in some areas and a relatively weak adhesive in other areas. In one embodiment, the adhesive layer provides initial tack and allows slight movement of the laminate to allow positioning adjustments prior to forming a permanent bond. In one embodiment, the adhesive permits facilitated stripping of the dry paint film layer from a substrate when use of the paint film layer is no longer desired. The adhesive may comprise a rubber based adhesive, acrylic adhesive, vinyl ether adhesive, silicone adhesive, or mixture of two or more thereof. The adhesive may be applied as a hot melt, solvent-based or water based adhesive. Included are adhesive materials described in "Adhesion and Bond", *Encyclopedia of Polymer Science and Engineering*, Vol. 1, pages 476-546, Interscience Publishers, 2nd Ed. 1985, the disclosure of which is hereby incorporated by reference. The adhesive materials that are useful may contain as a major constituent an adhesive polymer such as an acrylic-type polymer; block copolymer; natural, reclaimed, or styrene-butadiene rubber; tackified natural or synthetic rubber; a copolymer of ethylene and vinyl acetate; an ethylene-vinyl-acrylic terpolymer; polyisobutylene; poly (vinyl ether); etc. Other materials may be included in the adhesive such as tackifying resins, plasticizers, antioxidants, fillers, waxes, etc.

[0042] The adhesive layer **120** may contain one or more pigments to enhance the opacity of the paint film layers overlying it and permit the use of thinner dry paint film layers to achieve desired levels of opacity. Any of the pigments identified above may be used. Specific examples include titanium dioxide and carbon black. The pigment volume concentration may range up to about 10%, and in one embodiment from about 5 to about 10%, and in one embodiment about 2 to about 8%.

[0043] The backing liners **132** and **172** may independently comprise paper, polymer film, or a combination thereof. Paper liners are useful because of the wide variety of applications in which they can be employed. Paper is also relatively inexpensive and has desirable properties such as antiblocking, antistatic, dimensional stability, and can potentially be recycled. Any type of paper having sufficient tensile strength to be handled in conventional paper coating and treating apparatus can be employed as the backing liner. Thus, any type of paper can be used depending upon the end use and particular personal preferences. Included among the types of paper which can be used are clay coated paper, glassine, polymer coated paper, hemp, and similar cellulose materials prepared by such processes as the soda, sulfite or sulfate (Kraft) processes, the neutral sulfide cooking process, alkali-chlorine processes, nitric acid processes, semi-chemical processes, etc. Although paper of any weight may be employed as a backing liner, paper having weights in the

range of from about 30 to about 120 pounds per ream are useful, and papers having weights in the range of from about 60 to about 100 pounds per ream may be used. The term "ream" as used herein equals 3000 square feet.

[0044] Alternatively, the backing liners **132** and **172** may independently comprise a polymer film, and examples of polymer films include polyolefin, polyester, and combinations thereof. The polyolefin films may comprise polymer and copolymers of monoolefins having from 2 to about 12 carbon atoms, and in one embodiment from 2 to about 8 carbon atoms, and in one embodiment 2 to about 4 carbon atoms per molecule. Examples of such homopolymers include polyethylene, polypropylene, poly-1-butene, etc. Films prepared from blends of copolymers or blends of copolymers with homopolymers may be used. The films may be extruded in mono or multilayers.

[0045] Another type of material which may be used as the backing liners **132** and **172** is a polycoated kraft liner which is basically comprised of a kraft liner that is coated on either one or both sides with a polymer coating. The polymer coating, which can be comprised of high, medium, or low density polyethylene, propylene, polyester, or other similar polymer films, is coated onto the substrate surface to add strength and/or dimensional stability to the liner. The weight of these types of liners ranges from about 30 to about 100 pounds per ream, with about 94 to about 100 pounds per ream being useful. In total, the final backing liner **132** may comprise from about 10% to about 40% polymer and from about 60% to about 90% paper. For two sided coatings, the quantity of polymer may be approximately evenly divided between the top and bottom surface of the paper.

[0046] The release coating layer **135** may comprise a single coat of release coating material or multiple coats. When multiple coats are used, each coat may have the same formulation, or different formulations may be used. The release coating layer **135** may comprise any of the above indicated binders or resins which provide sufficient tack or adherence between the release coating layer **135** and either the dry paint film layer **110** (FIGS. 1 and 2) or transparent film layer **140** (FIGS. 3-5) to prevent separation of the release coating layer **135** from film layer **110** or **140** during the making of the dry paint transfer laminate **100**, **100A**, **100B**, **100C** or **100D** and normal handling of such laminate, and yet have sufficient release properties to provide for facilitated separation between the release coating layer **135** and film layer **110** or **140** when using the laminate. The release coating layer **135** may comprise an alkyd resin and/or a vinyl resin cross linked with a melamine resin. The alkyd resins include resins formed by the condensation of one or more polyhydric alcohols with one or more polybasic acids or anhydrides. The polyhydric alcohols include glycerol and the polybasic acids or anhydrides include phthalic anhydride. Modified alkyds wherein the polybasic acid is substituted in part by a monobasic acid such as acrylic acid or a vegetable oil fatty acid may be used. The vinyl resins that may be used include polyvinyl chloride, polyvinyl acetate, copolymers of vinyl chloride and vinyl acetate, acrylic resins, methacrylic resins, polystyrene resins, and the like. The melamine resins include amino resins made by the condensation of melamine with formaldehyde or a compound capable of providing methylene bridges. The cross linking of the alkyd and/or vinyl resin with the melamine resin typically occurs when the release coating **135** is

applied to the backing liner and dried or cured. In one embodiment, the release coating comprises on a solids basis from zero to about 80% by weight, and in one embodiment about 10 to about 30% by weight alkyd resin; from zero to about 80% by weight, and in one embodiment about 10 to about 30% by weight vinyl resin; and from about 10 to about 30% by weight, and in one embodiment about 20 to about 25% by weight melamine resin.

[0047] Release coating layer **135** may contain one or more solid particulates that project into the surface **114** of dry paint film layer **110** or the surface **141** of transparent film layer **140** to provide the surfaces **114** or **141** with a matte or flat finish. When particulates are present, the release coating layer **135** may be referred to as a matte release coat or matte release coating layer. The particulates that may be used may be any of the filler pigments described above for use in the paint film layers. Specific examples include talc and aluminum silicate. Particulates with irregular shapes (e.g., platelet shapes) may be used. By controlling the use of these particulates the surface finish of the dry paint film layer or the transparent film layer may be controlled. For example, by using these particulates, the dry paint film layer or the transparent film layer may be provided with a flat or semi-gloss finish. The paint film layer or transparent film layer may be provided with a glossy finish by not using or minimizing the use of these particulates. The weight ratio of particulates to resin or binder may range up to about 1.1:1, and in one embodiment about 0.7:1 to about 1.1:1, and in one embodiment from about 0.7:1 to about 0.9:1, and in one embodiment about 0.9:1 to about 1.1:1.

[0048] The release coating layers **136** and **176** may independently comprise any release coating composition known in the art. Silicone release coating compositions may be used. The silicone release coating compositions typically comprise polyorganosiloxanes such as polydimethylsiloxanes. The silicone release coating composition used in this invention may be room temperature cured, thermally cured, or radiation cured. Generally, the room temperature and thermally curable compositions comprise at least one polyorganosiloxane and at least one catalyst (or curing agent) for such polyorganosiloxane(s). These compositions may also contain at least one cure accelerator and/or adhesivity promoter. As is known in the art, some materials have the capability of performing both functions, i.e., the capability of acting as a cure accelerator to increase the rate, reduce the curing temperature, etc., and also as an adhesivity promoter to improve bonding of the silicone composition to the substrate. The use of such dual function additives where appropriate is within the purview of the invention.

[0049] In the embodiments illustrated in FIGS. 1-5, the release force required to separate release coating layer **135** from dry paint film layer **110** or transparent film layer **140** is advantageously greater than the release force required to separate release coating layer **136** from adhesive layer **120**. In one embodiment, the release force required to separate release coating layer **135** from dry paint film layer **110** or transparent film layer **140** is in the range of about 20 to about 180 grams per two inches (g/2 in), and in one embodiment about 70 to about 90 g/2 in. In one embodiment, the release force required to separate release coating layer **136** from adhesive layer **120** is in the range of about 30 to about 150 g/2 in, and in one embodiment about 30 to about 100 g/2 in, and in one embodiment about 30 to about 70 g/2 in. The test

method for determining these release forces involves measuring the force required to separate a two-inch wide release coated liner from an adhesive coated substrate with the release coated liner extending at an angle of 90° relative to the substrate and being pulled at a rate of 300 inches per minute.

[0050] In the embodiment illustrated in FIG. 6, the release force required to separate release coating layer **135** from dry paint film layer **110** is advantageously greater than the release force required to separate release coating layer **176** from adhesive layer **120**.

[0051] Each of the layers **110**, **120**, **135**, **136**, **140** and **176** may be applied and dried and/or cured using known techniques. The application techniques include gravure, reverse gravure, offset gravure, roll coating, brushing, knife-over roll, metering rod, reverse roll coating, doctor knife, dipping, die coating, slot die coating, spraying, curtain coating, slide coating, slide curtain coating, extrusion, co-extrusion, flexographic, letter press, rotary screen, flat screen, and the like. In one embodiment, the adhesive layer **120** is a pressure sensitive adhesive layer and it may be applied using transfer lamination. The decorative layers **150** and **160** may be applied using known printing techniques including gravure, flexographic, silk screen, ink jet, etc. The applied layers may be dried and/or cured by exposure to heat or to known forms of ionizing or actinic non-ionizing radiation. Drying or curing temperatures that may be used may range from about 115° C. to about 160° C., and in one embodiment about 140° C. to about 150° C. Useful types of radiation include ultraviolet light and electron beam. The equipment for generating these forms of thermal or radiation drying and/or curing are well known to those skilled in the art.

[0052] The dry paint transfer laminate **100** illustrated in FIG. 1 may be made by applying release coating **136** to lower surface **134** of backing liner **132** using one of the foregoing application techniques and then curing the release coating. The coat weight for the release coating layer **136** may be in the range of about 0.1 to about 1 gram per square meter (gsm), and in one embodiment about 0.25 to about 0.35 gsm. Release coating layer **135** is then applied to upper surface **133** of backing liner **132** using one of the above indicated application techniques (e.g., gravure) and then dried or cured. The coat weight for the release coating **135** may range from about 2.5 to about 6.5 gsm, and in one embodiment about 4.5 to about 5.5 gsm. The liquid paint or coating composition for forming dry paint film layer **110** is then applied to the surface of release coating layer **135** using one of the above indicated application techniques (e.g., reverse roll or slot die) and then dried or cured. The coat weight for the dry paint film layer **110** may range from about 20 to about 60 gsm, and in one embodiment about 30 to about 40 gsm. One or more coats may be applied. Pressure sensitive adhesive layer **120** is then applied to upper surface **112** of dry paint film layer **110** using one of the above indicated application techniques (e.g., slot die) and then dried or cured. The pressure sensitive adhesive may be applied using transfer lamination. The coat weight for the pressure sensitive adhesive layer **120** may range from about 10 to about 30 gsm, and in one embodiment about 11 to about 17 gsm. The dry paint transfer laminate **100** may then be wound into roll form as illustrated in FIG. 2 using known techniques.

[0053] The dry paint transfer laminate 100A illustrated in FIG. 3 may be made using the same procedure used for making the laminate 100 except that transparent film layer 140 is applied to the surface of release coating layer 135 and then dried or cured prior to the application of the dry paint film layer 110. The dry paint film layer 110 is then applied to the surface of the transparent film layer 140. The transparent film layer 140 may be applied using one of the foregoing application techniques (e.g., gravure). The coat weight for the transparent film layer 140 may range from about 1 to about 5 gsm, and in one embodiment about 2.5 to about 3.5 gsm. One or more coats may be applied.

[0054] The dry paint transfer laminate 100B illustrated in FIG. 4 may be made using the same procedure used for making the laminate 100A except that the liquid paint composition for forming the printed decorative layer 150 is applied to the surface of the transparent film layer 140 and then cured prior to the application of the dry paint film layer 110. The dry paint film layer 110 is then applied to the surface of the printed decorative layer 150. The printed decorative layer 150 may be applied using any of the foregoing printing techniques (e.g., gravure, flexographic, silk screen, ink jet, etc.). The coat weight for the printed decorative layer 150 may range from about 0.3 to about 2 gsm, and in one embodiment about 0.3 to about 0.7 gsm.

[0055] The dry paint transfer laminate 100C illustrated in FIG. 5 may be made using the same procedure used for making the laminate 100B except that the liquid paint composition for forming the second printed decorative layer 160 is applied to the surface of the transparent film layer 140 and then dried or cured prior to the application of the printed decorative layer 150. The printed decorative layer 150 is then applied over the surface of the second printed decorative layer 160. The second printed decorative layer 160 may be applied using any of the foregoing printing techniques (e.g., gravure, flexographic, silk screen, ink jet, etc.). The coat weight for the second printed decorative layer 160 may range from about 0.3 to about 2 gsm, and in one embodiment about 0.3 to about 0.7 gsm.

[0056] The dry paint transfer laminate 100D illustrated in FIG. 6 may be made using the same procedure used for making the laminate 100 illustrated in FIG. 1 except that release liner 170 is adhered to adhesive layer 120 with release coating layer 176 in contact with adhesive layer 120.

[0057] The dry paint transfer laminate 100 may be used by unrolling the laminate from the roll illustrated in FIG. 2, and simultaneously applying the laminate to the substrate (e.g., wall) to be covered. The substrate may comprise any flat surface. The flat surface may comprise wall board, plastic sheet, metal sheet, composites, and the like. The substrate may comprise an interior (i.e., indoor) surface or an exterior (i.e., outdoor) surface. The laminate is placed over the substrate with the adhesive layer 120 in contact with the substrate. The release liner 130 is then peeled off leaving the dry paint film layer 110 adhered to the substrate by the adhesive layer 120. An advantage of using this laminate, at least in one embodiment, is that it is possible to overlap part of the applied dry paint film layer with the next adjacent applied dry paint film layer due to the fact that the seams substantially disappear and therefore are not noticeable. This advantage is provided at least in part due to the fact that the dry paint film layer 110 is relatively thin.

[0058] The dry paint transfer laminate 100A may be applied to a substrate in the same manner as the laminate 100. When the release liner 130 is peeled off, the dry paint film layer 110, transparent film layer 140, and adhesive layer 120 remain adhered to the substrate with the adhesive layer 120 in contact with the substrate.

[0059] The dry paint transfer laminate 100B may be applied to a substrate in the same manner as the laminate 100. When the release liner 130 is peeled off, the dry paint film layer 110, printed decorative layer 150, transparent film layer 140, and adhesive layer 120 remain adhered to the substrate with the adhesive layer 120 in contact with the substrate.

[0060] The dry paint transfer laminate 100C may be applied to a substrate in the same manner as the laminate 100. When the release liner 130 is peeled off, the layers 110, 150 and 160, transparent film layer 140, and adhesive layer 120 remain adhered to the substrate with the adhesive layer 120 in contact with the substrate.

[0061] The dry paint transfer laminate 100D may be applied to a substrate in the same manner as the laminate 100 except that the laminate is advantageously provided in the form of a flat sheet rather than a roll and the release liner 170 is peeled off before the adhesive layer 120 is adhered to the substrate.

EXAMPLES 1 AND 2

[0062] A polyethylene terephthalate film backing liner corresponding to backing liner 132 is coated on one side with a silicone release coating corresponding to second release coating layer 136. The thickness of the release coated liner is 0.92 mil.

[0063] A matte release coat corresponding to first release coating layer 135 is applied to the other side of the backing liner using gravure at a coat weight of 6.5-7.75 gsm. The formulation for the matte release coat is as follows: 26% by weight methylisobutyl ketone, 6% by weight isopropanol, 34.8% by weight Lankyd 13-1425 (a product supplied by Akzo Resins identified as an acrylic modified alkylid), 2.6% by weight Elvacite 2042 (a product supplied by Lucite International identified as a polyethyl methacrylate polymer), 30% by weight Microtalc MP 15-38 (a product supplied by Barrett's Minerals identified as a talc extender pigment), 2.5% by weight Cypac 4040 (a product supplied by Cytec identified as paratoluene sulfonic acid) and 8.7% by weight Cymel 303 (a product supplied by Cytec identified as a melamine resin). The matte release coat is dried using forced hot air at a temperature of 149° C.

[0064] A transparent film layer corresponding to transparent film layer 140 is applied to the matte release coat using gravure at a coat weight of 2.7-2.9 gsm and dried using forced hot air at a temperature of 120° C. The formulation for the transparent film layer is as follows: 46.7% by weight methyl ethyl ketone, 31.3% by weight toluene, 11% by weight VYNS (a product of Union Carbide identified as a vinyl chloride/vinyl acetate copolymer containing 5-20% by weight vinyl acetate), and 11% by weight Vitel 2200B (a product of Bostic identified as a polyester copolymer).

[0065] The following paint compositions are used to form a dry paint film layer corresponding to dry paint film layer 110 on the transparent film layer, one for Example 1 and the

other for Example 2. Example 1 has a deep brown tone, while Example 2 has an orange pastel tone. In the following table, all numerical values are in parts by weight.

	Example 1	Example 2
Methylethyl ketone	66.7	66.7
Toluene	33.3	33.3
VYHH (product of Union Carbide identified as a vinyl chloride/vinyl acetate copolymer)	50.05	30.55
Edinol 9790 (a product of Cognis identified as a polyester plasticizer)	24.65	15.05
Yellow pigment 42 (iron oxide)	17.8	2.3
Orange pigment 36 (monoazo benzimidazole)	2.5	0.38
Black 7 (carbon black)	0.1	0.02
White 6 (titanium dioxide)	4.9	51.7

[0066] The pigment volume ratio for Example 1 is 10%, and for Example 2 it is 27%. The above paint formulations are applied to the transparent film layer using a reversed roller coater and dried at a temperature of 135° C. to drive off the solvents. The dry film thickness of each of the dry paint film layers is 0.7 mil.

[0067] A pigmented pressure sensitive adhesive is then applied to the dry paint film layer at a coat weight of 14-20 gsm using transfer lamination to provide an adhesive layer corresponding to pressure sensitive adhesive layer 120. The formulation for the pressure sensitive adhesive is as follows: 70-90% by weight 2-ethylhexyl acrylate, 1-10% by weight acrylic acid, 10-20% by weight methyl acrylate, 3.7% UCD 1106E (a product of Rohm and Haas identified as a titanium dioxide dispersion concentrate), and 0.3% by weight of UCD 1507E (a product of Rohm and Haas identified as a carbon black dispersion concentrate).

EXAMPLE 3

[0068] The procedure used for Examples 1 and 2 is repeated except that the following liquid paint composition is used to form the dry paint film layer corresponding to dry paint film layer 110. In the following table, all numerical values are in parts by weight.

Methylethyl ketone	29.6
Toluene	19.5
Vitel 2200 B	11.6
Vitel 2650 (product of Bostic identified as a polyester copolymer)	11.5
R-900 (product of DuPont identified as titanium dioxide)	27.5
955-39230 (product of Gibraltar Chemical Works identified as shading black)	0.2
99-34520 (product of Gibraltar Chemical Works identified as phthalo blue GS)	0.1
955-37470 (product of Gibraltar Chemical Works identified as carbazole violet)	tint

The foregoing paint composition has a light blue color. The dry film thickness of the dry paint film layer is 0.6-0.8 mil.

EXAMPLE 4

[0069] A polyethylene terphthalate film backing liner corresponding to backing liner 132 is coated on one side with

a silicone release coating corresponding to second release coating layer 136. The thickness of the release coated liner is 0.92 mil.

[0070] A matte release coat corresponding to first release coating layer 135 is applied to the other side of the backing liner using gravure at a coat weight of 4.4-4.6 gsm. The formulation for the matte release coat is as follows: 50.54% by weight methylisobutyl ketone, 7.84% by weight isopropanol, 8.93% by weight Lankyd 13-1425, 10.68% by weight VAGH (product of Union Carbide identified as hydroxy modified polyvinyl chloride/polyvinyl acetate copolymer), 22% by weight Microtalc MP 15-38, 2% by weight Cycat 4040, and 6.8% by weight Cymel 303. The matte release coat is dried using forced hot air at a temperature of 149° C.

[0071] A first coat of a transparent film layer corresponding to transparent film layer 140 is applied to the matte release coat using gravure at a coat weight of 1.3-2 gsm and dried using forced hot air at a temperature of 120° C. The dry film thickness is 0.05-0.1 mil. The formulation for this first transparent film layer coat is as follows: 41.5% by weight methyl ethyl ketone, 41.5% by weight methyl isobutyl ketone, and 17% by weight Elvacite 2042 (a product of Lucite International identified as a polymethyl methacrylate).

[0072] A second coat of a transparent film layer corresponding to transparent film layer 140 is applied over the first coat of transparent film layer using gravure at a coat weight of 1.0-1.5 gsm and dried using forced hot air at a temperature of 120° C. The dry film thickness is 0.03-0.7 mil. The formulation for this second transparent film layer coat is as follows: 41.5% by weight methyl ethyl ketone, 41.5% by weight methyl isobutyl ketone, and 17% by weight VYHH (a product of Union Carbide identified as a vinyl chloride/vinyl acetate copolymer containing 5-20% by weight vinyl acetate).

[0073] A decorative layer corresponding to second printed decorative layer 160 is printed over the second coat of the transparent coating layer at a coat weight of 3.0-3.2 gsm and dried in hot air at a temperature of 120° C. The paint composition used for this decorative layer has the following formulation (all numerical values are in parts by weight):

Methylethyl ketone	42.6
Methyl isobutyl ketone	38.7
VYHH	15.86
DP 80110 (product of Gibraltar Chemical Works identified as containing methylethyl ketone, toluene, carbon black and acrylic polymer)	2.1
DP 36640 (product of Gibraltar Chemical Works identified as containing methyl ethyl ketone, toluene, quinaacidone red, and acrylic polymer)	0.22
I8977 (product of Gibraltar Chemical Works identified as containing methyl ethyl ketone, toluene, R.S. Phthalo Blue, and acrylic polymer)	0.10
I8980 (product of Gibraltar Chemical Works identified as containing methyl ethyl ketone, toluene, isoindolinone yellow and acrylic polymer)	0.38

[0074] A decorative layer corresponding to printed decorative layer 150 is printed over the above indicated decora-

tive layer corresponding to second printed decorative layer **160** at a coat weight of 0.8 gsm and dried in hot air at a temperature of 120° C. The paint composition used for this decorative layer has the following formulation (all numerical values are in parts by weight):

Methylethyl ketone	42.85
Methyl isobutyl ketone	39.1
VYHH	16.0
DP 80110	1.71
DP 36640	0.18
18977	0.18

[0075] The following paint composition is coated over the above indicated decorative layer corresponding to printed decorative layer **150** at a coat weight of 30-32 gsm and dried in hot air at a temperature of 120° C. to provide a dry paint film layer corresponding to dry paint film layer **110**. In the following table, all numerical values are in parts by weight.

Methyl ethyl ketone	34
Toluene	16.7
VYHH	18.3
Edinol 9790	9
AVI-0301-3 Orange (product of Gibraltar Chemical Works identified as containing methyl ethyl ketone, toluene, diarylide orange, VYHH and Edinol 9790)	8.9
AVI-0301-5 Magenta (product of Gibraltar Chemical Works identified as containing methyl ethyl ketone, toluene, Metal Azo Red, VYHH and Edinol 9790)	5.3
AVI-0301-6 Iron Red (product of Gibraltar Chemical Works identified as containing methyl ethyl ketone, toluene, Iron Oxide Red, VYHH and Edinol 9790)	3.7
AVI-0301-1 TiO ₂ White (product of Gibraltar Chemical Works identified as containing methyl ethyl ketone, toluene, titanium dioxide, VYHH and Edinol 9790)	3.52
AVI-0301-2 Carbon Black (product of Gibraltar Chemical Works identified as containing methyl ethyl ketone, toluene, carbon black, VYHH and Edinol 9790)	0.03

[0076] A pigmented pressure sensitive adhesive is then applied over the dry paint film layer corresponding to dry paint film layer **110** at a coat weight of 17 gsm using transfer lamination to provide an adhesive layer corresponding to pressure sensitive adhesive layer **120**. The formulation for the pressure sensitive adhesive is as follows: 96% by weight of a non-tackified acrylic emulsion containing a crosslinked copolymer of butyl acrylate and ethyl hexyl acrylate, 3.7% by weight UCD 1106E, and 0.3% by weight UCD 1507E.

EXAMPLE 5

[0077] A polyethylene terphthalate film backing liner corresponding to backing liner **132** is coated on one side with a silicone release coating corresponding to second release coating layer **136**. The thickness of the release coated liner is 0.92 mil.

[0078] A matte release coat corresponding to first release coating layer **135** is applied to the other side of the backing liner using gravure at a coat weight of 4.4-4.6 gsm. The

matte release coat is dried using forced hot air at a temperature of 149° C. The formulation for the matte release coat is as follows (all numerical values are in parts by weight):

Methyl isobutyl ketone	52.54
Elvacite 4402 (product of Lucite International identified as hydroxy ethyl methacrylate modified acrylic resin)	20.98
VYNS	1.35
Microtalc 15-38	22.85
Byk 451 (product supplied by Byk Chemie identified as blocked acid catalyst)	2.2
Cymel 303	6.38

[0079] A transparent film layer corresponding to transparent film layer **140** is applied to the matte release coat using a reverse roll coater at a coat weight of 13 gsm and dried using forced hot air at a temperature of 120° C. The dry film thickness is 0.4 mil. The formulation for the transparent film layer coat is as follows (all numerical values are in parts by weight):

Rucothane CO-A-5002L (product of Ruco Chemical identified as polyester urethane)	62.5
Toluene	18.75
Isopropanol	18.75

[0080] A decorative layer corresponding to printed decorative layer **150** is printed over the above indicated transparent film layer at a coat weight of 1 gsm and dried in hot air at a temperature of 120° C. The paint composition used for this decorative layer has the following formulation (all numerical values are in parts by weight):

Methyl ethyl ketone	25.67
Methyl isobutyl ketone	22.0
VYHH	9.17
I8980	3.5
DP 37251 (product of Gibraltar Chemical Works identified as containing perylene red, methyl ethyl ketone, toluene and acrylic polymer)	0.99
DP80110	1.0
DP39600 (product of Gibraltar Chemical Works identified as containing TiO ₂ , methyl ethyl ketone, toluene and acrylic polymer)	37.47
18977	0.20

[0081] The following paint composition is coated over the above indicated decorative layer corresponding to printed decorative layer **150** at a coat weight of 66 gsm and dried in hot air at a temperature of 138° C. to provide a dry paint film layer corresponding to dry paint film layer **110**. In the following table, all numerical values are in parts by weight:

Methyl isobutyl ketone	24.11
Toluene	20.65
VYHH	11.54
R-900	38.4
Acroloid B-72 (product of Rohm and Haas identified as an acrylic resin)	3.86
I8980	2.6
DP37251	0.21
DP80110	0.40

[0082] A pressure sensitive adhesive is then applied over the dry paint film layer corresponding to dry paint film layer **110** at a coat weight of 15-20 gsm using transfer lamination to provide an adhesive layer corresponding to pressure sensitive adhesive layer **120**. The pressure sensitive adhesive is a non-tackified acrylic emulsion. The formulation for the pressure sensitive adhesive is as follows: 70-90% by weight 2-ethylhexyl acrylate, 1-10% by weight acrylic acid, and 10-20% by weight methyl acrylate.

EXAMPLE 6

[0083] A polyethylene terphthalate film backing liner corresponding to backing liner **132** is coated on one side with a silicone release coating corresponding to second release coating layer **136**. The thickness of the release coated liner is 0.92 mil.

[0084] A matte release coat corresponding to release coating layer **135** is applied to the other side of the backing liner using gravure. The release coat is dried using forced hot air at a temperature of 148.9° C. The matte release coat is applied at a coat weight of 4.0-5.0 gsm. The formulation for the matte release coat is as follows (all numerical values are in parts by weight):

Methyl isobutyl ketone	42.03
Isopropanol	8.51
Microtalc 15-38	23.87
Cymel 303	7.36
Cycat 4040	1.8
VROH (product supplied by Union Carbide identified as a vinyl chloride/vinyl acetate copolymer with OH functionality)	16.43

[0085] A transparent film layer corresponding to transparent film layer **140** is applied over Matte Release Coat No. 2 using a 2 mil byrd bar at a coat weight of 30 gsm and dried using hot air at a temperature of 126.7° C. The formulation for the transparent film layer is as follows (all numerical values are in parts by weight):

Water	7.98
N-methyl pyrrolidone	4.79
Texanol (product of Eastman Chemicals identified as an ester alcohol)	4.79
BYK 333 (product of Byk Chemie identified as a wetting agent)	0.4

-continued

Vycar 351 (product of Noveon identified as a polyvinyl chloride copolymer emulsion)	79.81
Antifoam PD-218 (product of Magrabar Chemical identified as an antifoam agent)	0.32
Rheolate 350 (product of Rheox, Inc. identified as a thickener)	1.92

[0086] The following paint composition is coated over the above indicated transparent film at a coat weight of 96 gsm and dried in hot air at a temperature of 126.7° C. to provide a dry paint film layer corresponding to dry paint film layer **110**. In the following table, all numerical values are in parts by weight:

Water	18.28
Surfynol CT-324 (product of Air Products identified as a surfactant)	0.98
R-900	32.88
Vycar 460X45 (product of Noveon identified as a vinyl chloride/acrylic copolymer)	34.72
Vycar 460X46 (product of Noveon identified as a vinyl chloride/acrylic copolymer)	11.57
Antifoam PD-218	0.19
Byk 333	0.23
Rheolate 350	1.2

[0087] A pressure sensitive adhesive is then applied over the dry paint film layer corresponding to dry paint film layer **110** at a coat weight of 17 gsm using transfer lamination to provide an adhesive layer corresponding to pressure sensitive adhesive layer **120**. The formulation for the pressure sensitive adhesive is as follows: 96% by weight of a non-tackified emulsion containing a crosslinked copolymer of butyl acrylate and ethyl hexyl acrylate, 3.7% by weight UCD 1106E, and 0.3% by weight UCD 1507E.

EXAMPLE 7

[0088] A polyethylene terphthalate film backing liner corresponding to backing liner **132** is coated on one side with a silicone release coating corresponding to second release coating layer **136**. The thickness of the release coated liner is 0.92 mil.

[0089] A matte release coat corresponding to first release coating layer **135** is applied to the other side of the backing liner using gravure at a coat weight of 4.4-4.6 gsm. The formulation for the matte release coat is as follows: 50.54% by weight methylisobutyl ketone, 7.84% by weight isopropanol, 8.93% by weight Lankyd 13-1425, 10.68% by weight VAGH (product of Union Carbide identified as hydroxy modified polyvinyl chloride/polyvinyl acetate copolymer), 22% by weight Microtalc MP 15-38, 2% by weight Cycat 4040, and 6.8% by weight Cymel 303. The matte release coat is dried using forced hot air at a temperature of 149° C.

[0090] A transparent film layer corresponding to transparent film layer **140** is applied to the matte release coat using gravure at a coat weight of 12-16 gsm and dried using forced hot air at a temperature of 165° C. The dry film thickness is 0.35-0.5 mil. The formulation for this transparent film layer is as follows (all numerical values are in parts by weight)

Cyclohexanone	69.3
Elvacite 2042	10.5
Solsperse 17000 (product of Avecia identified as a wetting agent)	0.1
Tinuvin 234 (product of Ciba identified as a light stabilizer)	0.6
Kynar 301F (product of Atofina identified as a polyvinyl fluoride homopolymer)	27.0
N-methyl-2-pyrrolidone	2.5

[0091] A decorative layer corresponding to second printed decorative layer **160** is printed over the transparent coating layer at a coat weight of 0.3-1.2 gsm and dried in hot air at a temperature of 105° C. The paint composition used for this decorative layer has the following formulation (all numerical values are in parts by weight):

Methylethyl ketone	36.0
Methyl propyl ketone	35.1
Kynar 7201 (SL) (product of Atofina identified as a polyvinyl fluoride copolymer)	10.2
Elvacite 2010 (product of Lucite International identified as a polymethyl methacrylate)	3.4
Tinuvin 234	0.27
DP35740 (product of Gibraltar Chemical Works identified as a buff mixed metal oxide pigment concentrate)	0.10
DP35820 (product of Gibraltar Chemical Works identified as a brown mixed metal oxide pigment concentrate)	11.7
DP39040 (product of Gibraltar Chemical Works identified as a black mixed metal oxide pigment concentrate)	3.3

[0092] A decorative layer corresponding to printed decorative layer **150** is printed over the above indicated decorative layer corresponding to second printed decorative layer **160** at a coat weight of 0.3-1.2 gsm and dried in hot air at a temperature of 105° C. The paint composition used for this decorative layer has the following formulation (all numerical values are in parts by weight):

Methylethyl ketone	34.0
Methyl propyl ketone	33.0
Kynar 7201 (SL)	9.6
Elvacite 2010	3.2
Tinuvin 234	0.25
DP35740	14.4
DP35820	5.0
DP39040	3.2

[0093] The following paint composition is coated over the above indicated decorative layer corresponding to printed decorative layer **150** at a coat weight of 6-10 gsm and dried in hot air at a temperature of 105° C. to provide a dry paint film layer corresponding to dry paint film layer **110**. In the following table, all numerical values are in parts by weight.

Methyl ethyl ketone	27.6
Methyl propyl ketone	26.3
Kynar 7201 (SL)	7.4
Elvacite 2010	2.5
Tinuvin 234	0.2
DP35740	4.1
DP35820	7.8
DP39040	0.6
DP39600 (product of Gibraltar Chemical Works identified as a white titanium dioxide pigment concentrate)	23.6

[0094] A pigmented pressure sensitive adhesive is then applied over the dry paint film layer corresponding to dry paint film layer **110** at a coat weight of 17 gsm using transfer lamination to provide an adhesive layer corresponding to pressure sensitive adhesive layer **120**. The formulation for the pressure sensitive adhesive is as follows: 96% by weight of a non-tackified acrylic emulsion containing a crosslinked copolymer of butyl acrylate and ethyl hexyl acrylate, 3.7% by weight UCD 1106E, and 0.3% by weight UCD 1507E.

[0095] While the invention has been explained in relation to its preferred embodiments, it is to be understood that various modifications thereof will become apparent to those skilled in the art upon reading the specification. Therefore, it is to be understood that the invention disclosed herein is intended to cover such modifications as fall within the scope of the appended claims.

1. A dry paint transfer laminate, comprising:

a dry paint layer which includes a color layer comprising a binder and a pigment, the dry paint layer having an upper surface and a lower surface;

an adhesive layer overlying the upper surface of the dry paint layer; and

a release liner overlying the lower surface of the dry paint layer, the release liner comprising a backing liner and a first release coating layer, the backing liner having an upper surface and a lower surface, the first release coating layer being adhered to the upper surface of the backing liner and overlying the lower surface of the dry paint layer, the first release coating layer comprising an alkyd resin and/or a vinyl resin cross-linked with a melamine resin.

2. The laminate of claim 1 wherein a transparent film layer is positioned between the lower surface of the dry paint layer and the first release coating layer.

3. The laminate of claim 1 wherein a printed decorative layer is positioned between the lower surface of the dry paint layer and the first release coating layer.

4. The laminate of claim 3 wherein a transparent film layer is positioned between the printed decorative layer and the first release coating layer.

5. The laminate of claim 3 wherein a second printed decorative layer is positioned between the printed decorative layer and the first release coating layer.

6. The laminate of claim 5 wherein a transparent film layer is positioned between the second printed decorative layer and the first release coating layer.

7. The laminate of claim 1 wherein a second release coating layer overlies the lower surface of the backing liner.

8. The laminate of claim 1 wherein another release liner overlies the adhesive layer.

9. The laminate of claim 1 wherein the alkyd resin is formed by the condensation of one or more polyhydric alcohols with one or more polybasic acids or anhydrides.

10. The laminate of claim 9 wherein the polybasic alcohol is glycerol.

11. The laminate of claim 9 wherein the polybasic anhydride is phthalic anhydride.

12. The laminate of claim 9 wherein the alkyd resin is a modified alkyd wherein the polybasic acid is substituted in part by a monobasic acid.

13. The laminate of claim 12 wherein the monobasic acid is acrylic acid or a vegetable oil fatty acid.

14. The laminate of claim 1 wherein the vinyl resin comprises polyvinyl chloride, polyvinyl acetate, copolymer of vinyl chloride and vinyl acetate, acrylic resin, methacrylic resin or polystyrene resin.

15. The laminate of claim 1 wherein the melamine resin comprises an amino resin made by the condensation of melamine with formaldehyde or a compound capable of providing methylene bridges.

16. The laminate of claim 1 wherein the alkyd resin is an acrylic modified alkyd resin.

17. The laminate of claim 1 wherein the vinyl resin comprises an ethyl methacrylate polymer, a vinyl chloride/vinyl acetate copolymer, a hydroxy modified vinyl chloride/vinyl acetate copolymer, or a hydroxy ethyl methacrylate modified acrylic polymer.

18. The laminate of claim 1 wherein the first release coating is derived from a composition which comprises on a solids basis from zero to about 80% by weight of an alkyd resin, from zero to about 80% by weight of a vinyl resin, and from about 10% to about 30% by weight of a melamine resin.

19. The laminate of claim 1 wherein the first release coating contains one or more solid particulates that project into the dry paint layer.

20-22. (canceled)

23. The laminate of claim 19 wherein the solid particulates comprise talc or aluminum silicate.

24. The laminate of claim 19 wherein the solid particulates have platelet shapes.

25-60. (canceled)

61. A dry paint transfer laminate, comprising:

a dry paint layer which includes a color layer comprising a binder and a pigment, the dry paint layer having an upper surface and a lower surface;

an adhesive layer overlying the upper surface of the dry paint layer; and

a release liner overlying the lower surface of the dry paint layer, the release liner comprising a backing liner and a first release coating layer, the backing liner having an upper surface and a lower surface, the first release coating layer being adhered to the upper surface of the backing liner and the lower surface of the dry paint layer, the release force required to separate the release liner from the dry paint layer being in the range from about 20 to about 180 grams per two inches, wherein a two-inch wide sample of the release liner is separated from the dry paint layer by being pulled at an angle of about 90° and at a rate of about 300 inches per minute.

62-104. (canceled)

105. A dry paint transfer laminate, comprising:

a dry paint layer which includes a color layer comprising a binder and a pigment, the dry paint layer having an upper surface and a lower surface;

an adhesive layer overlying the upper surface of the dry paint layer;

a transparent film layer overlying the lower surface of the dry paint layer, the transparent film layer having an upper surface and a lower surface;

a release liner overlying the lower surface of the transparent film layer, the release liner comprising a backing liner and a first release coating layer, the backing liner having an upper surface and a lower surface, the first release coating layer being adhered to the upper surface of the backing liner and the lower surface of the transparent film layer, the release force required to separate the release liner from the transparent film layer being in the range from about 20 to about 180 grams per two inches, wherein a two-inch wide sample of the release liner is separated from the transparent film layer by being pulled at an angle of about 90° and at a rate of about 300 inches per minute.

106-153. (canceled)

154. A dry paint transfer laminate, comprising:

a dry paint layer which includes a color layer comprising a binder and a pigment, the dry paint layer having an upper surface and a lower surface, the dry paint layer being derived from a liquid composition having a pigment volume concentration in the range from about 5% to about 35%;

an adhesive layer overlying the upper surface of the dry paint layer; and

a release liner overlying the lower surface of the dry paint layer.

155-206. (canceled)

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