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Divisional Application
to European Patent Application No. 90 117 765.9 ✓

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IMAGE FORMING METHOD ✓

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Image forming method - 1 -

1 Electrostatic Image Developing Toner and
 Process for its Production, and Binder
 Resin and Process for its Production

5 BACKGROUND OF THE INVENTION

Field of the invention

 The present invention relates to ~~a toner for~~
~~developing an electrostatic image (electrostatically~~
~~charged image)~~, used in an image forming ^{method} ~~process~~ such
10 as electrophotography, electrostatic recording or
 magnetic recording, ~~and a process for producing such a~~
~~toner. The present invention also relates to a binder~~
~~resin and a process for producing it.~~

Related Background Art

15 Methods as disclosed in U.S. Patent No.
 2,297,691, Japanese Patent Publications No. 42-23910
 and No. 43-24748 and so forth are conventionally known
 as electrophotography. In general, copies are
 obtained by forming an electrostatic latent image on a
20 photosensitive member, utilizing a photoconductive
 material and according to various means, subsequently
 developing the latent image by the use of a toner, and
 transferring the toner image to a transfer medium such
 as paper if necessary, followed by fixing by the
25 action of heat, pressure, heat-and-pressure, or
 solvent vapor. In the case when the process comprises



1 a toner-image transfer step, the process is usually
provided with the step of removing the toner remaining
on a photosensitive member.

As developing processes in which an
5 electrostatic latent image is formed into a visible
image by the use of a toner, known methods include the
magnetic brush development as disclosed in U.S. Patent
No. 2,874,063, the cascade development as disclosed in
U.S. Patent No. 2,618,552, the powder cloud
10 development as disclosed in U.S. Patent No. 2,221,776,
and the method in which a conductive magnetic toner is
used, as disclosed in U.S. Patent No. 3,909,258.

As toners used in these development processes,
fine powder obtained by dispersing a dye and/or
15 pigment in a natural or synthetic resin has been
hitherto used. For example, particles formed by
finely grinding a binder resin such as polystyrene
comprising a colorant dispersed therein, to have a
size of about 1 to 30 μ are used as the toner. A
20 toner incorporated with magnetic material particles
such as magnetite is also used as the magnetic toner.
On the other hand, in a system in which a two-
component type developer is used, the toner is used as
a mixture with carrier particles such as glass beads,
25 ion powder and ferrite particles.

Nowadays, such recording processes have been

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1 widely utilized not only in commonly available copying
machines, but also in printers for output information
from a computer, or for the printing of microfilms (or
copying from microfilms). Accordingly, a higher
5 performance has become required, and the above
recording processes have now been required to
simultaneously achieve the improvements in performance
such that an apparatus is made small-sized,
lightweight, low-energy, high-speed, maintenance-free,
10 and personal. In order to meet these requirements,
the needs on toners have become severe in various
aspects.

For example, with wide application of the
recording processes and wide use thereof in usual
15 offices or homes as mentioned above, it has become
necessary of course for toners to have safety as
materials and besides for manufacturers to pay
attention to odors thereof that are generated in the
course of fixing.

20 For example, with wide application of the
recording processes such as electrophotography and
wide use thereof in usual offices or homes as
mentioned above, it has become necessary, of course,
for developers to have safety as materials and besides
25 for manufacturers to take care of odors thereof that
are generated in the course of fixing. In most



1 instances, deodorizing filters for adsorbing odors or
ozone are attached to copying machines, printers and
so forth. This is not only disadvantageous for
production cost, but also troublesome for the
5 maintenance of deodorizing power because of periodical
replacement of filters.

With regard to this problem of odors, this is
of course an important problem when the standpoints of
users or manufacturers are taken into consideration.

10 In general, it is by no means easy from technical
viewpoints to solve this problem, when viewed from a
fixing method in which a toner containing a synthetic
resin as a main component is fixed on a transfer
medium such as paper by utilizing the action of
15 softening and melting by heat. It is not advisable to
lower, for example, development performances such as
image quality and durability of toner in order to
solve this problem.

Various methods have been proposed so that
20 these performances can be satisfied at the same time.
However, a method in which an additive is used may
often cause unexpected problems.

For this reason, it is preferred to improve a
binder resin itself. For the purpose of such an
25 improvement, it is considered better to decrease the
amount of a residual solvent or residual polymerizable



1 monomers that produce odors. Various methods have
been hitherto proposed for it with concurrent
attention to the influence on other development
performances.

5 For example, Japanese Patent Application Laid-
Open No. 55-155632 proposes that a polymer in which
the content of a solvent used for obtaining the
polymer or that of polymerizable monomers is less than
0.1 % by weight is used as a binder resin for a toner
10 so that the offset resistance, storage stability and
fluidity of the toner can be improved.

Japanese Patent Application Laid-Open No. 53-
17737 also discloses that residual polymerizable
monomers have influence on the triboelectricity,
15 blocking resistance and fixing properties of a toner,
and proposes to decrease a residual solvent or
residual polymerizable monomers of the solvent or
monomers used for obtaining a polymer as a binder
resin to be used for a toner.

20 Japanese Patent Application Laid-Open No. 64-
70765 also proposes a resin for a toner containing 200
ppm or less of residual monomers, in order to cope
with the problems that a work environment becomes poor
because of the odors generated when toner materials
25 are melted and kneaded or that odors are generated at
the time of copying to give unpleasantness. This



1 publication also discloses that an amount more than
200 ppm of residual monomers may result in a lowering
of blocking resistance and resistance to a vinyl
chloride plasticizer, leaving the problem of odors.

5 When, however, the problem is particularly
focused on the odors, it can not be said to be
sufficient to only decrease the amount of residual
polymerizable monomers, when taking account of the
possibility of wider application in future, of the
10 image forming method such as electrophotography and
electrostatic recording method.

In general, methods of polymerizing binder
resins for toners are known to include solution
polymerization, bulk polymerization and suspension
15 polymerization.

In particular, as disclosed in Japanese
Patent Application Laid-Open No. 63-223014, the
suspension polymerization requires no removal of a
solvent and also requires no strong stirrer, and hence
20 enables easy production of a resin. It also makes it
possible for a resin to be allowed to contain in any
desired amount of a THF-insoluble component that has
great influence on the fixing properties and offset
resistance of a toner. Thus, this is a preferable
25 method.

In the suspension polymerization, however, the

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1 resin is obtained in the form of beads. Hence, it has
no step of removing a solvent or polymerizable
monomers that remain in solution polymerization in
which a resin is in a molten state, and instead merely
5 has a drying step carried out for the purpose of
removing water content. As a result, solvents or
polymerizable monomers tend to remain in a large
quantity, and therefore it is necessary to pay
particular attention to the problem of odors as
10 discussed above.

SUMMARY OF THE INVENTION

An object of the present invention is to
provide ^{image forming method} ~~a toner for developing an electrostatic image,~~
15 that has solved the above problems, ~~and a resin suited~~
~~as a binder resin for such a toner, and also to~~
~~provide a process for producing these toner and resin.~~

~~Another object of the present invention is to~~
provide a toner for developing an electrostatic image,
20 that has achieved an improvement in to odors.

Still another object of the present invention
is to provide a toner for developing an electrostatic
image, which contains a binder resin polymerized in an
aqueous medium, and improved in odors.

25 A further object of the present invention is
~~to provide a toner that can be free of odors and also~~



1 ~~simultaneously satisfy superior performances in~~
respect of other properties.

A still further object of the present
invention is to provide a binder resin for a toner
5 improved in relation to odors.

A still further object of the present
invention is to provide a binder resin for a toner
polymerized in an aqueous medium, and improved in
odors.

10 A still further object of the present
invention is to provide a binder resin for a toner
that can satisfy at the same time the performances
~~superior in various points.~~

To achieve the above objects of the present
15 invention, the present invention provides ~~a toner for~~ ^[page 8a] ←
developing an electrostatic image, comprising a binder
resin and a coloring agent, said binder resin
comprising a styrene type binder resin, wherein

an aldehyde is contained in said toner in an
20 amount of not more than 0.005 % by weight based on the
weight of the toner.

The present invention also provides a process
for producing a toner, comprising the steps of m
elt-kneading a mixture containing at least a coloring
agent and a styrene type binder resin containing an
25 ~~aldehyde in an amount of not more than 0.01 % by~~



image forming method comprising:

electrostatically charging a chargeable member for supporting thereon an electrostatic image by a contact charging assembly;

forming an electrostatic image on the chargeable member;

developing the electrostatic image on the chargeable member to form a toner image with a toner comprising a styrene binder resin and a coloring agent, wherein an aldehyde is contained in said toner in an amount of not more than 0.005% by weight based on the weight of the toner;

transferring the toner image to a transfer paper; and
fixing the toner image on the transfer paper by applying a heat and pressure to the toner image.

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1 weight,

cooling the melt-kneaded product to obtain a cooled product, and

pulverizing the cooled product;

5 said toner containing the aldehyde in an amount of not more than 0.005 % by weight.

The present invention still also provides a binder resin comprising a styrene polymer, a styrene copolymer, a mixture of a styrene polymer and a styrene copolymer or a mixture of styrene copolymers,
10 containing not less than 50 % by weight of a styrene unit; wherein

an aldehyde is contained in an amount of not more than 0.01 % by weight based on the weight of said
15 binder resin.

The present invention further provides a process for producing a binder resin, comprising the steps of:

preparing a monomer composition comprising a polymerizable monomer containing at least not less
20 than 50 % by weight of a styrene monomer, and a polymerization initiator, and

subjecting said monomer composition to suspension polymerization in an aqueous medium having dissolved oxygen in an amount of not more than 2.5
25 mg/lit to form a styrene polymer or copolymer



1 containing an aldehyde monomer in an amount of not
more than 0.01 % by weight.

The present invention still further provides
an apparatus unit comprising

5 an electrostatically chargeable member for
supporting thereon an electrostatic image,

a means for electrostatically charging the
chargeable member, and

a developing means for developing an
10 electrostatic image supported on said chargeable
member; wherein

said developing means has a toner for
developing an electrostatic image, comprising a
styrene type binder resin and a coloring agent;
15 wherein an aldehyde is contained in said toner in an
amount of not more than 0.005 % by weight based on the
weight of the toner, and

said charging means and developing means are
integrally held together with said chargeable member
20 to form a unit so that a single unit capable of being
freely mounted on and detached from an apparatus main
body is formed.

The present invention still further provides a
facsimile apparatus comprising an electrophotographic
25 apparatus and a means for receiving image information
from a remote terminal; wherein



1 ~~said electrophotographic apparatus comprising~~
an electrostatically chargeable member for
supporting an electrostatic image,
a means for electrostatically charging the
5 chargeable member, and
a developing means for developing an
electrostatic image supported on said chargeable
member; wherein
said developing means has a toner for
10 developing an electrostatic image, comprising a
styrene type binder resin and a coloring agent;
wherein an aldehyde is contained in said toner in an
amount of not more than 0.005 % by weight based on the
~~weight of the toner.~~

15 BRIEF DESCRIPTION OF THE DRAWINGS

Fig. 1 schematically illustrates a charging
roller used in an electrophotographic apparatus.

Fig. 2 schematically illustrates an example of
20 the electrophotographic apparatus.

Fig. 3 is a block diagram showing an
example of a facsimile apparatus.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

25 The present inventors made intensive studies
on the factors of a binder resin for a toner that have

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1 influence on the odors of a toner. As a result, they
were convinced as follows: Although the amount of the
solvent or polymerizable monomers remaining in a
binder resin has an influence, the amount of oxidized
5 products thereof, in particular, residual aldehydes
produced as result of air oxidation of polymerizable
monomers, has a greater influence than the former has.
Hence, it is a good means for solving the problem of
preventing the odors of a toner to decrease the amount
10 of aldehydes that remain in a binder resin.

In particular, in a styrene type binder resin
such as a styrene polymer or copolymer most commonly
used as a binder resin, the benzaldehyde produced as a
result of air oxidation of styrene monomers was
15 revealed to be a component that occurs most the
problem of odors. Thus, it was found that a great
care must be taken in reducing the amount of residual
aldehydes.

According to the studies made by the present
20 inventors, the content of such aldehydes in a binder
resin must be not more than 0.01 % by weight, and
particularly preferably not more than 0.005 % by
weight. If the content of the aldehydes is more than
0.01 % by weight, a toner often gives out a strong
25 odor.

According to further studies made by the

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1 present inventors, the content of aldehydes in a toner
must be not more than 0.005 % by weight, and
particularly preferably not more than 0.004 % by
weight. If the content of the aldehydes is more than
5 0.005 % by weight, an odor is often strongly
perceived.

The binder resin of the present invention may
preferably include a styrene type binder resin
containing a component insoluble to tetrahydrofuran
10 (THF), which will be described later.

In the present invention, the binder resin may
also preferably be a styrene resin produced by
suspension polymerization, containing an aldehyde in
an amount of not more than 0.01 % by weight.

15 As a result of intensive studies made by the
present inventors on account of such problems in order
to decrease aldehydes, it was found that what is aimed
by them can be achieved when the method as will be
detailed below is employed.

20 The dissolved oxygen in the water that is a
dispersion medium used in suspension polymerization is
controlled to be not more than 2.5 mg/lit., and
preferably not more than 2.0 mg/lit., when measured at
a temperature of from 40 to 45°C. This enables
25 suppression of air oxidation of polymerizable monomer
such as styrene monomers, and consequently enables



1 suppression of formation of aldehydes such as
benzaldehyde.

It is conventionally known in suspension
polymerization that an atmosphere of a polymerization
5 system is replaced with nitrogen gas so that wasteful
consumption of a polymerization initiator can be
saved. However, what is thereby aimed is to prevent
the yield of polymerization from being lowered, and is
unsatisfactory for the purpose of decreasing the rate
10 of formation of aldehydes. It was found that in order
to decrease the rate of formation of aldehydes the
dissolved oxygen in the water used in suspension
polymerization must be decreased to a certain
concentration.

15 The mechanism thereof is presumed as follows:
Since in the suspension polymerization the
polymerization takes place in the liquid droplets of
polymerizable monomers suspended in the water, it is
presumed that the liquid droplets of polymerizable
20 monomers come into direct contact with the water in
the site of this polymerization reaction and are
strongly affected by the dissolved oxygen in the
aqueous phase. Various known techniques can be used
as a specific method of decreasing such dissolved
25 oxygen. It is preferred to use a method in which a
nitrogen-feed pipe is fitted in the water or aqueous



1 phase so that nitrogen is flowed through water and
thereby the dissolved oxygen can be decreased in a
good efficiency.

As a result, when the dissolved oxygen is in a
5 concentration of not more than 2.5 mg/lit within the
temperature range of from 40 to 45°C, the amount of
aldehydes in the binder resin becomes not more than
0.01 % by weight. In a preferred instance, the
aldehydes becomes not more than 0.005 % by weight when
10 the dissolved oxygen is in a concentration of not more
than 2.0 mg/lit. In addition, the wasteful
consumption of the polymerization initiator can be
decreased and at the same time it becomes possible to
reduce the concentration of residual polymerizable
15 monomers.

It is advisable to carry out in combination a
method in which the suspension of a polymer thus
obtained is heated at temperatures higher than about
70°C so that the residual monomers are evaporated at
20 the same time with the evaporation of water.

The concentration of dissolved oxygen in water
can be measured in the following way: Using a DO
meter YSI, manufactured by Nikkaki Co., an electrode
is put in air or water containing oxygen in a known
25 amount, and an O₂ calibration selector is turned to
adjust an indicated value to the oxygen concentration

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1 of a sample. Next, an electrode is put therein in the
state that water having a temperature of from 40 to
45°C is circulated in a flow velocity of about 30
cm/sec., and thus the dissolved oxygen is measured.
5 In the case when the water is in a standstill, the
electrode is manually moved and thus the dissolved
oxygen is measured. The value is read when the
indicated value has become stable.

The determination of aldehydes in a binder
10 resin or a toner is carried out by gas chromatography
in the following way.

Using 2.55 mg of dimethylformamide (DMF) as an
internal standard, 100 ml of acetone is added to make
up a solvent containing an internal standard material.
15 Next, 200 mg of a binder resin or 200 mg of a toner is
dissolved or dispersed in the above solvent to give a
solution or dispersion. The resulting solution or
dispersion is set on an ultrasonic shaking apparatus
for 30 minutes, and thereafter left standing for 1
20 hour. Next, filtration is carried out using a 0.5 µm
filter. In the gas chromatography, the sample is shot
in an amount of 4 µl.

The gas chromatography is carried out under
conditions as follows:

25 - Capillary column (30 m x 0.249 mm, DBWAX, film
thickness: 0.25 µm)



- 1 - Detector: FID (flame ionization detector); nitrogen
pressure: 0.35 kg/cm^2
- Injection temperature: 200°C ; detector temperature:
 200°C ; Column temperature: raised for 30 minutes from
5 50°C at a rate of 5°C/min .

- Preparation of calibration curve:

An aldehyde to be measured is added to a solution of
DMF and acetone prepared in the same amount of a
sample solution. A standard sample thus obtained is
10 similarly subjected to measurement by gas
chromatography to determine a value for weight
ratio/area ratio between the aldehyde and the internal
standard material DMF.

In the suspension polymerization, the
15 dissolved oxygen in the aqueous phase is controlled to
be 2.5 mg/lit . The binder resin as intended in the
present invention can be thereby obtained. In order
to highly satisfy grindability, offset resistance,
fixing properties, filming or melt-adhesion resistance
to a photosensitive member, image properties, etc.,
20 the binder resin may preferably contain from 10 to 70
% by weight, preferably from 10 to 60 % by weight, of
a tetrahydrofuran(THF)-insoluble matter, as proposed
in Japanese Patent Application Laid-Open No. 63-
25 223014. The binder resin may be more preferable,
which i) having a weight average molecular



1 weight/number average molecular weight (M_w/M_n) of ≥ 5 ,
at least one peak at the region of a molecular weight
of from 2,000 to 10,000 and at least one peak or
shoulder at the region of a molecular weight of from
5 15,000 to 100,000, in the molecular weight
distribution measured by gel permeation chromatography
(GPC) of a THF-soluble matter in the binder resin, and
ii) containing a component with a molecular weight of
not more than 10,000 in an amount of from 10 to 50 %
10 by weight based on the THF-soluble resin composition.

The THF-insoluble matter referred to in the
present invention indicates the weight proportion of a
polymer component that has become insoluble to THF
(i.e., substantially a cross-linked polymer) in a
15 resin or resin composition. This can be used as a
parameter that indicates the degree of cross-linking
of the resin composition containing a cross-linked
component. The THF-insoluble matter in the binder
resin is defined by a value measured in the following
20 way.

A sample (a 24 mesh-pass and 60 mesh-on
powder) of the resin or resin composition is weighed
in an amount of from 0.5 to 1.0 g (W_1 g), which is
then put in a cylindrical filter paper (for example,
25 No. 86R, available from Toyo Roshi K.K.) and set on a
Soxhlet extractor. Extraction is carried out for 6



1 hours using from 100 to 200 ml of THF as a solvent,
and the soluble component extracted by the use of the
solvent is evaporated, followed by vacuum drying at
100°C for several hours. Then the THF-soluble resin
5 component is weighed (W_2 g). The THF-insoluble matter
of the resin or resin composition is determined from
the following expression.

$$\text{THF-insoluble matter (\%)} = W_1 - W_2 / W_1 \times 100$$

The THF-insoluble matter in the toner is
10 defined by a value measured in the following way.

In the case when the toner is a non-magnetic
toner, the content of a dye or pigment is previously
measured by a known method. In the case when the
toner is a magnetic toner, the content of a dye or
15 pigment and that of a magnetic material are previously
measured by a known method. Next, a given amount of
from 0.5 to 1.0 g of the toner is weighed (W_1 g),
which is then put in a cylindrical filter paper (for
example, No. 86R, available from Toyo Roshi K.K.) and
20 set on a Soxhlet extractor. Extraction is carried out
for 6 hours using from 100 to 200 ml of chloroform as
a solvent, and the soluble component extracted by the
use of the solvent is evaporated, followed by vacuum
drying at 100°C for several hours. Then the THF-
25 soluble resin component is weighed (W_2 g). Then,
among coloring agents such as dyes or pigments and



1 magnetic materials contained in a given amount of the
toner, the weight of the components soluble to THF is
represented by W_3 g, and the weight of the components
insoluble to THF, by W_4 g. The THF-insoluble matter
5 of the resin component in the toner is calculated from
the following expression.

Content of THF-insoluble matter (%)

$$= (W_1 - W_2 - W_4) / (W_1 - W_3 - W_4) \times 100$$

In the present invention, the molecular weight
10 at the peak and/or shoulder on the chromatogram
obtained by GPC (gel permeation chromatography) is/are
measured under the following conditions.

Columns are stabilized in a heat chamber
heated to 40°C. To the columns kept at this
15 temperature, THF (tetrahydrofuran) as a solvent is
flowed at a flow rate of 1 ml per minute, and from 50
to 200 μ l of a THF sample solution of a resin prepared
to have a sample concentration of from 0.05 to 0.6 %
by weight is injected thereinto to make measurement.
20 In measuring the molecular weight of the sample, the
molecular weight distribution ascribed to the sample
is calculated from the relationship between the
logarithmic value and count number of a calibration
curve prepared using several kinds of monodisperse
25 polystyrene standard samples. As the standard
polystyrene samples used for the preparation of the



1 calibration curve, it is preferred to use, for
example, samples with molecular weights of 6×10^2 ,
2.1 $\times 10^3$, 4 $\times 10^3$, 1.75 $\times 10^4$, 5.1 $\times 10^4$, 1.1 $\times 10^5$,
3.9 $\times 10^5$, 8.6 $\times 10^5$, 2 $\times 10^6$ and 4.48 $\times 10^6$, which
5 are available from Pressure Chemical Co. or Toyo Soda
Manufacturing Co., Ltd. It is suitable to use at
least about 10 standard polystyrene samples. An RI
(refractive index) detector is used as a detector.

Columns may preferably be used in combination
10 of a plurality of commercially available polystyrene
gel columns so that the regions of molecular weights
of from 10^3 to 2×10^6 can be accurately measured.
For example, they may preferably comprise a
combination of μ -Styragel 500, 10^3 and 10^4 , available
15 from Waters Co.; Shodex KF-80M or a combination of KF-
801, 803, 804 and 805 or a combination of KA-802, 803,
804 and 805, available from Showa Denko K.K.; or a
combination of TSKgel G1000H, G2000H, G2500H, G3000H,
G4000H, G5000H, G6000H, G7000H and GMH, available from
20 Toyo Soda Manufacturing Co., Ltd.

In regard to the % by weight with respect to
the binder resin of the present invention, having a
molecular weight of not more than 10,000, a
chromatogram obtained by GPC is cut out at the part
25 corresponding to the molecular weight of not more than
10,000, and the weight ratio thereof to a cutting

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1 corresponding to a molecular weight of more than
10,000 is calculated. Using the % by weight of the
above THF-insoluble matter, the % by weight with
respect to the whole binder resin is calculated.

5 A styrene type binder resin is used as the
binder resin of the present invention.

The styrene type binder resin includes, for
example, styrene polymers, styrene copolymers, resin
compositions comprising styrene polymers and styrene
10 copolymers, and resin compositions comprising styrene
copolymers and different types of styrene copolymers.

The resin or resin composition in the toner of
the present invention includes those obtained by
polymerizing styrene with one or more kinds of
15 monomers selected from styrenes, acrylic acids,
methacrylic acids and derivatives thereof. These are
preferable in view of development properties and
triboelectric properties. As the examples of monomers
that can be used, the styrenes include α -
20 methylstyrene, vinyltoluene, and chlorostyrene. The
acrylic acids, methacrylic acids and derivatives
thereof include acrylic acid, methyl acrylate, ethyl
acrylate, propyl acrylate, butyl acrylate, octyl
acrylate, 2-ethylhexyl acrylate, n-tetradecyl
25 acrylate, n-hexadecyl acrylate, lauryl acrylate,
cyclohexyl acrylate, diethylaminoethyl acrylate,



1 dimethylaminoethyl acrylate, methacrylic acid, methyl
methacrylate, ethyl methacrylate, propyl methacrylate,
butyl methacrylate, amyl methacrylate, hexyl
methacrylate, 2-ethylhexyl methacrylate, octyl
5 methacrylate, decyl methacrylate, dodecyl
methacrylate, lauryl methacrylate, cyclohexyl
methacrylate, phenyl methacrylate, 2-hydroxyethyl
methacrylate, 2-hydroxypropyl methacrylate,
dimethylaminoethyl methacrylate, glycidyl
10 methacrylate, and stearyl methacrylate. Besides the
above monomers, other monomers may be used in a small
amount so long as the objects of the present invention
can be achieved, which include, for example,
acrylonitrile, 2-vinylpyridine, 4-vinylpyridine,
15 vinylcarbazole, vinyl methyl ether, butadiene,
isoprene, maleic anhydride, maleic acid, maleic acid
monoesters, maleic acid diesters, and vinyl acetate.

One or more kinds of these vinyl monomers are
used in combination of the styrene monomer. Of these,
20 preferred is a styrene copolymer which is formed using
styrene and an acrylate or methacrylate as main
components.

It is an important factor for obtaining the
resin intended in the present invention to select the
25 kinds of a polymerization initiator, a solvent and a
solution or dispersion medium and the conditions for



1 reaction.

The polymerization initiator includes, for example, organic peroxides such as benzoyl peroxide, 1,1-di(t-butylperoxy)-3,3,5-trimethylcyclohexane, n-
5 butyl-4,4-di(t-butylperoxy)valerate, dicumyl peroxide, α,α' -bis(t-butylperoxydiisopropyl)benzene, t-butylperoxycumene, and di-t-butyl peroxide; and azo or diazo compounds such as azobisisobutyronitrile and diazoaminoazobenzene.

10 The binder resin of the present invention may also be cross-linked in part or in its entirety, using a cross-linkable monomer.

A compound mainly having two or more polymerizable double bonds is used as the cross-
15 linkable monomer.

For example, a bifunctional cross-linking agent can be used, which includes, divinylbenzene, bis(4-acryloxypolyethoxyphenyl)propane, ethylene glycol diacrylate, 1,3-butylene glycol diacrylate, 1,4-
20 butanediol diacrylate, 1,5-pentanediol diacrylate, 1,6-hexanediol diacrylate, neopentyl glycol diacrylate, diethylene glycol diacrylate, triethylene glycol diacrylate, tetraethylene glycol diacrylate, diacrylates of polyethylene glycol #200, #400 and
25 #600, respectively, dipropylene glycol diacrylate, polypropylene glycol diacrylate, and polyester type



1 diacrylate (MANDA, available from Nippon Kayaku Co.,
Ltd.). It also include those in which the acrylate
units of the above acrylate type cross-linking agents
have been respectively replaced by methacrylate units.

5 A polyfunctional cross-linking agent can also
be used, which includes pentaerythritol triacrylate,
trimethylolethane triacrylate, trimethylolpropane
triacrylate, tetramethylolmethane tetraacrylate,
oligoester acrylate and methacrylate thereof, 2,2-
10 bis(4-methacryloxy, polyethoxyphenyl)propane, diallyl
phthalate, triallyl cyanurate, triallyl isocyanurate,
triallyl isocyanurate, triallyl trimellitate, and
diaryl chlorendate. Among these, divinylbenzene is
effective.

15 The components for the binder resin of the
present invention may preferably be synthesized by
suspension polymerization in order to control the THF-
insoluble matter. For the purpose of controlling
molecular weight distribution, preferred is a method
20 of synthesizing basically two or more kinds of
polymers.

The method is exemplified by a method in which
a first polymer or copolymer soluble in THF and also
soluble in a polymerizable monomer is dissolved in
25 polymerizable monomers containing cross-linkable
monomers and then the monomers are polymerized to give



1 a resin composition containing cross-linked resin
components. In this instance, the first polymer or
copolymer and the cross-linked latter (second) polymer
or copolymer are uniformly mixed, so that when the
5 product is applied in a toner it becomes possible to
improve fixing properties and offset resistance
without damage of the durability and blocking
resistance of the toner.

The first polymer or copolymer soluble in THF
10 may preferably be obtained by solution polymerization
or ionic polymerization. The second polymer or
copolymer for producing a component insoluble to THF
may preferably be synthesized by suspension
polymerization or bulk polymerization in the presence
15 of a cross-linkable monomer under conditions where the
first polymer or copolymer is dissolved therein. The
first polymer or copolymer may preferably be used in
an amount of from 10 to 120 parts by weight, and
preferably from 20 to 100 parts by weight, based on
20 100 parts by weight of polymerizable monomers used for
the formation of the second polymer or copolymer.

For example, in the process for producing the
binder resin of the present invention, it is preferred
that a first resin is prepared by solution
25 polymerization, the first resin thus prepared is
dissolved in polymerizable monomers, and the

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1 polymerizable monomers are subjected to suspension
polymerization in the presence of the resin and a
cross-linking agent. The first resin should be
dissolved in an amount of 10 to 120 parts by weight,
5 preferably from 20 to 100 parts by weight, based on
100 parts by weight of the monomers for the suspension
polymerization. In carrying out the suspension
polymerization, the cross-linking agent may preferably
be used in an amount of from about 0.1 to about 2.0 %
10 by weight based on the monomers used for the
suspension polymerization. These conditions may be
more or less varied depending on the kind of the
initiator and reaction temperatures.

There is a finding that a toner has a
15 difference in performance between the instance where
the first polymer or copolymer is dissolved in
monomers and the binder resin is obtained by
suspension polymerization and the instance where a
resin obtained by suspension polymerization without
20 dissolving the first polymer or copolymer and the
first polymer or copolymer are merely mixed. The
former brings about better results particularly in
respect of fixing properties.

The solution polymerization and suspension
25 polymerization according to the present invention
will be described below.



1 The solvent used in the solution
polymerization includes xylene, toluene, cumene,
cellosolve acetate, isopropyl alcohol, and benzene.
In the case of styrene monomers, xylene, toluene or
5 cumene is preferred. These may be appropriately
selected depending on the polymer to be produced by
polymerization. The polymerization initiator includes
di-tert-butyl peroxide, tert-butylperoxybenzoate,
benzoyl peroxide, 2,2'-azobisisobutyronitrile, and
10 2,2'-azobis(2,4-dimethylvaleronitrile), which may be
used in a concentration of not less than 0.1 part by
weight, and preferably from 0.4 to 15 parts by weight,
based on 100 parts by weight of monomers. Reaction
temperature may vary depending on the solvent used,
15 the initiator and the polymer obtained by
polymerization. Preferably, the reaction may be
carried out at 70°C to 180°C. The solution
polymerization may preferably be carried out using
from 30 parts by weight to 400 parts by weight of
20 monomers based on 100 parts by weight of the solvent.
It is also possible to use a method of obtaining the
product by thermal polymerization.

 The suspension polymerization may preferably
be carried out using not more than 100 parts by
25 weight, and preferably from 10 to 90 parts by weight,
of monomers based on 100 parts by weight of an aqueous



1 medium. A dispersant that can be used includes
polyvinyl alcohol, partially saponified polyvinyl
alcohol, and calcium phosphate. Its appropriate
amount depends on the amount of monomers based on the
5 aqueous medium. It is commonly used in an amount of
0.05 to 1 part by weight based on 100 parts by weight
of the aqueous medium. Polymerization temperature may
suitably be in the range of from 50 to 95°C, and
should be appropriately selected depending on the
10 polymerization initiator used and the polymer to be
obtained. The polymerization initiator may be of any
kinds, which can be used so long as they are insoluble
or sparingly soluble in water. For example, benzoyl
peroxide, tert-butylperoxyhexanoate or the like can be
15 used in an amount of from 0.5 to 10 parts by weight
based on 100 parts by weight of monomers.

In addition to the above binder resin
components, the toner in which the resin of the
present invention is employed may also contain the
20 following materials in a proportion smaller than the
content of the binder resin components, for example,
in an amount of not more than 50 % by weight, and more
preferably not more than 20 % by weight, so long as
the effect of the present invention is not adversely
25 affected.

Such materials include, for example, silicone



1 resins, polyesters, polyurethanes, polyamides, epoxy
resins, polyvinyl butyral, rosins, modified rosins,
terpene resins, phenol resins, hydrocarbon resins such
as low-molecular polyethylene and low-molecular
5 polypropylene, aromatic petroleum resins, chlorinated
paraffins, and paraffin waxes.

Commonly known dyes and pigments can be used
as the coloring agent contained in the toner according
to the present invention. Such dyes and pigments
10 include carbon black, nigrosine dyes, lamp black,
Sudan Black SM, First Yellow G, Benzidine Yellow,
Pigment Yellow, Indofirst Orange, Irgazine Red,
Paranitroaniline Red, Toluidine Red, Carmine 6B,
Permanent Bordeaux F3R, Pigment Orange R, Lithol Red
15 2G, Lake Red C, Rhodamine FB, Rhodamine B Lake, Methyl
Violet B Lake, Phthalocyanine Blue, Pigment Blue,
Brilliant Green B, Phthalocyanine Green, Oil Yellow
GG, Zapon First Yellow CGG, Kayaset Y963, Kayaset YG,
Sumiplast Yellow GG, Zapon First Orange RR, Oil
20 Scarlet, Sumiplast Orange G, Orazole Brown B, Zapon
First Scarlet CG, Aizenspiron Red BEH, and Oil Pink
OP. In general, these coloring agents may preferably
be added in an amount of from 5 to 20 % by weight
based on the binder resin.

25 In instances in which the toner according to
the present invention is used as a magnetic toner,



1 magnetic toner particles to be contained include
particles of metals composed of a ferromagnetic
element such as iron, cobalt and nickel, or alloys
comprising any of these metals, compounds such as
5 ferrite and magnetite, and alloys which do not
comprise any ferromagnetic element but may exhibit
ferromagnetic properties as a result of suitable heat
treatment (as exemplified by an alloy of the type
called Heusler's alloy containing manganese and
10 copper, such as manganese-copper-aluminum or manganese-
copper-tin, or chromium dioxide and others). Fine
powder of these magnetic materials may preferably be
contained in an amount of 30 to 150 parts by weight,
and more preferably from 40 to 100 parts by weight,
15 based on 100 parts by weight of the binder resin. It
is also possible to use magnetic fine particles as a
black or brown pigment.

A charge controlling agent contained in the
toner according to the present invention may be
20 selected from conventionally known charge controlling
agents. Examples of a positive charge controlling
agent are nigrosine, azine dyes containing an alkyl
group having 2 to 16 carbon atoms (Japanese Patent
Publication No. 42-1627), basic dyes as exemplified by
25 C.I. Basic Yellow 2 (C.I.41000), C.I. Basic Yellow 3,
C.I. Basic Red 1 (C.I.45160), C.I. Basic Red 9



1 (C.I.42500), C.I. Basic Violet 1 (C.I.42535), C.I.
Basic Violet 3 (C.I.42555), C.I. Basic Violet 10
(C.I.45170), C.I. Basic Violet 14 (C.I.42510), C.I.
Basic Blue 1 (C.I.42025), C.I. Basic Blue 3
5 (C.I.51005), C.I. Basic Blue 5 (C.I.42140), C.I. Basic
Blue 7 (C.I.42595), C.I. Basic Blue 9 (C.I.52015),
C.I. Basic Blue 24 (C.I.52030), C.I. Basic Blue 25
(C.I.52025), C.I. Basic Blue 26 (C.I.44025), C.I.
Basic Green 1 (C.I.42040), and C.I. Basic Green 4
10 (C.I.42000). Lake pigments of these basic dyes
(laking agents are exemplified by tungstophosphoric
acid, molybdophosphoric acid, tungstomolybdophosphoric
acid, tannic acid, lauric acid, gallic acid,
ferricyanides, and ferrocyanides) include C.I. Solvent
15 black 3 (C.I.26150), Hanza Yellow G (C.I.11680), C.I.
Mordant Black 11, and C.I. Pigment Black 1.

They also include, for example, quaternary
ammonium salts such as benzoylmethyl-hexadecylammonium
chloride and decyl-trimethylammonium chloride, or
20 polyamide resins such as vinyl polymers containing an
amino group and condensed polymers containing an amino
group. They preferably include nigrosine, quaternary
ammonium salts, triphenylmethane nitrogen-containing
compounds, and polyamides.

25 Examples of a negative charge controlling
agent are metal complexes of monoazo dyes, as

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1 disclosed in Japanese Patent Publications No. 41-
20153, No. 42-27596, No. 44-6397 and No. 45-26478,
nitramines and salts thereof, as disclosed in Japanese
Patent Application Laid-Open No. 50-133338 or dyes or
5 pigments such as C.I.14645, metal complex salts formed
by the union of Zn, Al, Co, Cr or Fe with salicylic
acid, naphthoic acid or dicarboxylic acid, as
disclosed in Japanese Patent Publications No. 55-
42752, No. 58-41508, No. 58-7384 and No. 59-7385,
10 sulfonated copper phthalocyanine pigments, styrene
oligomers into which a nitro group or halogen has been
introduced, and chlorinated paraffins. Particularly
from the viewpoint of their dispersibility to a resin,
preferred are metal complexes of monoazo dyes, and
15 metal complex salts of salicylic acid, alkylsalicylic
acid, naphthoic acid or dicarboxylic acid. These
charge controlling agents may preferably be added in
an amount of from 0.1 to 3 parts by weight based on
100 parts by weight of the binder resin. The ill
20 effects such that the developing power and
environmental stability may be lowered because of the
contamination of the surface of a developing sleeve,
caused by the above charge controlling agents, can be
thereby suppressed to minimums while keeping the good
25 triboelectric chargeability as described above.

In the toner of the present invention, an

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1 ethylenic olefin polymer may be used as a fixing aid
together with the binder resin.

Here, the polymer used as an ethylenic olefin
homopolymer or ethylenic olefin copolymer includes
5 polyethylene, polypropylene, an ethylene/propylene
copolymer, an ethylene/vinyl acetate copolymer, an
ethylene/ethyl acrylate copolymer, and ionomers having
a polyethylene skeleton. The above ethylenic olefin
copolymer may preferably contain olefin monomers in an
10 amount of not less than 50 mol %, and more preferably
not less than 60 mol %.

The toner of the present invention can be
usually be produced in the following way.

(1) The binder resin and the coloring agents such
15 as magnetic materials and dye or pigments are
uniformly dispersed using a mixing machine such as a
Henschel mixer.

(2) The dispersant thus obtained is melt-kneaded
at a temperature of from 90 to 180°C using a melt
20 kneader such as a kneader, an extruder and a roll
mill.

(3) The resulting kneaded product is cooled, and
then the cooled kneaded product is crushed with a
crusher such as a cutter mill and a hammer mill.
25 Thereafter, the crushed product is finely pulverized
using a fine grinder such as a jet mill.



1 (4) The finely pulverized product is classified to
give a toner, using a classifier such as a zig-zag
classifier and/or an elbow-jet classifier.

Electrophotography in which the toner
5 employing the resin binder of the present invention is
applied will be described below.

A process in which an electrostatic latent
image is formed into a visible image by the use of a
toner includes the magnetic brush development, the
10 cascade development, the powder cloud development, the
method disclosed in U.S. Patent No. 3,909,258 in which
a conductive magnetic toner is used, which are as
previously referred to, and a method in which a
magnetic toner with a high resistivity is used, as
15 disclosed in Japanese Patent Application Laid-Open No.
53-31136. The toner in which the binder resin
according to the present invention is used is also
suitable for a development process in which a one-
component developer comprising a magnetic toner
20 containing magnetic particles is used. In the step of
transferring a developed toner image to a transfer
medium, electrostatic transfer methods are used, as
exemplified by the corona transfer method and a method
in which a bias is applied to a contact transfer
25 member.

In recent years, a method in which a bias is



1 applied through a member coming into direct contact
with a photosensitive member has attracted notices
since the methods for electrostatic charging and/or
transfer and/or residual charge elimination that
5 utilize corona discharging on a photosensitive member
from a member not coming into contact with the
photosensitive member are accompanied with generation
of ozone. Following the shift to such a new method,
the activated carbon filters often attached to
10 conventional copying machines or printers are removed
in some instances. In such instances, the toner of
the present invention can be remarkably effective.

In the toner in which the binder resin of the
present invention, the blade cleaning method, the fur
15 brush cleaning method or the like may be applied in
the step of removing the toner remaining on a
photosensitive layer or an insulating layer. In
particular, the toner is suited for the blade cleaning
method.

20 As a method by which a toner image formed on
the transfer medium is fixed on the medium, the heat
fixing method, the solvent fixing method, the blush
fixing method, the laminate fixing method, etc. can be
used. The present invention is particularly suited
25 for the heat-roller fixing method.

An image forming process and an image forming



1 apparatus in both of which the toner of the present
invention can be preferably used will be further
described with reference to Figs. 1 and 2.

Fig. 1 schematically illustrates the
5 constitution of a contact charging assembly used in
Examples described later. The numeral 2 denotes a
photosensitive drum serving as a chargeable member,
which is comprised of a drum substrate made of
aluminum and formed on the periphery thereof an
10 organic photoconductor (OPC) serving as a
photosensitive layer, and is rotated at a given speed
in the direction of an arrow. The photosensitive drum
2 is 30 mm in outer diameter. The numeral 1 denotes a
charging roller which is a charging member brought
15 into contact with the photosensitive drum 2 at a given
pressure, and is comprised of a metallic core 1c, a
conductive rubber layer 1b provided thereon, and
further provided thereon a surface layer 1a, a release
film. The conductive rubber layer may preferably have
20 a thickness of from 0.5 to 10 mm, and preferably from
1 to 5 mm. The surface layer comprises a release
film. It is preferred to provide the release film so
that the toner according to the present invention may
match the image forming process. Since, however, a
25 release film with an excessively large resistivity may
give no electrostatic charges on the photosensitive



1 drum 2 and, on the other hand, a release film with an
excessively small resistivity may cause an excessively
large voltage applied to the photosensitive drum 2 to
damage the drum or produce pinholes, the release film
5 should have an appropriate resistivity, preferably a
volume resistivity of from 10^9 to 10^{14} $\Omega \cdot m$. Here, the
release film may preferably have a thickness of not
more than 30 μm , and more preferably from 10 to 30 μm .

The lower limit of the release film may be
10 smaller so long as no peel or turn-up may occur, and
can be considered to be about 5 μm .

The charging roller 1 has an outer diameter of
12 mm. The conductive rubber layer 1b, having a layer
thickness of about 3.5 mm, is composed of an ethylene-
15 propylene-diene terpolymer (EPDM), and the surface
layer 1a is formed of a nylon resin (specifically,
methoxymethylated nylon) in a thickness of 10 μm . The
charging roller 1 is made to have a hardness of 54.5°
(ASKER-C). The numeral 3 denotes an electric source
20 that applies a voltage to the charging roller 1, and
feeds a given voltage to the metallic core 1c
(diameter: 5 mm) of the charging roller 1. The
electric source that applies a voltage to the charging
roller 1 may preferably be the one capable of applying
25 a DC voltage overlaid with an AC voltage.

In order to adjust the electrical resistivity,

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1 it is preferred to disperse conductive fine powder
such as carbon in the conductive rubber layer and/or
the release film.

Preferable process conditions used here are
5 shown below.

Contact pressure : 5 to 500 g/cm

AC voltage : 0.5 to 5 KV_{pp}

AC frequency : 50 to 3,000 H_z

DC voltage (absolute value) : 200 to 900 V

10 In the apparatus shown in Fig. 2, the surface
of a photosensitive member 202 is negatively or
positively charged by the operation of a contact
charging assembly 201 having a voltage applying means
215, and a digital latent image is formed by image
15 scanning through exposure 205 using a laser beam (or
an analog latent image is formed by analog exposure).
The latent image thus formed is reversely developed
(or normally developed) using a negatively chargeable
one-component magnetic toner 210 held in a developing
20 assembly 209 equipped with a developing sleeve 204 in
which a magnetic blade 211 and a magnet are provided.
In the developing zone, an AC bias, a pulse bias
and/or a DC bias is/are applied between a conductive
substrate of the photosensitive drum 202 and the
25 developing sleeve 204 through a bias applying means
212. A transfer paper P is fed and delivered to a



1 transfer zone, where the transfer paper P is
electrostatically charged from its back surface (the
surface opposite to the photosensitive drum) through a
transfer means 203, so that the developed image (toner
5 image) on the surface of the photosensitive drum is
electrostatically transferred to the transfer paper P.
The transfer paper P separated from the photosensitive
drum 202 is subjected to fixing using a heat-pressure
roller fixing unit (thermal platen) 207 so that the
10 toner image on the transfer paper can be fixed.

The one-component toner remaining on the
photosensitive drum 202 after the transfer step is
removed by the operation of a cleaning assembly 208
having a cleaning blade. After the cleaning, the
15 residual charges on the photosensitive drum 202 is
eliminated by the erasing exposure 206, and thus the
procedure starting from the charging step using the
contact charging assembly 201 is repeated.

20 An electrostatic charge retainer (the
photosensitive drum) comprises a photosensitive layer
and a conductive substrate, and is rotated in the
direction of an arrow. In the developing zone, the
developing sleeve 204, a non-magnetic cylinder, which
is a toner supporting member, is rotated so as to move
25 in the same direction as the direction in which the
electrostatic charge retainer is rotated. In the



1 inside of the non-magnetic cylindrical sleeve 204, a
multi-polar permanent magnet (magnet roll) serving as
a magnetic field generating means is provided in an
unrotatable state. The one-component insulating
5 magnetic toner 210 held in the developing assembly 209
is coated on the surface of the non-magnetic
cylindrical sleeve 204, and, for example, negative
triboelectric charges are imparted to toner particles
because of the friction between the surface of the
10 sleeve 204 and the toner particles. A doctor blade
211 made of iron is disposed opposingly to one of the
magnetic pole positions of the multi-polar permanent
magnet, in proximity (with an interval of from 50 μm
to 500 μm) to the surface of the cylinder. Thus, the
15 thickness of a toner layer can be controlled to be
thin (from 30 μm to 300 μm) and uniform so that a
toner layer smaller in thickness than the gap between
the photosensitive drum 202 and developing sleeve 204
in the developing zone can be formed in a non-contact
20 state. The rotational speed of this developing sleeve
204 is regulated so that the peripheral speed of the
sleeve can be substantially equal or close to the
speed of the peripheral speed of the electrostatic
charge receptor. As the magnetic doctor blade 211, a
25 permanent magnet may be used in place of iron to form
an opposing magnetic pole. In the developing zone,

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1 the AC bias or pulse bias may be applied through the
bias means 212, between the developing sleeve 204 and
the surface on which electrostatic charges are
retained. This AC bias may have a frequency of from
5 200 to 4,000 Hz, and a Vpp of from 500 to 3,000 V.

When the toner particles are moved in the
developing zone, the toner particles are moved to the
latent image side by the electrostatic force of the
electrostatic charge retaining surface and the action
10 of the AC bias or pulse bias.

In place of the magnetic doctor blade 211, an
elastic blade made of an elastic material such as
silicone rubber may be used so that the layer
thickness of the toner layer can be controlled by
15 pressure and thereby the toner can be coated on a
toner supporting member.

The electrophotographic apparatus may be
constituted of a combination of plural components
integrally joined as one apparatus unit from among the
20 constituents such as the above photosensitive member,
developing means and cleaning means so that the unit
can be freely mounted on or detached from the body of
the apparatus. For example, at least one of the
charging means, developing means and cleaning means
25 may be integrally supported together with the
photosensitive member to form one unit that can be



1 freely mounted on or detached from the body of the
apparatus, and the unit can be freely mounted or
detached using a guide means such as a rail provided
in the body of the apparatus. Here, the above
5 apparatus unit may be so constituted as to be joined
together with the charging means and/or the developing
means.

In the case when the image forming apparatus
having the toner of the present invention is used as a
10 printer of a facsimile system, optical image exposing
light 305 serves as exposing light used for the
printing of received data. Fig. 3 illustrates an
example thereof in the form of a block diagram.

A controller 311 controls an image reading
15 part 310 and a printer 319. The whole of the
controller 311 is controlled by CPU 317. Image data
outputted from the image reading part is sent to the
other facsimile station through a transmitting circuit
313. Data received from the other station is sent to
20 a printer 319 through a receiving circuit 312. Given
image data are stored in an image memory 316. A
printer controller 318 controls the printer 319. The
numeral 314 denotes a telephone.

An image received from a circuit 315 (image
25 information from a remote terminal connected through
the circuit) is demodulated in the receiving circuit



1 312, and then successively stored in an image memory
316 after the image information is decoded by the CPU
317. Then, when images for at least one page have
been stored in the memory 316, the image recording for
5 that page is carried out. The CPU 317 reads out the
image information for one page from the memory 316 and
sends the coded image information for one page to the
printer controller 318. The printer controller 318,
having received the image information for one page
10 from the CPU 317, controls the printer 319 so that the
image information for one page is recorded.

The CPU 317 receives image information for
next page in the course of the recording by the
printer 319.

15 Images are thus received and recorded.

EXAMPLES

The present invention will be specifically
described below by giving Examples. The "part(s)" and
20 "%" used in Examples all refer to "parts by weight"
and "% by weight".

Example 1

(1-1) Preparation of binder resin:

In a reaction vessel, 200 parts of cumene was
25 introduced, and heated to its reflux temperature. A
mixture of 100 parts of styrene monomers and 8 parts

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1 of di-tert-butyl peroxide was dropwise added thereto
over a period of 4 hours under the reflux of cumene.
Also under the reflux of cumene (146°C to 156°C),
polymerization was completed and then the cumene was
5 removed. The resulting polystyrene was capable of
dissolving in THF, and had a weight average molecular
weight (Mw) of 3,700, a weight average molecular
weight/number average molecular weight (Mw/Mn) of
2.64, a main peak at a molecular weight of 3,500 as
10 measured by GPC, and a Tg of 57°C.

The above polystyrene in an amount of 30 parts
was dissolved in the following monomer mixture to give
a mixed solution.

15 Monomer mixture	Mixing proportion
Styrene monomer	54 parts
n-Butyl acrylate monomer	16 parts
Divinylbenzene	0.3 part
Benzoyl peroxide	1.3 parts

20 In the above mixed solution, 170 parts of
water with a dissolved oxygen of about 1.5 mg/lit. in
which 0.1 part of partially saponified polyvinyl
alcohol was dissolved was added to give a suspension
dispersion. In a reaction vessel, 15 parts of water
25 was put, nitrogen was introduced from a nitrogen feed
pipe, temperature was maintained at 40 to 45°C, and



1 the nitrogen was flowed so as for the dissolved oxygen
to be in a concentration of about 1.5 mg/lit. In this
state, the above suspension dispersion was added in
the reaction vessel, and suspension polymerization was
5 carried out at reaction temperatures of from 70 to
95°C for 9 hours. After completion of the reaction,
the reaction mixture was filtered, dehydrated and
dried to give a resin composition A comprised of
polystyrene and a styrene/n-butyl acrylate copolymer.

10 In the resulting resin composition A, a THF-
insoluble matter and a THF-soluble matter were in a
uniformly mixed state and the polystyrene and the
styrene/n-butyl acrylate copolymer were also in a
uniformly mixed state. The resin composition A thus
15 obtained was formed into powder of 24 mesh-pass and 60
mesh-on. About 0.5 g thereof was weighed and put into
a cylindrical filter paper No. 86R, manufactured by
Toyo Roshi Co., of 28 mm in diameter and 100 mm in
length. THF (200 ml) was refluxed at the rate of once
20 in every about 4 minutes, and then the THF-insoluble
matter was measured. The THF-insoluble matter in the
resulting resin composition A was in an amount of 25 %
by weight. The molecular weight distribution of the
THF-soluble matter was measured to reveal that it had
25 peaks at molecular weights of 4,000 and 34,000,
respectively, an Mn of 5,500, an Mw of 130,000, and an



1 Mw/Mn of 24. The component with a molecular weight of
not more than 10,000 was in an amount of 25 % by
weight. It was also confirmed that the glass
transition point (Tg) of the resin composition A was
5 58°C.

The content of benzaldehyde was not more than
0.003 % by weight, and that of styrene monomers was
0.018 % by weight.

The resulting resin composition A (10 g) was
10 put in a sealed glass container of 200 cc, and then
heated at 150°C for 10 minutes. Thereafter, odors
were evaluated with heating.

The resin composition slightly smelled, but
was regarded as non-problem in practical use.

15 The above resin composition A was pulverized
into powder of about 10 μ in average particle
diameter, which was then put in a color cartridge for
a copying machine FC-3, manufactured by Canon Inc., in
place of its toner. Development biases, transfer
20 electric currents and so forth were adjusted or
modified so that a uniform resin particle layer can be
formed on the surface of paper, and development on the
photosensitive member and transfer to the paper were
carried out. Thereafter, the paper thus processed was
25 passed through a fixing unit (a platen assembly), and
odors generated in that case were observed.



1 Evaluation on odors was made in the following
way: The above copying machine was placed at the
center of a small room of about 3 m square. Copies
were continuously taken according to the above
5 procedure of fixing the resin particles on paper. On
its surroundings, 10 panelists chosen at random
smelled while they were changing their positions
little by little, and evaluated odors on the bases of
the following:

- 10 (A): No odor at all.
 (B): A slight odor, but without any
 particular problems.
 (C): An offensive odor.

 Evaluation was organoleptically made according
15 to a panel test form. As a result, very good results
were obtained. The results are shown in Table 1. The
resin composition A of the present invention can be
applied to the surface treatment of paper by the means
as described above, even when used as it is.

20 (1-2) Preparation of toner:

Resin composition A (binder resin)	100 parts
Magnetite particles (average particle diameter: 0.3 μ ; serving as both a magnetic material and a coloring agent)	60 parts
25 Low-molecular polypropylene	3 parts
Negatively chargeable monoazo dye (a charge controlling agent)	1 part



1 The above materials were mixed, and the
mixture was thereafter hot-melted and kneaded at 120°C
using an extruder. After cooled, the kneaded product
was pulverized and classified to give a negatively
5 chargeable magnetic toner with a volume average
particle diameter of 11 μ .

The resulting magnetic toner was analyzed to
reveal that the content of benzaldehyde was not more
than 0.002 % by weight.

10 The negatively chargeable magnetic toner (100
parts) and 0.4 % by weight of negatively chargeable
colloidal silica (about 4 parts) were mixed to give a
magnetic toner having silica on its toner particle
surfaces. The magnetic toner thus prepared was loaded
15 into a modified machine of a laser beam printer LBP-
SX, manufactured by Canon Inc., in which a corona
charger was replaced with the contact charging roller
1 as shown in Fig. 1 in order to prevent generation of
ozone, and also an ozone filter was removed. Printing
20 was continuously carried out to obtain prints in solid
black on the whole area, and odors generated in that
case were observed.

The contact charging roller 1 had a diameter
of 12 mm; its metallic core 1c, a diameter of 5 mm;
25 its conductive rubber layer 1b, a thickness of about



1 3.5 mm; and the release film 1a formed of
methoxymethylated nylon, a thickness of 20 μm . The
roller 1 was pressed against the laminated-layer type
OPC photosensitive member 2 at a total pressure of 1.2
5 kg (linear pressure: 55 g/cm. A DC voltage (-700 V)
and an AC voltage (300 Hz, 1,500 V_{pp}) were applied to
the contact charging roller 1 through the voltage
applying means 3 so that the laminated-layer type OPC
photosensitive member 2 was electrostatically charged
10 and then an electrostatic image was formed using a
laser beam. The magnetic toner on the developing
sleeve was formed in a thickness of 130 μm , and the
closest gap between the developing sleeve and the
laminated-layer type OPC photosensitive member 2 was
15 set to be 300 μm . The electrostatic image was
developed to form a toner image, by a reversal
development system while a DC bias (-500 V) and an AC
bias (1,800 Hz, 1,600 V_{pp}) were applied to the
developing sleeve. The toner image thus formed was
20 electrostatically transferred to a plain paper.
Thereafter, the toner image transferred was fixed on
the plain paper by means of the heat roller having a
surface temperature of 180°C.

Evaluation on odors was made in the following
25 way: The above printer was placed at the center of a
small room of about 3 m square, and reproductions were

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1 taken. On its surroundings, 10 panelists chosen at
random smelled while they were changing their
positions little by little, and evaluated odors in the
same manner as in the above.

5 As a result, very good results were obtained,
and the toner was judged to have no problem of odors
(See Table 2).

Example 2

(2-1) Preparation of binder resin:

10 In a reaction vessel, 200 parts of cumene was
introduced, and heated to its reflux temperature. The
following mixture was dropwise added thereto over a
period of 4 hours under the reflux of cumene.

15 Monomer mixture	Mixing proportion
Styrene monomer	95 parts
α -Methylstyrene monomer	5 parts
Di-tert-butyl peroxide	8 parts

20 Also under the reflux of cumene, (146°C to
156°C), polymerization was completed and then the
cumene was removed. The resulting styrene/ α -
methylstyrene copolymer had an Mw of 4,500, an Mw/Mn
of 2.8, a main peak at a molecular weight of 4,400 in
the chart of GPC, and a Tg of 63°C.

25 The above styrene/ α -methylstyrene copolymer in
an amount of 30 parts was dissolved in the following

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1 monomer mixture to give a mixed solution.

Monomer mixture	Mixing proportion
Styrene monomer	55 parts
5 n-Ethylhexyl acrylate monomer	15 parts
Divinylbenzene	0.3 part
Benzoyl peroxide	1.3 parts

In the above mixed solution, 170 parts of water with a dissolved oxygen of about 1.8 mg/lit. in which 0.1 part of partially saponified polyvinyl alcohol was dissolved was added to give a suspension dispersion. In a reaction vessel, 15 parts of water was put, and the dissolved oxygen in water was made to be in a concentration of about 1.8 mg/lit. in the same manner as in Example 1. Similarly, the above suspension dispersion was added in the reaction vessel, and the reaction was carried out at reaction temperatures of from 70 to 95°C for 9 hours. After completion of the reaction, the reaction mixture was filtered, dehydrated and dried to give a resin composition B comprised of styrene/ α -methylstyrene copolymer and a styrene/2-hexyl acrylate copolymer.

In the resulting resin composition B, the THF-insoluble matter was in an amount of 32 % by weight. The molecular weight distribution of the THF-soluble matter was measured to reveal that it had peaks at



1 molecular weights of 5,000 and 42,000, respectively,
an Mn of 6,200, an Mw of 130,000, and an Mw/Mn of 21.
The component with a molecular weight of not more than
10,000 was in an amount of 20 % by weight. It was
5 also confirmed that the Tg of the resin composition B
was 58°C.

The content of benzaldehyde in the resin
composition B was 0.004 % by weight, and that of
styrene monomers was 0.035 % by weight.

10 Using the above resin composition B, tests
were carried out in the same manner as in Example 1 to
obtain good results.

(2-2) Preparation of toner:

A magnetic toner was prepared in the same
15 manner as in Example 1, except that the resin
composition was replaced with the resin composition B.
As a result, good results were similarly obtained.

The content of benzaldehyde in the toner was
confirmed to be 0.003 % by weight.

20 Example 3

(3-1) Preparation of binder resin:

In a reaction vessel, 200 parts of cumene was
introduced, and heated to its reflux temperature. The
following mixture was dropwise added thereto over a
25 period of 4 hours under the reflux of cumene.



1	Monomer mixture	Mixing proportion
	Styrene monomer	90 parts
	Methyl methacrylate monomer	10 parts
	Di-tert-butyl peroxide	8 parts

5 Also under the reflux of cumene (146°C to 156°C), polymerization was completed and then the cumene was removed. The resulting styrene/methyl methacrylate copolymer had an Mw of 3,900, an Mw/Mn of 2.6, a main peak at a molecular weight of 4,100, and a
10 Tg of 60°C.

 The above styrene/methyl methacrylate copolymer in an amount of 40 parts was dissolved in the following monomer mixture to give a mixed solution.

15	Monomer mixture	Mixing proportion
	Styrene monomer	38 parts
	n-Butyl methacrylate monomer	22 parts
	Divinylbenzene	0.24 part
20	Benzoyl peroxide	0.60 part
	tert-Butylperoxy-2-ethylhexanoate	0.80 part

 In the above mixed solution, 170 parts of water with a dissolved oxygen of about 1.8 mg/lit. in which 0.1 part of partially saponified polyvinyl
25 alcohol was dissolved was added to give a suspension dispersion. In a reaction vessel, 15 parts of water



1 was put, and the dissolved oxygen in water was made to
be in a concentration of about 1.8 mg/lit. in the same
manner as in Example 1. Similarly, the above
suspension dispersion was added in the reaction
5 vessel, and the reaction was carried out at reaction
temperatures of from 70 to 95°C for 9 hours. After
completion of the reaction, the reaction mixture was
filtered, dehydrated and dried to give a resin
composition C comprised of styrene/methyl methacrylate
10 copolymer and a styrene/n-butyl methacrylate
copolymer.

In the resulting resin composition C, the THF-
insoluble matter was in an amount of 35 % by weight.
The molecular weight distribution of the THF-soluble
15 matter was measured to reveal that it had peaks at
molecular weights of 4,000 and 43,000, respectively,
an Mn of 5,900, an Mw of 92,000, and an Mw/Mn of 16.
The component with a molecular weight of not more than
10,000 was in an amount of 32 % by weight. It was
20 also confirmed that the Tg of the resin composition C
was 60°C.

The content of benzaldehyde in the resin
composition C was not more than 0.003 % by weight, and
that of styrene monomers was 0.021 % by weight.
25 Evaluation on odors was made in the same manner as in
Example 1 to obtain good results.



1 (3-2) Preparation of toner:

A magnetic toner was prepared in the same manner as in Example 1, except that the resin composition was replaced with the resin composition C and the temperature for hot-melt kneading in the extruder was changed to 100°C. As a result, some panelists perceived a slight odor, but judged it to be of no particular problem.

The content of benzaldehyde in the toner in that case was confirmed to be 0.005 % by weight.

Example 4

(4-1) Preparation of binder resin:

Monomer mixture	Mixing proportion
Styrene monomer	55 parts
n-Butyl acrylate monomer	15 parts
Divinylbenzene	0.14 part
tert-Butylperoxy-2-ethylhexanoate	1.5 parts

In the above mixed solution, 170 parts of water with a dissolved oxygen of about 1.5 mg/lit. in which 0.1 part of partially saponified polyvinyl alcohol was dissolved was added to give a suspension dispersion. In a reaction vessel, 15 parts of water was put, and the dissolved oxygen in water was made to be in a concentration of about 1.5 mg/lit. in the same manner as in Example 1. Similarly, the above



1 suspension dispersion was added in the reaction
vessel, and the reaction was carried out at reaction
temperatures of from 70 to 95°C for 9 hours. After
completion of the reaction, the reaction mixture was
5 filtered, dehydrated and dried to give a resin
composition D comprised of a styrene/n-butyl acrylate
copolymer.

In the resulting resin composition D, the THF-
insoluble matter was in an amount of 44 % by weight.
10 The molecular weight distribution of the THF-soluble
matter was measured to reveal that it had a peak at a
molecular weight of 20,000, an Mn of 8,000, an Mw of
28,000, and an Mw/Mn of 3.5. The component with a
molecular weight of not more than 10,000 was in an
15 amount of 21 % by weight. It was also confirmed that
the Tg of the resin composition D was 56°C.

The content of benzaldehyde in the resin
composition D was not more than 0.003 % by weight, and
that of styrene monomers was 0.024 % by weight.
20 Evaluation on odors was made in the same manner as in
Example 1 to obtain good results, although fusing or
fixing properties to paper was slightly poor.

(4-2) Preparation of toner:

A magnetic toner was prepared in the same
25 manner as in Example 1, except that the resin
composition was replaced with the resin composition D.



1 Evaluation was also made. As a result, a solid black
image obtained was tolerable to practical use, but
fixing properties was slightly poor. In respect of
the odor, however, similarly good results were
5 obtained.

The content of benzaldehyde in the toner was
confirmed to be 0.003 % by weight.

Example 5

Evaluation of a panel test form was made in
10 the same manner as in Example 1, except that the
corona charger of the printer LBP-SX was not changed
and the ozone filter only was removed. As a result,
although the odor of aldehyde was little pointed out,
some panelists perceived the odor of ozone. The
15 toner, however, was judged to be good for practical
use.

Comparative Example 1

(1) Preparation of binder resin:

In a reaction vessel, 200 parts of cumene was
20 introduced, and heated to its reflux temperature. A
mixture of 100 parts of styrene monomers and 8 parts
of di-tert-butyl peroxide was dropwise added thereto
over a period of 4 hours under the reflux of cumene.
Also under the reflux of cumene (146°C to 156°C),
25 polymerization was completed and then the cumene was
removed. The resulting polystyrene was capable of



1 dissolving in THF, and had an Mw of 3,700, an Mw/Mn of
2.64, a main peak at a molecular weight of 3,500 as
measured by GPC, and a Tg of 57°C.

The above polystyrene in an amount of 30 parts
5 was dissolved in the following monomer mixture to give
a mixed solution.

Monomer mixture	Mixing proportion
Styrene monomer	54 parts
10 n-Butyl acrylate monomer	16 parts
Divinylbenzene	0.3 part
Benzoyl peroxide	1.3 parts

In the above mixed solution, 170 parts of
water with a dissolved oxygen of about 3.5 mg/lit. in
15 which 0.1 part of partially saponified polyvinyl
alcohol was dissolved was added to give a suspension
dispersion. In a reaction vessel, 15 parts of water
was put, and the dissolved oxygen in water was made to
be in a concentration of about 3.5 mg/lit., and
20 suspension polymerization was carried out at reaction
temperatures of from 70 to 95°C for 9 hours. After
completion of the reaction, the reaction mixture was
filtered, dehydrated and dried to give a comparative
resin composition E comprised of polystyrene and a
25 styrene/n-butyl acrylate copolymer.

The content of benzaldehyde in the above

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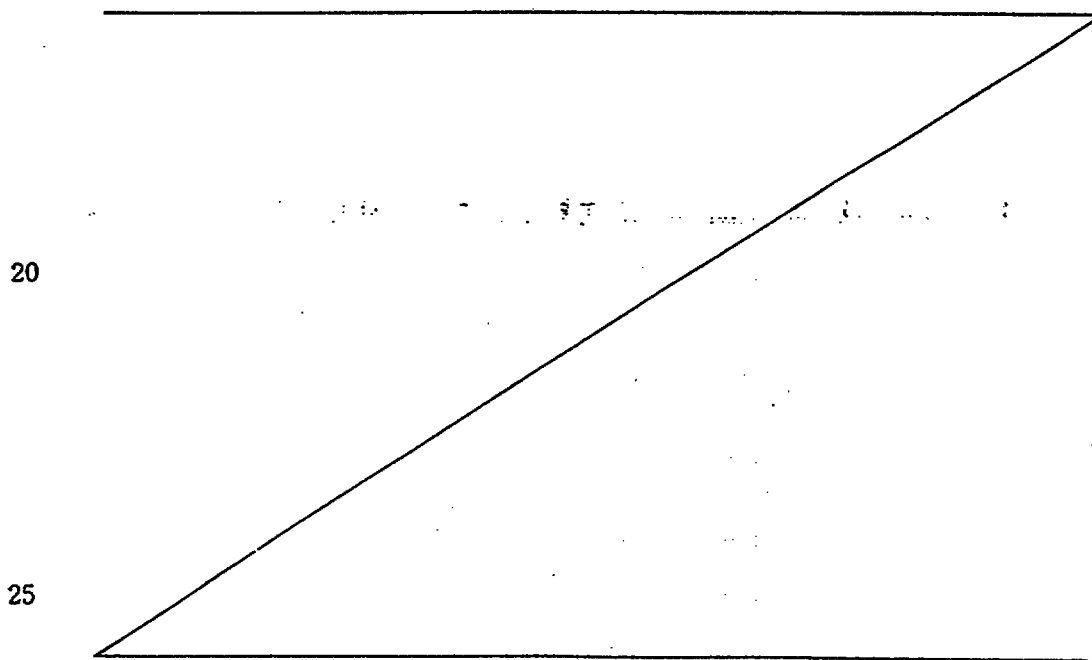


1 comparative resin composition E was 0.019 % by weight,
and that of styrene monomers was 0.07 % by weight. As
a result of a panel test carried out in the same
manner as in Example 1, many panelists perceived an
5 odor and considered it offensive, and the resin
composition was judged to be no good for its
application in the surface processing of paper.

(2-2) Preparation of toner:

Example 1 was repeated, except that the resin
10 composition was replaced with the comparative resin
composition E. As a result, many panelists perceived
an odor and considered it offensive, and the toner was
judged to be no good for practical use.

The content of benzaldehyde in the toner in
15 that case was confirmed to be 0.009 % by weight.



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1 Comparative Example 2

(1) Preparation of binder resin:

 In a reaction vessel, 200 parts of cumene was introduced, and heated to its reflux temperature. A
5 mixture of 100 parts of styrene monomers and 8 parts of di-tert-butyl peroxide was dropwise added thereto over a period of 4 hours under the reflux of cumene. Also under the reflux of cumene (146°C to 156°C), polymerization was completed and then the cumene was
10 removed. The resulting polystyrene was capable of dissolving in THF, and had an Mw of 3,700, an Mw/Mn of 2.64, a main peak at a molecular weight of 3,500 as measured by GPC, and a Tg of 57°C.

 The above polystyrene in an amount of 30 parts
15 was dissolved in the following monomer mixture to give a mixed solution.

Monomer mixture	Mixing proportion
Styrene monomer	54 parts
20 n-Butyl acrylate monomer	16 parts
Divinylbenzene	0.3 part
Benzoyl peroxide	1.3 parts

 In the above mixed solution, 170 parts of water with a dissolved oxygen of about 2.8 mg/lit. in
25 which 0.1 part of partially saponified polyvinyl alcohol was dissolved was added to give a suspension



1 dispersion. In a reaction vessel, 15 parts of water
was put, and the dissolved oxygen in water was made to
be in a concentration of about 2.8 mg/lit., and the
reaction was carried out at reaction temperatures of
5 from 70 to 95°C for 9 hours. After completion of the
reaction, the reaction mixture was filtered,
dehydrated and dried to give a comparative resin
composition F comprised of polystyrene and a styrene/n-
butyl acrylate copolymer.

10 The content of benzaldehyde in the above
comparative resin composition F was 0.015 % by weight,
and that of styrene monomers was 0.03 % by weight. As
a result of a panel test carried out in the same
manner as in Example 1, the resin composition was
15 judged to be no good as in Comparative Example 1.

(2) Preparation of toner:

Example 1 was repeated, except that the resin
composition used was replaced with the comparative
resin composition F. As a result, the toner was
20 judged to be no good as in Comparative Example 1.

The content of benzaldehyde in the toner in
that case was confirmed to be 0.007 % by weight.

Example 6

In a reaction vessel, 150 parts of cumene was
25 introduced, and heated to its reflux temperature. The
following mixture was dropwise added thereto over a



1 period of 4 hours under the reflux of cumene.

Monomer mixture	Mixing proportion
Styrene monomer	100 parts
5 Di-tert-butyl peroxide	4 parts

Also under the reflux of cumene (146°C to
156°C), polymerization was completed and then the
cumene was removed. The resulting styrene/methyl
methacrylate copolymer had an Mw of 6,900, an Mw/Mn of
10 2.3, a main peak at a molecular weight of 7,100, and a
Tg of 75°C.

The above styrene/methyl methacrylate
copolymer in an amount of 30 parts was dissolved in
the following monomer mixture to give a mixed
15 solution.

Monomer mixture	Mixing proportion
Styrene monomer	52 parts
n-Butyl acrylate monomer	18 parts
20 Divinylbenzene	0.3 part
Benzoyl peroxide	0.9 part
tert-Butylperoxy-2-ethylhexanoate	0.7 part

In the above mixed solution, 170 parts of
water with a dissolved oxygen of about 2.3 mg/lit. in
25 which 0.1 part of partially saponified polyvinyl
alcohol was dissolved was added to give a suspension

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1 dispersion. In a reaction vessel, 15 parts of water
was put, and the dissolved oxygen in water was made to
be in a concentration of about 2.3 mg/lit. in the same
manner as in Example 1. The above suspension
5 dispersion was added in the reaction vessel, and the
reaction was carried out at reaction temperatures of
from 70 to 95°C for 9 hours. After completion of the
reaction, the reaction mixture was filtered,
dehydrated and dried to give a resin composition G
10 comprised of a styrene polymer and a styrene/n-butyl
acrylate copolymer.

In the resulting resin composition G, the THF-
insoluble matter was in an amount of 30 % by weight.
The molecular weight distribution of the THF-soluble
15 matter was measured to reveal that it had peaks at
molecular weights of 7,500 and 43,000, respectively,
an Mn of 6,500, an Mw of 100,000, and an Mw/Mn of 15.
The component with a molecular weight of not more than
10,000 was in an amount of 18 % by weight. It was
20 also confirmed that the Tg of the resin composition G
was 61°C. The content of benzaldehyde in the resin
composition G was 0.008 % by weight, and that of
styrene monomers was 0.056 % by weight.

An odor test on the above resin composition G
25 was carried out in the same manner as in Example 1.
As a result, some panelists perceived an odor, but the



1 resin composition was judged to be good for practical
use.

Results of panel tests on odors, carried out
in Examples and Comparative Examples are shown below
5 in Tables 1 and 2.

Table 1
Evaluation on odors of binder resins

10		Example					Comparative example	
		1	2	3	4	6	1	2
	Resin composition:							
		A	B	C	D	G	E	F
15	Evaluation:						(persons)	
	(A):	9	7	8	8	5	2	3
	(B):	1	3	2	2	5	3	3
	(C):	0	0	0	0	1	5	4
	Overall judgement:							
20		Good	Good	Good	Good	Good	No good	No good



1

Table 2

Evaluation on odors of toners

5

10

15

Example					Comparative example		
1	2	3	4	5	1	2	
Resin composition:							
A	B	C	D	A	E	F	
Evaluation:					(persons)		
(A):	10	8	6	8	5	2	3
(B):	0	2	4	2	5	2	3
(C):	0	0	0	0	0	6	4
Overall judgement:							
	Good	Good	Good	Good	Good	No good	No good

With wide spread of electrophotography, toners are required also to have good properties against odors that may be generated at the time of fusing or fixing by heat. The present inventors made intensive studies so that such requirement can be met. As a result, they have discovered that the amount of oxidized products of polymerizable monomers remaining in a binder resin for a toner, in particular, the amount of aldehydes remaining therein has a great

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1 influence, and has reached a finding that, for the
achievement of a decrease thereof, it is necessary to
control the amount of dissolved oxygen in the water
used when suspension polymerization is carried out.

5 The binder resin for a toner that has been
synthesized through such measures brings about very
good results on odors. Thus, they have made it
possible to provide a suspension polymerization resin
and a toner which are free from the problem of odors.

10 The present invention provide a toner for
developing an electrostatic image. The toner comprises
a binder resin and a coloring agent. The binder resin
comprises a styrene type binder resin. The amount of
an aldehyde contained in the binder resin is not more
15 than 0.005 % by weight based on the weight of the toner.
The binder resin is produced by a process comprising
the steps of preparing a monomer composition comprising
a polymerizable monomer containing at least not less
than 50 % by weight of a styrene monomer, and a
20 polymerization initiator, and subjecting said monomer
composition to suspension polymerization in an aqueous
medium having dissolved oxygen in an amount of not more
than 2.5 mg/lit to form a styrene polymer or copolymer
containing an aldehyde monomer in an amount of not more
25 than 0.01 % by weight.

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The present invention provides
an image forming method comprising:
electrostatically charging a chargeable member for
supporting thereon an electrostatic image by a contact
charging assembly;
forming an electrostatic image on the chargeable
member;
developing the electrostatic image on the chargeable
member to form a toner image with a toner comprising a
styrene binder resin and a coloring agent, wherein an
aldehyde is contained in said toner in an amount of not
more than 0.005% by weight based on the weight of the
toner;
transferring the toner image to a transfer paper; and
fixing the toner image on the transfer paper by
applying heat and pressure to the toner image.

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Claims 1 to 32 for the divisional application

1. An image forming method comprising:
electrostatically charging a chargeable member for supporting thereon an electrostatic image by a contact charging assembly;
forming an electrostatic image on the chargeable member;
developing the electrostatic image on the chargeable member to form a toner image with a toner comprising a styrene binder resin and a coloring agent, wherein an aldehyde is contained in said toner in an amount of not more than 0.005% by weight based on the weight of the toner;
transferring the toner image to a transfer paper; and
fixing the toner image on the transfer paper by applying heat and pressure to the toner image.
2. The image forming method according to claim 1, including employing a contact charging roller to electrostatically charge the chargeable member.
3. The image forming method according to claim 1, including employing a photosensitive drum as the chargeable member for supporting thereon an electrostatic image and a contact charging assembly to electrostatically charge the chargeable member.
4. The image forming method according to claim 1, including employing a photosensitive drum as the chargeable member for supporting thereon an electrostatic image and a contact charging roller to electrostatically charge the chargeable member.
5. The image forming method according to claim 1, including fixing the toner image on the transfer paper employing a heat-pressure roller fixing unit.
6. The image forming method according to claim 1, wherein





said styrene binder resin contains THF-insoluble matter.

7. The image forming method according to any one of claims 1 to 6, wherein said styrene binder resin comprises a cross-linked styrene polymer or styrene copolymer or a mixture thereof.

8. The image forming method according to any one of claims 1 to 7, wherein said styrene binder resin contains THF-insoluble matter and contains an aldehyde in an amount of not more than 0.01% by weight based on the weight of the styrene binder resin.

9. The image forming method according to claim 8, wherein said styrene binder resin comprises a cross-linked styrene resin and contains an aldehyde in an amount of not more than 0.005% by weight based on the weight of the styrene binder resin.

10. The image forming method according to claim 9, wherein said aldehyde comprises benzaldehyde.

11. The image forming method according to any one of claims 1 to 10, wherein said styrene binder resin comprises a styrene polymer or a styrene copolymer prepared by suspension polymerization or a mixture thereof.

12. The image forming method according to any one of claims 1 to 11, wherein said aldehyde is contained in an amount of not more than 0.004% by weight based on the weight of the toner.

13. The image forming method according to any one of claims 1 to 12, wherein said coloring agent comprises a magnetic material.

14. The image forming method according to claim 13, wherein said magnetic material is present in an amount of from 30 to 150 parts by weight based on 100 parts by weight of the binder resin.

15. The image forming method according to claim 13, wherein





said magnetic material is present in an amount of from 40 to 100 parts by weight based on 100 parts by weight of the binder resin.

16. The image forming method according to any one of claims 1 to 15, wherein said coloring agent comprises at least one of a dye and a pigment.

17. The image forming method according to claim 16, wherein said coloring agent is present in an amount of from 5 to 20 % by weight based on the weight of the binder resin.

18. The image forming method according to any one of claims 1 to 17, wherein said styrene binder resin is cross-linked with divinylbenzene.

19. The image forming method according to any one of claims 1 to 18, wherein said styrene binder resin comprises a styrene-acrylate copolymer.

20. The image forming method according to any one of claims 1 to 19, wherein said styrene binder resin comprises a styrene-methacrylate copolymer.

21. The image forming method according to any one of claims 1 to 20, wherein said styrene binder resin contains from 10 to 70% by weight of a THF-insoluble matter.

22. The image forming method according to any one of claims 1 to 21, wherein said styrene binder resin contains from 10 to 60% by weight of a THF-insoluble matter.

23. The image forming method according to any one of claims 1 to 22, wherein said binder resin (i) has a weight average molecular weight/number average molecular weight(Mw/Mn) of ≥ 5 , at least one peak in the region of a molecular weight of from 2,000 to 10,000 and at least the peak or shoulder in the region of a molecular weight of from 15,000 to 100,000 in the molecular





weight distribution measured by gel permeation chromatography of a THF-soluble matter in the binder resin, and (ii) contains a component with a molecular weight of not more than 10,000 in an amount of from 10 to 50 % by weight based on the THF-soluble resin composition.

24. The image forming method according to claim 23, wherein said binder resin contains from 10 to 70% by weight of a THF-insoluble matter.

25. The image forming method according to claim 23, wherein said binder resin contains from 10 to 60% by weight of a THF-insoluble matter.

26. The image forming method according to claim 23, wherein said binder resin comprises a styrene binder resin cross-linked with a cross-linking agent and the cross-linked styrene binder resin is prepared by suspension polymerization.

27. The image forming method according to any one of claims 1 to 26, wherein said binder resin comprises a styrene binder resin containing coproduced benzaldehyde contaminant having an undesired odor, wherein said benzaldehyde is present in said toner in an amount of not more than 0.005% by weight based on the weight of the toner.

28. The image forming method according to any one of claims 1 to 27, wherein said binder resin contains THF-insoluble matter and contains benzaldehyde in an amount of not more than 0.01% by weight based on the weight of the styrene binder resin.

29. The image forming method according to claim 28, wherein said styrene binder resin comprises a cross-lined styrene resin and contains benzaldehyde in an amount of not more than 0.005% by weight based on the weight of the cross-linked styrene resin.

30. The image forming method according to any one of claims



1 to 29, wherein said binder resin has a weight average molecular weight/number average molecular weight(Mw/Mn) of ≥ 5 , at least one peak in the region of a molecular weight of from 2,000 to 10,000 and at least the peak or shoulder in the region of a molecular weight of from 15,000 to 100,000 in the molecular weight distribution measured by gel permeation chromatography of a THF-soluble matter in the binder resin.

31. The image forming method according to any one of claims 1 to 30, wherein said styrene type binder resin comprises a mixture of a non-crosslinked styrene polymer or styrene copolymer and a crosslinked styrene polymer or styrene copolymer.

32. The image forming method according to any one of claims 1 to 31, wherein said styrene type binder resin comprises a mixture of a styrene polymer or styrene copolymer prepared by solution polymerization and a styrene polymer or styrene copolymer prepared by suspension polymerization.

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