

LASER-MARKING ADDITIVE

This invention relates to a laser-marking additive, as well as a method of preparation thereof, a laser-markable composition comprising the laser-marking
5 additive and preparation thereof. The invention also relates to molded parts comprising laser-markable compositions and films made from laser-markable compositions.

Laser-marking additives are known, and include for example antimony trioxide, as described in WO01/00719. However, antimony trioxide is under
10 suspect of being carcinogenic and therefore antimony-free laser-marking additives are desired.

The object of the present invention is therefore to have a laser-marking additive which exhibits good laser-marking performance while having lower amounts of antimony.

It has surprisingly been found that a laser-marking additive which
15 comprises a bismuth containing compound and a functionalized polymer having 0.01 to 50 wt% of functional groups, in which the weight percentage is based on the total amount of functionalized polymer and bismuth containing compound, exhibits good laser-marking performance while having lower amounts of antimony. This has been exemplified in examples which are listed below.

20 An additional advantage of the laser-marking additive according to the invention is that it is easily prepared. Another advantage is that the laser-marking additive according to the invention comprises less halogens and preferably is halogen-free.

Antimony-free laser-marking additives are known. EP1190988 for
25 example describes laser-markable compounds comprising bismuth and at least one additional metal. US2007/02924 describes laser-markable compounds of the formula MOCl , in which M is either As, Sb or Bi, as well as BiONO_3 , $\text{Bi}_2\text{O}_2\text{CO}_3$, BiOOH , BiOF , BiOBr , Bi_2O_3 , $\text{BiOC}_3\text{H}_5\text{O}_7$, $\text{Bi}(\text{C}_7\text{H}_5\text{O}_2)_3$, BiPO_4 , $\text{Bi}_2(\text{SO}_4)_3$ as additive. Many of these additives comprise halogens, which is undesirable. Another disadvantage is that
30 certain matrix polymers in which Bismuth containing compounds are directly mixed show severe discoloration when high processing temperatures are used. It has been shown that temperatures above 220 °C show severe discoloration of the composition when matrix polymers such as polyesters and polyamides are used. This results in poor laser-marking performance. Without wishing to be bound by theory, the inventors

believe that this is most probably caused by a reaction between the laser-marking additive and the matrix polymer resulting in degradation.

It has been found that laser-marking additives according to the invention do not show discoloration upon mixing with a matrix polymer.

5 One of the solutions found to disperse laser-marking additives in matrix polymers is described in WO2004/050766. This document describes microspheres having a core and a shell and a laser light absorber in which antimony is used. Microspheres as described in WO2004/050766 have the disadvantage that at least two carriers are needed, one for the core and one for the shell, before the
10 microsphere is dispersed in the matrix polymer. Furthermore two processing steps are required to obtain the laser-marking additive which results in additional costs.

 It has surprisingly been found that the laser-marking additive according to the invention can be easily prepared by melt-blending a bismuth containing compound with a functionalized polymer having 0.01 to 50 wt% of functional
15 groups, in which the weight percentage is based on the total amount of functionalized polymer and bismuth containing compound. In this method one carrier is needed, which simplifies the process for preparation.

 Another advantage of the laser-marking additive according to the invention is that the Comparative Tracking Index (hereafter CTI) of a laser-markable
20 composition is less influenced when the laser-marking additive according to the invention is incorporated, as compared to compositions comprising antimony as laser-marking additive. Compositions comprising antimony have been shown to have a reduced CTI with respect to compositions that do not comprise antimony, while employing the laser-marking additive according to the invention hardly influences the
25 CTI.

 Preferably, the laser-marking additive is antimony-free, as antimony is under suspect of being carcinogenic.

 Preferably, the laser-marking additive is halogen-free, as halogens are undesired.

30 Laser-marking additives according to the invention are incorporated in a matrix polymer to provide a laser-markable composition. The matrix polymer includes thermoplastic polymers, such as polyamides, polycarbonates and polyesters. Preferably the matrix polymer is a polyamide, such as PA6, PA66, PA46, PA4,10, PA6,10, PA11, PA12 or a polyester such as PET, PBT and PEN. The laser-marking
35 additive is particularly advantageous melt-blended in matrix polymers that require a

temperature above 220 °C, as it has been shown that no discoloration of the laser-markable composition occurs at these temperatures.

Surprisingly it has been shown that the laser-markable additive when incorporated in a matrix polymer, can serve as a laser-markable masterbatch for any further thermoplastic polymer, including polyolefins, thermoplastic polyurethanes, polyamides, polycarbonates, styrenics and polyesters as long as the melting temperature of the further thermoplastic polymer is lower than the highest melting temperature of the matrix polymer.

Examples of polyamides include PA66, PA11, PA12, PA410, PA610, PA46. Examples of styrenics include Styrene Acrylonitrile (SAN), acrylonitrile butadiene styrene (ABS), polystyrene (PS) Examples of acrylics include Polymethylmethacrylate (PMMA), Polyhydroxyethylmethacrylate (HEMA). Examples of polyolefins include Polyethylene (PE), polypropylene (PP), ethylene propylene diene copolymers (EPDM), thermoplastic vulcanizates (TPV's) and copolymers thereof. Other examples include Ethylene methacrylate polymer (EMA), ethylene butyl acrylate copolymer (EBA), ethylene vinyl acetate copolymer (EVA), Maleic acid grafted PE and PP, Polyvinylchloride (PVC), thermoplastic polyurethanes (TPU) Polyhydroxyalkanoates (PHA's), polylactic acid (PLA), Polycaprolacton (PCL).

The obtained composition is here also denoted as laser-markable composition. This has the advantage that the resolution of the laser-markable composition is further enhanced. For producing a laser-markable masterbatch preferably a polyamide or polyester is used as matrix polymer, more preferably polyamide-6 or PBT.

The present invention also relates to a method for processing of a laser-markable composition, in which the processing of the laser-markable composition is effected at a temperature of at least 220 °C. This results in a composition that has good laser-marking performance, while showing less discoloration of the laser-markable composition.

The laser-markable composition might comprise additives, such as fillers, flame retardants, pigments etc. As whitener for the laser-markable composition various additives can be used, such as titane dioxide or zinc sulfide. The laser-marking additive according to the invention can advantageously be used in a composition which comprises zinc sulfide as whitener, as this allows the composition to be laser-marked by UV-lasers. Preferably, the laser-marking additive comprises aluminum to enhance the laser-marking performance.

The laser-marking additive is capable of absorbing laser light of a certain wavelength. In practice this wavelength lies between 157 nm and 10.6 micrometer, the customary wavelength range of lasers. If lasers with larger or smaller wavelengths become available, other absorbers may also be considered for application in the additive according to the invention. Examples of such lasers working in the said area are CO₂ lasers (10.6 micrometer), Nd:YAG lasers (1064, 532, 355, 266 nm) vanadat-and excimer lasers of the following wavelengths: F₂ (157 nm), ArF (193 nm), KrCl (222 nm), KrF (248 nm), XeCl (308 nm) and XeF (351 nm), FAYb fiber lasers, diode lasers and diode array lasers. Preferably Nd:YAG lasers and CO₂ lasers are used since these types work in a wavelength range which is very suitable for the induction of thermal processes that are applied for marking purposes.

Functionalized polymers are here understood to be polymers that have functional groups which can react with other functional groups.

Examples of suitable functional groups are carboxylic acid groups, anhydride groups, ester groups, salt groups, ether groups, epoxy groups, amine groups, alkoxy silane groups, alcohol groups or oxazoline groups. Preferably, the functional group is chosen from the group of maleic anhydride (MAH) or epoxy, as these groups have shown to show good laser performance in a laser-marking additive according to the invention.

Suitable polymers that can be provided with functional groups include for example polyolefins, elastomers, EP-rubbers, EPDM-rubbers and styrenic polymers.

Preferably, the polymer is a polyolefin. Examples of suitable polyolefins are ethylene polymers and propylene polymers. Examples of suitable ethylene polymers are all thermoplastic homopolymers of ethylene and copolymers of ethylene with as comonomer one or more α -olefins with 3-10 C-atoms, in particular propylene, isobutene, 1-butene, 1-hexene, 4-methyl-1-pentene and 1-octene, that can be prepared using the known catalysts such as for example Ziegler-Natta, Philips and single-site catalysts. The quantity of comonomer as a rule lies between 0 and 50 wt.%, and preferably between 5 and 35 wt. %. Such polyethylenes are known as high-density polyethylene (HDPE), low-density polyethylene (LDPE), linear low-density polyethylene (LLDPE), linear very low-density polyethylene (VL (L) DPE) and plastomers.

Examples of suitable propylene polymers are homopolymers of propylene, random copolymers, copolymers and single-site polymers.

The functional groups may be present in the polymer intrinsically, such as in copolymers, but may also be present due to grafting. Suitable polymers in which a functional group is intrinsically present include for example ethylene vinyl acetate (EVA), ethylene methylacrylate (EMA), ethylene butylacrylate (EBA), poly vinyl acetate (PVA), poly glycidyl methacrylate (PGMA), styrene maleic anhydride (SMA) and ionomers.

Preferably, the functional group is present in the polymer by grafting an ethylenically unsaturated functionalised compound on the polymer.

Suitable ethylenically unsaturated functionalised compounds are those which can be grafted on at least one of the aforesaid suitable polymers. The ethylenically unsaturated functionalised compounds contain a carbon-carbon double bond and can form a side branch on a polymer by grafting thereon.

Examples of suitable ethylenically unsaturated functionalised compounds are the unsaturated carboxylic acids and esters and anhydrides and metallic or non-metallic salts thereof. Preferably the ethylenic unsaturation in the compound is conjugated with a carbonyl group. Examples are acrylic, methacrylic, maleic, fumaric, itaconic, crotonic, methyl crotonic and cinnamic acid and esters, anhydrides and possible salts thereof. Of the compounds with at least one carbonyl group, maleic anhydride is preferred.

Examples of suitable ethylenically unsaturated functionalised compounds with at least one epoxy ring are, for example, glycidyl esters of unsaturated carboxylic acids, glycidyl ethers of unsaturated alcohols and of alkyl phenols and vinyl and allyl esters of epoxy carboxylic acids. Glycidyl methacrylate is particularly suitable.

Examples of suitable ethylenically unsaturated functionalised compounds with at least one amine functionality are for example allyl amine, propenyl, butenyl, pentenyl and hexenyl amine, amine ethers, for example isopropenylphenyl ethylamine ether. The amine group and the unsaturation should be in such a position relative to each other that they do not influence the grafting reaction to any undesirable degree.

The amines may be unsubstituted but may also be substituted with for example alkyl and aryl groups, halogen groups, ether groups and thioether groups.

Examples of suitable ethylenically unsaturated functionalised compounds with at least one alcohol functionality are all ethylenically unsaturated compounds with a hydroxyl group that may or may not be etherified or esterified, for example allyl and vinyl ethers of alcohols such as ethyl alcohol and higher branched

and unbranched alkyl alcohols as well as allyl and vinyl esters of alcohol substituted acids, preferably carboxylic acids and C3-C8 alkenyl alcohols.

In a preferred embodiment the functionalized polymer is chosen from the group of grafted polyolefin and poly (glycidyl methacrylate). More preferred the functionalized polymer is a grafted polyethylene or grafted polypropylene. Preferably the polyethylene or polypropylene is grafted with an ethylenically unsaturated functionalized compound.

The functionalized polymer has 0.01 to 50 wt% of functional groups, in which the weight percentage is based on the total amount of functionalized polymer and bismuth containing compound. Preferably the functionalized polymer has at least 0.05 wt% functional groups and more preferably at least 0.1 wt% functional groups, in which the weight percentage is based on the total amount of functionalized polymer and bismuth containing compound. Preferably the functionalized polymer has at most 40 wt% of functional groups, more preferably at most 30 wt% and even more preferably at most 20 wt% of functional groups, in which the weight percentage is based on the total amount of functionalized polymer and bismuth containing compound.

Bismuth-containing compounds are known to a person skilled in the art, and are for example described in US2007/02924. A Bismuth-containing compound is here understood to include bismuth-salts, bismuth-oxides etc. The compounds can, for example, be chosen from the group of BiONO_3 , $\text{Bi}_2\text{O}_2\text{CO}_3$, BiOOH , BiOF , BiOBr , Bi_2O_3 , $\text{BiOC}_3\text{H}_5\text{O}_7$, $\text{Bi}(\text{C}_7\text{H}_5\text{O}_2)_3$, BiPO_4 , $\text{Bi}_2(\text{SO}_4)_3$, and Bi-citrate. The Bismuth-containing compound is preferably halogen-free, as halogens are undesirable. More preferably, the Bismuth-containing compound is Bi-citrate, as Bi-citrate is halogen-free. Most preferred is Bi_2O_3 as Bismuth-containing compound, as Bi_2O_3 is halogen free, has a light color hence little influence on background color and gives high contrast at highest marking speed compared to other Bi- containing compounds.

In the present invention the bismuth-containing compound is present in the functionalized polymer in an amount of between 0.1 wt% and 95 wt%, more preferably between 5 and 80 wt% and most preferable between 50 and 80 wt%, based on the total amount of functionalized polymer and bismuth containing compound. To choose a suitable concentration the person skilled in the art will principally be guided by the desired amount of the laser-marking additive in the matrix polymer.

It is even possible that the amount of bismuth is as low as 500 ppm in the laser-markable composition to obtain good resolution, or even as low as 250 ppm. Preferably, the amount of Bismuth in a laser-markable composition is between 0.05 to

2 wt%, based on the total weight of the composition. This gives good laser-marking performance while retaining the mechanical properties of the composition.

The present invention also relates to a method for preparation of a laser-marking additive wherein the functionalized polymer is melt-blended with the bismuth-containing compound. This method offers the advantage of only involving one processing step.

The present invention also relates to a method for processing a laser-markable composition according to the invention in which the processing is effected at a temperature of at least 220 °C. This processing results in less degradation of the matrix polymer.

The present invention also relates to molded parts comprising the laser-markable composition. These parts are for example circuit breakers or lamp holders. The parts show good laser-marking performance.

The present invention also relates to films made from the laser-markable composition. These films show high laser-marking performance.

The invention will be elucidated on the basis of the following examples.

In the Examples and Comparative Experiments the following materials are used:

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As the absorber(s) in the laser-marking additive:

A-1 Bismuth oxide Bi_2O_3

A-2 Antimony tin oxide

A-3 Antimony tri oxide

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As polymer in the laser-marking additive (LMA)

P1 LLDPE grafted with 0.26 wt. % MAH relative to the functionalised polymer.

P2 Fusabond ® MO525D (Dupont), which is a polyethylene grafted with 0.9 wt. % MAH, relative to the functionalized polymer.

30 P3 LLDPE, which is a copolymer of ethylene and octene with a meltindex of 30.

As polymer in the laser-markable masterbatch (LMB)

P4 HDPE

35 As the matrix polymer in the laser-markable composition (LMC)

M-1. Akulon® K222-KGV4 from DSM: PA-6, 20% Glass fiber reinforced, comprises flame retardant and is halogen and phosphorous free.

M1-1 Polyamide 6 compound, 20% Glass fiber reinforced, comprises flame retardant and is halogen and phosphorous free.

- 5 M-1.2. Polyamide 6, 25% Talcum filled/reinforced, comprises flame retardant and is halogen and phosphorous free.

M-2 Polybutylene terephthalate (PBT) 1060 DSM

M-2.1 Polybutylene terephthalate 20% Glass fiber reinforced.

- 10 M-2.2 Polybutylene terephthalate 20% Glass fiber reinforced, comprises flame retardant and is halogen and phosphorous free.

M-3 TPE Thermoplastic co-polyether ester elastomer

All amounts are in parts per weight, except where stated otherwise.

Method of preparation laser-marking additive (LMA)

- 15 Using a twin-screw extruder (ZSK 30 of Werner & Pfleiderer) a number of laser-marking additives, LMA01 – LMA04 were produced, as well as a comparative example. The composition of the LMAs are given in Table 1. The screw speed was 250 rounds per minute and the throughput 20 kg/h. Temperature was 140 °C at zone 1 and 160 °C at zone 10.

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Table 1. Laser-marking additive

Compound	LMA01	LMA02	LMA03	LMA04	Comparative LMA_A
Polymer	P1 95	P1 50	P2 95	P2 50	P3 50
Absorber	A1 5	A1 50	A1 5	A1 50	A1 50

Method of preparation laser-markable composition (LMB)

- 25 Laser-marking compositions were produced on using a twin-screw extruder (ZSK 30 of Werner & Pfleiderer). The composition of the LMBs and the processing conditions are given in Table 1.1

The screw speed was 250 rounds per minute at a throughput of 10 kg per hour. From zone 1 to 10 the temperature was equal at 280 °C.

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Table 1.1. Laser-marking master-batch

Compound	LMB01
LMA02	25
M1	25
P4	47,5
P2	2,5
Tmelt [°C]	280

Method of preparation laser-markable composition (LMC)

5 Laser-marking compositions were produced on using a twin-screw extruder (ZSK 30 of Werner & Pfleiderer). The composition of the LMCs and the processing conditions are given in Table 2.

10 The screw speed was 250 rounds per minute at a throughput of 15 kg per hour. The temperature in zone 1 was 190 °C for polyamide (M-1,M-1.1, M-1.2) as matrix, and 230 °C for polybutylene terephthalate (M-2, M-2.1,M2.2) as matrix. The temperature in zone 10 was 280 °C for the matrix polymers compositions based on polyamide and polybutylene terephthalate (M-1, 1.1 M-2 M2.1 and M2.2). For the TPE Thermoplastic co-polyether ester elastomer (M-3) the temperature in zone 195 °C. The temperature in zone 10 was 240 °C.

Table 2. Laser-markable composition (LMC) and processing conditions

Compound	LMC01	LMC02	LMC03	LMC04	Comparative Example 1	Comparative Example 2	Comparative Example 3	Comparative Example 4
Laser- marking additive:	LMA02 2	LMA02 1	LMA02 0.5	LMA02 2	Bi ₂ O ₃ 0.25	Bi ₂ O ₃ 0.25	LMA_A 2	LMA_A 2
Matrix polymer: Polyamide M- 1	98	99	99.5		99.75		98	
Matrix polymer: PBT M- 2				98		99.75		98
T melt [°C]	300	300	301	300	280	280	300	300
Torque [%]	68	67	67	59	n.a.	n.a.	n.a.	n.a.

n.a.= not available; all amounts given in wt%, based on the total amount laser-
markable composition.

Table 2-1. Laser-markable composition (LMC) and processing conditions

		LMC05	LMC06	LMC07	LMC08	LMC09
Matrix polymer:	M-1.1	100	99	99,5	99,75	99
LMA:	LMA02		1	0,50	0,25	
LMA:	LMA04					1
Temp. [°C]		280-290				

Table 2-2. Laser-markable composition (LMC) and processing conditions

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		LMC10	LMC11	LMC12	LMC13	LMC14
Matrix polymer:	M-1.2	100	99	99,5	99,75	99
LMA:	LMA02		1	0,5	0,25	
LMA:	LMA04					1
Temp. [°C]		280-300				

Table 2-3. Laser-markable composition (LMC) and processing conditions

		LMC15	LMC16	LMC17	LMC18	LMC19	LMC20	LMC21
Matrix polymer								
	M-2.1				99	99,5	99,75	99
	M-3	98	99	99,5				
LMA:	LMA02	2	1	0,5	1	0,5	0,25	
LMA	LMA04							1
Temp. [°C]		240-250			280-300			

Table 2-4. Laser-markable composition (LMC) and processing conditions

		LMC22	LMC23	LMC24	LMC25
Matrix polymer:	M-2.2	99	99,5	99,75	99
LMA:	LMA02	1	0,5	0,25	
LMA:	LMA04				1
Temp. [°C]		280-290			

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		LMC26	LMC27	LMC28
further polymer:	P4	92	97	96
LMB:	LMB01	2	3	4
Temp. [°C]		180-190		

AI blends (LMC01 to LMC28), resulted in a composition, in which the presence of the laser-marking additive did hardly have any effect on the colour. Comparative Example 1 and 2, however, resulted in severe discoloration, and could no longer be processed

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into laser-markable samples. Also Comparative Examples 3 and 4 showed severe discoloration upon mixing with the matrix polymer, and could no longer be processed into laser-markable samples, due to degradation of the matrix polymer.

5 Preparation of laser-marking samples

From the laser-markable composition samples were produced using injection moulding. The temperature in zone 1 was set to 215 °C for all samples. The temperature of zone 2, zone 3 and the nose were all 225 °C for the samples with polyamide as matrix polymer and 230 °C, 240 °C and 240 °C respectively, for the sample with PBT as matrix polymer. For the sample with TPE (M-3) as matrix polymer the temperature in zone 1 was set 200 °C for all samples and 210°C, 230°C and 240°C in zone 2,3 and the nose.

Laser-marking performance

15 Laser-marking evaluations were performed with a diode-pumped Trumpf VMc3 laser system. So-called evaluation matrices were marked. In such matrices, the marking speed (v [mm/sec]) and frequency (f [kHz]) are varied at given power (p [%]), focal distance ($z=0$ [in focus] or 6 mm above the sample) and line spacing. Basically the evaluation matrices indicate which contrast can be obtained at
20 certain marking speed with varying laser parameters. An evaluation of the laser-marking performance with respect to contrast and marking speed in terms ranging from excellent (+++++) to poor (-----) is given in Table 3.

Table 3: Assessment of the laser-marking performance of the LMSA at a laser power of
25 40% and a line speed of 3000 mm/min

Sample	Sample description	Bi ₂ O ₃ content in weight percentage ¹	Marking performance	
Focus distance [+ mm]			0	6
Comparative Example	matrix polymer: M1; 1% A-2 4% A-3	0.00	++----	+-----
LMC01	matrix polymer: M1	1	+++++	+++++
LMC03	matrix polymer: M1	0.25	+++++	-++++
LMC04	matrix polymer: M2	1	+++++	-++++
LMC05	M-1.1	0,000	[++----	[+-----]
LMC06	M-1.1	0,500	[+++++]	[+++++]
LMC07	M-1.1	0,250	[+++++]	[+++++]
LMC08	M-1.1	0,125	[++++]	[++++]
LMC09	M-1.1	0,500	[+++++]	[+++++]
LMC10	M-1.2	0,000	[++----	[+-----]
LMC11	M-1.2	0,500	[+++++]	[+++++]
LMC12	M-1.2	0,250	[+++++]	[+++++]
LMC13	M-1.2	0,125	[++++]	[++++]
LMC14	M-1.2	0,500	[+++++]	[+++++]
LMC15	M-3	1,000	[+++++]	[+++++]
LMC16	M-3	0,500	[+++++]	[+++++]
LMC17	M-3	0,250	[+++++]	[+++++]
LMC18	M-2.1	0,500	[+++++]	[+++++]
LMC19	M-2.1	0,250	[+++++]	[+++++]
LMC20	M-2.1	0,125	[++++]	[++++]
LMC21	M-2.1	0,500	[+++++]	[+++++]
LMC22	M-2.2	0,500	[+++++]	[+++++]
LMC23	M-2.2	0,250	[+++++]	[+++++]
LMC24	M-2.2	0,125	[++++]	[++++]
LMC25	M-2.2	0,500	[+++++]	[+++++]
LMC26	P-4	0,500	[++++]	[++++]
LMC27	P-4	0,250	[+++++]	[+++++]
LMC28	P-4	0,125	[++++]	[++++]

¹with respect to the total amount of laser-markable composition.

- The results described in Table 3 clearly indicate that laser-markable
- 5 samples, comprising a bismuth containing compound show very good marking performance, even better than the comparative example which uses antimony compounds as laser-marking additive.

Comparative tracking index

CTI values were measured according to IEC 60112 for laser-markable compositions comprising the laser-marking additive according to the invention, as well as a comparative example that comprises antimony. The CTI-value for the matrix polymer without laser-marking additive is given as well. The results are summarized in Table 4.

Table 4: Assessment of CTI values

Sample	Matrix polymer:	Bi ₂ O ₃ content in weight percentage ¹	CTI [V] 50 drops	CTI [V] 100 drops
Comparative Example 1	M1	0.00	600	n.a
Comparative Example 2	M1; 1% A-2 4% A-3	0.00	475	n.a
LMC01	M1	1	600	n.a
LMC02	M1	0.5	600	n.a
LMC03	M1	0.25	600	n.a
LMC04	M1	0.25	600	n.a
LMC05	M-1.1	0,000	n.a.	n.a.
LMC06	M-1.1	0,500	n.a.	n.a.
LMC07	M-1.1	0,250	n.a.	n.a.
LMC08	M-1.1	0,125	n.a.	n.a.
LMC09	M-1.1	0,500	n.a.	n.a.
LMC10	M-1.2	0,000	600	525
LMC11	M-1.2	0,500	600	550
LMC12	M-1.2	0,250	600	550
LMC13	M-1.2	0,125	600	600
LMC14	M-1.2	0,500	600	550
LMC18	M-2.1	0,500	275	250
LMC19	M-2.1	0,250	250	250
LMC20	M-2.1	0,125	275	225
LMC21	M-2.1	0,500	275	250
LMC22	M-2.2	0,125	500	500
LMC23	M-2.2	0,500	600	600
LMC24	M-2.2	1,000	550	500
LMC25	M-2.2	0,500	550	500

¹with respect to the total amount of laser-markable composition. n.a. is not available.

Table 4 clearly shows that application of laser-marking additives comprising antimony (comparative example 2) leads to a decrease of CTI value with respect to the composition that does not comprise a laser-marking additive (comparative

example 1), whereas the employment of a laser-marking additive according to the invention does hardly influence the CTI value.

Flammability studies

5 **UL 94** test was performed on various samples. This is a plastics flammability standard. The standard classifies plastics according to how they burn in various orientations and thicknesses. From lowest (least flame-retardant) to highest (most flame-retardant), the measured classifications are:

- **V2** burning stops within 30 seconds on a vertical specimen; drips of flaming particles are allowed.
- **V0**: burning stops within 10 seconds on a vertical specimen; drips of particles allowed as long as they are not inflamed.

The results are shown in Table 5.

15 Table 5: Flammability experiments

Sample	Sample description	Bi ₂ O ₃ content in weight percentage ¹	²)UL94V	³)UL94V
Comparative Example 1	matrix polymer: M1	0.00		
Comparative Example 2	matrix polymer: M1; 1% A-2 4% A-3	0.00		
LMC05	M-1.1	0,000	V2	V2
LMC06	M-1.1	0,500	V2	V2
LMC07	M-1.1	0,250	V2	V2
LMC08	M-1.1	0,125	V2	V2
LMC09	M-1.1	0,500	V2	V2
LMC10	M-1.2	0,000	V2	V2
LMC11	M-1.2	0,500	V2	V2
LMC12	M-1.2	0,250	V2	V2
LMC13	M-1.2	0,125	V2	V2
LMC14	M-1.2	0,500	V2	V2
LMC22	M-2.2	0,125	V0	V0
LMC23	M-2.2	0,500	V0	V0
LMC24	M-2.2	1,000	V0	V0
LMC25	M-2.2	0,500	V0	V0

¹with respect to the total amount of laser-markable composition.

²)UL94V Thickness 0,57 mm ; conditioning 48 hrs 23°C/50% RH

³ UL94V Thickness 0,57 mm ; conditioning 168 hrs 70°C

20 Also Table 5 shows that upon addition of the laser-marking additive according to the invention the flammability test remains the same.

CLAIMS

1. Laser-marking additive characterized in that the laser-marking additive comprises a bismuth containing compound and a functionalized polymer having 0.01 to 50 wt% of functional groups, in which the weight percentage is based on the total amount of functionalized polymer and bismuth containing compound, wherein the bismuth containing compound is chosen from the group of Bi_2O_3 and Bi-citrate.
2. Laser-marking additive according to any of the claims above, characterized in that the functionalized polymer is a grafted polyethylene or grafted polypropylene.
3. Laser-marking additive according to any of the claims above, characterized in that the functional group is chosen from the group of maleic anhydride or epoxy.
4. Laser-marking additive according to any of the claims above, characterized in that the laser-marking additive comprises at least 0.05 wt% of functional groups, in which the weight percentage is based on the total amount of functionalized polymer and bismuth containing compound.
5. Laser-marking additive according to any of the claims above, characterized in that the laser-marking additive comprises at most 30 wt% functional groups in which the weight percentage is based on the total amount of functionalized polymer and bismuth containing compound.
6. Laser-marking additive according to any of the claims above, characterized in that the laser-marking additive is antimony-free.
7. Laser-marking additive according to any of the claims above, characterized in that the laser-marking additive is halogen-free.
8. Method of preparation of a laser-marking additive according to any of the claims above, characterized in that the functionalized polymer is melt-blended with the bismuth-containing compound.
9. Laser-markable composition comprising a thermoplastic polymer as matrix polymer wherein the thermoplastic polymer is chosen from the group of polyamides, polyesters and polycarbonates and a laser-marking additive according to any of the claims 1 to 7 and optionally a further thermoplastic polymer.
10. Laser-markable composition according to claim 9, characterized in that the amount of Bismuth is from 0.05 to 2 wt%, based on the total weight of the composition.

11. Method of preparation of a laser-markable composition according to claims 9 or 10, or for processing thereof, characterized in that the preparation or processing is effected at a temperature of at least 220 °C.
12. Molded part comprising the laser-markable composition according to claims 9 or 10.
13. Film made from the laser-markable composition according to claims 9 or 10.