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(71) Demandeur/Applicant:
GENERAL ELECTRIC COMPANY, US
(72) Inventeurs/Inventors:
KILGOUR, JOHN ALFRED, US;
CUA, EDWIN C., PH;
CUMMINGS, JOHN A., US
(74) Agent: MCFADDEN, FINCHAM

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(54) Title: STAR-BRANCHED SILICONE POLYMERS AS ANTI-MIST ADDITIVES FOR COATING APPLICATIONS

(57) **Abrégé/Abstract:**

A hydrido-silicone resin is incompletely reacted with an olefin under hydrosilation conditions to produce a partially substituted hydrido-silicone that is further reacted under hydrosilylation conditions with a vinyl containing silicone to consume the remaining hydride species to produce a composition that is useful as an anti-mist agent in the coating of flexible supports.



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(71) Applicant (for all designated States except US): **GENERAL ELECTRIC COMPANY** [US/US]; A New York Corporation, 1 River Road, Schenectady, NY 12345 (US).

(72) Inventors; and

(75) Inventors/Applicants (for US only): **KILGOUR, John, Alfred** [US/US]; 18 Royal Oak Drive, Clifton Park, NY 12065 (US). **CUA, Edwin, C.** [PH/PH]; 17 Carlos Street, Carmel 2 Subdivision, Quezon City, 1106 (PH). **CUMMINGS, John, A.** [US/US]; 10 Glenburine Drive, Gansevoort, NY 12831 (US).

(74) Agents: **WINTER, Catherine, J.** et al.; Patent Counsel, General Electric Company, 3135 Easton Turnpike (W3C), Fairfield, CT 06828 (US).

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(57) Abstract: A hydrido-silicone resin is incompletely reacted with an olefin under hydrosilation conditions to produce a partially substituted hydrido-silicone that is further reacted under hydrosilylation conditions with a vinyl containing silicone to consume the remaining hydride species to produce a composition that is useful as an anti-mist agent in the coating of flexible supports.

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STAR-BRANCHED SILICONE POLYMERS AS ANTI -MIST ADDITIVES FOR COATING APPLICATIONS

FIELD OF USE

The present invention relates to coating flexible materials or supports such as sheets of paper or other polymeric material, either woven or non-woven, with a silicone composition. The present invention also relates to the coating of flexible materials or supports with liquid compositions comprising one or more cross-linkable polyorganosiloxanes wherein such polyorganosiloxanes are cross-linkable by an addition reaction, a condensation reaction, a cationic reaction, or a free-radical reaction. The present invention also relates to star branched polyorganosiloxanes (silicone polymers) that reduce misting during the application of the silicone composition (polyorganosiloxane) to the flexible material or support. The flexible support may be paper, cardboard, plastic film, metal film and the like. Some exemplary applications are paper for foodstuffs, adhesive labels, adhesive tapes, seals and the like.

BACKGROUND OF THE INVENTION

The coating of flexible supports with liquid silicones is typically carried out on coating devices that operate continuously at very high speed. These devices usually comprise coating heads composed of several rolls, including in particular a pressure roll and a coating roll that are continuously fed with a silicone composition that may or may not be cross-linkable, by means of a series of rolls that are placed next to one another. A strip of flexible support of the desired material to be coated is fed at high speed between the pressure roll and the coating roll to be coated on at least one of its surfaces. When it is intended to cross link the silicone coating, apparatus to implement a cross linking reaction are

positioned downstream of the coating head. The apparatus that implements cross linking may be for example an oven or an emitter of radiation, e.g. ultraviolet (UV) radiation or an emitter of a beam of electrons (EB).

High speed coating of flexible supports with silicones has been associated with problems associated with the transfer of the silicone liquid (or fluid) from the coating roll to the flexible support which moves forward through the coating apparatus. One of the particular problems associated with transfer of the silicone liquid from the coating roll to the flexible support is the appearance of a fog, mist or aerosol in the immediate vicinity of the coating head and particularly close to the points of contact between the coating roll and the flexible support being coated. Typically, the density of this fog, mist or aerosol increases with an increase in the forward speed of the flexible support being coated by the apparatus.

The first effect of this transfer problem is to reduce the amount of silicone liquid actually transferred to the flexible support. A second effect is for the droplets comprising the fog, mist or aerosol to condense onto the newly coated flexible support downstream of the coating rolls creating an orange peel effect. This orange peel effect, or coating non-uniformity, creates problems with coverage, the mechanical properties of the coating, e.g. ruboff, and adhesion resistance.

An additional problem caused by non-uniformity in the coating is related to industrial hygiene and the safety of people operating the coating equipment who are working in the vicinity of the coating equipment.

SUMMARY OF THE INVENTION

The present invention provides for a composition comprising the reaction product of:

$M_a M^{Vi}_b D_c D^{Vi}_d T_e T^{Vi}_f$ and $((M'_g M_j M^{H}_{k-g} D'_h D_l D^{H}_{m-h} T'_i T_n T^{H}_{o-i})^p Q)_q$,

in the presence of a noble metal hydrosilylation catalyst where the subscripts a, b, c, d, e, f, g, h, i, j, k, l, m, n, o, p, are zero or positive and q is non-zero and positive, for mixtures of compounds the average values of each of the subscripts will most likely be non-integral, for specific compounds the subscripts will be integral, with

$$k + m + o - g - h - l < b + d + f, \quad p \text{ ranges from } 0.4 \text{ to } 4.0$$

where

$$(b+d+f)/(((k+m+o-g-h-l)p)q) \text{ ranges from } 4.59 \text{ to } 0.25 \text{ and}$$

$M_a M^{Vi}_b D_c D^{Vi}_d T_e T^{Vi}_f$ wherein the sum of the subscripts a + b ranges from 2 to 12; c + d ranges from 0 to 1000; e + f ranges from 0 to 10 and R¹ is a monovalent radical selected from the group consisting of halogens, hydrogen and C1 to C60 monovalent hydrocarbon radicals, polyesters, nitriles, alkyl halides and polyethers; with

$$M = R^2 R^3 R^4 SiO_{1/2};$$

$$M^{Vi} = R^{Vi} R^5 R^6 SiO_{1/2};$$

$$D = R^7 R^8 SiO_{2/2};$$

$$D^{Vi} = R^{Vi} R^{10} SiO_{2/2};$$

$$T = R^{11} SiO_{3/2};$$

$$T^{Vi} = R^{Vi} SiO_{3/2};$$

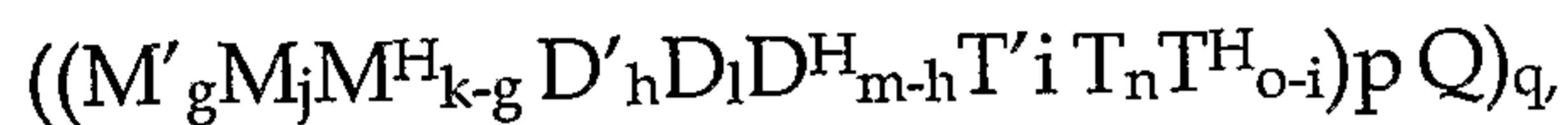
$$M' = (CH_2 CH_2 R^1) R^5 R^6 SiO_{1/2};$$

$$D' = (CH_2 CH_2 R^1) R^9 SiO_{2/2}; \text{ and}$$

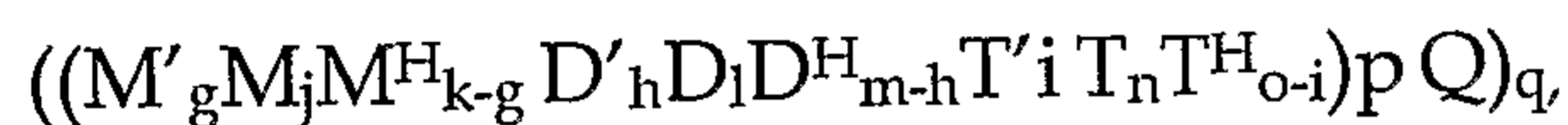
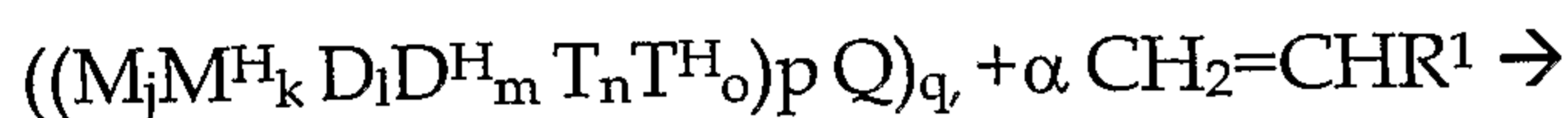


with each $\text{R}^2, \text{R}^3, \text{R}^4, \text{R}^5, \text{R}^6, \text{R}^7, \text{R}^8, \text{R}^9, \text{R}^{10},$ and R^{11} independently selected from the group of C1 to C60 monovalent hydrocarbon radicals and each R^{Vi} independently selected from the group of C2 to C60 monovalent alkenyl hydrocarbon radicals

wherein



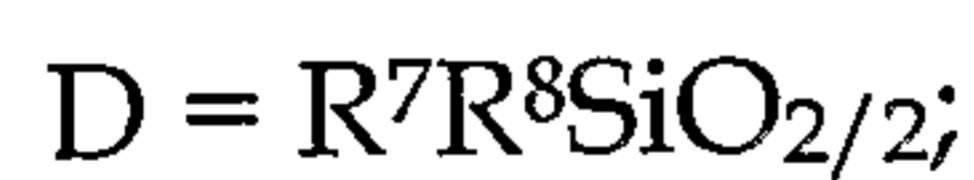
may be obtained as the reaction product of



where $\alpha + 1 \leq k + m + o$ and $g + h + i \leq k + m + o$

with $1.5 \leq k + m + o - g - h - i \leq 100$;

and R^1 is a monovalent radical selected from the group consisting of halogens, hydrogen and C1 to C60 monovalent hydrocarbon radicals, polyesters, nitriles, alkyl halides and polyethers; with





with each R^2 , R^3 , R^4 , R^5 , R^6 , R^7 , R^8 , R^9 , R^{10} , and R^{11} independently selected from the group of C1 to C60 monovalent hydrocarbon radicals.

The present invention further provides for a process to reduce misting in the coating of a flexible substrate said process comprising preparing a coating composition for coating said substrate and adding thereto the composition(s) of the present invention.

DETAILED DESCRIPTION OF THE INVENTION

The star branched siloxane compounds of the present invention are made as the reaction product of:



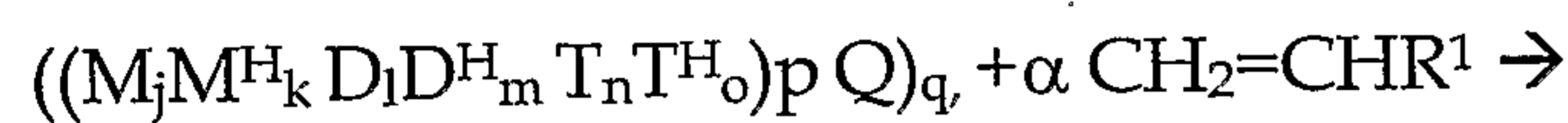
in the presence of a noble metal hydrosilylation catalyst where the subscripts a , b , c , d , e , f , g , h , i , j , k , l , m , n , o , p , are zero or positive and q is non-zero and positive, for mixtures of compounds the average values of each of the subscripts will most likely be non-integral, for specific compounds the subscripts will be integral, with

$k + m + o - g - h - l < b + d + f$, p ranges from 0.4 to 4.0, preferably 0.5 to 3.0, more preferably 0.5 to 2.5 and most preferably 1.5 to 2.5 and all sub-ranges there between and q ranges from 1 to 200, preferably 1 to 100, more preferably 1 to 75 and most preferably 1 to 50 and all sub-ranges there between where the ratio between the hydride containing precursor and

the vinyl containing precursor is defined by the following mathematical relationship between the stoichiometric subscripts of the precursors, $(b+d+f)/(((k+m+o-g-h-i)p)q)$ ranges from 4.59 to 0.25, preferably from 4.5 to 0.25; more preferably from 4.5 to 0.25 and most preferably from 4.0 to 0.25 and all sub-ranges there between and specifically including 3.5 to 0.25; 3.0 to 0.25; 2.5 to 0.25 and 2.0 to 0.25; and where the compound:



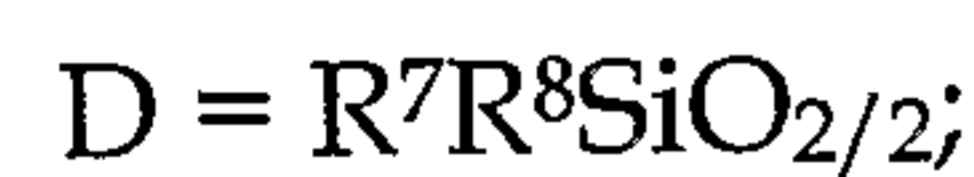
may be obtained by the following reaction

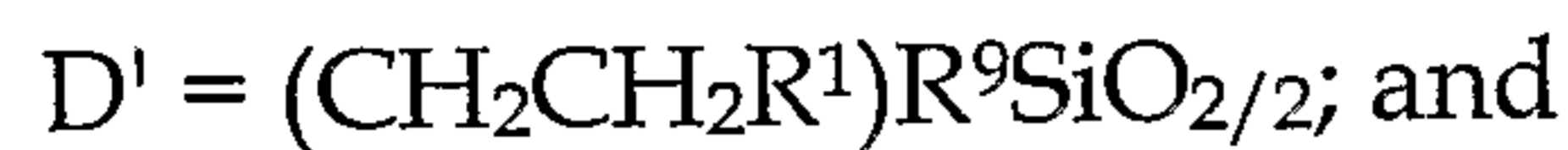
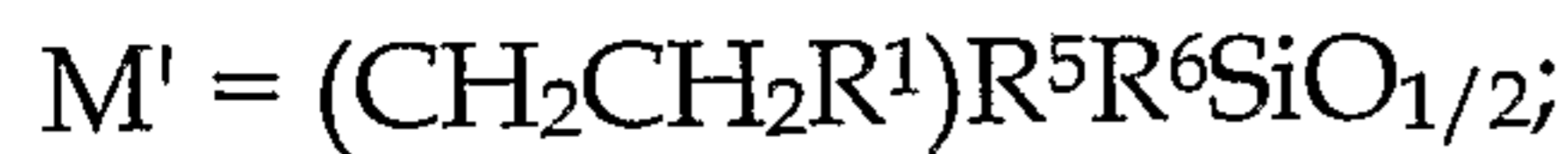


where $\alpha + 1 \leq k + m + o$ and $g + h + i \leq k + m + o$

with $1.5 \leq k + m + o - g - h - i \leq 100$;

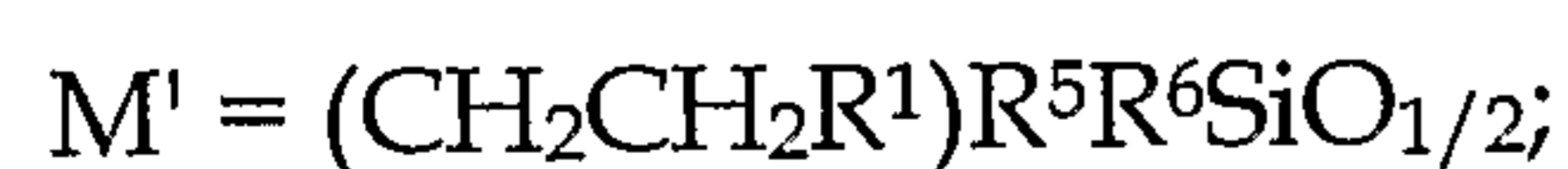
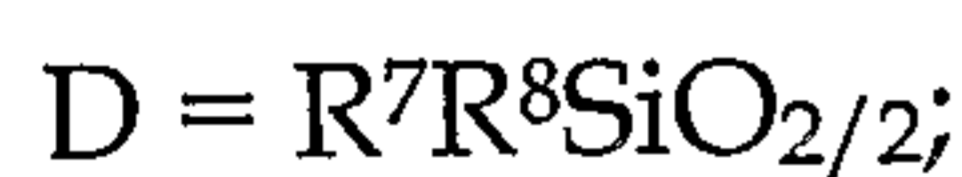
and R^1 is a monovalent radical selected from the group consisting of halogens, hydrogen and C1 to C60 monovalent hydrocarbon radicals, polyesters, nitriles, alkyl halides and polyethers; with





with each R^2 , R^3 , R^4 , R^5 , R^6 , R^7 , R^8 , R^9 , R^{10} , and R^{11} independently selected from the group of C1 to C60 monovalent hydrocarbon radicals. Methods for making MQ resins, such as $((\text{M}_j\text{M}^{\text{H}_k}\text{D}_l\text{D}^{\text{H}_m}\text{T}_n\text{T}^{\text{H}_o})_p\text{Q})_q$, are described in US patent 5,817,729, US patent 5,399,614 and US patent 2,676,182 herewith and hereby specifically incorporated by reference.

$\text{M}_a\text{M}^{\text{V}_b}\text{D}_c\text{D}^{\text{V}_d}\text{T}_e\text{T}^{\text{V}_f}$ may be made by hydrolysis and condensation from the component chlorosilanes, or via condensation followed by equilibration using either acid or base catalysis. The sum of the subscripts $a + b$ is 2 to 12; $c + d$ is 0 to 1000; $e + f$ is 0 to 10 and R^1 is a monovalent radical selected from the group consisting of halogens, hydrogen and C1 to C60 monovalent hydrocarbon radicals, polyesters, nitriles, alkyl halides and polyethers; with





with each $\text{R}^2, \text{R}^3, \text{R}^4, \text{R}^5, \text{R}^6, \text{R}^7, \text{R}^8, \text{R}^9, \text{R}^{10},$ and R^{11} independently selected from the group of C1 to C60 monovalent hydrocarbon radicals and each R^{Vi} independently selected from the group of C2 to C60 monovalent alkenyl hydrocarbon radicals.

The star branched silicone compounds of the present invention are described as the reaction product of the following two compounds:



because of the multiplicity of hydrosilylation sites available for reaction on each of the component molecules being reacted and the difficulties of reducing such a stochastic chemical reaction to an analytic description.

Many types of noble metal catalysts for this hydrosilylation reaction are known and such catalysts may be used for the reaction in the present instance. When optical clarity is required the preferred catalysts are catalysts that are soluble in the reaction mixture. By noble metal, Applicants define Ru, Rh, Pd, Os, Ir, and Pt as noble metals and also include Ni in the definition because of its known hydrogenation activity. Preferably the catalyst is a platinum compound and the platinum compound can be selected from those having the formula $(\text{PtCl}_2\text{Olefin})$ and $\text{H}(\text{PtCl}_3\text{Olefin})$ as described in U.S. patent number 3,159,601, hereby incorporated by reference. The olefin shown in the previous two formulas can be almost any type of olefin but is preferably an alkenylene having from 2 to 8 carbon atoms, a cycloalkenylene have from 5 to 7 carbon atoms or styrene. Specific olefins utilizable in the above formulas are ethylene, propylene, the various isomers of butylene, octylene, cyclopentene, cyclohexene, cycloheptene, and the like.

A further platinum containing material usable in the compositions of the present invention is the cyclopropane complex of platinum chloride described in U.S. patent number 3,159,662 hereby incorporated by reference.

Further the platinum containing material can be a complex formed from chloroplatinic acid with up to 2 moles per gram of platinum of a member selected from the class consisting of alcohols, ethers, aldehydes and mixtures of the above as described in U.S. patent number 3,220,972 hereby incorporated by reference.

The catalyst preferred for use with liquid injection molding compositions are described in U. S. Patents numbers 3,715,334; 3,775,452; and 3,814,730 to Karstedt. Additional background concerning the art may be found at J. L. Spier, "Homogeneous Catalysis of Hydrosilation by Transition Metals, in Advances in Organometallic Chemistry, volume 17, pages 407 through 447, F.G.A. Stone and R. West editors, published by the Academic Press (New York, 1979). Persons skilled in the art can easily determine an effective amount of platinum catalyst. Generally, an effective amount for hydrosilylation ranges from about 0.1 to 50 parts per million of the total organopolysiloxane composition and all sub-ranges there between.

EXPERIMENTAL

Example 1

200 grams (0.26 moles) of an $((M^H)_2Q)_4$ silicone and 332 grams (1.4 moles) of C16-18 terminal olefins were mixed with 5 ppm (wt% Pt) platinum catalyst and heated for four hours at 90 C. A loss of silylhydride indicated the completion of the reaction. 6039 grams (0.69 moles) of a vinyl terminated linear polysiloxane of about 8710 molecular weight was added and the reaction heated and stirred for four hours at 90 C. Loss of

silylhydride and increased viscosity indicated the completion of the reaction.

Table 1 shows examples of the synthesis of the structures of the anti mist additives based on the path described above. The SiH/SiVinyl is the ratio of moles of silyl hydrides available for reaction to the moles of silyl vinyl available for reaction. In the compounds shown, the SiH/SiVinyl ratio runs from 0.2 to 2.75, but a larger usable range spans from 0.22 to 4.5.

Table 1: Anti Mist Additive Synthesis

Type Five AMA's: Vinylterminated Polydimethylsiloxanes

Example	Olefin	Grams	gms ((MH) ₂ Q) ₄	ppm Pt	SiH/Vinyl	MviD115Mvi	ppm Pt
30	C16-18	33.3	20.0	5	0.5	604	5
31	C16-18	5.0	5.0	5	0.25	544	5
32	C16-18	7.0	7.0	5	0.35	544	5
33	C16-18	33.3	20.0	5	0.6	503	5
34	C16-18	7.0	7.0	5	0.5	380	5
35	C16-18	33.3	20.0	5	0.75	403	5
36	C16-18	33.3	20.0	5	0.75	403	5
37	C16-18	41.6	25.0	5	0.9	419	5
38	C16-18	9.0	9.0	5	0.45	544	5
39	C16-18	58.2	35.0	5	1	528	5
40	C16-18	2.2	3.5	5	0.2	594	5
41	C16-18	4.4	7.0	5	0.4	594	5
42	C16-18	3.1	5.0	5	0.3	566	5

Table 2 shows the anti misting behavior of the invention. The measurements were made during runs on 2.5 mil SC Rhi-Liner 12 paper using a pilot coater with a line speed of 2000 ft/minute. The paper was coated with a standard silicone paper release formulation containing ~

2% anti mist additive with a target of 0.6 to 0.9 pounds per ream. The mist was measured using a DustTrack Aerosol Monitor. The intake port was positioned in the highest observed misting area thus providing the highest expected values. The position does not reflect normal environmental testing nor does it guarantee specific values under all operating conditions. The measurement is in mg of mist material per cubic meter of air, the lower values being more desirable as they represent less misting.

Table 2: Anti Mist Measurements

Type Five AMA's: Organosilyl Terminated Polydimethylsiloxanes

AMA #	mg/m ³ at 2000 ft/min
control	102.00
30	34.00
31	75.00
32	6.74
33	80.00
34	0.61
35	71.30
36	1.34
37	34.20
38	1.05
39	7.49
40	18.70
41	0.51
42	5.64

The results show the anti misting materials generated for this invention reduce the amount of generated mist at 2000 ft/min compared to the control formulation containing no anti mist additive. Quite surprisingly the mist is often reduced by a factor of greater than ten, often by about 100, and in two cases by better than a factor of almost 200.

The foregoing examples are merely illustrative of the invention, serving to illustrate only some of the features of the present invention. The appended claims are intended to claim the invention as broadly as it has been conceived and the examples herein presented are illustrative of selected embodiments from a manifold of all possible embodiments. Accordingly it is Applicants' intention that the appended claims are not to be limited by the choice of examples utilized to illustrate features of the present invention. As used in the claims, the word "comprises" and its grammatical variants logically also subtend and include phrases of varying and differing extent such as for example, but not limited thereto, "consisting essentially of" and "consisting of." Where necessary, ranges have been supplied, those ranges are inclusive of all sub-ranges there between. It is to be expected that variations in these ranges will suggest themselves to a practitioner having ordinary skill in the art and where not already dedicated to the public, those variations should where possible be construed to be covered by the appended claims. It is also anticipated that advances in science and technology will make equivalents and substitutions possible that are not now contemplated by reason of the imprecision of language and these variations should also be construed where possible to be covered by the appended claims. All United States patents referenced herein are herewith and hereby specifically incorporated by reference.

WHAT IS CLAIMED

Having described the invention, that which is claimed is:

1. A composition comprising the reaction product of:



in the presence of a noble metal hydrosilylation catalyst where the subscripts a, b, c, d, e, f, g, h, i, j, k, l, m, n, o, p, are zero or positive and q is non-zero and positive, for mixtures of compounds the average values of each of the subscripts will most likely be non-integral, for specific compounds the subscripts will be integral, with

$$k + m + o - g - h - l < b + d + f, \text{ p ranges from 0.4 to 4.0}$$

where

$$(b+d+f)/(((k+m+o-g-h-l)p)q) \text{ ranges from 4.59 to 0.25 and}$$

$M_a M^{Vi}_b D_c D^{Vi}_d T_e T^{Vi}_f$ wherein the sum of the subscripts a + b ranges from 2 to 12; c + d ranges from 0 to 1000; e + f ranges from 0 to 10 and R¹ is a monovalent radical selected from the group consisting of halogens, hydrogen and C1 to C60 monovalent hydrocarbon radicals, polyesters, nitriles, alkyl halides and polyethers; with

$$M = R^2 R^3 R^4 SiO_{1/2};$$

$$M^{Vi} = R^{Vi} R^5 R^6 SiO_{1/2};$$

$$D = R^7 R^8 SiO_{2/2};$$

$$D^{Vi} = R^{Vi} R^{10} SiO_{2/2};$$

$$T = R^{11} SiO_{3/2};$$

$$T^{Vi} = R^{Vi}SiO_{3/2};$$

$$M' = (CH_2CH_2R^1)R^5R^6SiO_{1/2};$$

$$D' = (CH_2CH_2R^1)R^9SiO_{2/2}; \text{ and}$$

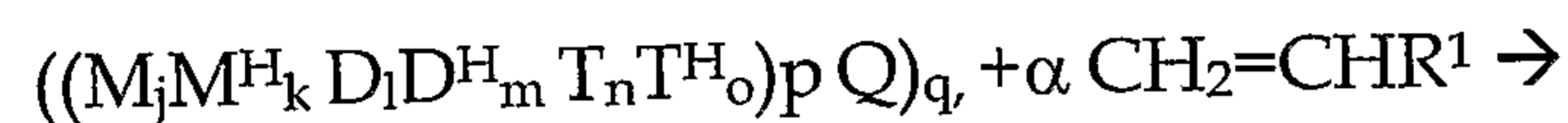
$$T' = (CH_2CH_2R^1)SiO_{3/2}$$

with each $R^2, R^3, R^4, R^5, R^6, R^7, R^8, R^9, R^{10},$ and R^{11} independently selected from the group of C1 to C60 monovalent hydrocarbon radicals and each R^{Vi} independently selected from the group of C2 to C60 monovalent alkenyl hydrocarbon radicals

wherein

$$((M'_g M_j M^{H_{k-g}} D'_h D_l D^{H_{m-h}} T'_i T_n T^{H_{o-i}})p Q)_q,$$

may be obtained as the reaction product of



$$((M'_g M_j M^{H_{k-g}} D'_h D_l D^{H_{m-h}} T'_i T_n T^{H_{o-i}})p Q)_q,$$

where $\alpha + 1 \leq k + m + o$ and $g + h + i \leq k + m + o$

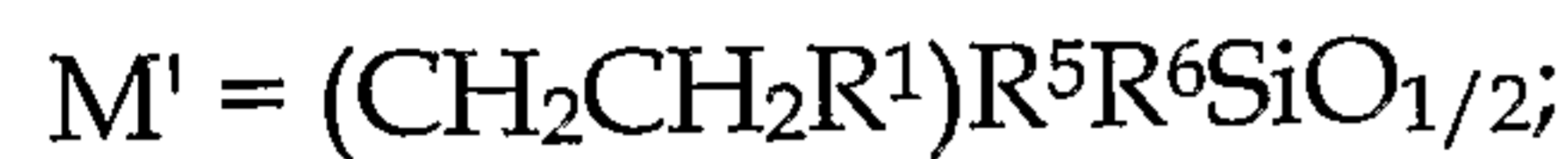
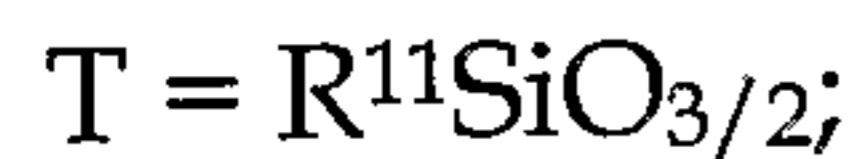
with $1.5 \leq k + m + o - g - h - i \leq 100;$

and R^1 is a monovalent radical selected from the group consisting of halogens, hydrogen and C1 to C60 monovalent hydrocarbon radicals, polyesters, nitriles, alkyl halides and polyethers; with

$$M = R^2R^3R^4SiO_{1/2};$$

$$M^H = HR^5R^6SiO_{1/2};$$

$$D = R^7R^8SiO_{2/2};$$



with each R^2 , R^3 , R^4 , R^5 , R^6 , R^7 , R^8 , R^9 , R^{10} , and R^{11} independently selected from the group of C1 to C60 monovalent hydrocarbon radicals.

2. The composition of claim 1 wherein R^1 is selected from the group consisting of C15 to C60 monovalent hydrocarbon radicals, C15 to C60 monovalent polyester radicals, C15 to C60 monovalent nitrile radicals, C15 to C60 monovalent alkyl halide radicals, C15 to C60 monovalent polyether radicals and mixtures thereof.

3. The composition of claim 1 wherein R^1 is selected from the group consisting of C30 to C60 monovalent hydrocarbon radicals, C30 to C60 monovalent polyester radicals, C30 to C60 monovalent nitrile radicals, C30 to C60 monovalent alkyl halide radicals, C30 to C60 monovalent polyether radicals and mixtures thereof.

4. The composition of claim 1 wherein R^1 is selected from the group consisting of C10 to C40 monovalent hydrocarbon radicals, C10 to C40 monovalent polyester radicals, C10 to C40 monovalent nitrile radicals, C10 to C40 monovalent alkyl halide radicals, C10 to C40 monovalent polyether radicals and mixtures thereof.

5. The composition of claim 2 where each R², R³, R⁴, R⁵, R⁶, R⁷, R⁸, R⁹, R¹⁰, and R¹¹ are methyl.
6. The composition of claim 3 where each R², R³, R⁴, R⁵, R⁶, R⁷, R⁸, R⁹, R¹⁰, and R¹¹ are methyl.
7. The composition of claim 4 where each R², R³, R⁴, R⁵, R⁶, R⁷, R⁸, R⁹, R¹⁰, and R¹¹ are methyl.
8. The composition of claim 1 wherein R¹ is styryl.
9. The composition of claim 7 where each R², R³, R⁴, R⁵, R⁶, R⁷, R⁸, R⁹, R¹⁰, and R¹¹ are methyl.
10. The composition of claim 7 where each R², R³, R⁴, R⁵, R⁶, R⁷, R⁸, R⁹, R¹⁰, and R¹¹ are selected from the group consisting of C30 to C60 monovalent hydrocarbon radicals, C30 to C60 monovalent polyester radicals, C30 to C60 monovalent nitrile radicals, C30 to C60 monovalent alkyl halide radicals, C1 to C60 monovalent polyether radicals and mixtures thereof.
11. A composition to reduce misting during the coating of flexible supports comprising the reaction product of:



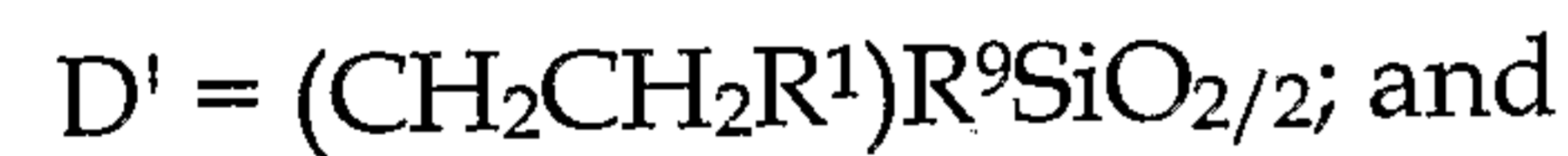
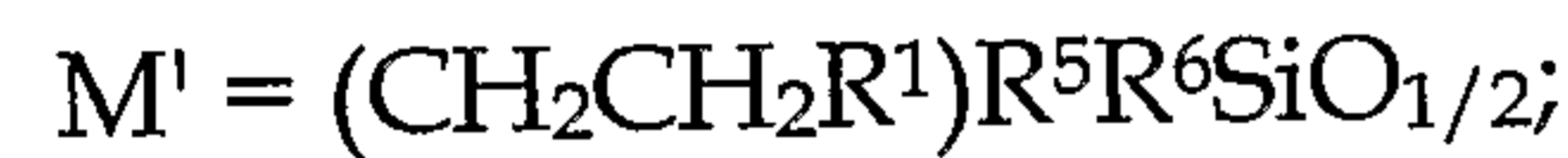
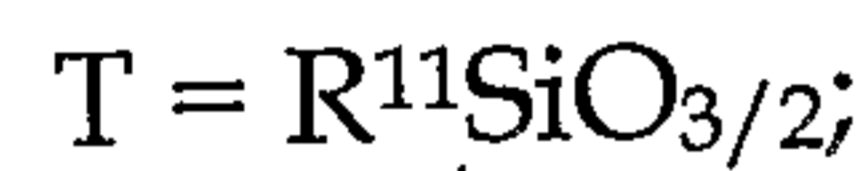
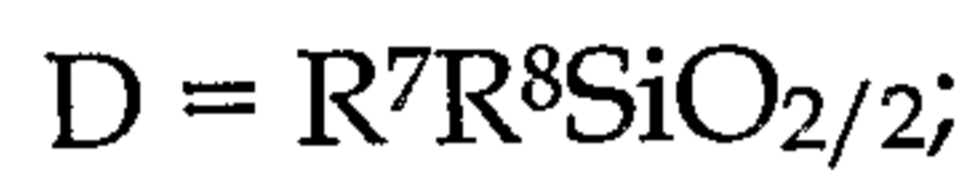
in the presence of a noble metal hydrosilylation catalyst where the subscripts a, b, c, d, e, f, g, h, i, j, k, l, m, n, o, p, are zero or positive and q is non-zero and positive, for mixtures of compounds the average values of each of the subscripts will most likely be non-integral, for specific compounds the subscripts will be integral, with

$$k + m + o - g - h - l < b + d + f, \text{ p ranges from 0.4 to 4.0}$$

where

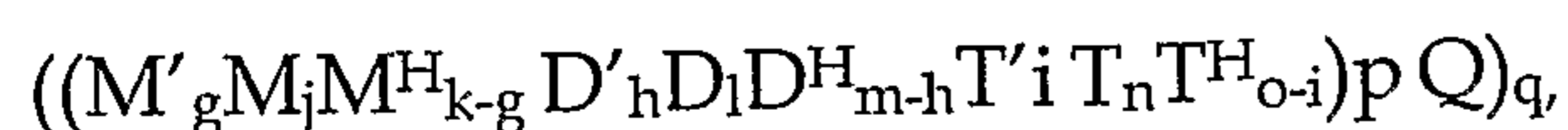
$(b+d+f)/(((k+m+o-g-h-i)p)q)$ ranges from 4.59 to 0.25 and

$M_a M^{Vi}_b D_c D^{Vi}_d T_e T^{Vi}_f$ wherein the sum of the subscripts $a + b$ ranges from 2 to 12; $c + d$ ranges from 0 to 1000; $e + f$ ranges from 0 to 10 and R^1 is a monovalent radical selected from the group consisting of halogens, hydrogen and C1 to C60 monovalent hydrocarbon radicals, polyesters, nitriles, alkyl halides and polyethers; with

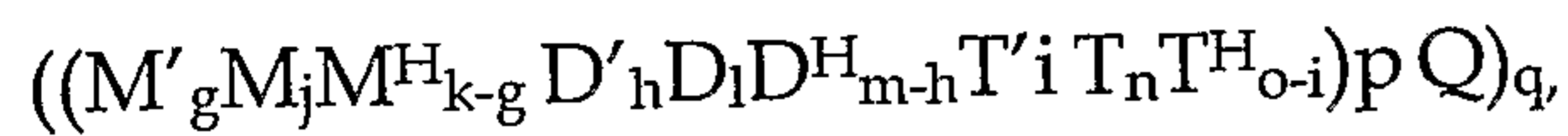
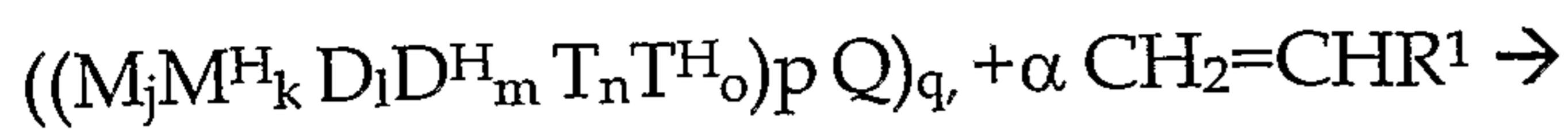


with each $R^2, R^3, R^4, R^5, R^6, R^7, R^8, R^9, R^{10},$ and R^{11} independently selected from the group of C1 to C60 monovalent hydrocarbon radicals and each R^{Vi} independently selected from the group of C2 to C60 monovalent alkenyl hydrocarbon radicals

wherein



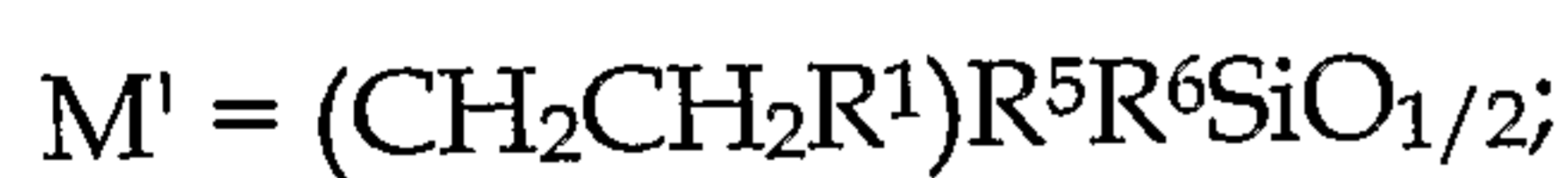
may be obtained as the reaction product of



where $\alpha + 1 \leq k + m + o$ and $g + h + i \leq k + m + o$

with $1.5 \leq k + m + o - g - h - i \leq 100$;

and R^1 is a monovalent radical selected from the group consisting of halogens, hydrogen and C1 to C60 monovalent hydrocarbon radicals, polyesters, nitriles, alkyl halides and polyethers; with



with each $R^2, R^3, R^4, R^5, R^6, R^7, R^8, R^9, R^{10}$, and R^{11} independently selected from the group of C1 to C60 monovalent hydrocarbon radicals.

12. The composition of claim 11 wherein R¹ is selected from the group consisting of C1 to C60 monovalent hydrocarbon radicals, C1 to C60 monovalent polyester radicals, C1 to C60 monovalent nitrile radicals, C1 to C60 monovalent alkyl halide radicals, C1 to C60 monovalent polyether radicals and mixtures thereof.
13. The composition of claim 11 wherein R¹ is selected from the group consisting of C15 to C60 monovalent hydrocarbon radicals, C15 to C60 monovalent polyester radicals, C15 to C60 monovalent nitrile radicals, C15 to C60 monovalent alkyl halide radicals, C1 to C60 monovalent polyether radicals and mixtures thereof.
14. The composition of claim 11 wherein R¹ is selected from the group consisting of C30 to C60 monovalent hydrocarbon radicals, C30 to C60 monovalent polyester radicals, C30 to C60 monovalent nitrile radicals, C30 to C60 monovalent alkyl halide radicals, C1 to C60 monovalent polyether radicals and mixtures thereof.
15. The composition of claim 12 where each R², R³, R⁴, R⁵, R⁶, R⁷, R⁸, R⁹, R¹⁰, and R¹¹ are methyl.
16. The composition of claim 13 where each R², R³, R⁴, R⁵, R⁶, R⁷, R⁸, R⁹, R¹⁰, and R¹¹ are methyl.
17. The composition of claim 14 where each R², R³, R⁴, R⁵, R⁶, R⁷, R⁸, R⁹, R¹⁰, and R¹¹ are methyl.
18. The composition of claim 11 wherein R¹ is styryl.
19. The composition of claim 17 where each R², R³, R⁴, R⁵, R⁶, R⁷, R⁸, R⁹, R¹⁰, and R¹¹ are methyl.

20. The composition of claim 17 where each R², R³, R⁴, R⁵, R⁶, R⁷, R⁸, R⁹, R¹⁰, and R¹¹ are selected from the group consisting of C30 to C60 monovalent hydrocarbon radicals, C30 to C60 monovalent polyester radicals, C30 to C60 monovalent nitrile radicals, C30 to C60 monovalent alkyl halide radicals, C1 to C60 monovalent polyether radicals and mixtures thereof.
21. A process to reduce misting in the coating of a flexible substrate said process comprising preparing a coating composition for coating said substrate and adding thereto the composition of claim 1.
22. A process to reduce misting in the coating of a flexible substrate said process comprising preparing a coating composition for coating said substrate and adding thereto the composition of claim 2.
23. A process to reduce misting in the coating of a flexible substrate said process comprising preparing a coating composition for coating said substrate and adding thereto the composition of claim 3.
24. A process to reduce misting in the coating of a flexible substrate said process comprising preparing a coating composition for coating said substrate and adding thereto the composition of claim 4.
25. A process to reduce misting in the coating of a flexible substrate said process comprising preparing a coating composition for coating said substrate and adding thereto the composition of claim 5.
26. A process to reduce misting in the coating of a flexible substrate said process comprising preparing a coating composition for coating said substrate and adding thereto the composition of claim 6.

27. A process to reduce misting in the coating of a flexible substrate said process comprising preparing a coating composition for coating said substrate and adding thereto the composition of claim 7.
28. A process to reduce misting in the coating of a flexible substrate said process comprising preparing a coating composition for coating said substrate and adding thereto the composition of claim 8.
29. A process to reduce misting in the coating of a flexible substrate said process comprising preparing a coating composition for coating said substrate and adding thereto the composition of claim 9.
30. A process to reduce misting in the coating of a flexible substrate said process comprising preparing a coating composition for coating said substrate and adding thereto the composition of claim 10.