

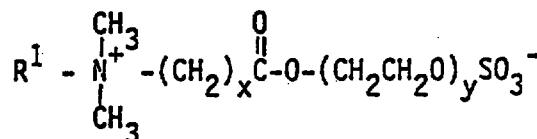
DETERGENT COMPOSITIONS

The present application relates to cationic compounds having
 5 clay-soil removal/anti-redeposition properties when used in
 detergent compositions.

A particularly important property of a detergent composition
 is its ability to remove particulate type soils from a variety of
 fabrics during laundering. Perhaps the most important particulate
 10 soils are the clay-type soils. Clay soil particles generally
 comprise negatively charged layers of aluminosilicates and posi-
 tively charged cations (e.g. calcium) which are positioned between
 and hold together the negatively charged layers.

A variety of models can be proposed for compounds which would
 15 have clay soil removal properties. One model requires that the
 compound have two distinct characteristics. The first is the
 ability of the compound to adsorb onto the negatively charged
 layers of the clay particle. The second is the ability of the
 compound, once adsorbed, to push apart (swell) the negatively
 20 charged layers so that the clay particle loses its cohesive force
 and can be removed in the wash water.

One class of clay-soil removal compounds which appears to
 work according to this model are the polyethoxy zwitterionic
 surfactants disclosed in U.S. Patent 4,301,044 to Wentler et al.,
 25 issued November 17, 1981. Representative of such compounds are
 those having the formula:



30 wherein R^1 is a C_{14} - C_{20} alkyl group; x is 1 or an integer of from
 3 to 5; and y is from 6 to 12. See also U.S. Patent 3,929,678 to
 Laughlin et al., issued December 30, 1975 (detergent composition
 containing polyethoxy zwitterionic surfactant plus other detergent
 surfactants); U.S. Patent 3,925,262 to Laughlin et al., issued
 35 December 9, 1975 (detergent composition containing polyethoxy
 zwitterionic surfactants with detergent builders); U.S. Patent

4,157,277 to Gosselink et al., issued June 26, 1979 (C₄ polyoxy-alkylene zwitterionic surfactants useful in detergent compositions); U.S. Patent 4,165,334 to Gosselink et al., issued August 21, 1979 (sulfonium-type polyethoxy zwitterionic surfactants).

5 These polyethoxy zwitterionic surfactants are generally compatible with other detergent surfactants such as the nonionic, zwitterionic and ampholytic types. However, as indicated in the Wentler et al. patent, most anionic surfactants interfere with the particulate soil removal performance of these compounds; anionic
10 soils such as fatty acids likewise interfere. Because anionic detergent surfactants form the most important class of such materials for use in detergent compositions, the lack of compatibility between these polyethoxy zwitterionic surfactants and anionic surfactants poses a significant handicap where particulate
15 (clay) soil removal is desired.

 In addition to clay soil removal, one of the other properties mentioned in the Laughlin et al. patents with regard to these polyethoxy zwitterionic surfactants is the ability to keep the removed soil in suspension during the laundering cycle. Soil
20 which is removed from the fabric and suspended in the wash water can redeposit onto the surface of the fabric. This redeposited soil causes a dulling or "graying" effect which is especially noticeable on white fabrics. Because soil is normally hydrophobic, this graying effect is a particularly important problem for
25 those fabrics made in total or in part from hydrophobic fibers, e.g. polyester.

 To minimize this problem, anti-redeposition or whiteness maintenance agents can be included in the detergent composition. Besides the previously mentioned polyethoxy zwitterionic surfac-
30 tants, there are a variety of other compounds which can be used as anti-redeposition agents. One class of agents are the water-soluble copolymers of acrylic or methacrylic acid with acrylic or methacrylic acid-ethylene oxide condensates disclosed in U.S. Patent 3,719,647 to Hardy et al., issued March 6, 1973. Another
35 class of anti-redeposition agents are the cellulose and carboxymethylcellulose derivatives disclosed in U.S. Patent

3,597,416 to Diehl, issued August 3, 1971 (ionic combination of dodecyltrimethyl phosphonium chloride and sodium carboxymethyl cellulose), and U.S. Patent 3,523,088 to Dean et al., issued August 4, 1970 (anti-redeposition agent consisting of alkali metal carboxymethylcellulose and hydroxypropylcellulose). A mixture of compounds has also been used to provide not only anti-redeposition, but also clay soil removal properties. See U.S. Patent 4,228,044 to Cambre, issued October 14, 1980, which discloses detergent compositions having anti-redeposition and clay soil removal properties which can comprise a nonionic alkyl polyethoxy surfactant, a polyethoxy alkyl quaternary cationic surfactant and a fatty amide surfactant.

These anti-redeposition agents do have a number of significant handicaps. While effective to keep soil suspended, these compounds may lack additional clay soil removal properties. Moreover, as disclosed in the Diehl and Dean et al. patents, mixtures of compounds can be required to achieve the anti-redeposition benefit. To the extent that there are combined anti-redeposition/clay soil removal benefits as disclosed in the Cambre patent, mixtures of compounds are also required.

It is therefore an object of the present invention to provide compounds useful in detergent compositions which provide particulate soil, in particular clay soil, removal benefits.

It is a further object of the present invention to provide compounds useful in detergent compositions which provide clay soil removal benefits and are anionic detergent surfactant compatible.

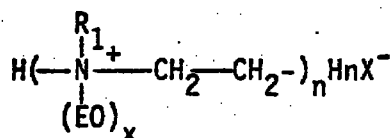
It is yet another object of the present invention to provide compounds useful in detergent compositions having anti-redeposition properties.

It is yet a further object of the present invention to provide compounds useful in detergent compositions which combine both clay soil removal and anti-redeposition properties.

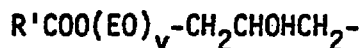
These and further objects of the present invention are hereinafter disclosed.

BACKGROUND ART

U. S. Patent 3,838,057 to Barnes et al., issued September 24, 1974, discloses toilet bars containing ethoxylated quaternary ammonium compounds, including ethoxylated, quaternized polyethyleneimines (PEIs) taught to be useful in the detergent, textile, and polymer industries, as anti-static and softening agents. These ethoxylated quaternized PEIs have the formula:

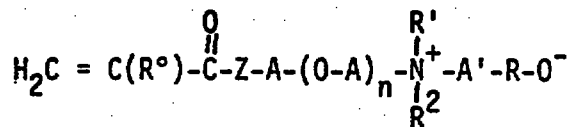


wherein R_1 is a compatible quaternary nitrogen substituent; n is at least 2; x is from 3 to 40; and X^- is a compatible anion. Preferred compounds are those where R_1 is a $\text{C}_8 - \text{C}_{22}$ alkyl group or the group:



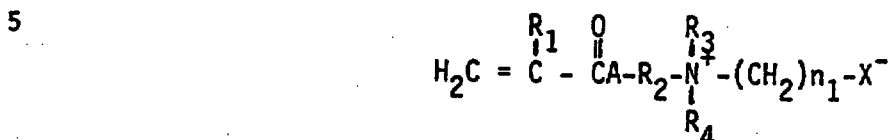
where R' is a $\text{C}_8 - \text{C}_{22}$ alkyl group and y is from 3 to 40. See also U. S. Patent 4,179,382 to Rudkin et al., issued December 18, 1979; U. S. Patent 4,152,272 to Young, issued May 1, 1979; and European Application 2,085 to Rudkin et al., published May 30, 1979, which disclose ethoxylated quaternized polyamines having C_{10} to C_{24} alkyl or alkenyl groups attached to one of the nitrogen atoms useful as fabric softeners.

U.S. Patent 3,671,305 to Brown et al. issued June 20, 1972, discloses zwitterionic monomers which form polymers used to treat films, sheets, and filamentary materials so as to give them a durable, hydrophilic, anti-static, anti-soiling, soil releasing finish. These monomers have the formula:

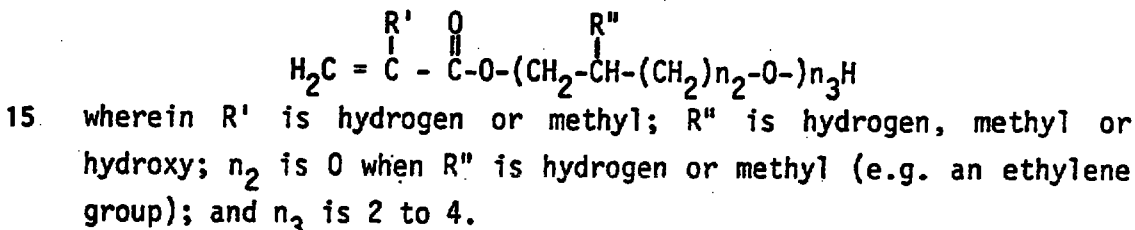


wherein n is 0 to 10; R^0 is hydrogen or methyl; Z is oxygen or ---NH--- ; A can be a $\text{C}_2\text{---C}_3$ alkylene group (e.g. ethylene) when n is 1-10; R' and R^2 can be $\text{C}_1\text{---C}_4$ alkyl; A' is $\text{C}_1\text{---C}_4$ alkylene; and R can be SO_2 .

U.S. Patent 3,671,502 to Samour et al. issued June 20, 1972, discloses co-polymers useful as binders in the production of non-wovens. These co-polymers consist essentially of from about 5 to about 90% of a monomer having the formula:



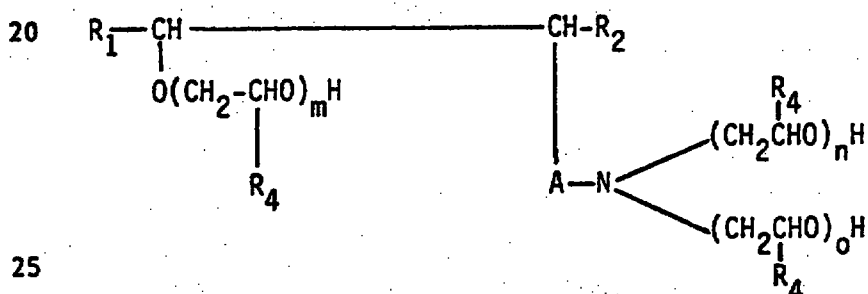
wherein R_1 is hydrogen or methyl; A is oxygen or $-\text{NH}-$; R_2 is ethylene, propylene, 2-hydroxypropylene or 2-acetoxypylene; R_3 and R_4 are alkyl; n_1 is 1 to 4; and X^- is SO_3^- or CO_2^- ; and from about 10 to about 95% by weight of a hydroxyacrylate such as a polyglycerol acrylate/methacrylate having the formula:



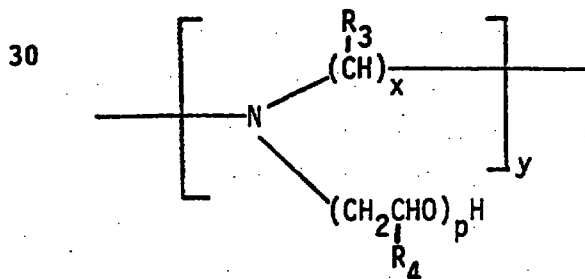
U. S. Patent 3,301,783 to Dickson, et al., issued January 31, 1967, discloses oxyalkylated, acylated, alkylated, carbonylated and olefinated derivatives of polyalkyleneimines, in particular polyethyleneimines (PEIs). For the oxyalkylated derivatives, the alkylene oxide (e.g. ethylene oxide) is reacted with the polyalkyleneimine in a mole ratio of from 1:1 to 1000:1, and preferably in a ratio of from 1:1 to 200:1. Among the ethoxylated PEIs disclosed are Examples 1-0₇ and 1-0₈ formed by condensing 105 and 200 moles, respectively, of ethylene oxide with a 900 M.W. PEI. The degree of ethoxylation calculates out to about 4.5 and about 8 ethoxy groups per reactive site, respectively. See also Examples 27-0₅ and 27-0₆ which disclose ethoxylated polypropyleneimines (M.W. 500) which have about 4 and about 8 ethoxy units per reactive site, respectively. Amongst the numerous disclosed uses of these polyalkyleneimine derivatives is a teaching that they are useful as detergents, softening agents, and anti-static agents. Preferred uses disclosed by this patent are as chelating agents, lubricating oil additives, emulsifying agents, and cutting oils.

U.S. Patent 2,792,371 to Dickson, issued May 14, 1957, teaches a process for breaking petroleum emulsions with oxy-alkylated tetraethylene pentaamines (TEPA). Ethoxylated TEPA's specifically disclosed include those having about 5 (Example 3aa),
 5 about 7 (Example 4aa), about 8.5 (Example 5a) and about 15.5 (Example 8c) ethoxy units per reactive site. Similarly, U.S. patent 2,792,370 to Dickson issued May 14, 1957, teaches a process for breaking petroleum emulsions with oxyalkylated triethylene tetramines (TETAs) including those having about 5.5 (Example 3aa),
 10 about 7.5 (Example 4aa), about 9 (Example 5a) and about 16.5 (Example 8c) ethoxy units per reactive site. See also U. S. patent 2,792,372 to Dickson, issued May 14, 1957, (oxyalkylated higher PEAs used to break petroleum emulsions); U. S. patent 2,792,369 to Dickson, issued May 14, 1957 (oxyalkylated diethylene triamines used to break petroleum emulsions).
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U. S. Patent 4,171,278 to Andree et al., issued October 16, 1979, discloses cold water detergent compositions containing a detergent surfactant (e.g. anionic) and a hydroxyalkyl amine in a weight ratio of 100:1 to 1:1. The amine can have the formula:



wherein R_1 is C_1-C_{16} alkyl; R_2 is H or C_1-C_{16} alkyl; $R_1 + R_2$ have 6-20 carbon atoms; R_4 is H or methyl; m, n, and o, are each 0 to 3 and A is bridging group such as



wherein R_3 is H or methyl; x is 2 to 6; y is 1 to 3; and p is 0 to

3; the sum of m to p being 1 to 5.5, and preferably 1 to 2. See also German Patent Document 2,165,900 to Henkel, published July 5, 1973, which discloses a washing agent for graying prevention formed by the reaction product of a PEI with an alkylglycidylether and ethylene oxide (2-hydroxyethyl moiety at each reactive site).

There are several patents which disclose detergent compositions, shampoo compositions and the like containing slightly ethoxylated PEIs (ethylene oxide:PEI weight ratio of 4:1 or less) to enhance the deposition and retention of particulate substances such as antimicrobials. See, for example, U.S. Patent 3,489,686 to Parran, issued January 13, 1970; U.S. Patent 3,580,853 to Parran, issued May 25, 1971; British Patent Specification 1,111,708 to Procter & Gamble published May 1, 1968, U.S. Patent 3,549,546 to Moore, issued December 22, 1970; and U.S. Patent 3,549,542 to Holderby, issued December 22, 1970.

DISCLOSURE OF THE INVENTION

The present invention relates to detergent compositions which comprise from 0.05 to 95% by weight of the composition of water-soluble cationic compounds having clay soil removal/ anti-redeposition properties.

These compounds are selected from ethoxylated cationic polymers which comprise a polymer backbone as hereinafter defined, at least 2 M groups and at least one L-X group, where M is a cationic group

attached to or integral with the backbone and contains an N^+ positively charged center; and L connects groups M and X or connects group X to the polymer backbone; wherein X is a nonionic group selected from H, C_1-C_4 alkyl or hydroxyalkyl ester or C_1-C_4 alkyl or hydroxyalkyl ether groups; L is a hydrophilic

chain consisting of the polyoxyalkylene moiety $-(R^6O)_m(CH_2CH_2O)_n-$, wherein R^6 is C_3-C_4 alkylene or hydroxyalkylene, m is from 0 to 5 and n is a number of at least 3 such that the moiety $-(CH_2CH_2O)_n-$ comprises at least 50% by weight of said polyoxyalkylene moiety.

In addition to the cationic compounds, the detergent compositions further comprise from 1 to 75% by weight of the composition of a nonionic, anionic, ampholytic, zwitterionic, or cationic detergent surfactant or mixture thereof. In addition to these detergent surfactants, the detergent composition can optionally comprise from 0 to 80% by weight of a detergent builder.

The cationic compounds of the present invention provide clay soil removal benefits while being anionic detergent surfactant compatible. It is believed that the positively charged cationic groups cause adsorption of the compound onto the negatively charged layers of the clay particle. It is also believed that the hydrophilic ethoxy units attached to the compound swell the clay particle so that it loses its cohesive character and is swept away in the wash water.

The anti-redeposition benefits provided by these cationic compounds are also believed to be due to the positively charged cationic groups which cause it to be adsorbed onto soil suspended in the wash water. As more and more of these compounds adsorb onto the suspended soil, it becomes encased within a hydrophilic layer provided by the attached ethoxy units. As such, the hydrophilically encased soil is prevented from redepositing on fabrics, in particular hydrophobic fabrics such as polyester, during the laundering cycle.

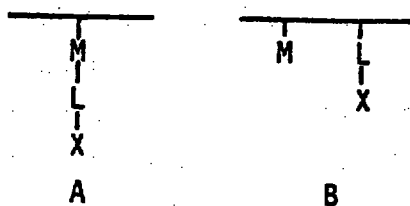
Cationic Polymers

The water-soluble cationic polymers of the present invention comprise a polymer backbone, at least 2 M groups and at least one L-X group, wherein M is a cationic group attached to or integral with the backbone; X is a nonionic group selected from the group consisting of H, C₁-C₄ alkyl or hydroxyalkyl ester or ether groups; and L is a hydrophilic chain connecting groups M and X or connecting X to the polymer backbone.

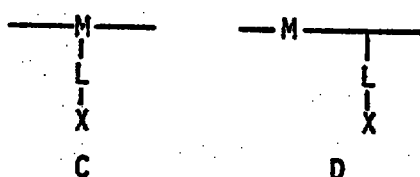
As defined herein, the term "polymer backbone" refers to a polymeric moiety comprising at least two units and to which groups M and L-X are attached to or integral with. Included within this term are oligomer backbones (2 to 4 units), and true polymer backbones (5 or more units).

As used herein, the term "attached to" means that the group is pendent from the polymer backbone, examples of which are represented by the following general structures A and B:

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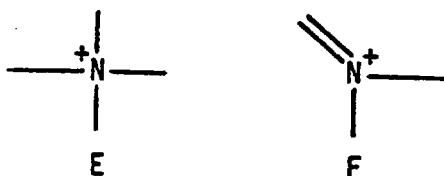


As used herein, the term "integral with" means that the group forms part of the polymer backbone, examples of which are represented by the following general structures C and D:



Any polymer backbone can be used as long as the cationic polymer formed is water-soluble and has clay soil removal/anti-redeposition properties. Suitable polymer backbones can be derived from the polyurethanes, the polyesters, the polyethers, the polyamides, the polyimides, the polyacrylates, the polyacrylamides, the polyvinylethers, the polyethylenes, the polypropylenes and like polyalkylenes, the polystyrenes and like polyalkarylenes, the polyalkyleneamines, the polyalkyleneimines, the polyvinylamines, the polyallylamines, the polydiallylamines, the polyvinylpyridines, the polyaminotriazoles, polyvinyl alcohol, the aminopolyureylenes, and mixtures thereof.

M can be any compatible cationic group which comprises an N^+ (quaternary), positively charged center. The quaternary positively charged center can be represented by the following general structures E and F:



Particularly preferred M groups are those containing a quaternary center represented by general structure E. The cationic group is preferably positioned close to or integral with the polymer backbone.

The positive charge of the N^+ centers is offset by the appropriate number of counter anions. Suitable counter anions include Cl^- , Br^- , SO_3^{-2} , SO_4^{-2} , PO_4^{-2} , $MeOSO_3^-$ and the like. Particularly preferred counter anions are Cl^- and Br^- .

5 X is a nonionic group selected from hydrogen (H), C_1-C_4 alkyl or hydroxyalkyl ester or ether groups, and mixtures thereof. The preferred ester or ether groups are the acetate ester and methyl ether, respectively. The particularly preferred nonionic groups are H and the methyl ether.

10 The cationic polymers for use herein normally have a ratio of cationic groups M to nonionic groups X of from 1:1 to 1:2. However, for example, by appropriate copolymerization of cationic, nonionic (i.e. containing the group L-X), and mixed cationic/nonionic monomers, the ratio of cationic
15 groups M to nonionic groups X can be varied. The ratio of groups M to groups X can usually range from 2:1 to 1:10. In preferred cationic polymers, the ratio is from 1:1 to 1:5. The polymers formed from such copolymerization are typically random, i.e. the cationic, nonionic, and mixed cationic/nonionic
20 monomers copolymerize in a nonrepeating sequence.

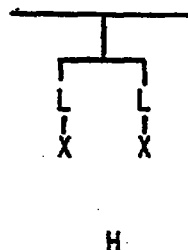
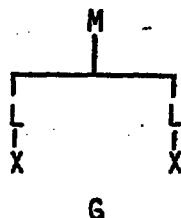
The units which contain groups M and groups L-X can comprise 100% of the cationic polymers. However, inclusion of other units (preferably nonionic) in the polymers is also permissible. Examples of other units include acrylamides,
25 vinyl ethers, and those containing unquaternized tertiary amine groups (M^1) containing an N center. These other units can comprise from 0 to 90% of the polymer (from 10 to 100% of the polymer being units containing M and L-X groups, including M^1 -L-X groups). Normally, these other units comprise from 0 to
30 50% of the polymer (from 50 to 100% of the polymer being units containing M and L-X groups).

The number of groups M and L-X each usually ranges from 2 to 200. Typically, the number of groups M and L-X are each from 3 to 100. Preferably, the number of groups
35 M and L-X are each from 3 to 40.

Other than moieties for connecting groups M and X, or for attachment to the polymer backbone, hydrophilic chain L usually consists entirely of the polyoxyalkylene moiety $-(R'O)_m(CH_2CH_2O)_n-$. The moieties $-(R'O)_m-$ and $(CH_2CH_2O)_n-$ of the polyoxyalkylene moiety can be mixed together, or preferably form blocks of $-(R'O)_m-$ and $-(CH_2CH_2O)_n-$ moieties. R' is preferably C_3H_6 (propylene); m is from 0 to 5, and preferably 0; i.e. the polyoxyalkylene moiety consists entirely of the moiety $-(CH_2CH_2O)_n-$. The moiety $-(CH_2CH_2O)_n-$ preferably comprises at least 85% by weight of the polyoxyalkylene moiety, and most preferably 100% by weight (m is 0). For the moiety $-(CH_2CH_2O)_n-$, n is usually from 3 to 100. Preferably, n is from 12 to 42.

A plurality (2 or more) of moieties -L-X can also be hooked together and attached to group M or to the polymer backbone, examples of which are represented by the following general structures G and H:

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Structures such as G and H can be formed, for example, by reacting glycidol with group M or with the polymer backbone, and ethoxylating the subsequently formed hydroxy groups.

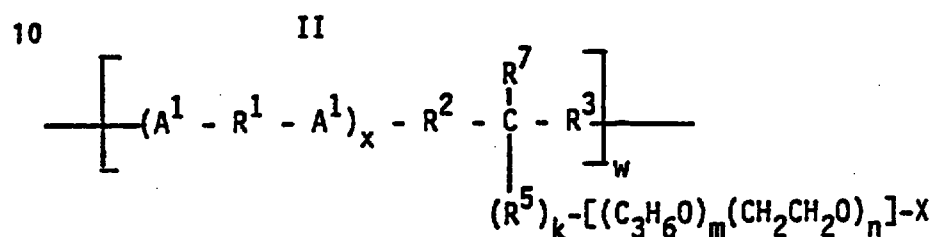
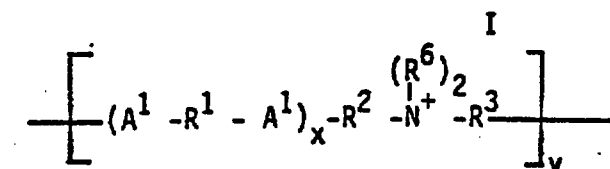
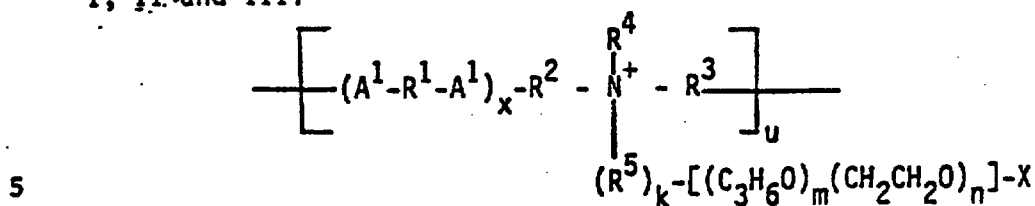
Representative classes of cationic polymers for use herein are as follows:

30 A. Polyurethane, Polyester, Polyether, Polyamide or Like Polymers

One class of suitable cationic polymers are derived from polyurethanes, polyesters, polyethers, polyamides and the like. These polymers comprise units selected from those having formulas

35

I, II, and III:



III

wherein A^1 is $\overset{\overset{O}{||}}{NC-}$, $\overset{\overset{O}{||}}{CN-}$, $\overset{\overset{O}{||}}{CO-}$, $\overset{\overset{O}{||}}{OC-}$ or $\overset{\overset{O}{||}}{C-}$;
 $\underset{\underset{R}{|}}{R}$ $\underset{\underset{R}{|}}{R}$

x is 0 or 1; R is H or C_1 - C_4 alkyl or hydroxyalkyl; R^1 is C_2 - C_{12} alkylene, hydroxyalkylene, alkenylene, cycloalkylene, arylene or alkarylene, or a C_2 - C_3 oxyalkylene moiety having from 2 to 20 oxyalkylene units provided that no O-O or O-N bonds are formed with A^1 ; when

x is 1, R^2 is $-R^5-$ except when A^1 is $\overset{\overset{O}{||}}{C-}$, or is $-(OR^8)_y-$ or $-OR^5-$ provided that no O-O or N-O bonds are formed with A^1 , and R^3 is

$-R^5-$ except when A^1 is $\overset{\overset{O}{||}}{C-}$, or is $-(R^8O)_y-$ or $-R^5O-$ provided that no O-O or O-N bonds are formed with A^1 ; when x is 0, R^2 is $-(OR^8)_y-$, $-OR^5-$, $-\overset{\overset{O}{||}}{COR^5-}$, $-\overset{\overset{O}{||}}{OCR^5-}$, $-\overset{\overset{O}{||}}{OCOR^5-}$, $-\overset{\overset{O}{||}}{NCR^5-}$, $-\overset{\overset{O}{||}}{NCOR^5-}$, $-\overset{\overset{O}{||}}{CNR^5-}$,

or $-\overset{\overset{OR}{||}}{CNR^5-}$, and R^3 is $-R^5-$; R^4 is C_1 - C_4 alkyl or hydroxyalkyl, or the moiety $-(R^5)_k - [(C_3H_6O)_m (CH_2CH_2O)_n] - X$; R^5 is C_1 - C_{12} alkylene, hydroxyalkylene, alkenylene, arylene, or alkarylene; each R^6 is

C_1-C_4 alkyl or hydroxyalkyl, or the moiety $-(CH_2)_r-A^2-(CH_2)_s-$, wherein A^2 is $-O-$ or $-CH_2-$; R^7 is H or R^4 ; R^8 is C_2-C_3 alkylene or

hydroxyalkylene; X is H, $-\overset{\overset{O}{\parallel}}{C}R^9$, $-R^9$ or a mixture thereof, wherein R^9 is C_1-C_4 alkyl or hydroxyalkyl; k is 0 or 1; n is a number of at least 3 such that the moiety $-(CH_2CH_2O)_n-$ comprises at least 85% by weight of the moiety $-[(C_3H_6O)_m(CH_2CH_2O)_n]-$; m is from 0 to 5; r is 1 or 2, s is 1 or 2, and r + s is 3 or 4; y is from 2 to 20; the number of u, v and w are such that there are at least 2 N^+ centers and at least 2 X groups.

In the above formulas, A^1 is preferably $-\overset{\overset{O}{\parallel}}{N}C-$ or $-\overset{\overset{O}{\parallel}}{C}N-$
 $\begin{array}{c} R \\ | \end{array}$ $\begin{array}{c} R \\ | \end{array}$

A^2 is preferably $-O-$; x is preferably 1; and R is preferably H. R^1 can be linear (e.g. $-CH_2-CH_2-CH_2-$,

$-CH_2-CH-$) or branched (e.g. $-CH_2-CH-$, $-\overset{\overset{CH}{|}}{CH_2}-CH-$)
 $\begin{array}{c} \text{O} \\ \text{---} \end{array}$ $\begin{array}{c} \text{CH}_3 \\ | \end{array}$ $\begin{array}{c} \text{O} \\ \text{---} \end{array}$

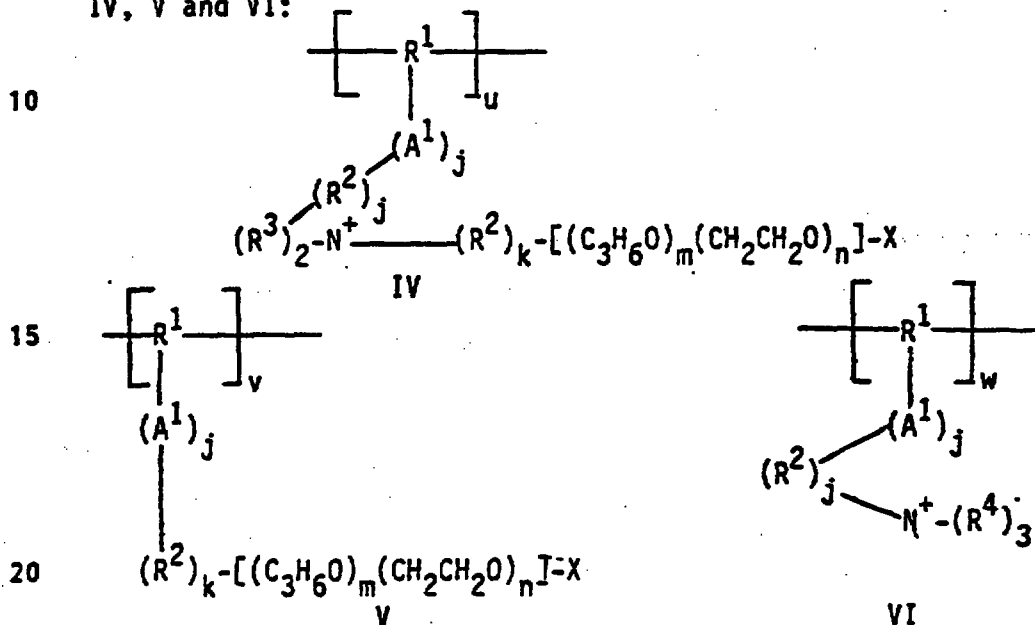
alkylene, hydroxyalkylene, alkenylene, cycloalkylene, alkarylene or oxyalkylene; when R^1 is a C_2-C_3 oxyalkylene moiety, the number of oxyalkylene units is preferably from 2 to 12; R^1 is preferably C_2-C_6 alkylene or phenylene, and most preferably C_2-C_6 alkylene (e.g. ethylene, propylene, hexamethylene). R^2 is preferably $-OR^5-$ or $-(OR^8)_y-$; R^3 is preferably $-R^5O-$ or $-(R^8O)_y-$; R^4 and R^6 are preferably methyl. Like R^1 , R^5 can be linear or branched, and is preferably C_2-C_3 alkylene; R^7 is preferably H or C_1-C_3 alkyl; R^8 is preferably ethylene; R^9 is preferably methyl; X is preferably H or methyl; k is preferably 0; m is preferably 0; r and s are each preferably 2; y is preferably from 2 to 12.

In the above formulas, n is preferably at least 6 when the number of N^+ centers and X groups is 2 or 3; n is most preferably at least 12, with a typical range of from 12 to 42 for all ranges of u + v + w. For homopolymers (v and w are 0), u is preferably from 3 to 40, and is most preferably from 3 to 20. For random copolymers

(u is at least 1 or preferably 0), v and w are each preferably from 3 to 40.

B. Polyacrylate, Polyacrylamide, Polyvinylether or Like Polymers

5 Another class of suitable cationic polymers are derived from polyacrylates, polyacrylamides, polyvinylethers and the like. These polymers comprise units selected from those having formulas IV, V and VI:



wherein A^1 is $-O-$, $-\overset{\overset{O}{\parallel}}{N}C-$, $-\overset{\overset{O}{\parallel}}{N}CO-$, $-\overset{\overset{O}{\parallel}}{C}NC-$, $-\overset{\overset{O}{\parallel}}{C}N-$, $-\overset{\overset{O}{\parallel}}{O}CN-$

25 $-\overset{\overset{O}{\parallel}}{O}C-$, $-\overset{\overset{O}{\parallel}}{O}CO-$, $-\overset{\overset{O}{\parallel}}{C}O-$, or $-\overset{\overset{O}{\parallel}}{N}CN-$; R is H or C_1-C_4 alkyl or

hydroxyalkyl; R^1 is substituted C_2-C_{12} alkylene, hydroxyalkylene, alkenylene, arylene or alkarylene, or C_2-C_3 oxyalkylene; each R^2 is C_1-C_{12} alkylene, hydroxyalkylene, alkenylene, arylene or alkarylene; each R^3 is C_1-C_4 alkyl or hydroxyalkyl, the moiety $-(R^2)_k-[(C_3H_6O)_m(CH_2CH_2O)_n]-X$, or together form the moiety $-(CH_2)_r-A^2-(CH_2)_s-$, wherein A^2 is $-O-$ or $-CH_2-$; each R^4 is C_1-C_4 alkyl or hydroxyalkyl, or two R^4 together form the moiety

35 $-(CH_2)_r-A^2-(CH_2)_s-$; X is H, $-\overset{\overset{O}{\parallel}}{C}R^5$, $-R^5$ or mixture thereof, wherein

R^5 is C_1 - C_4 alkyl or hydroxyalkyl; j is 1 or 0; k is 1 or 0; n is a number of at least 3 such that the moiety $-(CH_2CH_2O)_n-$ comprises at least 85% by weight of the moiety $-[(C_3H_6O)_m(CH_2CH_2O)_n]-$; m is

from 0 to 5; r is 1 or 2, s is 1 or 2

and $r + s$ is 3 or 4; the number of u , v and w are such that there are at least 2 N^+ centers and at least 2 X groups.

In the above formulas, A^1 is preferably $\begin{array}{c} O \\ || \\ -C- \\ | \\ R \end{array}$, $\begin{array}{c} O \\ || \\ -CO- \end{array}$ or $-O-$;

A^2 is preferably $-O-$; R is preferably H. R^1 can be linear (e.g.

$-CH_2-CH_2-CH_2-$, $-CH_2CH-$) or branched (e.g. $-CH_2-\overset{\overset{CH_3}{|}}{C}-$, $-CH_2\overset{\overset{CH_2}{|}}{CH}-$,

$-CH_2\overset{\overset{CH_3}{|}}{C}-$, $-CH_2\overset{\overset{\text{Cyclohexyl}}{|}}{C}-$) substituted alkylene, hydroxyalkylene,

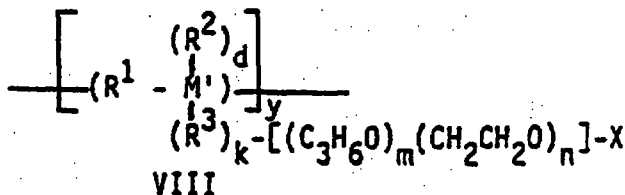
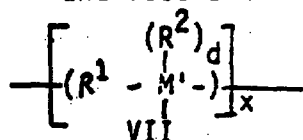
alkenylene, alkarylene or oxyalkylene; R^1 is preferably substituted C_2 - C_6 alkylene or substituted C_2 - C_3 oxyalkylene, and

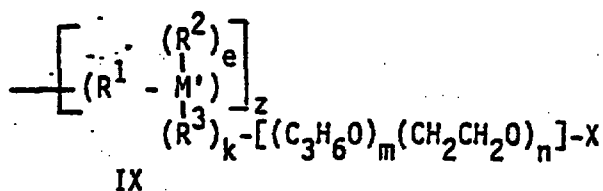
most preferably $-CH_2CH-$ or $-CH_2-\overset{\overset{CH_3}{|}}{C}-$. Each R^2 is preferably C_2 - C_3 alkylene; each R^3 and R^4 are preferably methyl; R^5 is preferably methyl; X is preferably H or methyl; j is preferably 1; k is preferably 0; m is preferably 0; r and s are each preferably 2.

In the above formulas, n , u , v and w can be varied according to the n , u , v and w for the polyurethane and like polymers.

C. Polyalkyleneamine, Polyalkyleneimine or Like Polymers

Another class of suitable cationic polymers are derived from polyalkyleneamines, polyalkyleneimines and the like. These polymers comprise units selected from those having formulas VII and VIII and IX:





- 5 wherein R^1 is $C_2 - C_{12}$ alkylene, hydroxyalkylene, alkenylene, cycloalkylene, arylene or alkarylene, or a $C_2 - C_3$ oxyalkylene moiety having from 2 to 20 oxyalkylene units provided that no O-N bonds are formed; each R^2 is $C_1 - C_4$ alkyl or hydroxyalkyl, or the moiety $-(R^3)_k - [(C_3H_6O)_m (CH_2CH_2O)_n] - X$; R^3 is $C_1 - C_{12}$
- 10 alkylene, hydroxyalkylene, alkenylene, arylene or alkarylene; M' is an N^+ or N center; X is H, $-CR^4$, $-R^4$ or mixture thereof,

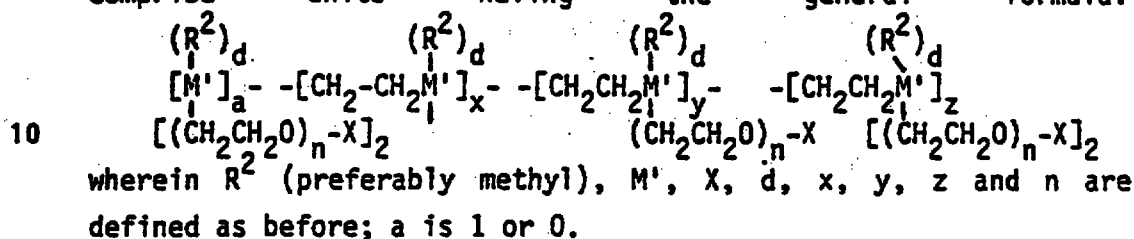
- wherein R^4 is $C_1 - C_4$ alkyl or hydroxyalkyl; d is 1 when M' is N^+ and is 0 when M' is N; e is 2 when M' is N^+ and is 1 when M' is N;
- 15 k is 1 or 0; n is a number of at least 3 such that the moiety $-(CH_2CH_2O)_n -$ comprises at least 85% by weight of the moiety $-(C_3H_6O)_m (CH_2CH_2O)_n$; m is from 0 to 5;

the number of x, y and z are such that there are at least 2 M' groups, at least 2 N^+ centers and at least 2 X groups.

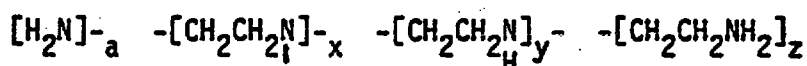
- 20 In the above formulas, R^1 can be varied like R^1 of the polyurethane and like polymers; each R^2 is preferably methyl or the moiety $-(R^3)_k - [(C_3H_6O)_m (CH_2CH_2O)_n] - X$; R^3 is preferably $C_2 - C_3$ alkylene; R^4 is preferably methyl; X is preferably H; k is preferably 0; m is preferably 0.

- 25 In the above formulas, n is preferably at least 6 when the number of M' and X groups is 2 or 3; n is most preferably at least 12, with a typical range of from 12 to 42 for all ranges of $x + y + z$. Typically, $x + y + z$ is from 2 to 40, and preferably from 2 to 20. For short chain
- 30 length polymers, $x + y + z$ can range from 2 to 9 with from 2 to 9 N^+ centers and from 2 to 11 X groups. For long chain length polymers, $x + y + z$ is at least 10, with a preferred range of from 10 to 42. For the short and long chain length polymers, the M' groups are typically a mixture of from 50 to 100% N^+
- 35 centers and from 0 to 50% N centers.

Preferred cationic polymers within this class are derived from the C₂-C₃ polyalkyleneamines (x + y + z is from 2 to 9) and polyalkyleneimines (x + y + z is at least 10, preferably from 10 to 42). Particularly preferred cationic polyalkyleneamines and polyalkyleneimines are the cationic polyethyleneamines (PEAs) and polyethyleneimines (PEIs). These preferred cationic polymers comprise units having the general formula:



Prior to ethoxylation, the PEAs used in preparing cationic polymers have the following general formula:



wherein x + y + z is from 2 to 9; and a is 0 or 1 (molecular weight of from 100 to 400). Each hydrogen atom attached to each nitrogen atom represents an active site for subsequent ethoxylation. For preferred PEAs, x + y + z is from 3 to 7 (molecular weight of from 140 to 310). These PEAs can be obtained by reactions involving ammonia and ethylene dichloride, followed by fractional distillation. The common PEAs obtained are triethylenetetramine (TETA) and tetraethylenepentamine (TEPA). Above the pentamines, i.e., the hexamines, heptamines, octamines and possibly nonamines, the cogenerically derived mixture does not appear to separate by distillation and can include other materials such as cyclic amines and particularly piperazines. There can also be present cyclic amines with side chains in which nitrogen atoms appear. See U.S. Patent 2,792,372 to Dickson, issued May 14, 1957, which describes the preparation of PEAs.

The minimum degree of ethoxylation required for preferred clay soil removal/anti-redeposition performance can vary depending upon the number of units in the PEA. Where y + z is 2 or 3, n is

preferably at least 6. Where $y + z$ is from 4 to 9, suitable benefits are achieved when n is at least 3. For preferred cationic PEAs, n is at least about 12, with a typical range of from 12 to 42.

5 The PEIs used in preparing the polymers have a molecular weight of at least 440 prior to ethoxylation, which represents at least about 10 units. Preferred PEIs used in preparing these polymers have a molecular weight of from 600 to 1800. The polymer backbone of these PEIs
10 can be represented by the general formula:

$$\text{H}_2\text{N} - \text{[-CH}_2\text{CH}_2\text{N-}]_x \text{[-CH}_2\text{CH}_2\text{N-}]_y^{\text{H}} \text{[-CH}_2\text{CH}_2\text{NH}_2]_z$$

wherein the sum of x , y and z represents a number of sufficient magnitude to yield a polymer having the molecular weights previously specified. Although linear polymer backbones are possible, branch chains can also occur. The relative proportions of primary, secondary and tertiary amine groups present in the polymer can vary, depending on the manner of preparation. The distribution of amine groups is typically as follows:

20

-CH ₂ CH ₂ -NH ₂	30%
-CH ₂ CH ₂ -NH-	40%
-CH ₂ CH ₂ -N-	30%

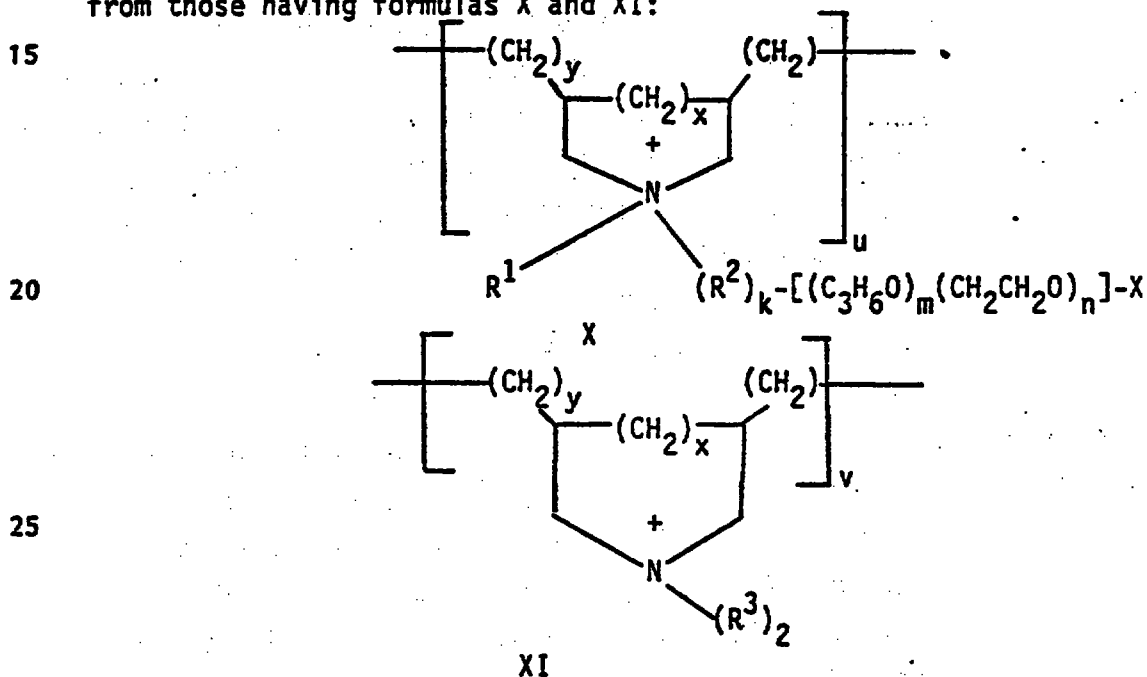
Each hydrogen atom attached to each nitrogen atom of the PEI represents an active site for subsequent ethoxylation. These PEIs
25 can be prepared, for example, by polymerizing ethyleneimine in the presence of a catalyst such as carbon dioxide, sodium bisulfite, sulfuric acid, hydrogen peroxide, hydrochloric acid, acetic acid, etc. Specific methods for preparing PEIs are disclosed in U.S. Patent 2,182,306 to Ulrich et al., issued December 5, 1939; U.S.
30 Patent 3,033,746 to Mayle et al., issued May 8, 1962; U.S. Patent 2,208,095 to Esselmann et al., issued July 16, 1940; U.S. Patent 2,806,839 to Crowther, issued September 17, 1957; and U.S. Patent 2,553,696 to Wilson, issued May 21, 1951.

35 As defined in the preceding formulas, n is at least about 3 for the cationic PEIs. However, it should be noted that the

minimum degree of ethoxylation required for suitable clay soil removal/anti-redeposition performance can increase as the molecular weight of the PEI increases, especially much beyond 1800. Also, the degree of ethoxylation for preferred polymers increases as the molecular weight of the PEI increases. For PEIs having a molecular weight of at least 600, n is preferably at least 12, with a typical range of from 12 to 42. For PEIs having a molecular weight of 1800, n is preferably at least 24, with a typical range of from 24 to 42.

D. Diallylamine Polymers

Another class of suitable cationic polymers are those derived from the diallylamines. These polymers comprise units selected from those having formulas X and XI:



wherein R^1 is $\text{C}_1\text{-C}_4$ alkyl or hydroxyalkyl, or the moiety $\text{(R}^2\text{)}_k - \text{[(C}_3\text{H}_6\text{O)}_m \text{(CH}_2\text{CH}_2\text{O)}_n\text{]} - \text{X}$; R^2 is $\text{C}_1\text{-C}_{12}$ alkylene, hydroxylalkylene, alkylene, arylene or alkarylene; each R^3 is $\text{C}_1\text{-C}_4$ alkyl or hydroxyalkyl, or together form the moiety $\text{-(CH}_2\text{)}_r\text{-A-(CH}_2\text{)}_s\text{-}$, wherein A is -O- or $\text{-CH}_2\text{-}$; X is H, -CR^4 , -R^4 or

mixture thereof, wherein R^4 is C_1 - C_4 alkyl or hydroxyalkyl; k is 1 or 0; n is a number of at least 3 such that the moiety $-(CH_2CH_2O)_n-$ comprises at least 85% by weight of the moiety $[(C_3H_6O)_m(CH_2CH_2O)_n]-$; m is from 0 to about 5;

5 r is 1 or 2, s is 1 or 2, and $r + s$ is 3 or 4; x is 1 or 0; y is 1 when x is 0 and 0 when x is 1; the number of u and v are such that there are at least 2 N^+ centers and at least 2 X groups.

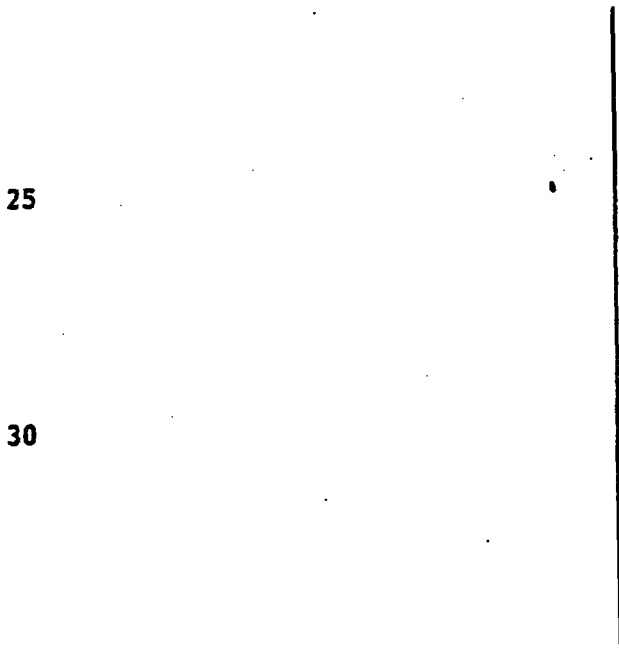
In the above formulas, A is preferably $-O-$; R^1 is preferably methyl; each R^2 is preferably C_2 - C_3 alkylene; each R^3 is preferably methyl; R^4 is preferably methyl; X is preferably H ; k is preferably 0; m is preferably 0; r and s are each preferably 2.

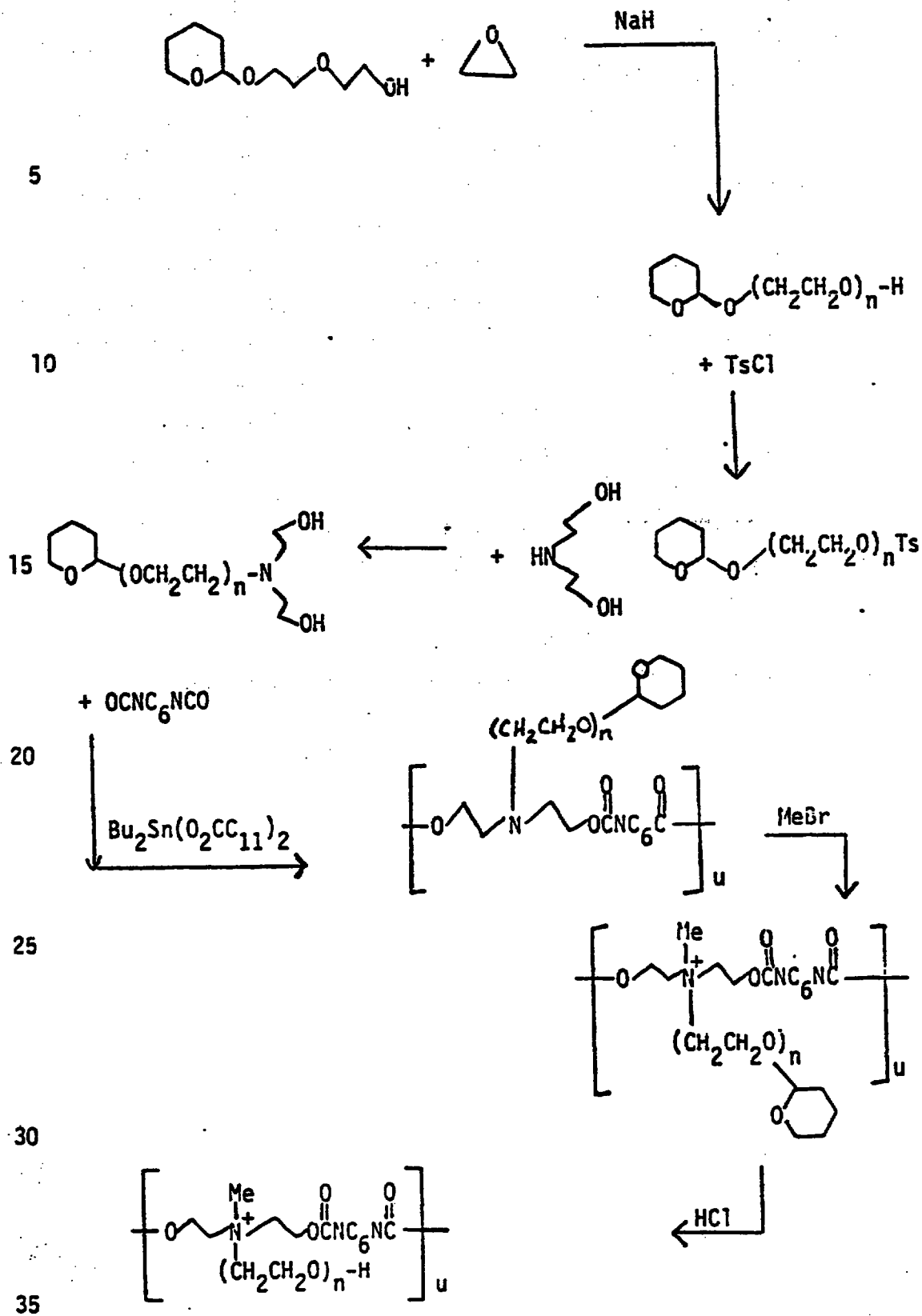
10 In the above formulas, n is preferably at least 6 when the number of N^+ centers and X groups are each 2 or 3, n is preferably at least 12, with a typical range of from 12 to 42 for all ranges of $u + v$. Typically, v is 0, and u is from 2 to 40, and preferably from 2 to 20.

Methods for Making Cationic Polymers

A. Polyurethane

The polyurethane versions can be prepared according to the following general scheme.





Example 1Step 1: Ethoxylation

The monotetrahydropyranyl ether of diethylene glycol (1.77 moles) [Compt. Rend., 260, 1399-1401 (1965)] is ethoxylated using 5 mole % NaH to generate a catalytic amount of the corresponding alkoxide. Ethoxylation is conducted at 90°-120°C until about 22 moles ($n = 22$) of ethylene oxide is taken up for each mole of the starting alcohol to form the ethoxylated compound.

Step 2: Tosylation

The ethoxylated compound from step 1 is dissolved in 1000 ml. of acetonitrile and then cooled to about 10°C. To this solution is added 2.67 moles of tosyl chloride dissolved in 500 ml. of acetonitrile and cooled to 10°C and then 2.9 moles of triethylamine is added. After the reaction is complete, H₂O is added to decompose the remaining tosyl chloride.

Step 3: Amination

To the reaction mixture from step 3 is added 3.4 moles of diethanolamine. After heating for 18 hrs. at 80°C, the reaction mixture is cooled and carefully acidified with HCl to a pH just above 7 and then extracted with ether. The aqueous phase is then extracted with a mixture of ether:acetonitrile (ratio of about 5:2) twice. The aqueous phase is separated and then made basic with 50% NaOH. This aqueous phase is extracted with dichloromethane (2000 ml.). The lower layer is separated and then extracted 3 times with 2000 ml. portions of 1/4 saturated NaCl solution while adding enough 50% NaOH to make the aqueous phase strongly basic (pH of about 11). The lower organic layer is stripped to give the desired aminated compound. Toluene (200 ml.) is added and the mixture stripped again to give the desired aminated monomer.

Step 4: Polymerization

The monomer from step 3 is dissolved in chloroform free of ethanol stabilizer. The monomer is previously evacuated in a Kugelrohr at 80°-90°C under a vacuum (pressure of 1 mm.) for at least 18 hours. The monomer in the chloroform is then dried overnight with 3Å molecular sieves and then transferred to a dry

flask (equipped with mechanical stirrer) under argon. To the monomer is added dibutyltin dilaurate catalyst (0.058 mole equiv.) in chloroform under argon. To the stirred reaction mixture is then added 0.7 moles of hexamethylenediisocyanate per mole of aminated monomer over a 5 minute period. The reaction mixture is stirred at room temperature for 18 hours. The chloroform is removed under a vacuum at about 70°C to give the resulting polymer.

Step 5: Quaternization and Removal of Protecting Groups

10 The polymer from step 4 is dissolved in methanol and an excess of methyl bromide is passed in. After about 5 hours, the pH is adjusted to about 4 with aqueous HCl and is then allowed to stand overnight to solvolyze the tetrahydropyranyl protecting group. The solution is then neutralized with NaOH and stripped to give the crude polyurethane. This crude polyurethane is dissolved in chloroform and filtered to remove any salts. The chloroform is stripped away to give the desired, largely salt-free polymer.

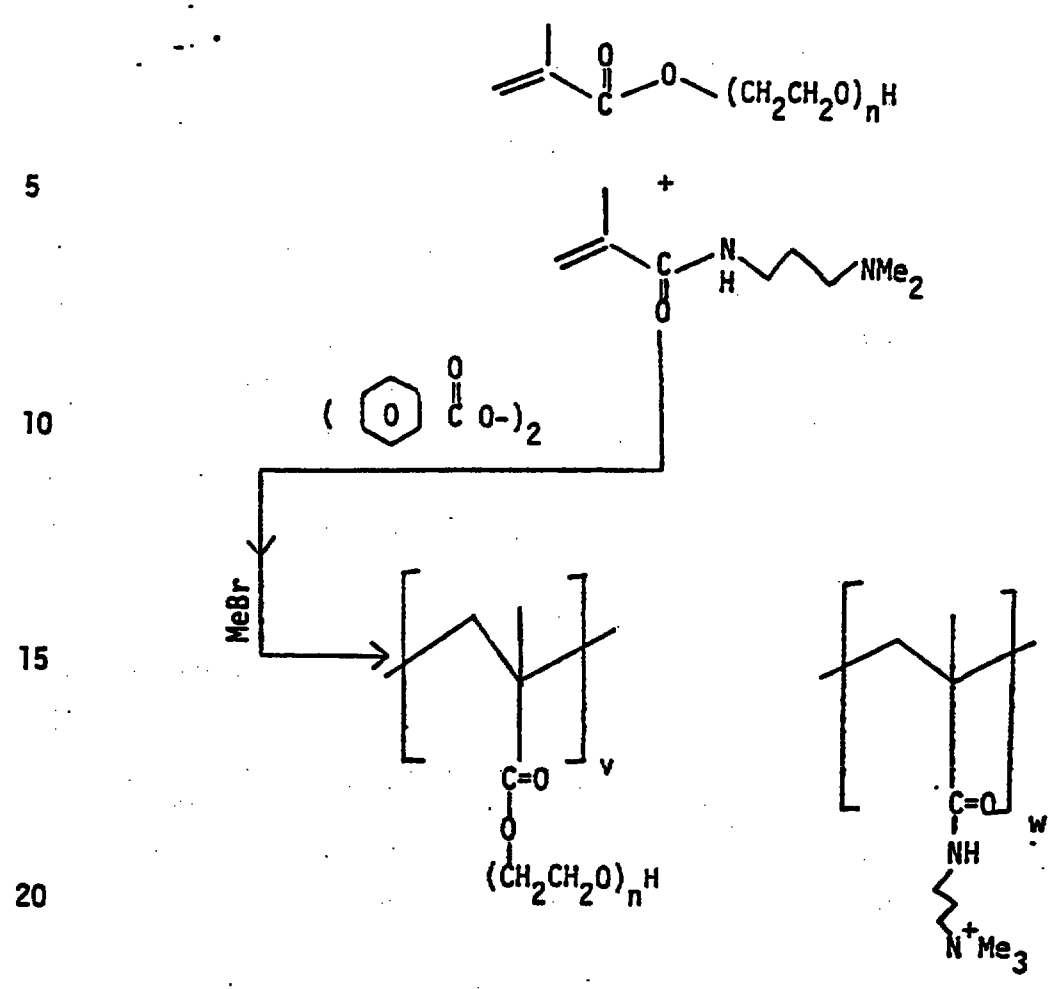
B. Random Copolymer of Ethoxylated Acrylate and a Cationic Methacrylamide

20 The random copolymer versions of the present invention can be prepared according to the following general scheme:

25

30

35



The synthesis of one such random copolymer is described as follows:

Example 2

5 Decaethylene glycol monomethacrylate monomer (0.008 moles)
and N-(3-dimethylaminopropyl)-methacrylamide monomer (0.011 moles)
are dissolved in 40 ml. of acetonitrile. The reaction mixture is
purged of oxygen by bubbling argon through it. A 0.23 g. portion
of benzoyl peroxide is separately dissolved in 10 ml. of
acetonitrile and similarly purged. The reaction mixture is heated
10 to reflux and the benzoyl peroxide solution then added dropwise
over 0.5 hours. Next, 0.28 g. of azobisisobutyronitrile in 5 ml.
of acetonitrile is added to the reaction mixture and heating
continued overnight. A stream of methyl bromide is then passed
through the reaction mixture which is then warmed slightly for 1
15 hour. The desired random copolymer is isolated by stripping off
the solvent.

C. Quaternized Polyethyleneamines and Polyethyleneimines

Quaternized polyethyleneamines and polyethyleneimines can be
prepared using standard methods for ethoxylating amines, with
20 subsequent quaternization. Representative syntheses of such
polyethyleneamines and polyethyleneimines are as follows:

Example 3a

Step 1: Ethoxylation

25 Tetraethylenepentamine (TEPA) (M.W. 189, 13.5 g., 0.071
moles) was placed in a nominally dry flask and dried by stirring
for 0.5 hrs. at 110°-120°C under vacuum (pressure less than 1 mm
Hg.). The vacuum was released by drawing ethylene oxide (EO) from
a prepurged trap connected to a supply tank. Once the flask was
filled with EO, an outlet stopcock was carefully opened to a trap
30 connected to an exhaust bubbler. After 3 hrs. stirring at
115°-125°C, H-NMR analysis indicated the degree of ethoxylation of
1 per reactive site. The reaction mixture was cooled while being
swept with argon and 0.5 g. (0.0125 moles) of 60% sodium hydride
in mineral oil was then added. The stirred reaction mixture was
35 swept with argon until hydrogen evolution ceased. EO was then
added to the mixture as a sweep under atmospheric pressure at

117°-135°C with moderately fast stirring. After 31 hrs., 459 g. (10.43 moles) of EO had been added to give a calculated total degree of ethoxylation of 21.

Step 2: Quaternization

- 5 A 34.8 g. (0.0052 moles) portion of the ethoxylated TEPA from step 1 which was a brown waxy solid, was dissolved in D₂O to give a 50% solution. The pH of the solution was about 8. The solution was heated to 60°C and methyl bromide gas swept through the reaction vessel whose exit was connected to a bubbler. Several
10 times during the reaction, the pH became acidic and NaHCO₃ was added to the reaction to maintain the pH at about 8. After about 20 hrs. a sweep bubbler was placed below the reaction mixture surface so that the methyl bromide was bubbled through the mixture while the stirring rate was increased. After a total of 22 hrs.,
15 the reaction mixture was diluted to 25% and dialized to remove salts. The reaction mixture was then freeze dried to give a pale yellowish tan crystalline solid as the quaternized ethoxylated TEPA.

Example 3b

20 Step 1: Ethoxylation

- By a procedure similar to that of Example 3a, PEI (21.5 g., M.W. 600, 0.5 moles) was dried at 120°C under vacuum and swept with EO until hydroxyethylation was complete (3 hrs.). The hydroxyethylated compound was cooled under argon and 0.1 g.
25 (0.0022 moles) of 50% NaH in mineral oil was added. The reaction mixture was heated to about 70°C and swept for 13 hrs. with EO until a total of 88.5 g. of EO had been added which gave a calculated degree of ethoxylation of 3.4.

- A 53 g. (0.0173 mole) portion of this compound was placed in
30 a similar apparatus, heated to 120°C and evacuated for 0.5 hrs. then cooled under argon and an additional 0.5 g. (0.010 moles) of 50% NaH was added. EO was swept in for 11 hrs. until 103 g. of EO had been added. This brought the total degree of ethoxylation up to 11.6.

- 35 A 74 g. portion (0.0082 moles) of the 11.6 ethoxylated PEI was placed in a similar apparatus and swept with EO for 6 hrs. at

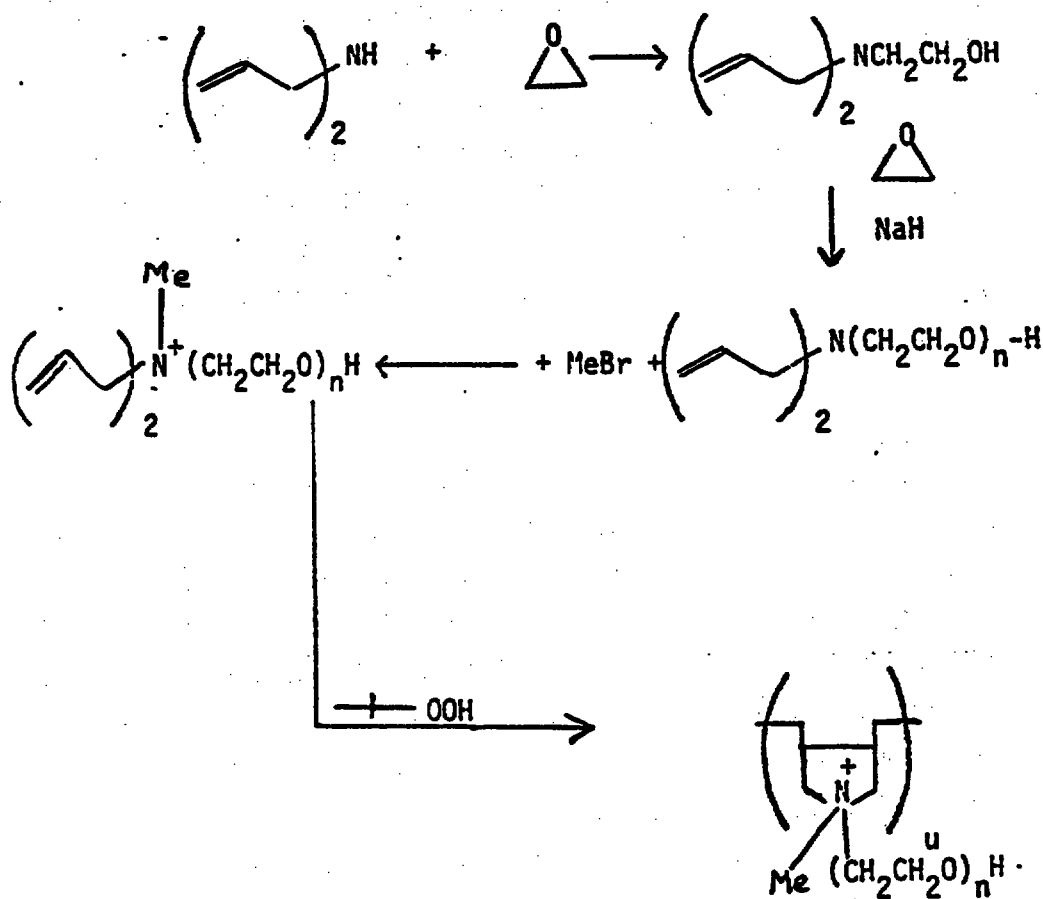
170°C until 70 g. EO had been added to give a total degree of ethoxylation = 23.4.

Step 2: Quaternization

By a procedure similar to that of Example 3a, 20 g. (0.00114 moles) of the 23.4 ethoxylated PEI from step 1 was dissolved in D₂O, heated to 50°-60°C and swept with methyl bromide for a total of 9 hrs. to provide the quaternized ethoxylated PEI.

D. Diallylamine Polymers

Diallylamine polymer versions of the present invention can be prepared according to the following general scheme:



The synthesis of one such polymer is described as follows:

Example 4

Step 1: Ethoxylation

Diallylamine (1.7 moles) is dissolved in methanol (160 ml.)
5 under argon and then heated to 45°C. Ethylene oxide is then added
for 2.5 hours. Methanol is then removed by heating the reaction
mixture to 100°C in vacuo. To the residue is added sodium hydride
in mineral oil (6.6 g., 0.165 moles) with stirring until the
10 evolution of hydrogen has ceased. Ethylene oxide is then added
until the degree of ethoxylation (n) is about 7.

Step 2: Quaternization

The crude ethoxylated diallylamine from step 1 is dissolved
in about an equal volume of 1N methanolic NaOH and then methyl
bromide is added. This methyl bromide addition is continued until
15 H-NMR analysis shows complete disappearance of the methylene
hydrogens adjacent to the tertiary nitrogen. Additional portions
of 1 N methanolic NaOH are added as needed to maintain the pH of
the reaction mixture at about 9. The methanol is removed,
yielding a damp mass. This damp mass is washed with several
20 portions of dichloromethane. The combined washes are concentrated
to yield the desired quaternized compound.

Step 3: Polymerization

The quaternized monomer from step 2 is mixed with D₂O (20
ml.) and heated to 95°C under argon for 1 hour.
25 Tertbutylhydroperoxide (25 drops) is then added and the reaction
continued at 90°C for 18 hours. Then 20 more drops of the
hydroperoxide is added. After heating 3 more days, water is then
removed in vacuo (50°-60°C at pressure of 0.1 mm) to yield the
crude polymer.

30 The level at which the cationic compound(s) can be present in
the detergent compositions of the present invention can vary
depending upon the compounds used, the particular detergent
formulation (liquid, granular) and the benefits desired. These
compositions can be used as laundry detergents, laundry additives,
35 and laundry pretreatments. The cationic compounds are
included in an amount of from 0.05 to 95% by weight

of the composition, with the usual range being from 0.1 to 10% by weight for laundry detergents. In terms of the benefits achieved, preferred detergent compositions can comprise from 0.5 to 5% by weight of the cationic compounds of the present invention. Typically, these preferred compositions comprise from 1 to 3% by weight of these compounds. These compounds are normally present at a level that provides from 2 ppm to 200 ppm, preferably from 10 ppm to 100 ppm, of the compound in the wash solution at recommended U.S. usage levels, and normally from 30 ppm to 1000 ppm, preferably from 50 ppm to 500 ppm for European usage levels.

Detergent Surfactants

The amount of detergent surfactant included in the detergent compositions of the present invention can vary from 1 to 75% by weight of the composition depending upon the detergent surfactant(s) used, the type of composition to be formulated (e.g. granular, liquid) and the effects desired. Preferably, the detergent surfactant(s) comprises from 10 to 50% by weight of the composition. The detergent surfactant can be nonionic, anionic, ampholytic, zwitterionic, cationic, or a mixture thereof:

A. Nonionic Surfactants

Suitable nonionic surfactants for use in detergent compositions of the present invention are generally disclosed in U.S. Patent 3,929,678 to Laughlin et al., issued December 30, 1975 at column 13, line 14 through column 16, line 6.

Classes of nonionic surfactants included are:

1. The polyethyleneoxide condensates of alkyl phenols.
- These compounds include the condensation products of alkyl phenols having an alkyl group containing from about 6 to 12 carbon atoms in either a straight chain or branched chain configuration with ethylene oxide, the ethylene oxide being present in an amount equal to 5 to 25 moles of ethylene oxide per mole of alkyl phenol. The alkyl substituent in such compounds can be derived, for example, from polymerized propylene, diisobutylene, and the like.

Examples of compounds of this type include nonyl phenol condensed with about 9.5 moles of ethylene oxide per mole of nonyl phenol; dodecylphenol condensed with about 12 moles of ethylene oxide per mole of phenol; dinonyl phenol condensed with about 15 moles of ethylene oxide per mole of phenol; and diisooctyl phenol condensed with about 15 moles of ethylene oxide per mole of phenol. Commercially available nonionic surfactants of this type include Igepal CO-630, marketed by the GAF Corporation, and Triton (RTM) X-45, X-114, X-100, and X-102, all marketed by the Rohm & Haas Company.

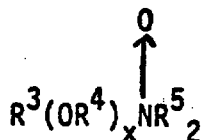
2. The condensation products of aliphatic alcohols with from about 1 to about 25 moles of ethylene oxide. The alkyl chain of the aliphatic alcohol can either be straight or branched, primary or secondary, and generally contains from about 8 to about 22 carbon atoms. Examples of such ethoxylated alcohols include the condensation product of myristyl alcohol condensed with about 10 moles of ethylene oxide per mole of alcohol; and the condensation product of about 9 moles of ethylene oxide with coconut alcohol (a mixture of fatty alcohols with alkyl chains varying in length from 10 to 14 carbon atoms). Examples of commercially available nonionic surfactants of this type include Temdol (RTM) 15-S-9, marketed by Union Carbide Corporation, Neodol 45-9, Neodol 23-6.5, Neodol 45-7, and Neodol 45-4, marketed by Shell Chemical Company, and Kyro (RTM) EOB, marketed by The Procter & Gamble Company.

3. The condensation products of ethylene oxide with a hydrophobic base formed by the condensation of propylene oxide with propylene glycol. The hydrophobic portion of these compounds has a molecular weight of from about 1500 to 1800 and exhibits water insolubility. The addition of polyoxyethylene moieties to this hydrophobic portion tends to increase the water solubility of the molecule as a whole, and the liquid character of the product is retained up to the point where the polyoxyethylene content is about 50% of the total weight of the condensation product, which corresponds to condensation with up to about 40 moles of ethylene oxide. Examples of compounds of this type include certain of the commercially available Pluronic (RTM) surfactants, marketed by Wyandotte Chemical Corporation.

-4: The condensation products of ethylene oxide with the product resulting from the reaction of propylene oxide and ethylenediamine. The hydrophobic moiety of these products consists of the reaction product of ethylenediamine and excess propylene oxide, the moiety having a molecular weight of from about 2500 to about 3000. This hydrophobic moiety is condensed with ethylene oxide to the extent that the condensation product contains from about 40% to about 80% by weight of polyoxyethylene and has a molecular weight of from about 5,000 to about 11,000. Examples of this type of nonionic surfactant include certain of the commercially available Tetronic (RTM) compounds, marketed by Wyandotte Chemical Corporation.

5. Semi-polar nonionic detergent surfactants which include water-soluble amine oxides containing one alkyl moiety of from about 10 to 18 carbon atoms and 2 moieties selected from the group consisting of alkyl groups and hydroxyalkyl groups containing from 1 to about 3 carbon atoms; water-soluble phosphine oxides containing one alkyl moiety of from about 10 to 18 carbon atoms and 2 moieties selected from the group consisting of alkyl groups and hydroxyalkyl groups containing from about 1 to 3 carbon atoms; and water-soluble sulfoxides containing one alkyl moiety of from about 10 to 18 carbon atoms and a moiety selected from the group consisting of alkyl and hydroxyalkyl moieties of from about 1 to 3 carbon atoms.

Preferred semi-polar nonionic detergent surfactants are the amine oxide detergent surfactants having the formula



wherein R^3 is an alkyl, hydroxyalkyl, or alkyl phenyl group or mixtures thereof containing from about 8 to about 22 carbon atoms; R^4 is an alkylene or hydroxyalkylene group containing from 2 to 3 carbon atoms or mixtures thereof; x is from 0 to about 3; and each R^5 is an alkyl or hydroxyalkyl group containing from 1 to about 3

carbon atoms or a polyethylene oxide group containing from one to about 3 ethylene oxide groups. The R^5 groups can be attached to each other, e.g., through an oxygen or nitrogen atom to form a ring structure.

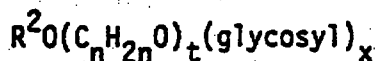
5 Preferred amine oxide detergent surfactants are C_{10} - C_{18} alkyl dimethyl amine oxide and C_8 - C_{12} alkoxy ethyl dihydroxy ethyl amine oxide.

6. Alkylpolysaccharides disclosed in EP-A-0070074 having a
10 hydrophobic group containing from about 6 to about 30 carbon atoms, preferably from about 10 to about 16 carbon atoms and a polysaccharide, e.g., a polyglycoside, hydrophilic group containing from about $1\frac{1}{2}$ to about 10, preferably from about $1\frac{1}{2}$ to about 3, most preferably from about 1.6 to about 2.7 saccharide
15 units. Any reducing saccharide containing 5 or 6 carbon atoms can be used, e.g. glucose, galactose and galactosyl moieties can be substituted for the glucosyl moieties. (Optionally the hydrophobic group is attached at the 2, 3, 4, etc. positions thus giving a glucose or galactose as opposed to a glucoside or galactoside.) The intersaccharide bonds can be, e.g., between the one
20 position of the additional saccharide units and the 2-, 3-, 4-, and/or 6 positions on the preceding saccharide units.

Optionally, and less desirably, there can be a polyalkyleneoxide chain joining the hydrophobic moiety and the polysaccharide
25 moiety. The preferred alkyleneoxide is ethylene oxide. Typical hydrophobic groups include alkyl groups, either saturated or unsaturated, branched or unbranched containing from about 8 to about 18, preferably from about 10 to about 16, carbon atoms. Preferably, the alkyl group is a straight chain saturated alkyl
30 group. The alkyl group can contain up to 3 hydroxy groups and/or the polyalkyleneoxide chain can contain up to about 10, preferably less than 5, most preferably 0, alkyleneoxide moieties. Suitable alkyl polysaccharides are octyl, nonyldecyl, undecyldodecyl, tridecyl, tetradecyl, pentadecyl, hexadecyl, heptadecyl, and
35 octadecyl, di-, tri-, tetra-, penta-, and hexagluco-sides, galactosides, lactosides, glucoses, fructosides, fructoses, and/or

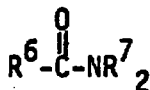
galactoses. Suitable mixtures include coconut alkyl, di-, tri-, tetra-, and pentagluco-
sides and tallow alkyl tetra-, penta-, and hexagluco-
sides.

The preferred alkylpolyglycosides have the formula



wherein R^2 is selected from the group consisting of alkyl, alkyl-phenyl, hydroxyalkyl, hydroxyalkylphenyl, and mixtures thereof in which the alkyl groups contain from about 10 to about 18, preferably from about 12 to about 14, carbon atoms; n is 2 or 3, preferably 2; t is from 0 to about 10, preferably 0; and x is from $1\frac{1}{2}$ to about 10, preferably from about $1\frac{1}{2}$ to about 3, most preferably from about 1.6 to about 2.7. The glycosyl is preferably derived from glucose. To prepare these compounds, the alcohol or alkyl-polyethoxy alcohol is formed first and then reacted with glucose, or a source of glucose, to form the glucoside (attachment at the 1-position). The additional glycosyl units can then be attached between their 1-position and the preceding glycosyl units 2-, 3-, 4- and/or 6- position, preferably predominately the 2-position.

7. Fatty acid amide detergent surfactants having the formula:



wherein R^6 is an alkyl group containing from about 7 to about 21 (preferably from about 9 to about 17) carbon atoms and each R^7 is selected from the group consisting of hydrogen, C_1 - C_4 alkyl, C_1 - C_4 hydroxyalkyl, and $-(C_2H_4O)_xH$ where x varies from about 1 to about 3.

Preferred amides are C_8 - C_{20} ammonia amides, monoethanol-amides, diethanolamides, and isopropanol amides.

B. Anionic Surfactants

Anionic surfactants suitable in detergent compositions of the present invention are generally disclosed in U.S. Patent 3,929,678

to Laughlin et al., issued December 30, 1975 at column 23, line 58 through column 29, line 23,

Classes of anionic surfactants included are:

5 1. Ordinary alkali metal soaps such as the sodium, potassium, ammonium and alkylammonium salts of higher fatty acids containing from about 8 to about 24 carbon atoms, preferably from about 10 to about 20 carbon atoms.

10 2. Water-soluble salts, preferably the alkali metal, ammonium and alkylammonium salts, of organic sulfuric reaction products having in their molecular structure an alkyl group containing from about 10 to about 20 carbon atoms and a sulfonic acid or sulfuric acid ester group. (Included in the term "alkyl" is the alkyl portion of acyl groups.)

15 Examples of this group of anionic surfactants are the sodium and potassium alkyl sulfates, especially those obtained by sulfating the higher alcohols (C_8 - C_{18} carbon atoms) such as those produced by reducing the glycerides of tallow or coconut oil; and the sodium and potassium alkylbenzene sulfonates in which the alkyl group contains from about 9 to about 15 carbon atoms, in
20 straight chain or branched chain configuration, e.g., those of the type described in U.S. Patents 2,220,099 and 2,477,383. Especially valuable are linear straight chain alkylbenzene sulfonates in which the average number of carbon atoms in the alkyl group is from about 11 to 13, abbreviated as C_{11} - C_{13} LAS.

25 Preferred anionic surfactants of this type are the alkyl polyethoxylate sulfates, particularly those in which the alkyl group contains from about 10 to about 22, preferably from about 12 to about 18 carbon atoms, and wherein the polyethoxylate chain contains from about 1 to about 15 ethoxylate moieties preferably
30 from about 1 to about 3 ethoxylate moieties. These anionic detergent surfactants are particularly desirable for formulating heavy-duty liquid laundry detergent compositions.

Other anionic surfactants of this type include sodium alkyl glyceryl ether sulfonates, especially those ethers of higher
35 alcohols derived from tallow and coconut oil; sodium coconut oil fatty acid monoglyceride sulfonates and sulfates; sodium or

potassium salts of alkyl phenol ethylene oxide ether sulfates containing from about 1 to about 10 units of ethylene oxide per molecule and wherein the alkyl groups contain from about 8 to about 12 carbon atoms; and sodium or potassium salts of alkyl ethylene oxide ether sulfates containing about 1 to about 10 units of ethylene oxide per molecule and wherein the alkyl group contains from about 10 to about 20 carbon atoms.

Also included are water-soluble salts of esters of alpha-sulfonated fatty acids containing from about 6 to 20 carbon atoms in the fatty acid group and from about 1 to 10 carbon atoms in the ester group; water-soluble salts of 2-alkoxy-alkane-1-sulfonic acids containing from about 2 to 9 carbon atoms in the acyl group and from about 9 to about 23 carbon atoms in the alkane moiety; alkyl ether sulfates containing from about 10 to 20 carbon atoms in the alkyl group and from about 1 to 30 moles of ethylene oxide; water-soluble salts of olefin sulfonates containing from about 12 to 24 carbon atoms; and beta-alkoxy alkane sulfonates containing from about 1 to 3 carbon atoms in the alkyl group and from about 8 to 20 carbon atoms in the alkane moiety.

3. Anionic phosphate surfactants.
4. N-alkyl substituted succinamates.

C. Ampholytic Surfactants

Ampholytic surfactants can be broadly described as aliphatic derivatives of secondary or tertiary amines, or aliphatic derivatives of heterocyclic secondary and tertiary amines in which the aliphatic radical can be straight chain or branched and wherein one of the aliphatic substituents contains from about 8 to 18 carbon atoms and at least one contains an anionic water-solubilizing group, e.g. carboxy, sulfonate, sulfate. See U.S. Patent 3,929,678 to Laughlin et al., issued December 30, 1975 at column 19, lines 18-35 for examples of ampholytic surfactants.

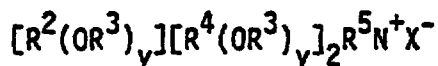
D. Zwitterionic Surfactants

Zwitterionic surfactants can be broadly described as derivatives of secondary and tertiary amines, derivatives of heterocyclic secondary and tertiary amines, or derivatives of quaternary ammonium, quaternary phosphonium or tertiary sulfonium compounds. See U.S. Patent 3,929,678 to Laughlin et al., issued December 30, 1975 at column 19, line 38 through column 22, line 48

for examples of zwitterionic surfactants.

E. Cationic Surfactants

Cationic surfactants can also be included in detergent compositions of the present invention. Suitable cationic surfactants include the quaternary ammonium surfactants having the formula:



wherein R^2 is an alkyl or alkyl benzyl group having from about 8 to about 18 carbon atoms in the alkyl chain; each R^3 is selected from the group consisting of $-CH_2CH_2-$, $-CH_2CH(CH_3)-$, $-CH_2CH(CH_2OH)-$, $-CH_2CH_2CH_2-$, and mixtures thereof; each R^4 is selected from the group consisting of C_1-C_4 alkyl, C_1-C_4 hydroxyalkyl, benzyl, ring structures formed by joining the two R^4 groups, $-CH_2CHOHCHOHCOR^6CHOHCH_2OH$ wherein R^6 is any hexose or hexose polymer having a molecular weight less than about 1000, and hydrogen when y is not 0; R^5 is the same as R^4 or is an alkyl chain wherein the total number of carbon atoms of R^2 plus R^5 is not more than about 18; each y is from 0 to about 10 and the sum of the y values is from 0 to about 15; and X is any compatible anion.

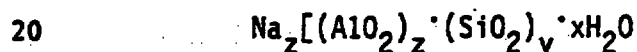
Preferred of the above are the alkyl quaternary ammonium surfactants, especially the mono-long chain alkyl surfactants described in the above formula when R^5 is selected from the same groups as R^4 . The most preferred quaternary ammonium surfactants are the chloride, bromide and methylsulfate C_8-C_{16} alkyl trimethylammonium salts, C_8-C_{16} alkyl di(hydroxyethyl)methylammonium salts, the C_8-C_{16} alkyl hydroxyethyldimethylammonium salts, and

C₈-C₁₆ alkyloxypropyl trimethylammonium salts. Of the above, decyl trimethylammonium methylsulfate, lauryl trimethylammonium chloride, myristyl trimethylammonium bromide and coconut trimethylammonium chloride and methylsulfate are particularly preferred.

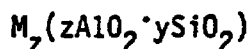
Detergent Builders

Detergent compositions of the present invention can optionally comprise inorganic or organic detergent builders to assist in mineral hardness control. These builders can comprise from 0 to 80% by weight of the composition. When included, these builders typically comprise up to 60% by weight of the detergent composition. Built liquid formulations preferably comprise from 10 to 25% detergent builder while built granular formulations preferably comprise from 10 to 50% by weight detergent builder.

Suitable detergent builders include crystalline aluminosilicate ion exchange materials having the formula:



wherein z and y are at least about 6, the mole ratio of z to y is from about 1.0 to about 0.5; and x is from about 10 to about 264. Amorphous hydrated aluminosilicate materials useful herein have the empirical formula



wherein M is sodium, potassium, ammonium or substituted ammonium, z is from about 0.5 to about 2; and y is 1; this material having a magnesium ion exchange capacity of at least about 50 milligram equivalents of CaCO₃ hardness per gram of anhydrous aluminosilicate.

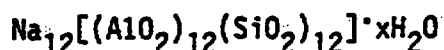
The aluminosilicate ion exchange builder materials are in hydrated form and contain from about 10% to about 28% of water by weight if crystalline, and potentially even higher amounts of

water if amorphous. Highly preferred crystalline aluminosilicate ion exchange materials contain from about 18% to about 22% water in their crystal matrix. The preferred crystalline aluminosilicate ion exchange materials are further characterized by a particle size diameter of from about 0.1 micron to about 10 microns. Amorphous materials are often smaller, e.g., down to less than about 0.01 micron. More preferred ion exchange materials have a particle size diameter of from about 0.2 micron to about 4 microns. The term "particle size diameter" represents the average particle size diameter of a given ion exchange material as determined by conventional analytical techniques such as, for example, microscopic determination utilizing a scanning electron microscope. The crystalline aluminosilicate ion exchange materials are usually further characterized by their calcium ion exchange capacity, which is at least about 200 mg. equivalent of CaCO_3 water hardness/g. of aluminosilicate, calculated on an anhydrous basis, and which generally is in the range of from about 300 mg. eq./g. to about 352 mg. eq./g. The aluminosilicate ion exchange materials are still further characterized by their calcium ion exchange rate which is at least about 2 grains Ca^{++} /gallon/minute/gram/gallon of aluminosilicate (anhydrous basis), and generally lies within the range of from about 2 grains/gallon/minute/gram/gallon to about 6 grains/gallon/minute/gram/gallon, based on calcium ion hardness. Optimum aluminosilicates for builder purposes exhibit a calcium ion exchange rate of at least about 4 grains/gallon/minute/gram/gallon.

The amorphous aluminosilicate ion exchange materials usually have a Mg^{++} exchange capacity of at least about 50 mg. eq. CaCO_3 /g. (12 mg. Mg^{++} /g.) and a Mg^{++} exchange rate of at least about 1 grain/gallon/minute/gram/gallon. Amorphous materials do not exhibit an observable diffraction pattern when examined by Cu radiation (1.54 Angstrom Units).

Useful aluminosilicate ion exchange materials are commercially available. These aluminosilicates can be crystalline or amorphous in structure and can be naturally-occurring aluminosilicates or synthetically derived. A method for producing

aluminosilicate ion exchange materials is disclosed in U.S. Patent 3,985,669 to Krummel, et al. issued October 12, 1976 (herein incorporated by reference). Preferred synthetic crystalline aluminosilicate ion exchange materials useful herein are available under the designations Zeolite A, Zeolite P (8), and Zeolite X. In an especially preferred embodiment, the crystalline aluminosilicate ion exchange material has the formula



wherein x is from about 20 to about 30, especially about 27.

Other examples of detergency builders include the various water-soluble, alkali metal, ammonium or substituted ammonium phosphates, polyphosphates, phosphonates, polyphosphonates, carbonates, silicates, borates, polyhydroxysulfonates, polyacetates, carboxylates, and polycarboxylates. Preferred are the alkali metal, especially sodium, salts of the above.

Specific examples of inorganic phosphate builders are sodium and potassium tripolyphosphate, pyrophosphate, polymeric metaphosphate having a degree of polymerization of from about 6 to 21, and orthophosphate. Examples of polyphosphonate builders are the sodium and potassium salts of ethylene-1,1-diphosphonic acid, the sodium and potassium salts of ethane 1-hydroxy-1,1-diphosphonic acid and the sodium and potassium salts of ethane, 1,1,2-triphosphonic acid. Other phosphorus builder compounds are disclosed in U.S. Patents 3,159,581; 3,213,030; 3,422,021; 3,422,137; 3,400,176 and 3,400,148.

Examples of nonphosphorus, inorganic builders are sodium and potassium carbonate, bicarbonate, sesquicarbonate, tetraborate decahydrate, and silicate having a mole ratio of SiO_2 to alkali metal oxide of from about 0.5 to about 4.0, preferably from about 1.0 to about 2.4.

Useful water-soluble, nonphosphorus organic builders include the various alkali metal, ammonium and substituted ammonium polyacetates, carboxylates, polycarboxylates and polyhydroxysulfonates. Examples of polyacetate and polycarboxylate builders

are the sodium, potassium lithium, ammonium and substituted ammonium salts of ethylenediamine tetraacetic acid, nitrilotriacetic acid, oxydisuccinic acid, mellitic acid, benzene polycarboxylic acids, and citric acid.

5 Highly preferred polycarboxylate builders are disclosed in U.S. Patent No. 3,308,067 to Diehl, issued March 7, 1967.

Such materials include the water-soluble salts of homo- and copolymers of aliphatic carboxylic acids such as maleic acid, itaconic acid, mesaconic acid, fumaric
10 acid, aconitic acid, citraconic acid and methylenemalononic acid.

Other builders include the carboxylated carbohydrates disclosed in U.S. Patent 3,723,322 to Diehl issued March 28, 1973.

Other useful builders are sodium and potassium carboxymethyloxymalonate, carboxymethyloxysuccinate, cis-cyclohexanehexacarboxylate, cis-cyclopentanetetracarboxylate phloroglucinol trisulfonate, water-soluble polyacrylates (having molecular weights of
15 from about 2,000 to about 200,000 for example), and the copolymers of maleic anhydride with vinyl methyl ether or ethylene.

20 Other suitable polycarboxylates are the polyacetal carboxylates disclosed in U.S. Patent 4,144,226, to Crutchfield et al. issued March 13, 1979, and U.S. Patent 4,246,495, to Crutchfield et al., issued March 27, 1979.

These polyacetal carboxylates can be prepared by bringing
25 together under polymerization conditions an ester of glyoxylic acid and a polymerization initiator. The resulting polyacetal carboxylate ester is then attached to chemically stable end groups to stabilize the polyacetal carboxylate against rapid depolymerization in alkaline solution, converted to the corresponding salt,
30 and added to a surfactant.

Other useful detergency builder materials are the "seeded builder" compositions disclosed in Belgian Patent No. 798,856, issued October 29, 1973.

Specific examples of such seeded builder mixtures are: 3:1 wt.
35 mixtures of sodium carbonate and calcium carbonate having 5 micron particle diameter; 2.7:1 wt. mixtures of sodium sesquicarbonate

and calcium carbonate having a particle diameter of 0.5 microns; 20:1 wt. mixtures of sodium sesquicarbonate and calcium hydroxide having a particle diameter of 0.01 micron; and a 3:3:1 wt. mixture of sodium carbonate, sodium aluminate and calcium oxide having a particle diameter of 5 microns.

Other Optional Detergent Ingredients

Other optional ingredients which can be included in detergent compositions of the present invention, in their conventional art-established levels for use (i.e., from 0 to about 20%), include solvents, bleaching agents, bleach activators, soil-suspending agents, corrosion inhibitors, dyes, fillers, optical brighteners, germicides, pH adjusting agents (monoethanolamine, sodium carbonate, sodium hydroxide, etc.), enzymes, enzyme-stabilizing agents, perfumes, fabric softening components, static control agents, and the like.

Detergent Formulations

Granular formulations embodying the detergent compositions of the present invention can be formed by conventional techniques, i.e., by slurring the individual components in water and then atomizing and spray-drying the resultant mixture, or by pan or drum granulation of the ingredients. Granular formulations preferably comprise from 10 to 30% detergent surfactant, usually anionic.

Liquid formulations embodying the detergent compositions can be built or unbuilt. If unbuilt, these compositions conventionally contain approximately 15 to 50% total surfactant, from 0 to 10% of an organic base such as a mono-, di-, or tri-alkanol amine, a neutralization system such as an alkali metal hydroxide and a lower primary alcohol such as ethanol or isopropanol, and approximately 20 to 80% water. Such compositions are normally homogeneous single phase liquids of low viscosity (approximately 100 to 150 centipoise at 75°F).

Built liquid detergent compositions can be in the form of single phase liquids provided that the builder is solubilized in

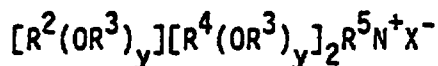
the mixture at its level of use. Such liquids conventionally contain 10 to 25% total surfactant, 10 to 25% builder which can be organic or inorganic, 3 to 10% of a hydrotrope system and 40 to 77% water. Liquids of this type also have a low viscosity (100 to 150 centipoise at 75°F). Built liquid detergents incorporating components that form heterogeneous mixtures (or levels of builder that cannot be completely dissolved) can also comprise detergent compositions of the present invention. Such liquids conventionally employ viscosity modifiers to produce systems having plastic shear characteristics to maintain stable dispersions and to prevent phase separation or solid settlement.

Near Neutral Wash pH Detergent Formulations

While the detergent compositions of the present invention are operative within a wide range of wash pHs (e.g. from about 5 to about 12), they are particularly suitable when formulated to provide a near neutral wash pH, i.e. an initial pH of from about 6.0 to about 8.5 at a concentration of from about 0.1 to about 2% by weight in water at 20°C. Near neutral wash pH formulations are better for enzyme stability and for preventing stains from setting. In such formulations, the wash pH is preferably from about 7.0 to about 8.5, and more preferably from about 7.5 to about 8.0.

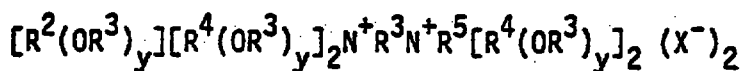
Preferred near neutral wash pH detergent formulations are disclosed in EP-A-0095205. These preferred formulations comprise:

- (a) from about 2 to about 60% (preferably from about 10 to about 25%) by weight of an anionic synthetic surfactant as previously defined;
- (b) from about 0.25 to about 12% (preferably from about 1 to about 4%) by weight of a cosurfactant selected from the group consisting of:
 - (i) quaternary ammonium surfactants having the formula:



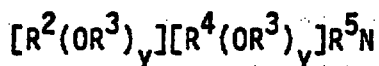
wherein R^2 , each R^3 , R^4 , R^5 , X and y are as previously defined;

(ii) diquatary ammonium surfactants having the formula:



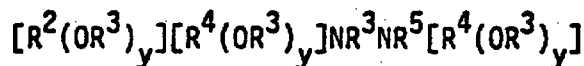
wherein R^2 , R^3 , R^4 , y and X are as defined above; particularly preferred are the C_8 - C_{16} alkyl pentamethylethylene-diamine chloride, bromide and methylsulfate salts;

(iii) amine surfactants having the formula:



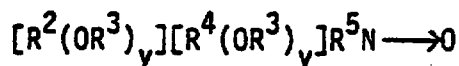
wherein R^2 , R^3 , R^4 , R^5 and y are as defined above; particularly preferred are the C_{12} - C_{16} alkyl dimethyl amines;

(iv) diamine surfactants having the formula:



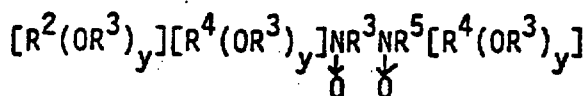
wherein R^2 , R^3 , R^4 , R^5 and y are as defined above; particularly preferred are the C_{12} - C_{16} alkyl dimethyl diamines;

(v) amine oxide surfactants having the formula:



wherein R^2 , R^3 , R^4 , R^5 and y are as defined above; particularly preferred are the C_{12} - C_{16} alkyl dimethyl amine oxides; and

(vi) di(amine oxide) surfactants having the formula:



wherein R^2 , R^3 , R^4 , R^5 and y are as defined above; preferred are the C_{12} - C_{16} alkyl trimethylethylene di(amine oxides) and

(c) from about 5% to about 40% by weight (preferably to about 30% by weight, and most preferably from about 10 to 20% by weight) of a fatty acid containing from about 10 to about 22 carbon atoms (preferably a C₁₀-C₁₄ saturated fatty acid or mixture thereof); the mole ratio of the anionic surfactant to the cosurfactant being at least 1 and preferably from about 2:1 to about 20:1.

Such compositions also preferably contain from about 3 to about 15% by weight of an ethoxylated alcohol or ethoxylated alkyl phenol (nonionic surfactants) as previously defined. Highly preferred compositions of this type also preferably contain from about 2 to about 10% by weight of citric acid and minor amounts (e.g., less than about 20% by weight) of neutralizing agents, buffering agents, phase regulants, hydrotropes, enzymes, enzyme stabilizing agents, polyacids, suds regulants, opacifiers, antioxidants, bactericides, dyes, perfumes and brighteners, such as those described in U.S. Patent 4,285,841 to Barrat et al., issued August 25, 1981.

Specific Embodiments of Detergent Compositions

According to the Present Invention

The following embodiments illustrate, but are not limiting of, detergent compositions of the present invention:

A granular detergent composition is as follows:

<u>Component</u>	<u>Wt. %</u>
Polyurethane of Example 1	1.0
Sodium C ₁₄ -C ₁₅ alkylethoxysulfate	10.7
C ₁₃ linear alkyl benzene sulfonic acid	4.3
C ₁₂ -C ₁₄ alkylpolyethoxylate (6)	0.5
Sodium toluene sulfonate	1.0
Sodium tripolyphosphate	32.9
Sodium carbonate	20.3
Sodium silicate	5.8
Minors and water	Balance to 100

The components are added together with continuous mixing to form an aqueous slurry which is then spray dried to form the composition. Instead of the polyurethane,

the random copolymer of Example 2, the PEA of Example 3a, the PEI of Example 3b or the diallylamine polymer of Example 4 can be substituted therefor.

Embodiment II

5 A liquid detergent composition is as follows:

<u>Component</u>	<u>Wt. %</u>
Random copolymer of Example 2	1.0
Sodium C ₁₄ -C ₁₅ alkyl polyethoxy (2.5) sulfate	8.3
C ₁₂ -C ₁₄ alkyl dimethyl amine oxide	3.3
10 Sodium toluene sulfonate	5.0
Monoethanolamine	2.3
Sodium nitrilotriacetate	18.2
Minors and water	Balance to 100

The components are added together with continuous mixing to form the composition. Instead of the random copolymer, the polyurethane of Example 1, the PEA of Example 3a, the PEI of Example 3b or the diallylamine polymer of Example 4 can be substituted therefor.

Embodiments III and IV

20 Liquid detergent compositions are as follows:

<u>Component</u>	<u>Wt. %</u>	
	<u>III</u>	<u>IV</u>
Polyurethane of Example 1	1.5	1.5
C ₁₄ -C ₁₅ alkylethoxysulfuric acid	10.8	-
25 C ₁₄ -C ₁₅ alkylpolyethoxy (2.25) sulfuric acid	-	10.8
C ₁₃ linear alkylbenzene sulfonic acid	7.2	7.2
C ₁₂ alkyl trimethylammonium chloride	1.2	1.2
C ₁₂ -13 alcohol polyethoxylate (6.5)	6.5	6.5
Coconut fatty acid	15.0	15.0
30 Citric acid monohydrate	6.9	4.0
Diethylenetriamine pentaacetic acid	0.9	0.9
Protease enzyme	0.8	0.8
Amylase enzyme	0.3	0.3
Monoethanolamine	13.6	2.0
35 Triethanolamine	3.0	4.0
Sodium hydroxide	-	2.0

Potassium hydroxide	-	2.8
1,2-Propanediol	5.0	5.0
Ethanol	3.0	7.0
Sodium formate	1.0	1.0
5 Sodium toluene sulfonate	5.0	-
Minors and water	Balance to 100	

Embodiment IV is prepared by adding the components together with continuous mixing, in the following order to produce a clear liquid: a paste premix of the alkylbenzene sulfonic acid, 0.9 parts of the sodium hydroxide, propylene glycol, and 2.3 parts of the ethanol; a paste premix of the alkylpolyethoxysulfuric acid, 1.1 parts of the sodium hydroxide and 3.1 parts of the ethanol; alcohol polyethoxylate; premix of monoethanolamine, triethanolamine and brighteners, 1.5 parts potassium hydroxide; balance of the ethanol; citric acid; formate; 1.4 parts potassium hydroxide; fatty acid; pentaacetic acid; alkyl trimethylammonium chloride; adjust pH to about 8.4 with potassium hydroxide, water or citric acid; enzymes; polyurethane; and perfume.

Embodiment III can be prepared in a similar manner. Instead of the polyurethane of Example 1, the random copolymer of Example 2, the PEI of Example 3b or the diallylamine polymer of Example 4 can be substituted therefor.

Embodiment V

A liquid detergent composition is as follows:

25	<u>Component</u>	<u>Wt. %</u>
	PEA of Example 3a	1.0
	Sodium C ₁₂ alkylpolyethoxy (3) sulfate	12.6
	C ₁₂ -C ₁₃ alcohol polyethoxylate (6.5)	23.4
	Monoethanolamine	2.0
30	Ethanol	9.0
	Citric acid monohydrate	0.8
	Minors and water	Balance to 100

The components are added together with continuous mixing to form the composition. Instead of the PEA, the polyurethane of Example 1, the random

copolymer of Example 2, the PEI of Example 3b or the diallylamine polymer of Example 4 can be substituted therefor.

Clay Soil Removal/Anti-Redeposition Properties of
Various Ethoxylated Quaternized Amines

5 A. Experimental Method

1. Clay Soil Removal

Clay soil removal comparisons were conducted in a standard 1 liter Tergotometer employing water of 7 grain hardness (3:1 $\text{Ca}^{++}:\text{Mg}^{++}$) and a temperature of 100°F. Soiled swatches were
10 washed in the Tergotometer for 10 minutes and rinsed twice with water (7 grain hardness) at 70°F for 2 minutes.

65% polyester/35% cotton blend fabric was used for the swatches. The swatches were 5 inches by 5 inches in size and were soiled by dipping in an aqueous slurry of local clay and subse-
15 quently baked to remove the water. The dipping and baking was repeated 5 times.

One wash employed 2000 ppm of a control liquid detergent composition containing the following surfactants:

	<u>Surfactant</u>	<u>Amount (%)</u>
20	Sodium $\text{C}_{14}\text{-C}_{15}$ alkyl ethoxysulfate	10.8
	C_{13} linear alkylbenzene sulfonic acid	7.2
25	$\text{C}_{12}\text{-C}_{13}$ alcohol poly- ethoxylate (6.5)	6.5
	C_{12} alkyl trimethyl- ammonium chloride	1.2

A second wash used the same detergent composition but also containing an ethoxylated quaternized amine at 20 ppm. Neither
30 composition contained optical brighteners. The product washes approximated a conventional home use laundry situation. After laundering, the swatches were dried in a mini-dryer.

The swatches were graded before and after washing on a Gardner Whiteness meter reading the L, a, and b coordinates.
35 Whiteness (W) was calculated as:

$$W = \frac{7L^2 - 40Lb}{700}$$

5 The clay soil removal performance of each detergent composition was determined by finding the difference in whiteness (ΔW) before and after washing as:

$$\Delta W = W_{\text{after}} - W_{\text{before}}$$

10 The improvement in clay soil removal performance of the composition containing the ethoxylated quaternized amine was measured as the difference in W values ($\Delta^2 W$) relative to the control composition.

2. Anti-Redeposition

15 Anti-redeposition comparisons were conducted in a 5 pot Automatic Miniwasher (AMW) employing 7 grain hardness water and temperature of 95°F. Test swatches were washed for 10 minutes and rinsed twice with water (7 grain hardness) at 75°F for 2 minutes.

20 After the AMW pots were filled with 6 liters of water each, the detergent composition to be tested (control or containing 20 ppm ethoxylated quaternized amine as in clay soil removal test) was added and agitated for 2 minutes. A background soil mixture (200 ppm artificial body soil, 100 ppm vacuum cleaner soil and 200 ppm clay soil) was then added and agitated for an additional 3 minutes. Three 5 inch square test swatches (50% polyester/50% cotton T-shirt material) were then added, along with two 80% cotton/20% polyester terry clothes and two 11 inch square swatches of 100% polyester knit fabric. The 10 minute wash cycle commenced at this point.

25 Following the rinse cycle, the test swatches were dried in a mini-dryer. Gardner Whiteness meter readings (L, a and b) were then determined for the three test swatches. Anti-redeposition performance (ARD) was then calculated according to the following equation.

$$ARD = \frac{7L^2 - 40Lb}{700}$$

35 The ARD values for the three test swatches were then averaged. The improvement in anti-redeposition performance of the composition containing the ethoxylated quaternized amine was measured as

the difference in ARD values (Δ ARD) relative to the control composition.

B. Test Results

The results from testing the clay-soil removal and anti-redeposition performance of various ethoxylated quaternized amines is shown in the following Table:

<u>Amine *</u> <u>Type</u>	<u>Amine</u> <u>M.W.</u>	<u>Degree of</u> <u>Ethoxylation</u>	<u>Quat **</u> <u>Group</u>	<u>Δ^2W</u>	<u>ΔARD</u>
PEA	103	3	C ₁	2.0	12.2
		6		6.3	16.4
		12		8.5	17.7
		24		7.6	16.4
		36		9.5	-
PEA	189	18	C ₁	3.9	-
		22		6.0	18.3
PEA	309	24	C ₁	4.4	17.0

* PEA = polyethyleneamine.

** C₁ = methyl

For comparison, PEG 6000 (polyethylene glycol having M.W. of 6000) has a Δ^2W value of 4.9 and a Δ ARD value of 8.9.



CLAIMS

1. A detergent composition characterized in that it comprises:

- (a) from 1% to 75% by weight of the composition of a nonionic, anionic, ampholytic, zwitterionic, or cationic detergent surfactant or mixtures thereof; and
- (b) from 0.05 to 95% by weight of the composition of a water-soluble cationic compound having clay soil removal/anti-redeposition properties selected from ethoxylated cationic polymers which comprise a polymer backbone as hereinbefore defined, at least 2 M groups and at least one L-X group, wherein M is a cationic group attached to or integral with the backbone and contains an N^+ positively charged center; and L connects groups M and X or connects group X to the polymer backbone; wherein X is a nonionic group selected from H , C_1-C_4 alkyl or hydroxyalkyl ester or C_1-C_4 alkyl or hydroxyalkyl ether groups; L is a hydrophilic chain consisting of the polyoxyalkylene moiety $-(R^6O)_m(CH_2CH_2O)_n-$, wherein R^6 is C_3-C_4 alkylene or hydroxyalkylene, m is from 0 to 5 and n is a number of at least 3 such that the moiety $-(CH_2CH_2O)_n-$ comprises at least 50% by weight of said polyoxyalkylene moiety.

2. The composition of Claim 1 characterized in that said backbone is selected from the polyurethanes, the polyesters, the polyethers, the polyamides, the polyimides, the polyacrylates, the polyacrylamides, the polyvinylethers, the polyalkylenes, the polyalkarylenes, the polyalkyleneimines, the polyvinylamines, the polyallylamines, the polydiallylamines, the polyvinylpyridines, the polyaminotriazoles, polyvinyl alcohol, the aminopolyureylenes and mixtures thereof.
3. The composition of any of Claims 1-2 characterized in that the ratio of groups M to groups X is from 2:1 to 1:10.
4. The composition of any of Claims 1-3 characterized in that units of the polymer containing groups M and L-X comprise from 50-100% of the polymer.



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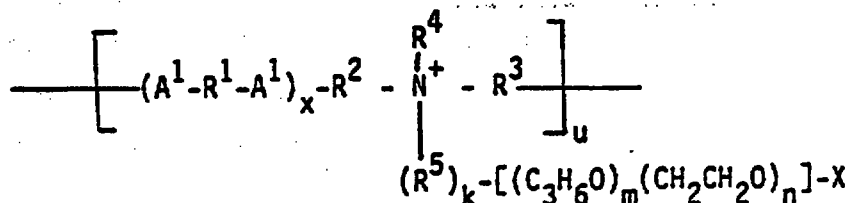
5. The composition of any of Claims 1-4 characterized in that the number of groups M and L-X are each from 3 to 40.

6. The composition of any of Claims 1-5 characterized in that m and n are numbers such that the moiety $-(CH_2CH_2O)_n-$ comprises at least 85% by weight of said polyoxyalkylene moiety.

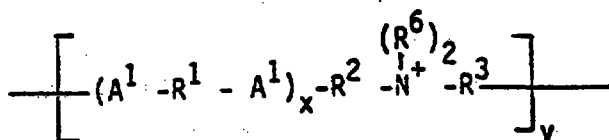
5 7. The composition of any of Claims 1-6 characterized in that m is 0 and n is at least 12.

8. The composition of any of Claims 1-7 characterized in that X is H or methyl ether.

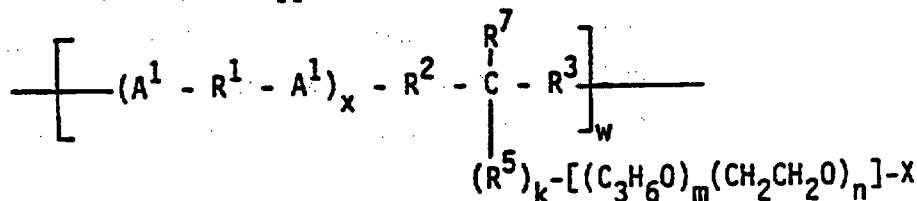
10 9. The composition of Claim 1 characterized in that said polymer comprises units selected from those having formulas I, II and III:



I



II



III

25 wherein A^1 is $\overset{\overset{O}{||}}{NC-}$, $\overset{\overset{O}{||}}{CN-}$, $\overset{\overset{O}{||}}{CO-}$, $\overset{\overset{O}{||}}{OC-}$ or $\overset{\overset{O}{||}}{C-}$;



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x is 0 or 1; R is H or C₁-C₄ alkyl or hydroxyalkyl; R¹ is C₂-C₁₂ alkylene, hydroxyalkylene, alkenylene, cycloalkylene, arylene or alkarylene, or a C₂-C₃ oxyalkylene moiety having from 2 to 20 oxyalkylene units provided that no O-O or O-N bonds are formed with A¹; when

x is 1, R² is -R⁵- except when A¹ is $\overset{\text{O}}{\parallel}\text{C}-$, or is $-(\text{OR}^8)_y-$ or $-\text{OR}^5-$ provided that no O-O or N-O bonds are formed with A¹, and R³ is

-R⁵- except when A¹ is $\overset{\text{O}}{\parallel}\text{C}-$, or is $-(\text{R}^8\text{O})_y-$ or $-\text{R}^5\text{O}-$ provided that no O-O or O-N bonds are formed with A¹; when x is 0, R² is $-(\text{OR}^8)_y-$, $-\text{OR}^5-$, $-\overset{\text{O}}{\parallel}\text{COR}^5-$, $-\overset{\text{O}}{\parallel}\text{OCR}^5-$, $-\overset{\text{O}}{\parallel}\text{OCOR}^5-$, $-\overset{\text{O}}{\parallel}\text{NCR}^5-$, $-\overset{\text{O}}{\parallel}\text{NCOR}^5-$,

$-\overset{\text{OR}}{\parallel}\text{CNR}^5-$, $-\overset{\text{OR}}{\parallel}\text{OCNR}^5-$, and R³ is -R⁵-; R⁴ is C₁-C₄ alkyl or

hydroxyalkyl, or the moiety $-(\text{R}^5)_k-[(\text{C}_3\text{H}_6\text{O})_m(\text{CH}_2\text{CH}_2\text{O})_n]-\text{X}$; R⁵ is C₁-C₁₂ alkylene, hydroxyalkylene, alkenylene, arylene, or alkarylene; each R⁶ is C₁-C₄ alkyl or hydroxyalkyl, or the moiety $-(\text{CH}_2)_r-\text{A}^2-(\text{CH}_2)_s-$, wherein A² is -O- or -CH₂-; R⁷ is H or R⁴; R⁸ is C₂-C₃ alkylene or

hydroxyalkylene; X is H, $\overset{\text{O}}{\parallel}\text{CR}^9$, -R⁹ or mixture thereof, wherein R⁹ is C₁-C₄ alkyl or hydroxyalkyl; k is 0 or 1;

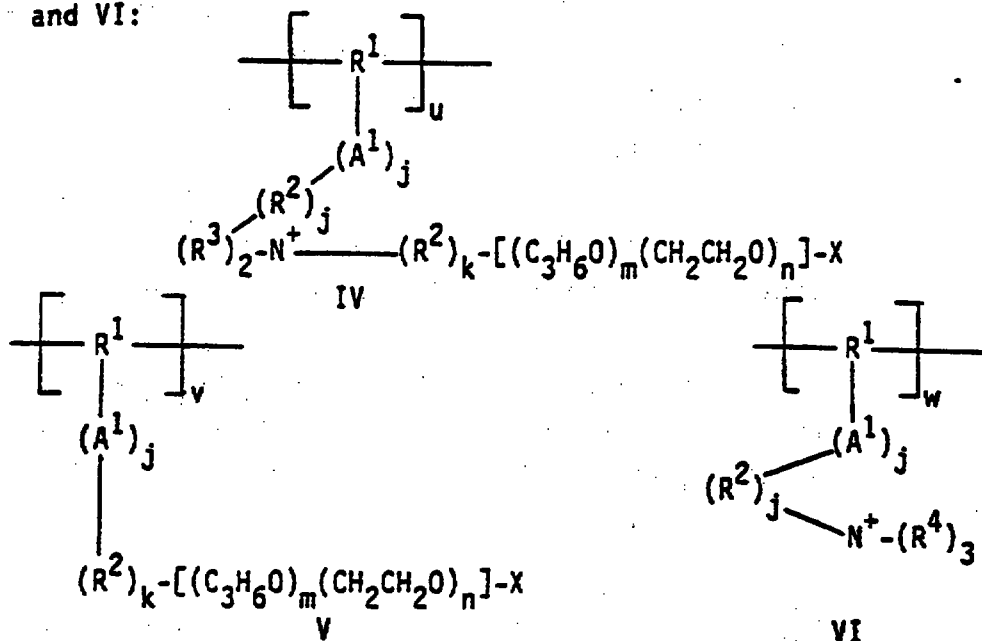
n is a number of at least 3 such that the moiety $-(\text{CH}_2\text{CH}_2\text{O})_n-$ comprises at least 85% by weight of the moiety $-(\text{C}_3\text{H}_6\text{O})_m(\text{CH}_2\text{CH}_2\text{O})_n-$; m is from 0 to 5; r is 1 or 2, s is 1 or 2, and r + s is 3 or 4; y is from 2 to 20; the number of u, v and w are such that there are at least 2 N⁺ centers and at least 2 X groups.

10. The composition of Claim 9 characterized in that A¹ is

$\overset{\text{O}}{\parallel}\text{NC}-$ or $\overset{\text{O}}{\parallel}\text{CN}-$; R¹ is C₂-C₆ alkylene, R² is $-\text{OR}^5-$ or $-(\text{OR}^8)_y-$; R³ is $-\text{R}^5\text{O}-$ or $-(\text{R}^8\text{O})_y-$; R⁴ and R⁶ are each methyl; R⁵ is C₂-C₃ alkylene; R⁷ is H or methyl; R⁸ is ethylene; X is H or methyl; k is 0; y is from 2 to 12.



11. The composition of Claim 1 characterized in that said polymer comprises units selected from those having formulas IV, V and VI:



wherein A^1 is $-\text{O}-$, $-\text{NC}-$, $-\text{NCO}-$, $-\text{CNC}-$, $-\text{CN}-$, $-\text{OCN}-$

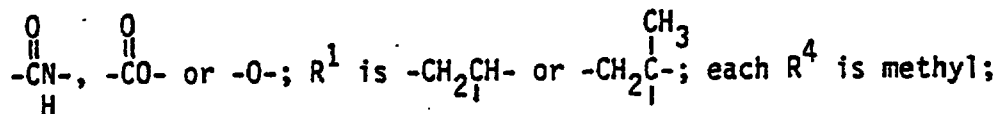
$-\text{OC}-$, $-\text{OCO}-$, $-\text{CO}-$, or $-\text{NCN}-$; R is H or $\text{C}_1\text{-C}_4$ alkyl or

hydroxyalkyl; R^1 is substituted $\text{C}_2\text{-C}_{12}$ alkylene, hydroxyalkylene, alkenylene, arylene or alkarylene, or $\text{C}_2\text{-C}_3$ oxyalkylene; each R^2 is $\text{C}_1\text{-C}_{12}$ alkylene, hydroxyalkylene, alkenylene, arylene or alkarylene; each R^3 is $\text{C}_1\text{-C}_4$ alkyl or hydroxyalkyl, the moiety $-(\text{R}^2)_k - [(\text{C}_3\text{H}_6\text{O})_m (\text{CH}_2\text{CH}_2\text{O})_n] - \text{X}$, or together form the moiety $-(\text{CH}_2)_r - \text{A}^2 - (\text{CH}_2)_s -$, wherein A^2 is $-\text{O}-$ or $-\text{CH}_2-$; each R^4 is $\text{C}_1\text{-C}_4$ alkyl or hydroxyalkyl, or two R^4 together form the moiety

$-(\text{CH}_2)_r - \text{A}^2 - (\text{CH}_2)_s -$; X is H , $-\text{CR}^5$, $-\text{R}^5$ or mixture thereof, wherein R^5 is $\text{C}_1\text{-C}_4$ alkyl or hydroxyalkyl; j is 1 or 0; k is 1 or 0; n is a number of at least 3 such that the moiety $-(\text{CH}_2\text{CH}_2\text{O})_n -$ comprises at least 85% by weight of the moiety $-(\text{C}_3\text{H}_6\text{O})_m (\text{CH}_2\text{CH}_2\text{O})_n -$; m is from 0 to 5; r is 1 or 2, s is 1 or 2 and $r + s$ is 3 or 4; the number of u , v and w are such that there are at least 2 N^+ centers and at least 2 X groups.



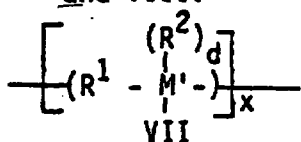
12. The composition of Claim 11 characterized in that A¹ is



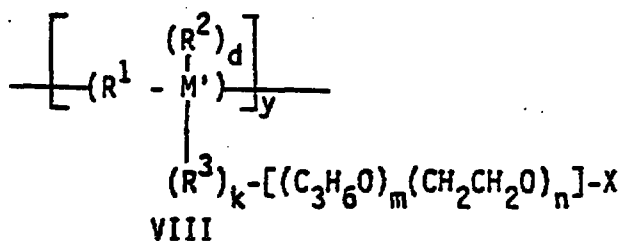
X is H or methyl; k is 0.

13. The composition of any of Claims 9-12 characterized in that v and w are 0 and u is from 3 to 40.

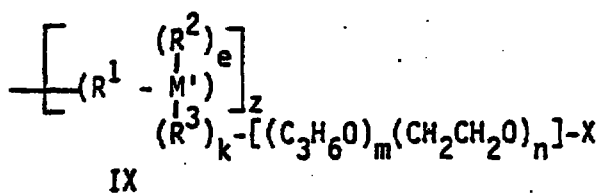
14. The composition of Claim 1 characterized in that said polymer comprises units selected from those having formulas VII and VIII.



VII



VIII



IX

wherein R¹ is C₂ - C₁₂ alkylene, hydroxyalkylene, alkenylene, cycloalkylene, arylene or alkarylene, or a C₂-C₃ oxyalkylene moiety having from 2 to 20 oxyalkylene units provided that no O-N bonds are formed; R² is C₁-C₄ alkyl or hydroxyalkyl, or the moiety - (R³)_k - [(C₃H₆O)_m(CH₂CH₂O)_n] - X; R³ is C₁-C₁₂ alkylene, hydroxyalkylene, alkenylene, arylene or alkarylene; M' is an N⁺ or N center; X is H, -CR⁴, -R⁴ or mixture thereof,

wherein R⁴ is C₁-C₄ alkyl or hydroxyalkyl; d is 1 when M' is N⁺ and is 0 when M' is N; e is 2 when M' is N⁺ and is 1 when M' is N; k is 1 or 0; n is a number of at least 3 such that the moiety - (CH₂CH₂O)_n - comprises at least 85% by weight of the moiety - [(C₃H₆O)_m(CH₂CH₂O)_n] -; m is from 0 to 5;

the number of x, y and z are such that there are at least 2 M' groups, at least 2 N⁺ centers, and at least 2 X groups.

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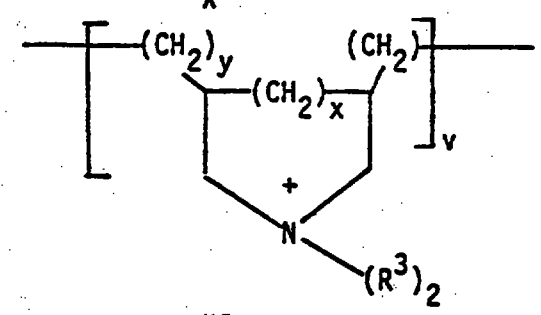
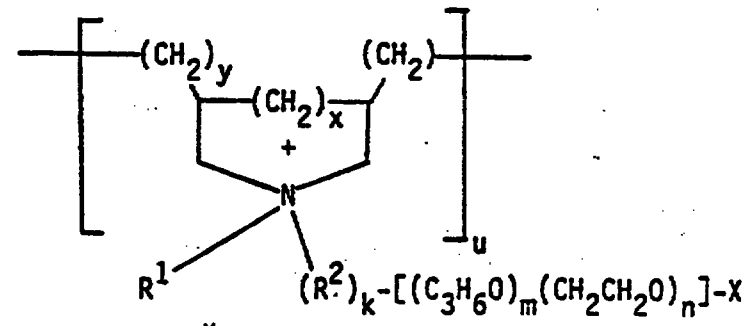


15. The composition of Claim 14 characterized in that R^1 is ethylene; each R^2 is methyl or the moiety $-[(C_3H_6O)_m(CH_2CH_2O)_n]-X$; X is H; k is 0.

16. The composition of any of Claims 14-15 characterized in that the M' groups are a mixture of from 50 to 100% N^+ centers and from 0 to 50% N centers.

17. The composition of any of Claims 14-16 characterized in that $x + y + z$ is from 2 to 40.

18. The composition of Claim 1 characterized in that said polymer comprises units selected from those having formulas X and XI.



XI

wherein R^1 is C_1-C_4 alkyl or hydroxyalkyl, or the moiety $-(R^2)_k-[(C_3H_6O)_m(CH_2CH_2O)_n]-X$; R^2 is C_1-C_{12} alkylene, hydroxyalkylene, alkylene, arylene or alkarylene; each R^3 is C_1-C_4 alkyl or hydroxyalkyl, or together form the moiety $-(CH_2)_r-A-(CH_2)_s$, wherein A is $-O-$ or $-CH_2-$; X is H, $-C(=O)R^4$, $-R^4$ or mixtures thereof,



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wherein R^4 is C_1 - C_4 alkyl or hydroxyalkyl; k is 1 or 0;
 n is a number of at least 3 such that the moiety
 $-(CH_2CH_2O)_n-$ comprises at least 85% by weight of the
moiety $-[(C_3H_6O)_m(CH_2CH_2O)_n]-$; m is from 0 to 5;
 r is 1 or 2, s is 1 or 2, and
 $r + s$ is 3 or 4; x is 1 or 0; y is 1 when x is 0 and 0 when x is
1; the number of u and v are such that there are at least 2 N^+
centers and at least 2 X groups.

19. The composition of Claim 18 characterized in that R^1 is
methyl; each R^3 is methyl; X is H; k is 0.

20. The composition of any of Claims 18-19 characterized in
that v is 0 and u is from 2 to 40.

21. The composition of any of Claims 9-20 characterized in that m
is 0 and n is at least 12.

22. The composition of any of Claims 1 to 21 characterized
in that it comprises from 0.1 to 10% by weight of said
cationic compound.

23. The composition of Claim 22 characterized in that it
comprises from 1 to 3% by weight of said cationic compound.

24. The composition of any of Claims 22-23 characterized in that
said detergent surfactant is selected from nonionic
surfactants, anionic surfactants or mixtures thereof.

25. The composition of any of Claims 22-24 characterized in that
it further comprises up to 80% by weight of a detergent
builder.