

DETERGENCY BUILDER SYSTEM

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The present invention relates to detergency builder systems useful in detergent compositions.

BACKGROUND ART

10 The term detergency builder can be applied to any component of a detergent composition which increases the detergent power of a surface active agent, hereinafter surfactant. Generally recognized functions of detergency builders include removal of alkaline earth, e.g., calcium, and other undesirable metal ions from washing solutions by sequestration or precipitation, provid-
15 ing alkalinity and buffer capacity, prevention of flocculation, maintenance of ionic strength, protection of anionic surfactants from precipitation, extraction of metals from soils as an aid to their removal, soil suspension, and peptization and dispersion of soil. Polyphosphates such as tripolyphosphates and pyrophosphates
20 are widely used as ingredients in detergent compositions and are highly effective detergency builders. However, the effect of phosphorus on eutrophication of lakes and streams has been questioned and the use of phosphates in detergent compositions has been subject to government regulation or prohibition.

25 These circumstances have developed a need for highly effective and efficient phosphorus-free detergency builders. Many materials and combinations of materials have been used or proposed as detergency builders. Carbonates and silicates are widely used in granular detergent compositions, but by themselves are deficient as detergency builders in a number of respects. Alumino-
30 silicates such as described in U.S. Patent 4,274,975, issued June 23, 1981, to Corkill et al., have also been used to replace polyphosphates. Aluminosilicates, however, have relatively low calcium and magnesium binding constants and can present solubility
35 problems, particularly in combination with silicates.

Very useful phosphorus-free detergent builder materials have been found to include the ether polycarboxylates. A number of ether carboxylate types have, in fact, been disclosed in the art for use as detergent builders. Many, but not all, ether carboxylates are deficient in calcium binding power relative to inorganic polyphosphates. Some ether carboxylates, however, such as oxydisuccinate as disclosed in Berg; U.S. Patent 3,128,287; Issued April 7, 1964 and Lamberti et al; U.S. Patent 3,635,830; Issued January 18, 1972, are quite effective in binding hardness ions such as calcium. These selected ether carboxylates can therefore be utilized in detergent builder systems which are as effective as conventional phosphorus-type builders in enhancing cleaning performance of detergent products containing them.

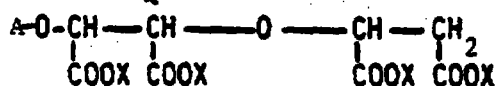
Even though certain ether carboxylate compounds can be as effective in builder performance as phosphate materials, ether carboxylates tend to be relatively expensive materials. Accordingly, it would be desirable to formulate ether carboxylate-containing detergent compositions which provide builder performance that is superior to that of conventional phosphate builders. Such improved builder systems could then be utilized in somewhat lower concentrations in detergent products or could be employed in detergent products which are superior in cleaning performance to conventional phosphate-containing formulations.

In view of the foregoing, it is an object of the present invention to provide ether carboxylate-containing builder compositions which, as a system, provide better builder performance than do conventional phosphate materials such as sodium tripolyphosphate. It is a further object of the present invention to provide improved detergent and laundry additive compositions employing such ether carboxylate-containing builder systems.

SUMMARY OF THE INVENTION

The present invention provides a detergent builder composition especially useful in phosphorus-free detergent or laundry additive products, said composition comprising:

- 5 (A) from 70% to 99% by weight of an ether carboxylate sequestering agent^{constituted by compound(s)} having the formula:

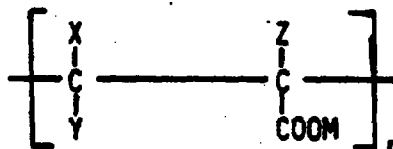


wherein A is H or $\begin{array}{c} \text{---CH-CH}_2 \\ | \quad | \\ \text{COOX COOX} \end{array}$; and

X is H or a water-soluble salt-forming cation; and

- (B) from 1% to 30% by weight of a dispersing/anti-redeposition agent selected from the group consisting of:

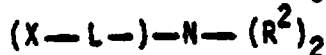
- 15 i) polycarboxylates which are polymers or copolymers which contain at least 60% by weight of segments having the general formula:



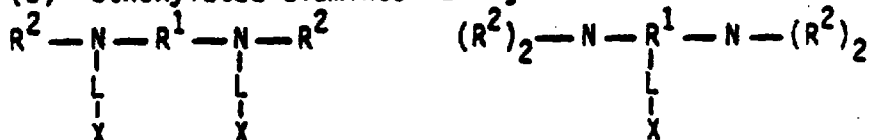
20 wherein X, Y and Z are, independently, selected from hydrogen, methyl, carboxy, carboxymethyl, hydroxy and hydroxymethyl; M is H or a salt-forming cation and n ranges from 30 to 400;

- 25 ii) ethoxylated amine material selected from the group consisting of

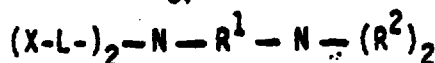
- (a) ethoxylated monoamines having the formula:



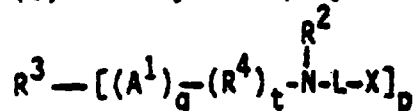
- (b) ethoxylated diamines having the formula:



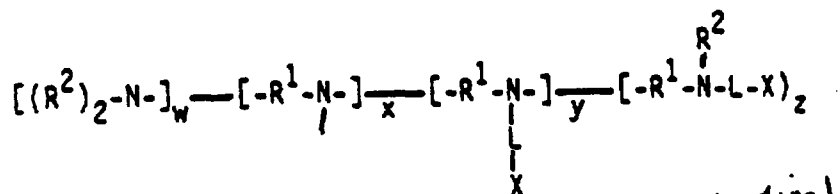
or



- (c) ethoxylated polyamines having the formula:



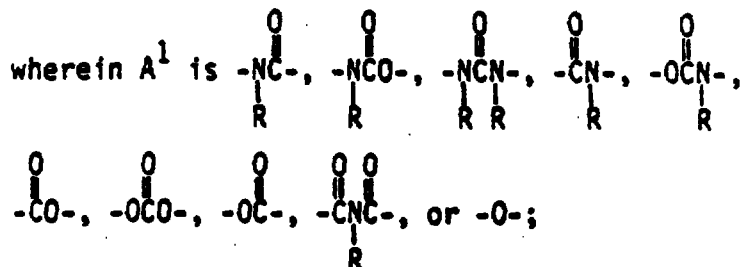
(d) ethoxylated amine polymers having the general formula:



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wherein $[-R^1-N-]$ represents ~~branched chain~~ tertiary amine; and

(e) mixtures of such ethoxylated amines;



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R is H or C_1-C_4 alkyl or hydroxyalkyl; R^1 is C_2-C_{12} alkylene, hydroxyalkylene, alkenylene, 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, the moiety $-L-X$, or two R^2 together form the moiety $-(CH_2)_r-A^2-(CH_2)_s-$, wherein A^2 is $-O-$ or $-CH_2-$, r is 1 or 2, s is 1 or 2, and r + s is 3 or 4; X is H, a nonionic group, an anionic group or mixture thereof; R^3 is a substituted C_3-C_{12} alkyl, hydroxyalkyl, alkenyl, aryl, or alkaryl group having p substitution sites; R^4 is C_1-C_{12} alkylene, hydroxyalkylene, alkenylene, 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; L is a hydrophilic chain which contains the polyoxyalkylene moiety $-[(R^5O)_m(CH_2CH_2O)_n]-$, wherein R^5 is C_3-C_4 alkylene or hydroxyalkylene and m and n are numbers such that the moiety $-(CH_2CH_2O)_n-$ comprises at least 50% by weight of said polyoxyalkylene moiety; for said monoamines, m is from 0 to 4, and n is at least 12; for said diamines, m is from 0 to 3, and n is at

75 least 6 when R^1 is C_2-C_3 alkylene, hydroxyalkylene, or alkenylene, and at least 3 when R^1 is other than C_2-C_3 alkylene, hydroxyalkylene or alkenylene; for said polyamines and amine polymers, m is from 0 to 10 and n is at least 3; p is from 3 to 8; q is 1 or 0; t is 1 or 0, provided that t is 1 when q is 1; w is 1 or 0; x is 0 or an integer; and y + z is at least 2; and

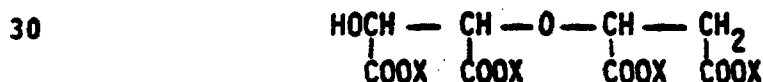
80 iii) combinations of said polycarboxylate and ethoxylated amine dispersing/anti-redeposition agents; the weight ratio of sequestering agent to dispersing/anti-redeposition agent within said composition being within the range of from 70:30 to 99:1.

15 The present invention also provides detergent and laundry additive compositions containing the two-component, ether carboxylate-based-builder systems herein.

DETAILED DESCRIPTION OF THE INVENTION

20 One essential component of the detergent builder compositions herein is a particular type of ether carboxylate sequestering agent having the general formula hereinbefore set forth. Compounds falling within this general structure bind water-hardness ions such as calcium in aqueous solutions, e.g., a laundry washing solution, by forming polydentate structures therewith.

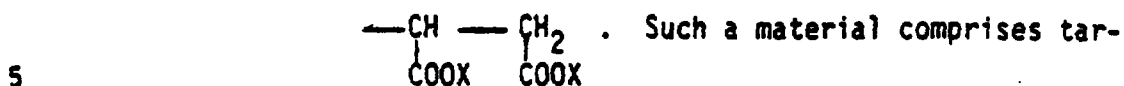
25 One type of operable ether carboxylate suitable for use in the builder compositions herein is that wherein in the above general formula A is H. This material comprises tartrate monosuccinic acid and its water-soluble salts. Such compounds have the general formula:



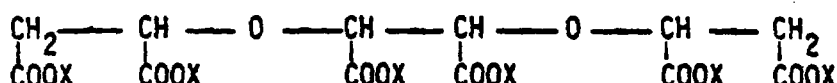
wherein X is H or water-soluble salt-forming cation. The material in either its acid or water-soluble salt form is hereinafter referred to as "TMS." Preferred salt-forming cations for TMS include alkali metal (sodium, potassium, lithium) ammonium, C_1-C_4 substituted ammonium and C_1-C_4 alkanolamine.

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Another type of ether carboxylate which is related to TMS and which is suitable for use in builder compositions herein is the material of the broadly-defined structural formula wherein A is



trate disuccinic acid and its water-soluble salts. Such compounds have the general formula:



10 wherein X is H or a water-soluble salt-forming cation. The material in either its acid or water-soluble salt form is hereinafter referred to as "TDS." Preferred salt-forming cations for TDS are the same as those set forth hereinbefore for TMS.

Both TMS and TDS, can be synthesized by the calcium catalyzed
15 reaction of maleic acid salts with tartaric acid salts. Such a reaction, in fact, produces a mixture of tartrate monosuccinate and tartrate disuccinate with the relative amounts of tartrate monosuccinate and tartrate disuccinate in such a mixture depending on the molar ratio of the maleic and tartaric reactants used and
20 upon the reaction conditions used. Accordingly, such a reaction can be used to form a two-component ether carboxylate mixture which can be used as the essential ether carboxylate component in the compositions of the present invention. The weight ratio of TMS to TDS in such mixtures can range from 97:3 to 20:80, more
25 preferably from 95:5 to 40:60.

As indicated, the procedure used to prepare the admixture of TMS and TDS involves the calcium catalyzed reaction of a maleic acid salt and a tartaric acid salt. Such a process involves the formation of an aqueous reaction mixture containing, as reactants,
30 from 20% to 60% by weight of both calcium and monovalent salts of maleic acid and tartaric acid. Such a reaction mixture corresponds to the over-neutralized mixture which is formed by combining maleic and tartaric acids in a molar ratio of from 0.5:1 to 8:1, along with particular amounts of a source of calcium
35 cations and a neutralizing agent comprising an hydroxide of a monovalent cation. The source of calcium cations, preferably

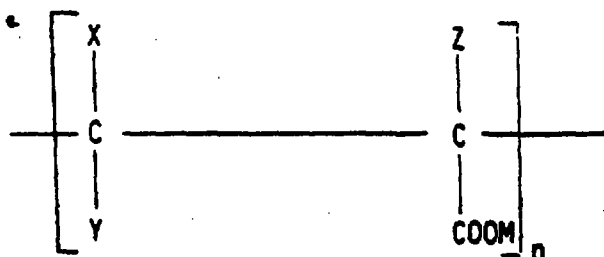
calcium hydroxide, is added to the reaction mixture in a mole ratio of calcium to tartaric acid with the ranges of from 0.1:1 to 2:1 with the proviso that the moles of calcium added not exceed the total moles of maleic and tartaric acids added. The monovalent neutralizing agent is added in an amount such that the ratio of moles of monovalent cations to (moles of tartaric acid + moles of maleic acid - moles of calcium cations) ranges from 2.1:1 to 3.8:1. Such a reaction mixture is maintained at a temperature of from about 20°C to 120°C for a period of time sufficient to form a reaction product mixture containing both a) tartrate monosuccinic acid salt, and b) tartrate disuccinic acid salt. Such a reaction product mixture is thereafter treated to reduce its calcium content to the extent that the molar ratio of calcium to tartrate succinate compounds therein is less than 1:10.

~~TMS, TDS and their admixture, as well as procedures for their preparation, are described in greater detail in the U. S. patent 4663071.~~

The ether carboxylate sequestering agent will comprise from 70% to 99% by weight of the builder compositions. More preferably this ether carboxylate will comprise from 80% to 95% by weight of the builder compositions. Most preferably, the ether carboxylate component will comprise from 85% to 92% by weight of the builder compositions herein.

The second essential component of the builder compositions herein comprises one or more selected types of dispersing/anti-redeposition agents. These selected types of dispersing/anti-redeposition agents ^{are} include (1) certain types of polycarboxylate materials and (2) certain types of ethoxylated amine materials.

The polycarboxylate materials which can be employed as the dispersing/anti redeposition agent component herein are these polymers or copolymers which contain at least 60% by weight of segments with the general formula



wherein X, Y, and Z are each selected from the group consisting of hydrogen, methyl, carboxy, carboxymethyl, hydroxy and hydroxymethyl; M is H or a salt-forming cation and n is from 30 to 400. Preferably, X is hydrogen or hydroxy, Y is hydrogen or carboxy, Z is hydrogen and M is hydrogen, alkali metal, ammonium or substituted ammonium.

Polycarboxylate materials of this type can be prepared by polymerizing or copolymerizing suitable unsaturated monomers, preferably in their acid form. Unsaturated monomeric acids that can be polymerized to form suitable polymeric polycarboxylates include acrylic acid, maleic acid (or maleic anhydride), fumaric acid, itaconic acid, aconitic acid, mesaconic acid, citraconic acid and methylenemalononic acid. The presence in the polycarboxylates herein of monomeric segments, containing no carboxylate radicals such as vinylmethyl ether, styrene, ethylene, etc. is suitable provided that such segments do not constitute more than 40% by weight.

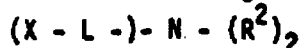
Particularly suitable polycarboxylates can be derived from acrylic acid. Such acrylic acid-based polymers which are useful herein are the water-soluble salts of polymerized acrylic acid. The average molecular weight of such polymers in the acid form ranges from 4,000 to 10,000, more preferably from 4000 to 7000 and most preferably from 4000 to 5000. Water-soluble salts of such acrylic acid polymers can include, for example, the alkali metal, ammonium and substituted ammonium salts. Soluble polymers of this type are known materials. Use of polyacrylates of this type in detergent compositions has been disclosed, for example, in Diehl; U.S. Patent 3,308,067; Issued March 7, 1967.

Acrylic/maleic-based copolymers may also be used as a preferred component of the dispersing/anti-redeposition agent. Such materials include the water-soluble salts of copolymers of acrylic

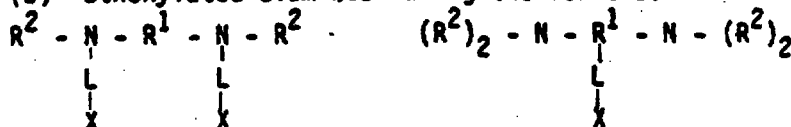
acid and maleic acid. The average molecular weight of such copolymers in the acid form ranges from 5,000 to 20,000, preferably from 6000 to 15000, more preferably from 7000 to 12000. The ratio of acrylate to maleate segments in such copolymers will generally range from 30:1 to 1:1, more preferably from 10:1 to 2:1. Water-soluble salts of such acrylic acid/maleic acid copolymers can include, for example, the alkali metal, ammonium and substituted ammonium salts. Soluble acrylate/maleate copolymers of this type are known materials which are described in European Patent Application No. 66915, published December 15, 1982.

Certain ethoxylated amine compounds may also be used as the dispersing/anti-redeposition component of the builder compositions herein. Such compounds are selected from the group consisting of:

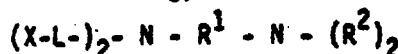
(1) ethoxylated monoamines having the formula:



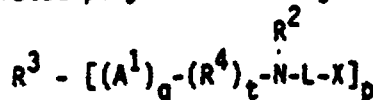
(2) ethoxylated diamines having the formula:



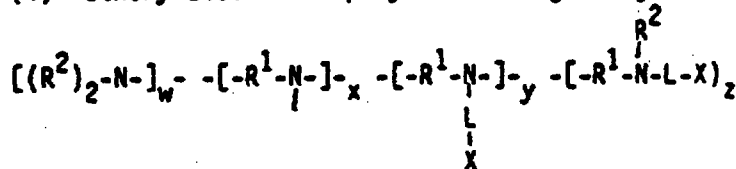
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(3) ethoxylated polyamines having the formula:

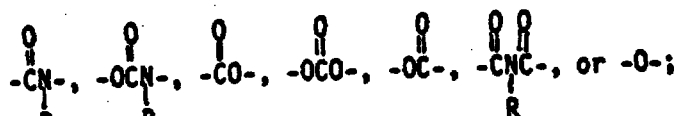


(4) ethoxylated amine polymers having the general formula:



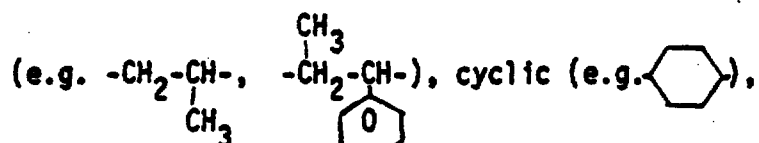
wherein $[-R^1 - N -]$ represents ~~branched-chain~~ tertiary amine radical

and (5) mixtures thereof; wherein A^1 is $\begin{array}{c} O \\ || \\ -NC- \\ | \\ R \end{array}$, $\begin{array}{c} O \\ || \\ -NCO- \\ | \\ R \end{array}$, $\begin{array}{c} O \\ || \\ -NCN- \\ | \quad | \\ R \quad R \end{array}$,



R is H or C₁-C₄ alkyl or hydroxyalkyl; R¹ is C₂-C₁₂ alkylene, hydroxyalkylene, alkenylene, arylene or alkarylene, or a C₂-C₃ oxyalkylene moiety having from 2 to 20 oxyalkylene units provided that no O-N bonds are formed; each R² is C₁-C₄ alkyl or hydroxy-
 5 alkyl, the moiety -L-X, or two R² together form the moiety -(CH₂)_r-A²-(CH₂)_s-, wherein A² is -O- or -CH₂-, r is 1 or 2, s is 1 or 2, and r + s is 3 or 4; X is H, a nonionic group, an anionic group or mixture thereof; R³ is a substituted C₃-C₁₂ alkyl, hydroxyalkyl, alkenyl, aryl, or alkaryl group having p substi-
 10 tution sites; R⁴ is C₁-C₁₂ alkylene, hydroxyalkylene, alkenylene, 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; L is a hydrophilic chain which contains the polyoxy-alkylene moiety -[(R⁵O)_m(CH₂CH₂O)_n]-, wherein R⁵ is C₃-C₄ alkylene-
 15 or hydroxyalkylene and m and n are numbers such that the moiety -(CH₂CH₂O)_n- comprises at least 50% by weight of said polyoxy-alkylene moiety; for said monoamines, m is from 0 to 4, and n is at least 12; for said diamines, m is from 0 to 3, and n is at least 6 when R¹ is C₂-C₃ alkylene, hydroxyalkylene, or alkenylene,
 20 and at least 3 when R¹ is other than C₂-C₃ alkylene, hydroxy-alkylene or alkenylene; for said polyamines and amine polymers, m is from 0 to 10 and n is at least 3; p is from 3 to 8; q is 1 or 0; t is 1 or 0, provided that t is 1 when q is 1; w is 1 or 0; x is 0 or an integer; and y + z is at least 2.

25 ~~As indicated,~~ In the preceding formulas, R¹ can be branched



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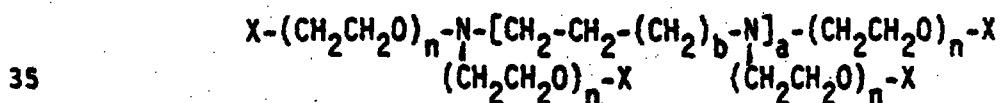
alkylene, hydroxyalkylene, alkenylene, arylene, alkarylene or oxyalkylene. R¹ is preferably C₂-C₆ alkylene for the ethoxylated diamines and amine polymers. For the ethoxylated diamines, the minimum degree of ethoxylation required for suitable clay soil
 35 removal/anti-redeposition properties decreases on going from C₂-C₃ alkylene (ethylene, propylene) to hexamethylene. However, for the

ethoxylated amine polymers, in particular the ethoxylated polyalkyleneamines and polyalkyleneimines, especially at higher molecular weights, C₂-C₃ alkylenes (ethylene, propylene) are preferred for R¹ with ethylene being most preferred. Each R² is preferably the moiety -L-X.

In the preceding formulas, hydrophilic chain L usually consists entirely of the polyoxyalkylene moiety $-(R^5O)_m(CH_2CH_2O)_n-$. The moieties $-(R^5O)_m-$ and $-(CH_2CH_2O)_n-$ of the polyoxyalkylene moiety can be mixed together or preferably form blocks of $-(R^5O)_m-$ and $-(CH_2CH_2O)_n-$ moieties. R⁵ is preferably C₃H₆ (propylene). For the ethoxylated polyamines and amine polymers, m is preferably from 0 to 5. For all ethoxylated amines used in the present invention, m is most 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).

In the preceding formulas, X is H, a nonionic group, anionic group or mixture thereof. Suitable nonionic groups include C₁-C₄ alkyl or hydroxyalkyl ester or ether groups, preferably acetate or methyl ether, respectively; or mixtures thereof. The particularly preferred group is H. With regard to anionic groups, PO₃⁻² and SO₃⁻ are suitable. The particularly preferred anionic group is SO₃⁻. It has been found that the percentage of anionic groups relative to H and nonionic groups can be important to the anti-redeposition properties provided by the ethoxylated amine. A mixture of from 0 to 30% anionic groups and from 70 to 100% H and nonionic groups provides preferred properties. A mixture of from 5 to 10% anionic groups and from 90 to 95% H and nonionic groups provides the most preferred properties. Usually, a mixture of from 0 to 80% anionic groups and from 20 to 100% H and nonionic groups provides suitable anti-redeposition properties.

Preferred ethoxylated mono- and diamines have the formula:



wherein X and n are defined as before, a is 0 or 1, and b is from

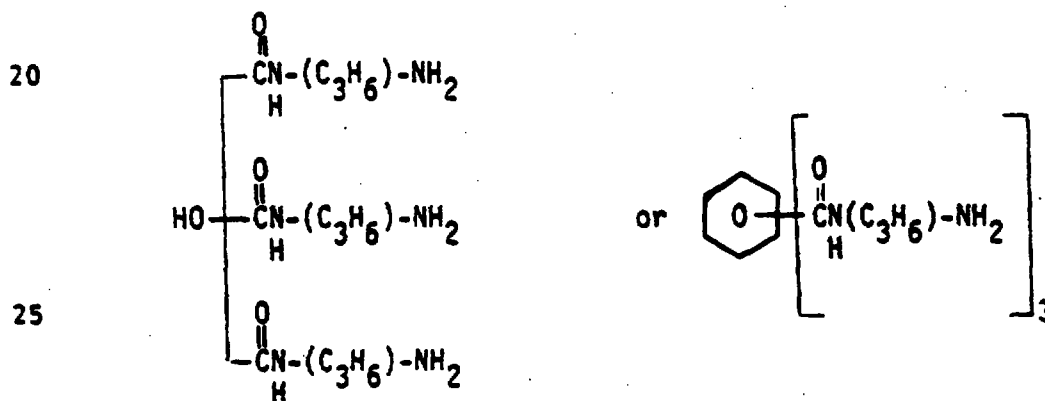
0 to 4. For preferred ethoxylated monoamines ($a = 0$), n is at least 15, with a typical range of from 15 to 35. For preferred ethoxylated diamines ($a = 1$), n is at least 12 with a typical range of from 12 to 42.

5 In the preceding formula for the ethoxylated polyamines, R^3 (linear, branched or cyclic) is preferably a substituted C_3 - C_6 alkyl, hydroxyalkyl or aryl group;

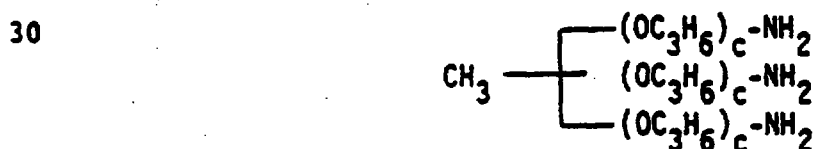
10 A^1 is preferably $\begin{array}{c} \text{O} \\ \parallel \\ \text{CN}- \\ | \\ \text{H} \end{array}$; n is preferably at least 12, with a

typical range of from 12 to 42; p is preferably from 3 to 6. When R^3 is a substituted aryl or alkaryl group, q is preferably 1 and R^4 is preferably C_2 - C_3 alkylene. When R^3 is a substituted alkyl, hydroxyalkyl, or alkenyl group, and when q is 0, R^4 is preferably a C_2 - C_3 oxyalkylene moiety; when q is 1, R^4 is preferably C_2 - C_3 alkylene.

These ethoxylated polyamines can be derived from polyamino amides such as:



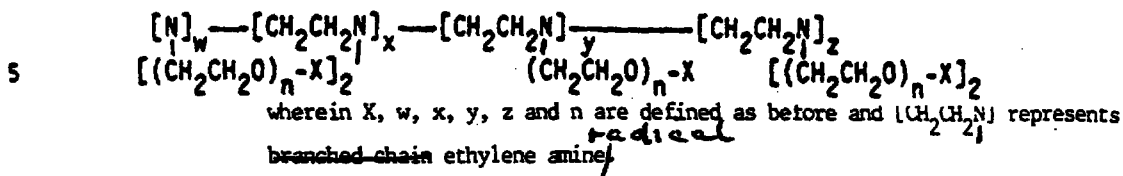
These ethoxylated polyamines can also be derived from polyamino-propyleneoxide derivatives such as:



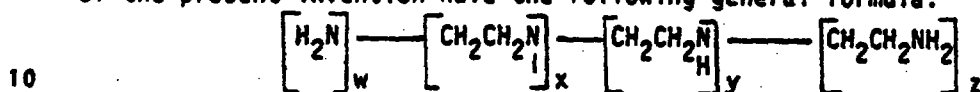
wherein each c is a number of from 2 to 20.

35 Preferred ethoxylated amine polymers are the ethoxylated C_2 - C_3 polyalkyleneamines and polyalkyleneimines. Particularly preferred ethoxylated polyalkyleneamines and polyalkyleneimines

are the ethoxylated polyethyleneamines (PEAs) and polyethylene-
imines (PEIs). These preferred compounds ^{have} ~~comprise units~~ having
the general formula:



Prior to ethoxylation, PEAs useful in preparing compounds
of the present invention have the following general formula:



wherein $x + y + z$ is from 2 to 9, $y + z$ is from 2 to 9 and w 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, $y + z$ is from 3 to 7
15 (molecular weight of from 140 to 310) and most preferably from 3
to 4 (molecular weight of from 140 to 200). These PEAs can be ob-
tained by reactions involving ammonia and ethylene dichloride,
followed by fractional distillation. The common PEAs obtained are
triethylenetetramine (TETA) and tetraethylenepentamine (TEPA).
20 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
25 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
30 preferably at least 6. Where $y + z$ is from 4 to 9, suitable
benefits are achieved when n is at least 3. For most preferred
ethoxylated PEAs, n is at least 12 with a typical range of from 12
to 42.

PEIs useful in preparing the dispersing/anti-redeposition
35 agents used in the present invention have a molecular weight of at
least 440 prior to ethoxylation, which represents at least 10

units. Preferred PEIs used in preparing these compounds have a molecular weight of from 600 to 1800. The polymer backbone of these PEIs can be represented by the general formula:

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

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

10 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:

15	-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 can be prepared, for example, by polymerizing ethyleneimine in the presence of a catalyst such as carbon dioxide, sodium bisulfite,

20 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. 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

25 2,806,839 to Crowther, issued September 17, 1957; and U.S. Patent 2,553,696 to Wilson, issued May 21, 1951.

As defined in the preceding formulas, n is at least 3 for the ethoxylated PEIs. However, it should be noted that the minimum degree of ethoxylation required for suitable clay soil removal/

30 anti-redeposition performance can increase as the molecular weight of the PEI increases, especially much beyond 1800. Also, the degree of ethoxylation for preferred compounds 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

35 typical range of from 12 to 42. For PEIs having a molecular

weight of at least 1800, n is preferably at least 24, with a typical range of from 24 to 42.

The ethoxylated amine compounds useful in dispersing/anti-redeposition agents in the builder compositions of the present invention can be prepared by standard methods for ethoxylating amines. For the diamines, polyamines, and amine polymers such as the polyalkyleneamines and polyalkyleneimines, there is preferably an initial step of condensing sufficient ethylene oxide to provide 2-hydroxyethyl groups at each reactive site (hydroxyethylation). This initial step can be omitted by starting with a 2-hydroxyethyl amine such as triethanolamine (TEA). The appropriate amount of ethylene oxide is then condensed with these 2-hydroxyethylamines using an alkali metal (e.g., sodium, potassium) hydride or hydroxide as the catalyst to provide the respective ethoxylated amines. The total degree of ethoxylation per reactive site (n) can be determined according to the following formula:

$$\text{Degree of Ethoxylation} = E / (A \times R)$$

wherein E is the total number of moles of ethylene oxide condensed (including hydroxyethylation), A is the number of moles of the starting amine, and R is the number of reactive sites (typically 3 for monoamines, 4 for diamines, $2 \times p$ for polyamines, and $3 + y + z$ for the amine polymers) for the starting amine.

Preferred embodiments of the builder compositions herein utilize a combination of polycarboxylates and ethoxylated amines as the dispersing/anti-redeposition agent components. In such embodiments, the weight ratio of polycarboxylate to ethoxylated amine generally ranges from 5:1 to 1:5, more preferably from 3:2 to 2:3. Compositions containing such a combination of polycarboxylate and ethoxylated amine dispersing/anti-redeposition agents are especially effective at promoting certain types of fabric cleaning.

Whether a single material or a combination of compounds, the dispersing/anti-redeposition component will comprise from 1% to 30% by weight of the builder composition, more preferably from 5% to 20% by weight, most preferably from 8% to 15% by weight. Furthermore, within the

builder compositions herein, the weight ratio of ether carboxylate to dispersing/anti-redeposition agent ranges from 70:30 to 99:1, preferably from 80:20 to 95:5.

The builder compositions herein can be prepared by simply combining the essential ether carboxylate sequestering agent and the polycarboxylate and/or ethoxylated amine dispersing/anti-redeposition agent in the desired proportions. This combination of components can be prepared as a builder composition per se. More frequently however, the essential components of the builder compositions herein will simply be incorporated individually into a detergent composition or laundry additive composition. In such detergent or laundry additive compositions, the weight ratio of the essential ether carboxylate component to the essential dispersing/anti-redeposition component will range from 70:30 to 99:1, more-preferably from 80:20 to 95:5.

Detergent or laundry additive compositions incorporating the builder systems of the present invention ^{may} contain ~~as essential components~~ from 5% to 50% of the ether carboxylate sequestering agent, from 0.2% to 5% by weight of the dispersing/anti-redeposition agent, and from 5% to 95% of an additional component selected from surfactants, additional detergent builders, chelating agents, enzymes, fabric whiteners and brighteners, sudsing control agents, solvents, hydrotropes, bleaching agents, bleaching precursors, buffering agents, additional soil removal/anti-redeposition agents, soil release agents, fabric softening agents, perfumes, colourants and opacifiers and combinations thereof.

Typical laundry detergent compositions within the scope of the present invention contain from 5% to 30% of a surfactant and from 5% to 80% total detergency builder. Of this builder component from 20% to 100% by weight of builder component can be the two-compound builder systems of the present invention with the balance of the builder component being optional known builders.

In a preferred detergent or laundry additive composition:

- (A) the ether carboxylate sequestering agent comprises from 10% to 30% by weight of the composition;
- 5 (B) the dispersing/anti-redeposition agent comprises from 0.5% to 3% by weight of the composition;
- (C) the weight ratio of sequestering agent to dispersing/anti-redeposition agent in the composition ranges from 80:20 to 95:5; and
- 10 (D) the additional component is a surfactant which comprises from 10% to 30% by weight of the composition.

The detergent compositions of this invention are effective in cleaning solutions over the broad cleaning solution pH range of from 6 to 13. The compositions can be formulated to provide a desired cleaning solution pH by proper selection of the acid form
5 of appropriate salts or mixtures thereof. Preferred water-soluble salts of the builder compounds, for example, can be the alkali metal salts such as sodium, potassium, lithium and ammonium or substituted ammonium, e.g. triethanol ammonium. Depending on the pH of the desired solution, the salts are partially or fully
10 neutralized.

The detergent compositions of this invention can be prepared in solid or liquid physical form.

The detergent compositions of this invention are particularly suitable for laundry use, but are also suitable for the cleaning
15 of hard surfaces and for dishwashing.

In a laundry method using the detergent composition of this invention, typical laundry wash water solutions comprise from 0.1% to 1% by weight of the detergent compositions of this invention.

Surfactants

Various types of surfactants can be used in the detergent or laundry additive compositions of this invention. Preferred detergent compositions contain from 5% to 40% surfactant. Useful surfactants include anionic, nonionic, ampholytic, zwitterionic and cationic surfactants or mixtures of such materials. Detergent compositions for laundry use typically contain from 5% to 30% anionic surfactants, mixtures of anionic and nonionic surfactants or cationic surfactants. Detergent compositions for use in automatic dishwashing machines typically contain from 2% to 6% by weight of a relatively low sudsing nonionic surfactant or mixtures thereof and, optionally, suds control agents. Particularly suitable low sudsing nonionic surfactants are the alkoxylation products of compounds containing at least one reactive hydrogen wherein, preferably, at least 20% by weight of the alkylene oxide by weight is propylene oxide. Examples are products of the BASF-Wyandotte Corporation designated Pluronic(RIM), Tetronic(RIM), Pluradot (RIM) and block polymeric variations in which propoxylation follows ethoxylation. Preferred suds control agents include mono- and distearyl acid phosphates.

The various classes of surfactants useful in the detergent and laundry additive compositions herein are exemplified as follows:

(A) Anionic soap and non-soap surfactants

This class of surfactants includes alkali metal monocarboxylates (soaps) such as the sodium, potassium, ammonium and alkylolammonium salts of higher fatty acids containing from 8 to 24 carbon atoms and preferably from 12 to 18 carbon atoms. Suitable fatty acids can be obtained from natural sources such as, for instance, from plant or animal esters (e.g., palm oil, coconut oil, babassu oil, soybean oil, castor oil, tallow, whale and fish oils, grease, lard, and mixtures thereof). The fatty acids also can be synthetically prepared (e.g., by the oxidation of petroleum, or by hydrogenation of carbon monoxide by the Fischer-Tropsch process). Resin acids are suitable such as rosin and those resin acids in tall oil. Naphthenic acids are also suitable. Sodium and potassium soaps can be made by direct saponification of the fats and oils or by the neutralization of the free

fatty acids which are prepared in a separate manufacturing process. Particularly useful are the sodium and potassium salts of the mixtures of fatty acids derived from coconut oil and tallow, i.e., sodium or potassium tallow and coconut soap. Soaps and
5 fatty acids also act as detergency builders in detergent compositions because they remove multivalent ions by precipitation.

Anionic surfactants also include water-soluble salts, particularly the alkali metal and ethanolamine salts of organic sulfuric reaction products having in their molecular structure an
10 alkyl radical containing from 8 to 22 carbon atoms and a sulfonic acid or sulfuric acid ester radical. (Included in the term alkyl is the alkyl portion of alkylaryl radicals.) Examples of this group of non-soap anionic surfactants are the alkyl sulfates, especially those obtained by sulfating the higher alcohols (C_8 - C_{18}
15 carbon atoms); alkyl benzene sulfonates, in which the alkyl group contains from 9 to 15 carbon atoms, in straight chain or branched chain configuration, sodium alkyl glyceryl ether sulfonates; fatty acid monoglyceride sulfonates and sulfates; sulfuric acid esters of the reaction product of one mole of a C_{12-18} alcohol and 1 to 6
20 moles of ethylene oxide and salts of alkyl phenol ethylene oxide ether sulfate with 1 to 10 units of ethylene oxide per molecule and in which the alkyl radicals contain 8 to 12 carbon atoms.

Additional examples of non-soap anionic surfactants are the reaction products of fatty acids esterified with isethionic acid
25 and neutralized with sodium hydroxide where, for example, the fatty acids are derived from coconut oil and sodium or potassium salts of fatty acid amide of methyl lauride in which the fatty acids, for example are derived from coconut oil.

Still other anionic surfactants include the classes designated
30 as succinamates and succinates. These classes include such surface active agents as disodium N-octadecylsulfosuccinamate; tetrasodium N-(1,2-dicarboxyethyl)-N-octadecylsulfosuccinamate; the diamyl ester of sodium sulfosuccinic acid; the dihexyl ester of sodium sulfosuccinic acid and the dioctyl ester of sodium sulfosuccinic acid.

35 Anionic phosphate surfactants are also useful in the detergent or laundry additive compositions of the present invention.

These are surface active materials having substantial detergent capability in which the anionic solubilizing group connecting hydrophobic moieties is an oxy acid of phosphorus. The more common solubilizing groups are $-SO_4H$, $-SO_3H$, and $-CO_2H$. Alkyl phosphate esters such as $(R-O)_2PO_2H$ and $ROPO_3H_2$ in which R represents an alkyl chain containing from 8 to 20 carbon atoms are useful.

These esters can be modified by including in the molecule from one to 40 alkylene oxide units, e.g., ethylene oxide units.

Particularly useful anionic surfactants for incorporation into the compositions herein are alkyl ether sulfates. The alkyl ether sulfates are condensation products of ethylene oxide and monohydric alcohols having 10 to 20 carbon atoms. Preferably, R has 12 to 18 carbon atoms. The alcohols can be derived from fats, e.g., coconut oil or tallow, or can be synthetic. Such alcohols are reacted with 0.5 to 30, and especially 1 to 6, molar proportions of ethylene oxide and the resulting mixture of molecular species, having, for example, an average of 3 to 6 moles of ethylene oxide per mole of alcohol, is sulfated and neutralized.

Other suitable anionic surfactants are olefin and paraffin sulfonates having from 12 to 24 carbon atoms.

(B) Nonionic surfactants

Alkoxylated nonionic surfactants may be broadly defined as compounds produced by the condensation of alkylene oxide groups (hydrophilic in nature) with an organic hydrophobic compound, which may be aliphatic or alkyl aromatic in nature. The length of the hydrophilic or polyoxyalkylene radical which is condensed with any particular hydrophobic group can be readily adjusted to yield a water-soluble compound having the desired degree of balance between hydrophilic and hydrophobic elements.

Alkoxylated nonionic surfactants include:

(1) The condensation product of aliphatic alcohols having from 8 to 22 carbon atoms, in either straight chain or branched chain configuration, with from 5 to 20 moles of ethylene oxide per mole of alcohol.

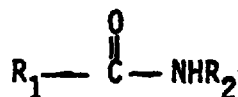
(2) The polyethylene oxide condensates of alkyl phenols, e.g., the condensation products of alkyl phenols having an alkyl group containing from 6 to 12 carbon atoms in either a straight chain or branched chain configuration, with ethylene oxide, the ethylene oxide being present in amounts of from 5 to 25 moles of ethylene oxide per mole of alkyl phenol. The alkyl substituent in such compounds may be derived from polymerized propylene, diisobutylene, octene, or nonene, for example.

(3) Materials derived from the condensation of ethylene oxide with a product resulting from the reaction of propylene oxide and a compound with reactive hydrogen such as glycols and amines such as, for example, compounds containing from 40% to 80% polyoxyethylene by weight resulting from the reaction of ethylene oxide with a hydrophobic base constituted of the reaction product of ethylene diamine and propylene oxide.

Non-polar nonionic surfactants include the amine oxides and corresponding phosphine oxides. Useful amine oxide surfactants include those having the formula $R^1R^2R^3N-O$ wherein R^1 is an alkyl group containing from 10 to 28 carbon atoms, from 0 to 2 hydroxy groups and from 0 to 5 ether linkages, there being at least one moiety of R^1 which is an alkyl group containing from 10 to 18 carbon atoms and R^2 and R^3 are selected from the group consisting of alkyl radicals and hydroxyalkyl radicals containing from 1 to 3 carbon atoms.

Specific examples of amine oxide surfactants include: dimethyldodecylamine oxide, dimethyltetradecylamine oxide, ethylmethyltetradecylamine oxide, cetyldimethylamine oxide, diethyltetradecylamine oxide, dipropyldodecylamine oxide, bis-(2-hydroxyethyl)dodecylamine oxide, bis-(2-hydroxypropyl)methyltetradecylamine oxide, dimethyl-(2-hydroxydodecyl)amine oxide, and the corresponding decyl, hexadecyl and octadecyl homologs of the above compounds.

Additional operable nonionic surfactants include alkyl glucosides and alkylamides of the formula



wherein R_1 is C_{10} - C_{18} alkyl and R_2 is -H, $-CH_2$ or $-C_2H_5$.

(C) Zwitterionic Surfactants

Zwitterionic surfactants include derivatives of aliphatic quaternary ammonium, phosphonium, and sulfonium compounds in which
5 the aliphatic moiety can be straight or branched chain and wherein one of the aliphatic substituents contains from 8 to 24 carbon atoms and one contains an anionic water-solubilizing group. Particularly preferred zwitterionic materials are the ethoxylated ammonium sulfonates and sulfates disclosed in U.S. Patents
10 3,925,262, Laughlin et al, issued December 9, 1975 and 3,929,678, Laughlin et al, issued December 30, 1975. Ammonioamidates are also useful zwitterionic surfactants.

(D) Ampholytic Surfactants

Ampholytic surfactants include derivatives of aliphatic -
15 heterocyclic secondary and tertiary amines in which the aliphatic moiety can be straight chain or branched and wherein one of the aliphatic substituents contains from 8 to 24 carbon atoms and at least one aliphatic substituent contains an anionic water-solubilizing group.

20 (E) Cationic Surfactants

Cationic surfactants comprise a wide variety of compounds characterized by one or more organic hydrophobic groups in the cation and generally by a quaternary nitrogen associated with an acid radical. Pentavalent nitrogen ring compounds are also
25 considered quaternary nitrogen compounds. Suitable anions are halides, methyl sulfate and hydroxide. Tertiary amines can have characteristics similar to cationic surfactants at washing solutions pH values less than 8.5.

A more complete disclosure of cationic surfactants can be
30 found in U.S. Patent 4,228,044, issued October 14, 1980, to Cambre.

When cationic surfactants are used in combination with anionic surfactants and certain detergency builders including polycarboxylates, compatibility must be considered. A type of
35 cationic surfactant generally compatible with anionic surfactants

and polycarboxylates is a C_{8-18} alkyl tri C_{1-3} alkyl ammonium chloride or methyl sulfate.

More complete disclosures of surfactants suitable for incorporation in detergent and laundry additive compositions of the present invention are in U.S. Patents 4,056,481, Tate (November 1, 1977); 4,049,586, Collier (September 20, 1977); 4,040,988, Vincent et al (August 9, 1977); 4,035,257, Cherney (July 12, 1977); 4,033,718, Holcolm et al (July 5, 1977); 4,019,999, Ohren et al (April 26, 1977); 4,019,998, Vincent et al (April 26, 1977); and 3,985,669, Krummel et al (October 12, 1976).

Optional Detergency Builders

The detergent and laundry additive compositions of the present invention can contain detergency builders in addition to the particular ether carboxylate compounds or mixtures described hereinbefore as essential components.

Suitable additional polycarboxylate detergency builders include the acid form and alkali metal, ammonium and substituted ammonium salts of citric, ascorbic, phytic, mellitic, benzene pentacarboxylic, oxydiacetic, carboxymethyloxysuccinic, carboxymethyloxymalonic, cis-cyclohexanehexacarboxylic, and cis-cyclopentanetetetracarboxylic acids.

The polyacetal carboxylates disclosed in U.S. Patent 4,144,226 issued March 13, 1979, to Crutchfield et al and U.S. Patent 4,146,495 issued March 27, 1979 to Crutchfield et al can be incorporated in the detergent and laundry additive compositions of the invention.

Also suitable in the detergent and laundry additive compositions of the invention are the 3,3-dicarboxy-4-oxa-1,6-hexanedioates and the related compounds disclosed in U.S. 4566984.

30

Suitable ether polycarboxylates also include cyclic compounds, particularly alicyclic compounds, such as described in U.S. Patents 3,923,679; 3,835,163; 4,158,635; 4,120,874 and 4,102,903.

35 Polyphosphonate detergency builders comprise a large range of organic compounds having two or more - C - PO_3M_2 groups,

wherein M is hydrogen or a salt-forming radical. Suitable phosphonates include ethane-1-hydroxy-1,1-diphosphonates, ethane-hydroxy-1,1,2-triphosphonates and their oligomeric ester chain condensates. Suitable polyphosphonates for use in the compositions of the invention also include nitrogen-containing polyphosphonates such as ethylenediaminetetrakis (methylenephosphonic) acid and diethylenetriaminepentakis (methylenephosphonic) acid and alkali metal, ammonium and substituted ammonium salts thereof. In common with other phosphorus-containing components, the incorporation of phosphonates may be restricted or prohibited by government regulation.

As discussed hereinbefore C_{8-24} alkyl monocarboxylic acid and soluble salts thereof have a detergent builder function in addition to surfactant characteristics. C_8-C_{24} alkyl, alkenyl, alkoxy and thio-substituted alkyl dicarboxylic acid compounds, such as 4-pentadecene -1,2-dicarboxylic acid, salts thereof and mixtures thereof, are also useful optional detergency builders.

Inorganic detergency builders useful in the detergent and laundry additive compositions of this invention at total combined levels of from 0% to 75% by weight, include alkali metal phosphates, sodium aluminosilicates, alkali metal silicates and alkali metal carbonates.

Phosphate detergency builders include alkali metal orthophosphates which remove multivalent metal cations from laundry solutions by precipitation and the polyphosphates such as pyrophosphates, tripolyphosphates and water-soluble metaphosphates that sequester multivalent metal cations in the form of soluble complex salts or insoluble precipitating complexes. Sodium pyrophosphate and sodium tripolyphosphate are particularly suitable in granular detergent and laundry additive compositions to the extent that governmental regulations do not restrict or prohibit the use of phosphorus-containing compounds in such compositions. Granular detergent and laundry additive composition embodiments of the invention particularly adapted for use in areas where the incorporation of phosphorus-containing compounds is

restricted contains low total phosphorus and, preferably, essentially no phosphorus.

Other optional builder material include aluminosilicate ion exchange materials, e.g. zeolites. Crystalline aluminosilicate ion exchange materials useful in the practice of this invention have the formula $\text{Na}_z[(\text{AlO}_2)_z(\text{SiO}_2)_y] \times \text{H}_2\text{O}$ wherein z and y are at least 6, the molar ratio of z to y is from 1.0 to 0.5 and x is from 10 to 264. In a preferred embodiment the aluminosilicate ion exchange material has the formula $\text{Na}_{12}[(\text{AlO}_2)_{12}(\text{SiO}_2)_{12}] \times \text{H}_2\text{O}$ wherein x is from 20 to 30, especially 27.

Amorphous hydrated aluminosilicate material useful herein has the empirical formula: $\text{Na}_2(z\text{AlO}_2 \cdot y\text{SiO}_2)$, z is from 0.5 to 2, y is 1 and said material has a magnesium ion exchange capacity of at least 50 milligram equivalents of CaCO_3 hardness per gram of anhydrous aluminosilicate.

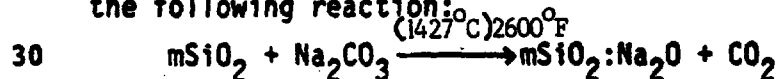
The aluminosilicate ion exchange builder materials herein are in hydrated form and contain from 10% to 28% of water by weight if crystalline and potentially even higher amounts of water if amorphous. Highly preferred crystalline aluminosilicate ion exchange materials contain from 18% to 22% water in their crystal matrix. The crystalline aluminosilicate ion exchange materials are further characterized by a particle size diameter of from 0.1 micron to 10 microns. Amorphous materials are often smaller, e.g., down to less than 0.01 micron. Preferred ion exchange materials have a particle size diameter of from 0.2 micron to 4 microns. The term "particle size diameter" herein 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 herein are usually further characterized by their calcium ion exchange capacity, which is at least 200 mg. equivalent of CaCO_3 water hardness/gm. of aluminosilicate, calculated on an anhydrous basis, and which generally is in the range of from 300 mg.eq./g. to 352 mg. eq./g. The aluminosilicate ion exchange materials herein are still further characterized by their calcium

ion exchange rate which is at least 2 grains Ca⁺⁺/ gallon/ minute/gram of aluminosilicate (anhydrous basis), and generally lies within the range of from 2 grains/gallon/ minute/gram to 6 grains/gallon/minute/gram, based on calcium ion hardness. Optimum aluminosilicate for builder purposes exhibit a calcium ion exchange rate of at least 4 grains/gallon/minute/gram.

The amorphous aluminosilicate ion exchange materials usually have a Mg⁺⁺ exchange capacity of at least 50 mg. eq. CaCO₃/g(12 mg. Mg⁺⁺/g.) and a Mg⁺⁺ exchange rate of at least 1 gr./gal./ min./g./gal. Amorphous materials do not exhibit an observable diffraction pattern when examined by Cu radiation (1.54 Angstrom Units).

Aluminosilicate ion exchange materials useful as optional builders in the detergent and laundry additive compositions of this invention are commercially available. The aluminosilicates useful in this invention 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 discussed in U.S. Pat. No. 3,985,669, issued October 12, 1976. Preferred synthetic crystalline aluminosilicate ion exchange materials useful herein are available under the designation Zeolite A, Zeolite B, and Zeolite X.

Other optional builders include alkali metal silicates. Suitable alkali metal silicates have a mole ratio of SiO₂: alkali metal oxide in the range of from 1:1 to 4:1. The alkali metal silicate suitable herein include commercial preparations of the combination of silicon dioxide and alkali metal oxide or carbonate fused together in varying proportions according to, for example, the following reaction:



The value of m, designating the molar ratio of SiO₂:Na₂O, ranges from 0.5 to 4 depending on the proposed use of the sodium silicate. The term "alkali metal silicate" as used herein refers to silicate solids with any ratio of SiO₂ to alkali metal oxide. Silicate solids normally possess a high alkalinity content; in addition water of hydration is frequently present as, for example,

in metasilicates which can exist having 5, 6, or 9 molecules of water. Sodium silicate solids with a $\text{SiO}_2:\text{Na}_2\text{O}$ mole ratio of from 1.5 to 3.5, are preferred in granular laundry detergent compositions.

5 Silicate solids are frequently added to granular detergent or laundry additive compositions as corrosion inhibitors to provide protection to the metal parts of the washing machine in which the detergent or laundry additive composition is utilized. Silicates have also been used to provide a degree of crispness and pour-
10 ability to detergent or laundry additive granules which is very desirable to avoid lumping and caking.

Alkali metal carbonates are useful in the granular detergent or laundry additive compositions of the invention as a source of washing solution alkalinity and because of the ability of the
15 carbonate ion to remove calcium and magnesium ions from washing solutions by precipitation.

Preferred granular compositions free of inorganic phosphates contain from 8% to 40% by weight sodium carbonate, from 0% to 30% sodium aluminosilicate, from 0.5% to 10% sodium silicate solids,
20 from 5% to 35% of the particular ether carboxylate compounds of this invention, from 0.2% to 5% by weight of the particular dispersing/anti-redeposition agents of this invention, and from 10% to 25% surfactant.

Preferred liquid compositions free of inorganic phosphates
25 contain from 8% to 30% by weight of non-soap anionic surfactants, from 2% to 25% ethoxylated nonionic surfactants, from 5% to 20% of a C_{8-24} alkyl or alkenyl mono-or dicarboxylic acid or salt thereof, from 2% to 18% of the particular ether carboxylate compounds of the present invention and from 0.2% to 5% by weight of the
30 dispersing/anti-redeposition agents of the present invention. Some liquid formulations may also contain from 0.5 to 5% of a cationic or amine oxide surfactant.

Additional Optional Components

Granular detergent or laundry additive compositions of this
35 invention can contain materials such as sulfates, borates,

perborates organic peroxy acid salts, peroxy bleach precursors and activators and water of hydration.

Liquid detergent or laundry additive compositions of this invention can contain water and other solvents. Low molecular weight primary or secondary alcohol exemplified by methanol, ethanol, propanol, and isopropanol are suitable. Monohydric alcohols are preferred for solubilizing the surfactant but polyols containing from 2 to 6 carbon atoms and from 2 to 6 hydroxy groups can be used and can provide improved enzyme stability. Examples of polyols include propylene glycol, ethylene glycol, glycerine and 1,2-propanediol. Ethanol is a particularly preferred alcohol.

The detergent or laundry additive compositions of the invention can also contain such materials as proteolytic and amylolytic enzymes, fabric whiteners and optical brighteners, sudsing control agents, hydrotropes such as sodium toluene, xylene or cumene sulfonate, perfumes, colorants, opacifiers, and alkalinity control or buffering agents such as monoethanolamine and triethanolamine. The use of these materials is known in the detergent art.

Soil release agents, such as disclosed in the art to reduce oily staining of polyester fabrics, are also useful in the detergent and laundry additive compositions of the present invention. U.S. Patent 3,962,152 issued June 8, 1976, to Nicol et al. discloses copolymers of ethylene terephthalate and polyethylene oxide terephthalate as soil release agents. U.S. Patent 4,174,305 issued November 13, 1979, to Burns et al. discloses cellulose ether soil release agents. U.S. 4,702,857,

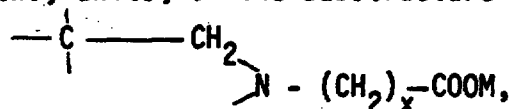
~~by Gosselink discloses block polyester compounds useful as soil release agents in detergent and laundry additive compositions.~~

The detergent and laundry additive compositions herein may also optionally contain one or more iron and magnesium chelating agents. Such chelating agents can be selected from the group consisting of amino carboxylates, amino phosphonates, polyfunctionally - substituted aromatic chelating agents and mixtures thereof.

Without relying on theory,

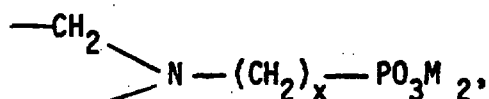
it is speculated that the benefit of these materials is due in part to their exceptional ability to remove iron and manganese ions from washing solutions by formation of soluble chelates.

Amino carboxylates useful as optional chelating agents in compositions of the invention have one or more, preferably at least two, units, of the substructure



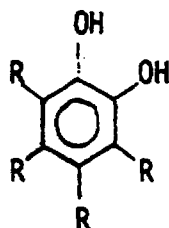
wherein M is hydrogen, alkali metal, ammonium or substituted ammonium (e.g. ethanolamine) and x is from 1 to 3, preferably 1. Preferably, these amino carboxylates do not contain alkyl or alkenyl groups with more than 6 carbon atoms. Alkylene groups can be shared by substructures. Operable amine carboxylates include ethylenediaminetetraacetates, N-hydroxyethylethylenediaminetriacetates, nitrilotriacetates, ethylenediamine tetrapropionates, diethylenetriaminepentaacetates, and ethanoldiglycines.

Amino phosphonates are also suitable for use as chelating agents in the compositions of the invention when at least low levels of total phosphorus are permitted in detergent compositions. Compounds with one or more, preferably at least two, units of the substructure



wherein M is hydrogen, alkali metal, ammonium or substituted ammonium and x is from 1 to 3, preferably 1, are useful and include ethylenediaminetetrakis (methylenephosphonates), nitrilotris (methylenephosphonates) and diethylenetriaminepentakis (methylenephosphonates). Preferably, these amino phosphonates do not contain alkyl or alkenyl groups with more than 6 carbon atoms. Alkylene groups can be shared by substructures.

Polyfunctionally - substituted aromatic chelating agents are also useful in the compositions herein. These materials comprise compounds having the general formula



5 wherein at least one R is $-SO_3H$ or $-COOH$ or soluble salts thereof and mixtures thereof. U.S. Patent 3,812,044 issued May 21, 1974, to Connor et al discloses polyfunctionally - substituted aromatic chelating and sequestering agents. Preferred compounds of this type in acid form are dihydroxydisulfobenzenes and 1,2-dihydroxy
10 -3,5-disulfobenzene or other disulfonated catechols in particular. Alkaline detergent compositions can contain these materials in the form of alkali metal, ammonium or substituted ammonium (e.g. mono-or triethanolamine) salts.

If utilized, optional chelating agents will generally com-
15 prise from 0.1% to 10% by weight of the detergent or laundry additive compositions herein. More preferably chelating agents will comprise from 0.75% to 3% by weight of such compositions.

The detergent and laundry additive compositions of this invention can also include a bleach system comprising an inorganic
20 or organic peroxy bleaching agent and, in preferred compositions, an organic peroxy acid bleach precursor. Suitable inorganic peroxygen bleaches include sodium perborate mono- and tetrahydrate, sodium percarbonate, sodium persulfate and urea-hydrogen peroxide addition products and the clathrate $4Na_2SO_4:2H_2O_2:1NaCl$.
25 Suitable organic bleaches include peroxyauric acid, peroxyoctanoic acid, peroxydecanoic acid, peroxydodecanedioic acid, diperoxyazelaic acid, mono- and diperoxyphthalic acid and mono- and diperoxyisophthalic acid. The bleaching agent is generally present in the detergent and laundry additive compositions of this invention at a level of from 5% to
30 50% preferably from 10% to 25% by weight.

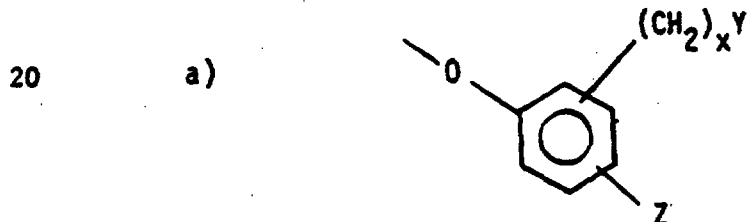
The detergent and laundry additive compositions of the invention may also contain an organic peroxy acid bleach precursor at a level of from 0.5% to 10%, preferably from 1% to 6% by
35 weight. Suitable bleach precursors are disclosed in UK-A-2040983,

and include for example, the peracetic acid bleach precursors such as tetraacetylenediamine, tetraacetylmethylenediamine, tetraacetylhexylenediamine, sodium p-acetoxybenzene sulfonate, tetraacetylglycouril, pentaacetylglucose, octaacetylactose, and methyl o-acetoxy benzoate. Highly preferred bleach precursors, however, have the general formula

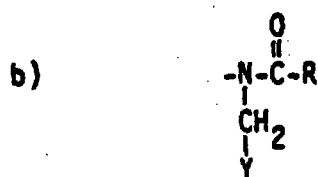


wherein R is an alkyl group containing from 6 to 12 carbon atoms wherein the longest linear alkyl chain extending from and including the carboxyl carbon contains from 5 to 10 carbon atoms and L is a leaving group, the conjugate acid of which has a logarithmic acidity constant in the range from 6 to 13.

The alkyl group, R, can be either linear or branched and, in preferred embodiments, it contains from 7 to 9 carbon atoms. Preferred leaving groups L have a logarithmic acidity constant in the range from 7 to 11, more preferably from 8 to 10. Examples of leaving groups are those having the formula



and



wherein Z is H, R¹ or halogen, R¹ is an alkyl group having from 1 to 4 carbon atoms, X is 0 or an integer of from 1 to 4 and Y is selected from SO₃M, OSO₃M, CO₂M, N⁺(R')₃Q⁻ and N⁺(R¹)₂-O⁻ wherein M is H, alkali metal, alkaline earth metal, ammonium or substituted ammonium, and Q is halide or methosulfate.

The preferred leaving group L has the formula (a) in which Z is H, x is 0 and Y is sulfonate, carboxylate or dimethylamine oxide radical. Highly preferred materials are sodium 3,5,5-

trimethylhexanoyloxybenzene sulfonate, sodium 3,5,5-trimethylhexanoyloxybenzoate, sodium 2-ethylhexanoyl oxybenzenesulfonate, sodium nonanoyl oxybenzene sulfonate and sodium octanoyl oxybenzenesulfonate, the acyloxy group in each instance preferably
5 being p-substituted.

The bleach precursor (activator) herein will normally be added in the form of particles comprising finely-divided bleach activator and a binder. The binder is generally selected from nonionic surfactants such as the ethoxylated tallow alcohols,
10 polyethylene glycols, anionic surfactants, film forming polymers, fatty acids and mixtures thereof. Highly preferred are nonionic surfactant binders, the bleach activator being admixed with the binder and extruded in the form of elongated particles through a radial extruder as described in European Patent Application No.
15 62523. Alternatively, the bleach activator particles can be prepared by spray drying.

The following embodiments illustrate, but are not limiting of, the builder compositions of the present invention, as well as detergent compositions containing the builder systems herein. All
20 percentages herein are by weight unless indicated otherwise.

EXAMPLE I

In this Example a builder composition is formulated by preparing a mixture of ether carboxylates and by adding thereto an ethoxylated polyamine dispersing/anti-redeposition agent.

25 A. Ether Carboxylate Mixture Preparation

A mixture of tartrate monosuccinate (TMS) and tartrate disuccinate (TDS) is prepared by a procedure which involves the reaction of maleate salts and tartrate salts. In such a procedure, maleic anhydride (2205g, 22.5 moles) is heated in 2000g of
30 distilled water until dissolved. The resultant solution of maleic acid is cooled to $85 \pm 5^\circ\text{C}$ and 2250g L-(+)- tartaric acid (15.0 moles) is added with stirring at $85 \pm 5^\circ\text{C}$ until a homogeneous clear acid solution is obtained.

Separately, 1111g of calcium hydroxide (15.0 moles) is slowly
35 added to a mixture of 4440g of 50% sodium hydroxide solution (55.5 moles) and 1000g distilled water while stirring at a moderate rate

such that only a small fraction of unwetted calcium hydroxide is upon the surface of the solution at a time. Stirring is continued until an essentially uniform base mixture is obtained.

5 The base mixture is then added at a uniform rate over 0.5 hour to the moderately stirred acid solution which is at 70-85°C. The resulting reaction mixture is cooled with warm (ca. 60°C) water in order to maintain a reaction temperature of $90 \pm 5^\circ\text{C}$ most of the time. The reaction mixture may, however, boil briefly from time to time. The object is to prevent major losses of water
10 vapor and also to limit the amount of insoluble salt which crystallizes upon the cool reaction vessel walls. As the last 10% of base is added, the reaction temperature is held at 85°C. The reaction mixture is quickly weighed and brought to 13,020g, i.e., 50% active, with 200g of distilled water. (Active is defined here
15 as total weight of organics taken as their sodium salts i.e., sodium maleate and sodium tartrate or $160 \times 22.5 \text{ moles} + 194 \times 15.0 \text{ moles} = 6510\text{g.}$)

The reaction mixture is immediately heated with steam, stirred moderately in a covered reactor, and a 0.40g sample taken
20 with time arbitrarily set at zero. The reaction mixture which is a white suspension, is brought to 98-100°C within 10 minutes. Within 15 to 20 minutes of time zero, the reaction mixture clears. Samples ($0.40 \pm 0.04\text{g}$) of the reaction solution are taken every half hour to be dissolved in 100 ml 0.1N sulfuric acid solution
25 and immediately submitted for high pressure liquid chromatography (HPLC) analysis in order to monitor the course of the reaction.

The results of HPLC analysis of the 1.5 hour sample indicate that the reaction is to be quenched at the 2.0 hour point. Quenching consists of cooling the reaction product mixture to 50°C
30 within 10 minutes. The homogeneous, almost colorless quenched reaction product solution is reweighed and is made up again to 13,020g with 327g of distilled water to give a reaction product solution containing 50% active.

HPLC analysis indicates that the composition of the reaction
35 product solution is 11.1% tartrate, 1.7% malate, 12.6% maleate, 10.9% fumarate, 35.0% peak 2A, 19.6% peak 2B, 3.3% peak 3A, and

5.9% peak 3B. Peaks 2A and 2B are isomers of sodium tartrate monosuccinate (TMS) and peaks 3A and 3B are isomers of sodium tartrate disuccinate (TDS). Therefore, the HPLC estimated yield of TMS + TDS based upon all peak areas is 63.7%. The approximate weight ratio of TMS:TDS is 86:14. All yields are based upon HPLC refractive index raw data, i.e., are not corrected to mole %. Calculated yield of this reaction based on tartrate is 4,139g.

A second reaction product batch of the same size is made using similar procedures. HPLC analysis indicates that the composition of this second reaction product solution is 9.8% tartrate, 1.7% malate, 12.4% maleate, 10.1% fumarate, 35.0% peak 2A, 18.1% peak 2B, 5.1% peak 3A, and 7.9% peak 3B. Again peaks 2A and 2B are isomers of sodium tartrate monosuccinate (TMS) and peaks 3A and 3B are isomers of sodium tartrate disuccinate (TDS). Therefore, the HPLC-estimated yield of TMS + TDS based upon all peak areas is 66.1%. The approximate weight ratio of TMS:TDS is 80:20. Yield is 4400g based on calculations.

Both reaction product batches are combined to give 26,040g of solution which is calculated to contain 8539g of TMS/TDS and 30 moles of calcium ion. This solution is then diluted with 26,040g of water. While this solution is at 26°C and stirred vigorously, a 28% solution of 7500g (30 mole) of ethanehydroxydiphosphonate disodium salt dissolved in 18,750g of water is added followed by 3178g of 50% sodium hydroxide solution to give a pH of 10.5. Stirring is continued for 18 hours; the final pH is eleven. The resulting precipitate (EHDP-calcium complex) is then removed by filtration using suction filtration equipment with a paper filter, and the filtrate is washed with 4 liters of water. The resulting supernatant, 56 liters, is filtered again through a glass frit to remove any remaining fine particles. This clear solution is then evaporated in a steam heated vat with a compressed air stream blown above the surface to give a solution of 32,550g.

This solution is then poured into 80 liters of vigorously stirred methanol. This is done to help separate the less soluble TMS and TDS from the more soluble maleic and fumaric acid salts. The stirring is continued for 15 minutes followed by a 1/2 hour

settling period. Then the liquid is decanted from the gummy solid by siphon. This solid is dissolved in 13,500g of distilled water to give 26,685g of solution which is then poured into 68 liters of methanol, essentially repeating the above. The resulting solid is
5 dissolved in 6 liters of distilled water (pH = 8.4), and the vat is heated with steam. Methanol is removed with a stream of nitrogen directed on the surface of the solution which is well stirred. This is continued until ¹H-NMR analysis indicates that the methanol is removed. The resulting solution is 16,380g. To
10 reduce viscosity, 2 liters of water are added, and the mixture is filtered to give 18,887g of solution. This solution is analyzed and found to have the following composition by high pressure liquid chromatography using a refractive index detector: 43.6% TMS/TDS (8,235g or 96.4% recovery by workup), 2.1% tartrate, 0.5%
15 malate, 0.9% maleate, and 1.1% fumarate. The TMS/TDS ratio is 78.2:21.8. The calcium ion level of the solution is 0.048 weight % as determined by atomic absorption.

B. Ethoxylated Polyamine Preparation

Tetraethylenepentamine (TEPA) (M.W. 189, 61.44 g., 0.325
20 moles) is placed in a nominally dry flask and dried by stirring for 0.5 hours at 110°-120°C under a vacuum (pressure less than 1 mm.) The vacuum is released by drawing ethylene oxide (EO) from a prepurged trap connected to a supply tank. Once the flask is filled with EO, an outlet stopcock is carefully opened to a trap
25 connected to an exhaust bubbler. After 3 hours stirring at 107°-115°C, 99.56 g. of EO is added to give a calculated degree of ethoxylation of 0.995. The reaction mixture is cooled while being swept with argon and 2.289 g. (0.057 moles) of 60% sodium hydride in mineral oil are then added. The stirred reaction mixture is
30 swept with argon until hydrogen evolution ceased. EO is then added to the reaction mixture under atmospheric pressure at 109°-118°C with moderately fast stirring. After 23 hours, a total of 1503 g. (34.17 moles) of EO has been added to give a calculated total degree of ethoxylation of 15.02. The ethoxylated TEPA
35 obtained is a tan waxy solid.

C. Builder Composition Preparation

94 grams of the TMS/TDS mixture prepared in Part A are admixed with 6 grams of the ethoxylated TEPA material as prepared in Part B. Such a composition is especially suitable for use as a builder system in surfactant-containing detergent compositions or in a laundry additive composition.

EXAMPLE II

A granular detergent composition for household laundry use is as follows:

10	<u>Component</u>	<u>Wt. %</u>
	Sodium C ₁₄ -C ₁₅ alkylsulfate	13.3
	Sodium C ₁₃ linear alkyl benzene sulfonate	5.7
	C ₁₂ -C ₁₃ alkylpolyethoxylate (6.5)	1.0
	Sodium toluene sulfonate	1.0
15	TMS/TDS, sodium salt, 86/14 weight ratio (TMS:TDS of the Example I type)	25.0
	Sodium N-hydroxyethylethylenediaminetriacetate	2.0
	Sodium polyacrylate (Avg. M.W. approx. 5000)	2.0
	Sodium carbonate	20.3
20	Sodium silicate	5.8
	Polyethylene glycol (Avg. M.W. approx. 8000)	1.0
	Sodium sulfate, water and miscellaneous	Balance to 100%

The components are added together with continuous mixing with sufficient extra water (40% total) to form an aqueous slurry which is then spray dried to form the composition.

EXAMPLE III

A liquid detergent composition for household laundry use is as follows:

	<u>Component</u>	<u>Wt. %</u>
30	Potassium C ₁₄ -C ₁₅ alkyl polyethoxy (2.5) sulfate	8.3
	C ₁₂ -C ₁₄ alkyl dimethyl amine oxide	3.3
	Potassium toluene sulfonate	5.0
	Monoethanolamine	2.3
	TMS/TDS triethanolamine salt, 85/15 TMS/TDS	15.0

Potassium salt of 1,2-dihydroxy-3,5-disulfobenzene	1.5
Ethoxylated tetraethylenepentamine (Example I-type)	1.5
Potassium polyacrylate (avg. M.W. approx. 9000)	1.5
Water and miscellaneous	Balance to 100%

- 5 The components are added together with continuous mixing to form the composition.

EXAMPLE IV

A liquid detergent composition for household laundry use is prepared by mixing the following ingredients:

10	C ₁₃ alkylbenzenesulfonic acid	10.5%
	Triethanolamine cocoalkyl sulfate	4.0
	C ₁₄₋₁₅ alcohol ethoxy-7	12.0
	C ₁₂₋₁₈ alkyl monocarboxylic acids	15.0
	TMS/TDS, triethanolamine salt 85/15 TMS/TDS	5.0
15	Diethylenetriaminepentakis (methylenephosphonic) acid	0.8
	Polyacrylic acid (avg. M.W. approx. 5000)	0.8
	Triethanolamine	4.5
	Ethanol	8.6
	1,2-Propanediol	3.0
20	Water, perfume, buffers and miscellaneous	Balance to 100%

EXAMPLE V

In the Compositions which follow, the abbreviations used have the following designations:

	C ₁₂ LAS	:	Sodium linear C ₁₂ benzene sulfonate
25	TAS	:	Sodium tallow alcohol sulfonate
	TAE _n	:	Hardened tallow alcohol ethoxylated with n moles of ethylene oxide per mole of alcohol
30	Dobanol (RIM) 45 _E 7	:	A C ₁₄₋₁₅ primary alcohol condensed with 7 moles of ethylene oxide
	TAED	:	Tetraacetyl ethylene diamine
	NOBS	:	Sodium nonanoyl oxybenzenesulfonate
	INOBS	:	Sodium 3,5,5 trimethyl hexanoyl oxybenzene sulfonate
35	Silicate	:	Sodium silicate having an SiO ₂ :Na ₂ O ratio of 1:6

	Sulfate	:	Anhydrous sodium sulfate
	Carbonate	:	Anhydrous sodium carbonate
	CMC	:	Sodium carboxymethyl cellulose
5	Silicone	:	Comprising 0.14 parts by weight of an 85:15 by weight mixture of silanated silica and silicone, granulated with 1.3 parts of sodium tripolyphosphate, and 0.56 parts of tallow alcohol condensed with 25 molar proportions of ethylene oxide
10	PC1	:	Copolymer of 3:7 maleic/acrylic acid, average molecular weight 70,000, as sodium salt
15	PC2	:	Polyacrylic acid, average molecular weight 4,500, as sodium salt
	TMS/TDS	:	Tartrate monosuccinate/tartrate disuccinate mixture in a weight ratio of 80:20, sodium salt form
20	Perborate	:	Sodium perborate tetrahydrate of nominal formula $\text{NaBO}_2 \cdot 3\text{H}_2\text{O} \cdot \text{H}_2\text{O}_2$
	Enzyme	:	Protease
	EDTA	:	Sodium ethylene diamine tetra acetate
25	Brightener	:	Disodium 4,4'-bis(2-morpholino-4-anilino-s-triazin-6-ylamino) stilbene-2:2'di-sulfonate
	DETPMP	:	Diethylene triamine penta(methylene phosphonic acid), marketed by Monsanto under the Trade name Dequest 2060
30	EDTMP	:	Ethylenediamine tetra (methylene phosphonic acid), marketed by Monsanto, under the Trade name Dequest 2041

Granular detergent compositions are prepared as follows. A base powder composition is first prepared by mixing all components except, where present, Dobanol 45E7, bleach, bleach activator, enzyme, suds suppresser, phosphate and carbonate in crutcher as an aqueous slurry at a temperature of 55°C and containing 35% water.

The slurry is then spray dried at a gas inlet temperature of 330°C to form base powder granules. The bleach activator, where present, is then admixed with TAE₂₅ as binder and extruded in the form of elongated particles through a radical extruder as described in European Patent Application Number 62523. The bleach activator noodles, bleach, enzyme, suds suppressor, phosphate and carbonate are then dry-mixed with the base powder composition and finally Dobanol (RIM) 45E7 is sprayed into the final mixture.

COMPOSITIONS

	<u>A</u>	<u>B</u>	<u>C</u>	<u>D</u>
10 C ₁₂ LAS	4	9	8	8
TAS	4	3	-	3
TAE ₂₅	0.5	0.5	0.8	-
TAE ₁₁	-	1	-	-
15 Dobanol (RIM) 45E7	4	-	4	2
NOBS	-	2	-	-
INOBS	3	-	-	-
TAED	0.5	-	3	-
Perborate	19	20	10	24
20 EDTMP	0.3	-	0.4	0.1
DETPMP	-	0.4	-	-
EDTA	0.2	0.2	0.2	0.1
Magnesium (ppm)	1000	1000	750	-
PC1	2	1	2	2
25 PC2	1	1	-	1
TMS/TDS	25	7	15	10
Zeolite A*	-	15	14	-
Sodium tripolyphosphate	-	-	-	12
Coconut Soap	-	-	-	2
30 Carbonate	17	15	10	-
Silicate	3	2	2	7
Silicone	0.2	0.2	0.3	0.2
Enzyme	0.8	0.5	0.4	0.3
Brightener	0.2	0.2	0.2	0.2

Sulfate,

Moisture &

Miscellaneous - - - - - to 100 - - - - -

*Zeolite A of 4 A pore size.

5 The above compositions are zero and low phosphate detergent compositions displaying excellent bleach stability, fabric care and detergency performance across the range of wash temperatures with particularly outstanding performance in the case of Compositions A, B and C on greasy and particulate soils at low wash
10 temperatures.

EXAMPLE VI

Aqueous washing solutions corresponding to solutions containing 1500 ppm of various granular detergent compositions are tested for their ability to remove several types of soils from several
15 types of fabrics. The granular detergent composition of these types are those which contain the following components in the following amount:

	<u>Component</u>	<u>Wt. %</u>
	Sodium C ₁₃ linear alkylbenzenesulfonate	7.4
20	Sodium C ₁₄ -C ₁₅ alkylsulfate	7.4
	C ₁₂ -C ₁₃ alkylpolyethoxylate (2.5)	1.5
	Sodium Silicate	4.7
	Sodium Carbonate	17.3
	Builder	31.5
25	Dispersing/Anti-redeposition Agent	2
	Sodium Diethylene Triamine Penta Acetate (DTPA)	
	Chelating Agent (Optional)	1
	Sodium Sulfate, Water and Minors (12.7cm) (12.7cm)	Balance to 100%

Artificially soiled 5" x 5" fabrics representing a range of
30 typical consumer stains are washed in a mini-washer using two gallons of aqueous washing solution as hereinbefore described. Each such treatment employs a different combination of builder, dispersing/anti-redeposition agent and/or chelating agent as set forth in the following table:

Treatment		Dispersing/Anti-Redeposition Agent		Chelant
No.	Builder			
1	TMS/TDS ^A	None		None
2	TMS/TDS	50/50 Mixture of PC2 ^B and PEA ₁₈₉ E ₁₅ ^C		None
3	TMS/TDS	50/50 Mixture of PC2 and PEA ₁₈₉ E ₁₅		DTPA ^D
4	TMS/TDS	None		DTPA
5	STPP ^E	None		None
10	(A) Mixture of tartrate monosuccinate and tartrate disuccinate in a TMS to TDS weight ratio of 80/20, sodium salt form			
	(B) Polyacrylic acid, average molecular weight 4500, as sodium salt			
15	(C) Ethoxylated tetraethylenepentamine having a molecular weight prior to ethoxylation of 189 and a degree of ethoxylation of 15			
	(D) Sodium diethylenetriaminepentaacetate			
	(E) Sodium tripolyphosphate			
20	Test fabrics are washed with these treatment solutions in wash water of 98°F (36.7°C) and rinsed in water at 70°F (21.1°C). Water hardness is 12 grains/gallon. Clean white cotton terry cloths are added as ballast fabrics to realize a test fabric weight of 300 grams per treatment. All fabrics are subsequently dried in mini-dryers.			
25	Three replicates of each such treatment are conducted. A balanced complete block paired comparison test design provides for the fabrics representing each stain type for a given treatment to be viewed relative to the other treatments. Stain removal is graded by expert graders. Each grader provides numerical cleaning difference grades on a nine point scale (-4 through +4) for each comparison.			
30				

Treatment means are calculated and are listed in the table hereinafter after normalization of the means based on a zero value for treatment number one (TMS/TDS alone).

		<u>Panel Score Units</u>					
		<u>Treatment No.</u>					
	<u>Soils</u>	<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>	<u>LSD^A</u>
	Clay on Cotton	0.0	1.7*	1.6*	-0.1	1.4	1.52
5	Clay on Poly-cotton	0.0	2.6*	2.6*	0.2	1.4*	1.03
	Grass on Poly-cotton	0.0	0.7	0.6	0.1	0.5	1.36
	Tea on Poly-cotton	0.0	0.6	1.0*	0.8	0.9*	0.92
	Spaghetti Sauce on Poly-cotton	0.0	0.4	0.3	-0.4	-1.4*	1.03
10	Bacon Grease on Cotton	0.0	-0.2	-0.0	0.2	-1.1*	0.48
	Animal Blood on Cotton	0.0	1.2*	1.5*	0.6*	1.0*	0.55
	Poly-cotton Anti-redeposition Swatch	0.0	3.9*	4.3*	0.2	1.9*	0.81
	Cotton Anti-redeposition Swatch	0.0	1.2	1.2	0.3	-0.8	1.38
15	Facial Soil on Poly-cotton	0.0	0.7*	0.7*	0.1	-0.3	0.49

(A) Least significant difference at 95% confidence level

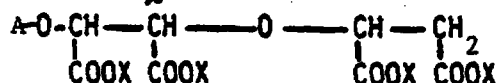
* Indicates value is significantly different than Treatment 1, a plus value indicating improved stain removal.



CLAIMS

1. A detergent builder composition especially useful in phosphorus-free detergent or laundry additive products, said composition comprising:

- 5 (A) from 70% to 99% by weight of an ether carboxylate sequestering agent/constituted by compound(s) having the formula:

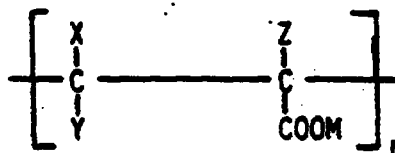


wherein A is H or $\begin{array}{c} \text{---CH---CH}_2 \\ | \quad | \\ \text{COOX COOX} \end{array}$; and

X is H or a water-soluble salt-forming cation; and

- (B) from 1% to 30% by weight of a dispersing/anti-redeposition agent selected from the group consisting of:

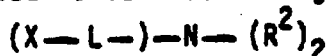
- i) polycarboxylates which are polymers or copolymers which contain at least 60% by weight of segments having the general formula:



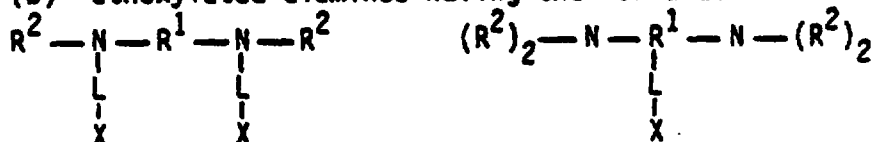
wherein X, Y and Z are, independently, selected from hydrogen, methyl, carboxy, carboxymethyl, hydroxy and hydroxymethyl; M is H or a salt-forming cation and n ranges from 30 to 400;

- ii) ethoxylated amine material selected from the group consisting of

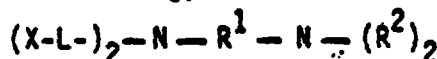
- (a) ethoxylated monoamines having the formula:



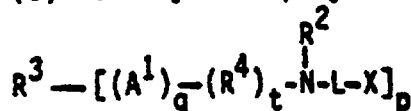
- (b) ethoxylated diamines having the formula:



or

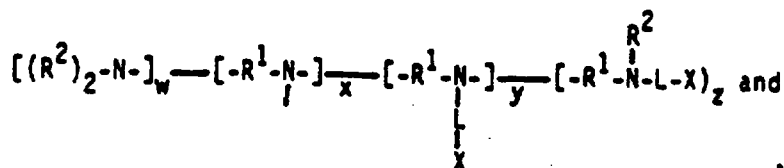


- (c) ethoxylated polyamines having the formula:



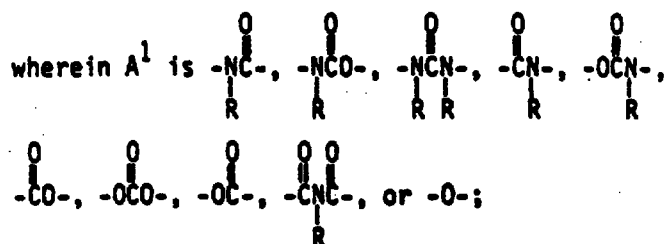


(d) ethoxylated amine polymers having the general formula:



wherein $[-R^1-N-]$ represents ~~branched-chain~~ tertiary amine; and

(e) mixtures of such ethoxylated amines;



R is H or C_1-C_4 alkyl or hydroxyalkyl; R^1 is C_2-C_{12} alkylene, hydroxyalkylene, alkenylene, 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, the moiety $-L-X$, or two R^2 together form the moiety $-(CH_2)_r-A^2-(CH_2)_s-$, wherein A^2 is $-O-$ or $-CH_2-$, r is 1 or 2, s is 1 or 2, and $r + s$ is 3 or 4; X is H, a nonionic group, an anionic group or mixture thereof; R^3 is a substituted C_3-C_{12} alkyl, hydroxyalkyl, alkenyl, aryl, or alkaryl group having p substitution sites; R^4 is C_1-C_{12} alkylene, hydroxyalkylene, alkenylene, 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; L is a hydrophilic chain which contains the polyoxyalkylene moiety $-[(R^5O)_m(CH_2CH_2O)_n]-$, wherein R^5 is C_3-C_4 alkylene or hydroxyalkylene and m and n are numbers such that the moiety $-(CH_2CH_2O)_n-$ comprises at least 50% by weight of said polyoxyalkylene moiety; for said monoamines, m is from 0 to 4, and n is at least 12; for said diamines, m is from 0 to 3, and n is at



75 least 6 when R^1 is C_2-C_3 alkylene, hydroxyalkylene, or alkenylene, and at least 3 when R^1 is other than C_2-C_3 alkylene, hydroxyalkylene or alkenylene; for said polyamines and amine polymers, m is from 0 to 10 and n is at least 3; p is from 3 to 8; q is 1 or 0; t is 1 or 0, provided that t is 1 when q is 1; w is 1 or 0; x is 0 or an integer; and y + z is at least 2; and

80 iii) combinations of said polycarboxylate and ethoxylated amine dispersing/anti-redeposition agents;

the weight ratio of sequestering agent to dispersing/anti-redeposition agent within said composition being within the range of from 70:30 to 99:1.

2. A builder composition according to Claim 1 wherein

(A) the ether carboxylate sequestering agent comprises from 80% to 95% by weight of the composition;

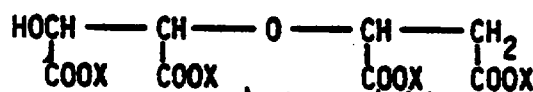
5 (B) the dispersing/anti-redeposition agent comprises from 5% to 20% by weight of the composition; and

(C) the weight ratio of sequestering agent to dispersing/anti-redeposition agent in the composition ranges from 80:20 to 95:5.

3. A builder composition according to Claim 1 or Claim 2 wherein

(A) the ether carboxylate sequestering agent is selected from

5 i) tartrate monosuccinic acid, or water-soluble salt thereof, of the structure;



wherein X is H or a ^{water-soluble} salt-forming cation;

10 ii) tartrate disuccinic acid, or ^{water-soluble} salt thereof, of the structure:

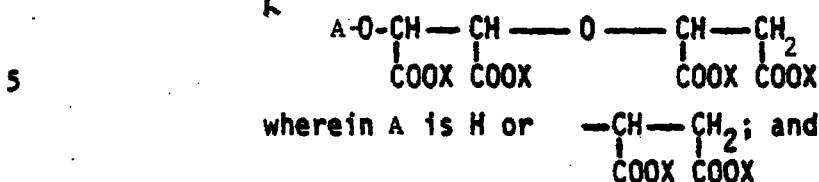


water-soluble

- wherein X is H or a salt-forming cation, or
- 15 iii) a combination of said tartrate monosuccinic acid or salt and said tartrate disuccinic acid or salt, in a weight ratio of tartrate monosuccinic acid or salt, to tartrate disuccinic acid or salt, of from 97:3 to 20:80; and
- 20 (B) the dispersing/anti-redeposition agent is selected from
- i) water-soluble salts of polyacrylic acid;
- ii) ethoxylated amine polymers; and
- iii) combinations of said polyacrylic acid salts and said ethoxylated amine polymers in a weight ratio
- 25 of polyacrylic acid salt to ethoxylated amine polymer of from 5:1 to 1:5.

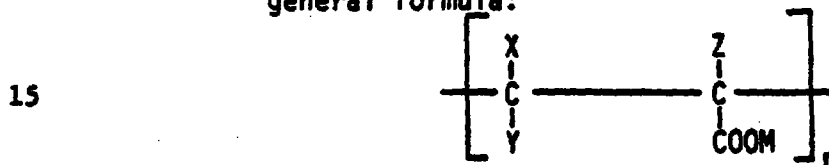
4. A detergent or laundry additive composition comprising:

- (A) from 5% to 50% by weight of an ether carboxylate sequestering agent, *constituted by compounds* having the formula:



X is H or a water-soluble salt-forming cation; and

- (B) from 0.2% to 5% by weight of a dispersing/anti-redeposition agent selected from the group consisting of:
- 10 i) polycarboxylates which are polymers or copolymers which contain at least 60% by weight of segments having the general formula:



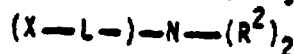
wherein X, Y and Z are, independently, selected from hydrogen, methyl, carboxy, carboxymethyl, hydroxy and hydroxymethyl; M is H or a salt-forming cation and n ranges from 30 to 400;

- 20 ii) ethoxylated amine materials selected from the group consisting of



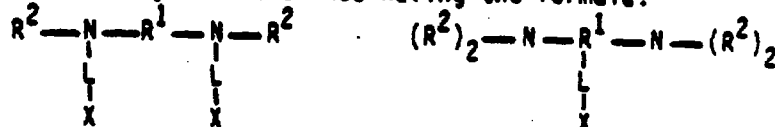
-45-

(a) ethoxylated monoamines having the formula:



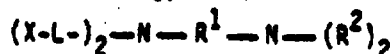
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(b) ethoxylated diamines having the formula:

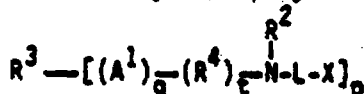


or

30

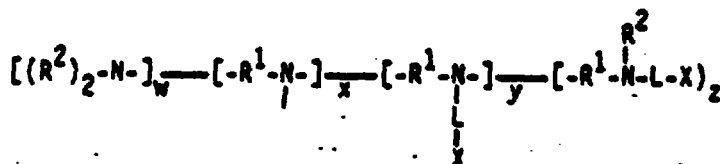


(c) ethoxylated polyamines having the formula:



35

(d) ethoxylated amine polymers having the general formula:

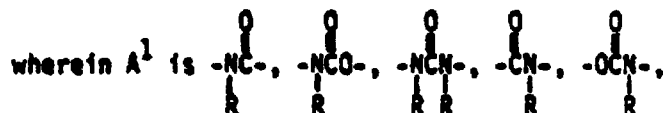


radical

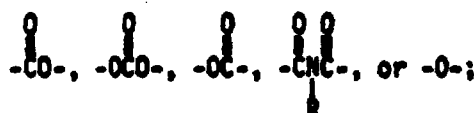
wherein $[-R^1-N-]$ represents branched chain tertiary amine; and

40

(e) mixtures of such ethoxylated amines;



45



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R is H or C₁-C₄ alkyl or hydroxyalkyl; R¹ is C₂-C₁₂ alkylene, hydroxyalkylene, alkenylene, arylene or alkarylene, or a C₂-C₃ oxyalkylene moiety having from 2 to 20 oxyalkylene units provided that no O-N bonds are formed; each R² is C₁-C₄ alkyl or hydroxyalkyl, the moiety -L-X, or two R² together form the moiety -(CH₂)_r-A²-(CH₂)_s-, wherein A² is -O- or -CH₂-, r is 1 or 2, s is 1 or 2, and r + s is 3 or 4; X is H, a nonionic group, an anionic group or mixture thereof; R³ is a substituted C₃-C₁₂ alkyl, hydroxyalkyl, alkenyl, aryl, or alkaryl group having p substitution sites; R⁴ is C₁-C₁₂

55



alkylene, hydroxyalkylene, alkenylene, arylene or
60 alkarylene, or a C_2-C_3 oxyalkylene moiety ^{having} ~~have~~ from
2 to 20 oxyalkylene units provided that no O-O or
O-N bonds are formed; L is a hydrophilic chain
which contains the polyoxyalkylene moiety
65 $-(R^5O)_m(CH_2CH_2O)_n-$, wherein R^5 is C_3-C_4 alkylene
or hydroxyalkylene and m and n are numbers such
that the moiety $-(CH_2CH_2O)_n-$ comprises at least 50%
by weight of said polyoxyalkylene moiety; for said
monoamines, m is from 0 to 4, and n is at least 12;
70 for said diamines, m is from 0 to 3, and n is at
least 6 when R^1 is C_2-C_3 alkylene, hydroxyalkylene,
or alkenylene, and at least 3 when R^1 is other than
 C_2-C_3 alkylene, hydroxyalkylene or alkenylene; for
said polyamines and amine polymers, m is from 0 to
10 and n is at least 3; p is from 3 to 8; q is 1 or
75 0; t is 1 or 0, provided that t is 1 when q is 1; w
is 1 or 0; x is 0 or an integer and y + z is at
least 2; and

iii) combinations of said polycarboxylate and ethoxylated
amine dispersing/anti-redeposition agents;
80 the weight ratio of sequestering agent to dispers-
ing/anti-redeposition agent within said composition
being within the range of from 99:1 to 70:30; and

(C) from 5% to 95% by weight of a an additional component se-
lected from the group consisting of surfactants, additional
85 detergent builders, chelating agents, enzymes, fabric whiteners
and brighteners, sudsing control agents, solvents, hydrotropes,
bleaching agents, bleach precursors, buffering agents, additional
soil removal/anti-redeposition agents, soil release agents, fabric
softening agents, perfumes, colourants, opacifiers and combinations
90 of said additional components.

5. A detergent or laundry additive composition according to
Claim 4 wherein

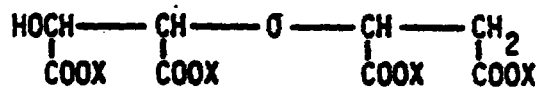


- (A) the ether carboxylate sequestering agent comprises from 10% to 30% by weight of the composition;
- 5 (B) the dispersing/anti-redeposition agent comprises from 0.5% to 3% by weight of the composition;
- (C) the weight ratio of sequestering agent to dispersing/anti-redeposition agent in the composition ranges from 80:20 to 95:5; and
- 10 (D) the additional component is a surfactant which comprises from 10% to 30% by weight of the composition.

6. A detergent or laundry additive composition according to Claim 4 or Claim 5 wherein

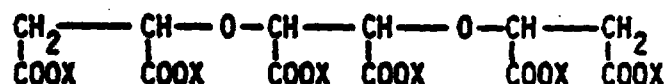
- (A) the ether carboxylate sequestering agent is selected from

- 5 i) tartrate monosuccinic acid, or water-soluble salt thereof, of the structure;



wherein X is H or a water-soluble salt-forming cation;

- 10 ii) tartrate disuccinic acid, or water-soluble salt thereof, of the structure:



wherein X is H or a water-soluble salt-forming cation; or

- 15 iii) a combination of said tartrate monosuccinic acid or salt and said tartrate disuccinic acid or salt, in a weight ratio of tartrate monosuccinic acid or salt, to tartrate disuccinic acid or salt, of from 97:3 to 20:80; and

- 20 (B) the dispersing/anti-redeposition agent is selected from
- i) water-soluble salts of polyacrylic acid;
- ii) ethoxylated amine polymers; and
- iii) combinations of said polyacrylic acid salts and said ethoxylated amine polymers in a weight ratio
- 25 of polyacrylic acid salt to ethoxylated amine polymer of from 5:1 to 1:5.



7. A detergent composition or laundry additive according to Claims 4 to 6 wherein the ethoxylated amine polymer component is selected from

- 5
- (A) an ethoxylated polyethyleneamine having a molecular weight of from 140 to 310 prior to ethoxylation; and
 - (B) an ethoxylated polyethyleneimine having a molecular weight of from 600 to 1800 prior to ethoxylation.

8. A detergent composition according to any of Claim 4 to 7 wherein the dispersing/anti-redeposition agent comprises a water-soluble salt of poly acrylic acid having a molecular weight (acid form) of from 4,000 to 10,000.

5

9. A detergent composition according to Claim 4 which comprises

- 5
- (A) from 5% to 40% by weight of a surfactant;
 - (B) from 5% to 50% by weight of an ether carboxylate sequestering agent which is a combination of sodium tartrate monosuccinate and sodium tartrate disuccinate in a weight ratio of the monosuccinate to the disuccinate of from 97:3 to 20:80; and
 - (C) from 0.2% to 5% by weight of a dispersing/anti-redeposition agent selected from
 - 10- i) a water-soluble salt of poly acrylic acid having a molecular weight (acid form) of from 4,000 to 10,000;
 - 15 ii) ethoxylated polyethyleneamines having a molecular weight of from 100 to 400 prior to ethoxylation and a degree of ethoxylation of at least 3; and
 - 20 iii) combinations of said polyacrylate and said ethoxylated polyethyleneamine in a weight ratio of from 5:1 to 1:5; the weight ratio of sequestering agent to dispersing/anti-redeposition agent in said composition ranging from 99:1 to 70:30.



5 10. A detergent composition according to any of Claims 4 to 9 wherein the dispersing/anti-redeposition agent is a combination of sodium polyacrylate and an ethoxylated polyethyleneamine having a molecular weight of from 140 to 200 prior to ethoxylation and a degree of ethoxylation of from 12 to 42.

5 11. A detergent composition according to any of Claims 4 to 10 which additionally contains from 0.1% to 10% by weight of a chelating agent selected from amino carboxylates, amino phosphonates, poly-functionally substituted aromatic chelating agents and combinations of these materials.

12. A detergent composition according to Claim 11 wherein the chelating agent is a diethylenetriaminepentaacetate.

DKD/jmc

(CAS:3358R2Z)
