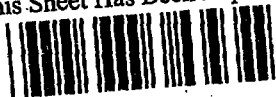
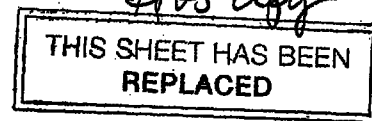


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HOECHST AKTIENGESELLSCHAFT HOE 93/F 0024

Dr.KD/do

Description

5 Terpolymers based on α,β -unsaturated dicarboxylic anhydrides, α,β -unsaturated compounds and polyoxyalkylene ethers of lower unsaturated alcohols.

10 Mineral oils and mineral oil distillates, such as diesel fuel or heating oil, generally contain a proportion of dissolved n-paraffins which crystallize out on lowering of the temperature and can thereby lead to a deterioration of the flow properties of these oils or distillates. During transport of mineral oils through pipelines, this can lead to deposits on the wall and in particular cases (for example, while a pipeline is shut down) even lead to complete blockage of the pipeline.

15 Precipitation of paraffins can also lead to complications during the storage and further processing of the mineral oils. In the case of mineral oil distillates, the crystallization can result in blockage of the filters in diesel engines and furnaces.

20 Apart from the classical methods of overcoming these paraffin problems (thermally, mechanically or by means of solvents), which only relate to the removal of the precipitates already formed, recent years have seen the development of a number of chemical additives (paraffin

25 inhibitors) which, by means of physical interaction with the precipitating paraffin crystals, lead to a modification of the shape, size and adhesion properties of the crystals. Here the additives act as additional crystal nuclei and partly crystallize out with the paraffins;

30 part of their action is also explained by dispersion of the crystals. The modified crystals have less tendency to form deposits, are also smaller and possess an altered crystal form. Oils mixed with additives can still be pumped or processed at temperatures which are often more

35 than 20°C lower than for oils not containing additives.



Some copolymers based on maleic anhydride and α,β -unsaturated compounds are known as paraffin inhibitors for crude oils and mineral oil distillates.

5 EP-B-0 154 177 describes reaction products of copolymers based on maleic anhydride and α,β -unsaturated compounds with primary monoalkylamines and/or aliphatic alcohols. These copolymers are particularly suitable as paraffin inhibitors for paraffin-containing petroleum products, for example crude oils and distillation residues from
10 petroleum refining.

EP-A-0 436 151 discloses reaction products of copolymers based on maleic anhydride and α,β -unsaturated compounds such as styrene with dialkylamines. These copolymers are added to petroleum middle distillates in amounts of from
15 50 to 1000 ppm, preferably from 100 to 500 ppm. Such petroleum middle distillates generally already contain flow improvers such as ethylene-vinyl ester copolymers.

EP-A-0 283 293 discloses copolymers derived from the polymerization of an aliphatic olefin with maleic an-
20 hydride, where the copolymer must contain both an ester group and also an amide group, each of which contains an alkyl group having at least 10 carbon atoms, and also copolymers from the reaction of a secondary amine with a polymer containing anhydride groups, where equal amounts
25 of amides and amine salts are produced from the anhydride groups.

The as yet unpublished German Patent Application P 41 23 795.1 relates to copolymers of ethylenically unsaturated carboxylic esters with polyoxyalkylene ethers
30 of lower unsaturated alcohols and also to their use in paraffin-containing oils, such as crude oils, residual oils and oil distillates.

However, the paraffin-inhibiting activity of the known paraffin inhibitors is inadequate, in particular in



middle distillates, so that cooling can result in the formation of paraffin crystals, some large, which form a sediment because of their relatively high density and can lead to a paraffin-rich layer at the bottom and a
5 paraffin-depleted upper layer.

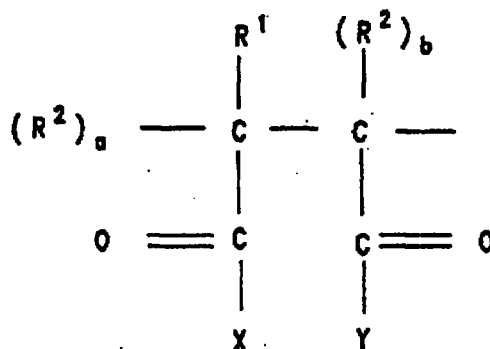
It has now been found that, despite the known difficulties in using allyl compounds as monomers (H.-G. Elias, Makromoleküle [Macromolecules], 4th edition (1981), pp. 571, 581, 585), it is likewise possible to use
10 terpoly-meres based on α,β -unsaturated dicarboxylic anhydrides, α,β -unsaturated compounds and polyoxyalkylene ethers of lower unsaturated alcohols.

It has likewise been found that addition of alcohol/amine-modified terpolymers based on α,β -unsaturated dicarboxylic anhydrides, α,β -unsaturated compounds
15 and polyoxyalkylene ethers of lower unsaturated alcohols, if desired in admixture with known paraffin inhibitors, preferably copolymers based on ethylene and vinyl acetate, results in the paraffin crystals which precipi-
20 tate on cooling remaining dispersed. As a result of this uniform dispersion, a homogeneously turbid phase is obtained in which the CFPP (cold filter plugging point) value, which is critical for operability, of the upper and lower phases is approximately the same.

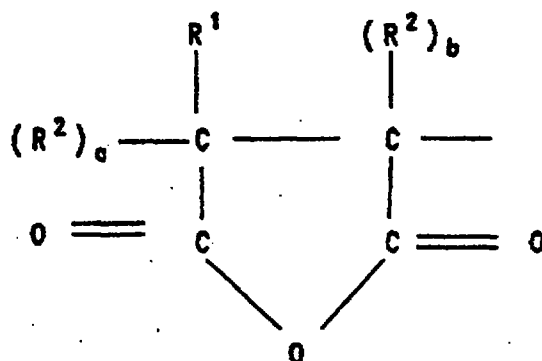
25 The invention provides terpolymers based on α,β -unsaturated dicarboxylic anhydrides, α,β -unsaturated compounds and polyoxyalkylene ethers of lower unsaturated alcohols, which comprise
20-80 mol %, preferably 40-60 mol %, of bivalent structural units A, B and/or C.
30



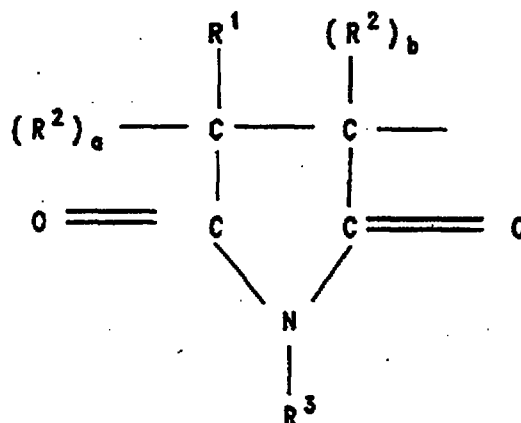
(A)



(B)



(C)



where

R^1 and R^2 are, independently of one another, hydrogen or methyl,

a and b are equals zero or one and $a + b$ is one,

5 X and Y are identical or different and are the $-N-HR^3$, group

where R^3 is C_6-C_{40} -alkyl, C_5-C_{20} -cycloalkyl or C_6-C_{18} -aryl, the $-N-(R^3)_2$, group

where R^3 is identical or different and is as defined



above,

and/or

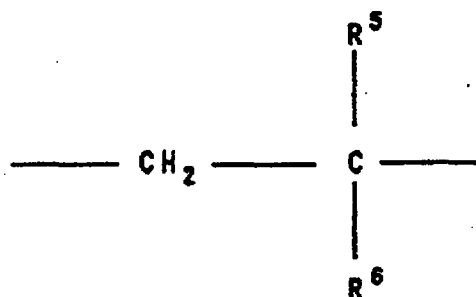
the $-O-R^4$, group

where R^4 is hydrogen, a cation of the formula $H_3N^+(R^3)_2$, or

- 5 $H_3N^+R^3$, C_6-C_{40} -alkyl, C_5-C_{20} -cycloalkyl or C_6-C_{18} -aryl, preferably phenyl,

19-80 mol %, preferably 39-60 mol %, of bivalent structural units D

(D)



in which

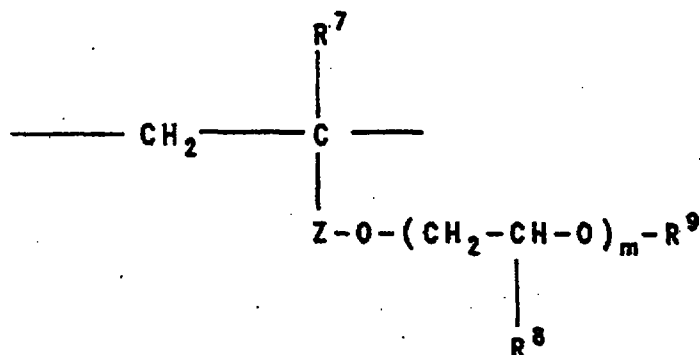
- 10 R^5 is hydrogen or C_1-C_4 -alkyl and

R^6 is C_6-C_{60} -alkyl or C_6-C_{18} -aryl,

and

1-30 mol %, preferably 1-20 mol %, of bivalent structural units E

(E)



- 15 in which

R^7 is hydrogen or methyl,

R^8 is hydrogen or C_1-C_4 -alkyl,

Z is C_1-C_4 -alkylene,



m is a number from 1 to 100,

R^9 is C_1-C_{24} -alkyl, C_5-C_{20} -cylcoalkyl, C_6-C_{18} -aryl or $-C(O)-R^{10}$, where

R^{10} is C_1-C_{40} -alkyl, C_5-C_{10} -cycloalkyl or C_6-C_{18} -aryl.

- 5 The abovementioned alkyl, cylcoalkyl and aryl radicals may be unsubstituted or substituted. Suitable substituents of the alkyl and aryl radicals are, for example, (C_1-C_6) -alkyl, halogens such as fluorine, chlorine, bromine and iodine, preferably chlorine, and (C_1-C_6) -alkoxy.
- 10

Alkyl (R^3 , R^4) is, according to the invention, generally a straight-chain or branched hydrocarbon radical having 6-40, preferably 10-24, carbon atoms. Individual mention may be made of: n-hexyl, n-octyl, decyl, dodecyl, tetradecyl, hexadecyl, octadecyl, dodecenyl, tetrapropenyl, tetradecenyl, pentapropenyl, hexadecenyl, octadecenyl and eicosyl or mixtures such as coconut alkyl, tallow alkyl and behenyl.

15

Cylcoalkyl (R^3 , R^4 , R^9 and R^{10}) is, according to the invention, generally a cyclic aliphatic radical having 5-20 carbon atoms. Preferred cycloalkyl radicals are cyclopentyl and cyclohexyl.

20

The terpolymers of the invention comprise the bivalent structural units A, B, and/or C and also D and E. They additionally contain only, in a manner known per se, the terminal groups formed during the polymerization by initiation, inhibition and chain termination.

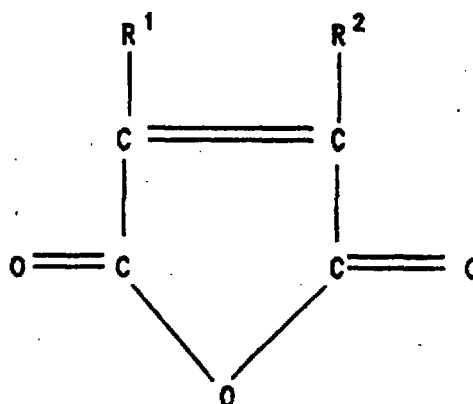
25

In detail, the structural units A, B and C are derived from α,β -unsaturated dicarboxylic anhydrides of the formula F and/or G

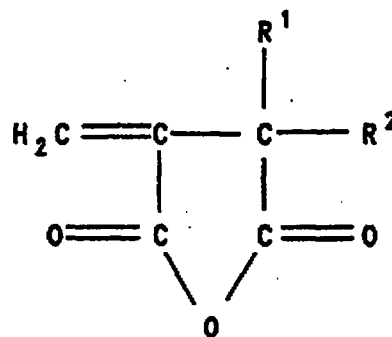
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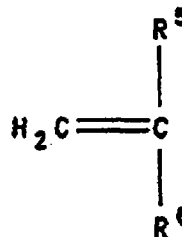
(G)



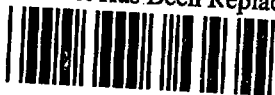
such as maleic anhydride, itaconic anhydride and citraconic anhydride, preferably maleic anhydride.

The structural units D are derived from the α,β -unsaturated compounds of the formula H.

(H)



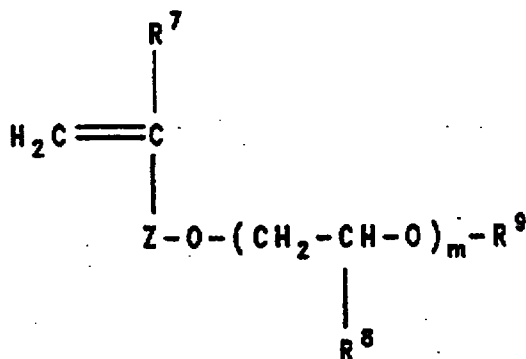
- 5 Examples which may be mentioned are the following α,β -unsaturated compounds: styrene, α -methylstyrene, dimethylstyrene, α -ethylstyrene, diethylstyrene, i-propylstyrene, tert-butylstyrene, diisobutylene and



5 α -olefins such as decene, dodecene, tetradecene, pentadecene, hexadecene, octadecene, C_{20} - α -olefin, C_{24} - α -olefin, C_{30} - α -olefin, tripropenyl, tetrapropenyl, pentapropenyl and mixtures thereof. Preference is given to α -olefins having from 10 to 24 carbon atoms and styrene, particularly preference being given to α -olefins having from 12 to 20 carbon atoms.

10 The structural units E are derived from the polyoxyalkylene ethers of lower unsaturated alcohols of the formula J.

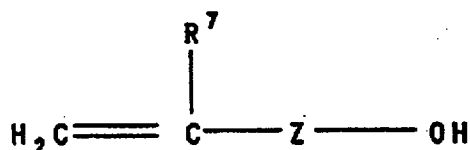
(J)



The monomers of the formula J are etherification products ($R^9 = -C(O)R^{10}$) or esterification products ($R^9 = -C(O)R^{10}$) of polyoxyalkylene ethers ($R^9 = H$).

15 The polyoxyalkylene ethers ($R^9 = H$) can be prepared by known processes by the addition reaction of α -olefin oxides, such as ethylene oxide, propylene oxide and/or butylene oxide, with polymerizable lower unsaturated alcohols of the formula K

(K)



20 Such polymerizable lower unsaturated alcohols are, for example, allyl alcohol, methylallyl alcohol, butenols such as but-3-en-1-ol and but-1-en-3-ol, or methyl-



butenols such as 2-methylbut-3-en-1-ol, 2-methylbut-3-en-2-ol and 3-methylbut-3-en-1-ol. Preference is given to addition products of ethylene oxide and/or propylene oxide with allyl alcohol.

- 5 Subsequent etherification of these polyoxyalkylene ethers to form compounds of the formula J where $R^9 = C_1$ to C_{24} -alkyl, cycloalkyl or aryl is carried out by processes known per se. Suitable processes are known, for example, from J. March, Advanced Organic Chemistry, 2nd Edition, p. 357 ff. (1977).
- 10

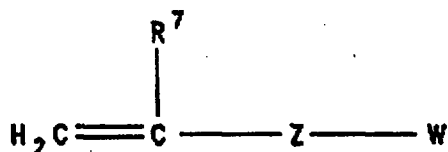
These etherification products of the polyoxyalkylene ethers can also be prepared by the addition reaction of α -olefin oxides, preferably ethylene oxide, propylene oxide and/or butylene oxide, with alcohols of the formula

15 L



in which R^9 is C_1 - C_{24} -alkyl, C_5 - C_{20} -cycloalkyl or C_6 - C_{18} -aryl, by known processes and reaction with polymerizable lower unsaturated halides of the formula M

(M)



- 20 where W is a halogen atom and R^7 and Z are as defined above. Preferred halides are the chlorides and bromides. Suitable methods of preparation are given, for example, in J. March, Advanced Organic Chemistry, 2nd Edition, p. 357 ff. (1977).

- 25 The esterification of the polyoxyalkylene ethers ($R^9 = -C(O)-R^{10}$) is carried out by reaction with common esterifying agents such as carboxylic halides, carboxylic



anhydrides or carboxylic esters with C_1 - C_4 -alcohols. Preference is given to using the halides and anhydrides of C_1 - C_{40} -alkyl-, C_5 - C_{10} -cylcoalkyl- or C_6 - C_{18} -arylcarboxylic acids. The esterification is generally carried out at
5 temperatures of from 0 to 200°C, preferably from 10 to 100°C. The carboxylic acid derivative is generally used in a stoichiometric amount based on the alcohol group of the polyoxyalkylene ether. However, it is possible to add the acid component in excess, for example in an excess
10 from 20 to 100%, and also in a substoichiometric amount. The esterification is expediently carried out in a solvent. Suitable solvents are, for example, aromatic hydrocarbons, for example alkylaromatics such as toluene, xylene, trimethylbenzenes, dimethylethylbenzenes,
15 dimethylnaphthalene, and mixtures of aromatics.

For the monomers of formula J, the index m gives the degree of alkoxylation, i.e. the number of moles of α -olefin oxide adducted per mole of the formula K or L.

The structural unit A contains the groups $-NHR^3$, $-N(R^3)_2$,
20 and/or $-OR^4$, which are derived from primary amines of the formula (N) NH_2R^3 , the secondary amines of the formula (P) and the alcohols of the formula (Q) $HO-R^4$.

Examples which may be mentioned of primary amines are:
n-hexylamine, n-octylamine, n-tetradecylamine, n-hexadecyl-
25 amine, n-stearylamine and N,N-dimethylaminopropylenediamine, cyclohexylamine, dehydroabietylamine and mixtures thereof.

Examples which may be mentioned of secondary amines are:
didecylamine, ditetradecylamine, distearylamine,
dicoconut fatty amine and ditallow fatty amine, and
30 mixtures thereof.

In the context of the invention, relatively short and/or long-chain alcohols (C_6 - C_{40}) of the formula



are used.



Alcohols of this type are known per se. Examples which may be mentioned are n-butanol, n-hexanol, n-octanol, n-dodecanol and, as relatively long-chain alcohols, stearyl alcohol, behenyl alcohol or the alcohols known as [®]Alfols (Condea) which have a hydrocarbon-chain length of up to 40 carbon atoms.

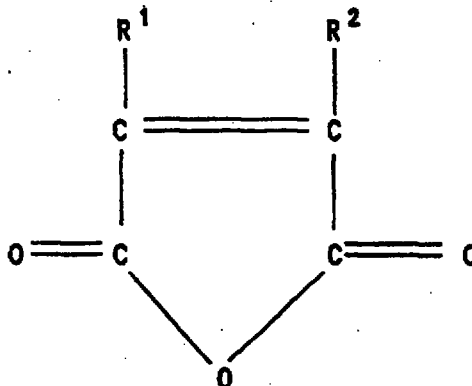
According to the invention, a cation (R^4) is an ammonium cation of the formula $H_2N^+(R^3)_2$ or $H_3N^+R^3$.

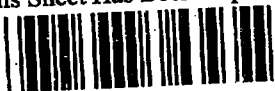
The terpolymers of the invention possess K values (measured by the method of Ubbelohde in 5% strength by weight solution in toluene at 25°C) of from 8 to 100, preferably from 8 to 50, corresponding to average molecular weights ($\bar{M}_w$) of between about 500 and 100,000.

The proportion of the individual bivalent structural units A to E in the terpolymers of the invention is essentially determined by the mixing ratios of the reactants used.

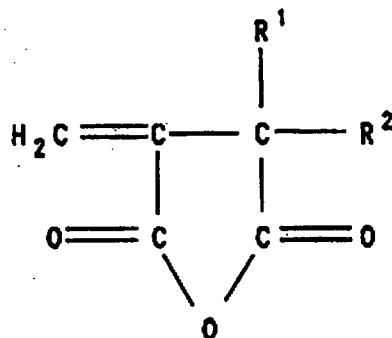
The invention also provides a process for preparing the terpolymers of the invention based on α, β -unsaturated dicarboxylic anhydrides, α, β -unsaturated compounds and polyoxyalkylene ethers of lower unsaturated alcohols, which comprises first polymerizing with one other monomers of the formula F and/or G

(F)



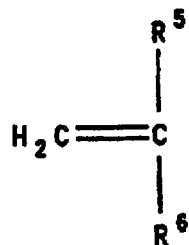


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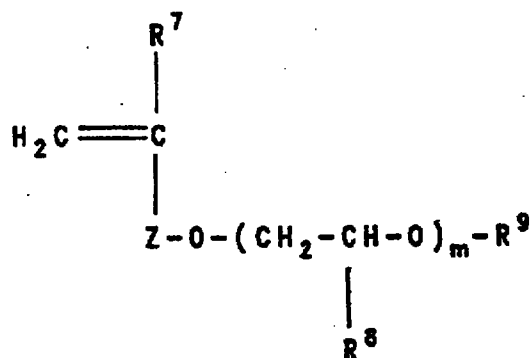
where R^1 and R^2 are, independently of one another, hydrogen or methyl,
monomers of the formula H

(H)



where R^5 is hydrogen or $\text{C}_1\text{-C}_4$ -alkyl and R^6 is $\text{C}_6\text{-C}_{60}$ -alkyl
5 or $\text{C}_6\text{-C}_{18}$ -aryl,
and monomers of the formula J

(J)



in which

R^7 is hydrogen or methyl,

R^8 is hydrogen or $\text{C}_1\text{-C}_4$ -alkyl,

10 Z is $\text{C}_1\text{-C}_4$ -alkylene,

m is a number from 1 to 100,

R^9 is $\text{C}_1\text{-C}_{24}$ -alkyl, $\text{C}_5\text{-C}_{20}$ -cycloalkyl, $\text{C}_6\text{-C}_{18}$ -aryl or



$-C(O)-R^{10}$, where

R^{10} is C_1-C_{40} -alkyl, C_5-C_{20} -cycloalkyl or C_6-C_{18} -aryl,

and subsequently reacting the product with primary and/or secondary amines of the formulae

5 (N) $-N-HR^3$,

(P) $-N-(R^3)_2$,

where R^3 is C_6-C_{40} -alkyl, C_5-C_{20} -cycloalkyl or C_6-C_{18} -aryl, and/or alcohols of the formula

(Q) $HO-R^4$,

10 where R^4 is hydrogen, a cation of the formula $H_2N^+(R^3)_2$ or $H_3N^+R^3$, C_6-C_{40} -alkyl, C_5-C_{20} -cycloalkyl or C_6-C_{18} -aryl, preferably phenyl.

The polymerization is carried out using known batch or continuous polymerization processes, such as bulk,
15 suspension, precipitation or solution polymerization, and initiation by suitable free-radical initiators, for example hydroperoxides, peroxides or azo compounds, such as dilauroyl peroxide, dibenzoyl peroxide, t-butyl
20 perpivalate, t-butyl permaleate, t-butyl perbenzoate, dicumyl peroxide, t-butyl cumyl peroxide, di-t-butyl peroxide, cumene hydroperoxide, t-butyl hydroperoxide, 2,2'-azo-bis(2-methylpropanonitril), 2,2'-azobis(2-methylbutyronitril) and mixtures of these. These initiators are generally used in amounts of from 0.1 to 20% by
25 weight, preferably from 0.2 to 10% by weight, based on the monomers.

The molar ratios between the α,β -unsaturated dicarboxylic anhydrides, α,β -unsaturated compounds and polyoxyalkylene ethers of lower unsaturated alcohols are between 1 :
30 0.5 - 2 : 0.01 - 0.5, preferably 1 : 0.9 - 1.1 : 0.04 - 0.2.

The polymerization is generally carried out at temperatures of 40-400°C, preferably 80-250°C, and when α,β -unsaturated compounds or solvents having boiling points
35 below the polymerization temperature are used, it is expediently carried out under pressure. The



polymerization is expediently carried out with the exclusion of air, for example under nitrogen, since oxygen interferes with the polymerization. When selecting the initiator or the initiator system it is expedient to ensure that the half-life of the initiator or the initiator system is less than 3 hours at the selected polymerization temperature.

To obtain low-molecular-weight copolymers it is frequently expedient to carry out the polymerization in the presence of regulators known per se. Suitable regulators are, for example, organic mercapto compounds, such as 2-mercaptoethanol, 2-mercaptopropanol, mercaptoacetic acid, mercaptopropionic acid, tert-butyl mercaptan, n-butyl mercaptan, n-octyl mercaptan, n-dodecyl mercaptan and tert-dodecyl mercaptan, which are generally used in amounts of from 0.1% by weight to 10% by weight.

Suitable apparatuses for the polymerization are, for example, conventional stirred reactors with, for example, anchor, blade, impeller or multistage-impulse counter-current stirrer, and for continuous production, cascades of stirred reactors or static mixers.

A preferred process for preparing the terpolymers of the invention is solution polymerization. It is carried out in solvents in which the monomers and terpolymers formed are soluble. Suitable solvents are all those which fulfil this requirement and do not undergo reaction with the monomers or with the terpolymers formed. For example, these are organic, preferably aromatic, solvents such as cumene, toluene, xylene, ethylbenzene or commercial solvent mixtures such as [®]Solvent Naphtha, [®]Shellsol AB or [®]Solvesso 150, 200, 250.

In the preparation, all the monomers can be initially charged and polymerized by addition of a free-radical initiator and application of heat. However, the solvent and a proportion of the monomers (for example about 5-20%) is



expediently charged initially and the remainder of the monomer mixture metered in with the initiator and any coinitiator and regulator used. Preferably, the solvent and α, β -unsaturated compounds of the formula H, particularly C_4 - C_{60} - α -olefins, are initially charged into the polymerization reactor and after the polymerization temperature has been attained the acid anhydride group-containing monomer of the formula F and/or G and also the monomer of the formula J, both dissolved in solvent if desired, and the initiator and also any coinitiator and regulator used are metered in.

The concentration of the monomers to be polymerized is between 20 and 95% by weight, preferably between 50 and 90% by weight.

The solid terpolymer can be isolated by precipitation with suitable non-solvents, such as acetone or methanol, or by evaporation of the solvent. However, it is expedient to select for the polymerization a solvent in which the further reaction with amines and/or alcohols can be carried out. Generally it is an advantage to use the anhydrides of the dicarboxylic acids instead of the free acids for the polymerization, since these react better with olefins and can subsequently be reacted selectively with amines and/or alcohols. The use of the corresponding dicarboxylic acids, is, however, not excluded.

After the polymerization, the reaction with amines of the formula N or P and/or alcohols of the formula Q is carried out.

The reaction of the terpolymers with the primary and/or secondary amines is carried out at temperatures between 30 and 250°C over a period of from 0.5 to 20 hours. The primary and/or secondary amine, preferably fatty amine, is used in amounts from about 1 to 2 mol per mol of copolymerized dicarboxylic anhydride, i.e. about 0.9-2.5



mol per mol. The use of larger or smaller amounts is possible, but gives no advantage.

5 If 2 mol of a secondary amine are used, amide-ammonium salts are obtained at low reaction temperatures (30-120°C). The formation of a second amide group requires temperatures above 120°C, longer residence times and removal of water. If amounts of less than 1 mol are used, complete conversion to the monoamide does not take place. The selection of the reaction conditions/derivative
10 depends on the application.

In the reaction of the terpolymers with primary and/or secondary amines N or P and/or alcohols of the formula Q, the reaction of the terpolymers with the alcohol to give the mono- or diester is expediently carried out first.
15 The degree of reaction of the anhydride groups with the alcohols is generally between 60 and 95 mol %. The entire amount or a proportion of the partially esterified terpolymers are then reacted with the primary and/or secondary amines to give amides, ammonium salts, diamides
20 and/or cyclic imides.

Most expediently, the preparation of the terpolymers of the invention proceeds by first carrying out the reaction with the alcohols of the formula Q in solution, suspension or melt to give the mono- or diesters. To
25 accelerate the di-esterification, which proceeds with elimination of water, catalysts, generally acids such as sulphuric acid or p-toluenesulphonic acid, may be added. To remove the water of reaction, the reaction is preferably carried out either in suspension or solution
30 using a water-immiscible solvent, such as toluene or xylene, and the water of reaction is distilled off azeotropically. If the terpolymer to be reacted is insoluble in the solvent at the beginning of the reaction, it dissolves with increasing degree of esterification so at the end of the reaction a clear solution is
35 formed.



The preferred temperature range for the formation of the mono- or diesters is in the range 60-180°C, preferably 80-140°C.

5 Subsequent to the mono-esterification, the amidation with primary and/or secondary amines of the formulae N and/or P is carried out, preferably in the same solvent, in the temperature range 50-250°C, preferably 100-200°C, the water being likewise removed azeotropically.

10 However, it is also possible to carry out the amidation reaction simultaneously with or prior to the esterification reaction. In the case of simultaneous esterification and amidation, the starting terpolymer is reacted with a mixture of alcohols of the formula Q and/or primary and/or secondary amines of the formulae N
15 and/or P.

The terpolymers of the invention are particularly suitable as paraffin inhibitors for paraffin-containing crude oils and petroleum products which contain paraffin waxes, asphaltenes, resins, etc. Examples of paraffin-containing
20 petroleum products in the context of the invention are crude oils, distillation residues from petroleum refining or other paraffin-containing oils such as middle distillates (cf. for example, Compositions and Properties of Petroleum, F. Enke Publishers, Stuttgart, 1981, pages
25 1-37).

Paraffins here may be straight-chain or branched alkanes having about 10-50 carbon atoms.

The concentrations in which the paraffin inhibitors of the invention are used are generally 10-10,000 ppm, preferably 20-5,000 ppm, particularly preferably 50-1,000
30 ppm, in the petroleum product.

The optimum use concentration for a particular paraffin-containing oil can in each case be determined, for



example, by determination of the pour point (DIN ISO 3016).

In the case of crude oils, for example, the addition of the paraffin inhibitors of the invention may take place
5 either in the well or during transport, storage or further processing.

It has been found that the terpolymers of the invention in admixture with ethylene-vinyl ester copolymers possess an excellent action as paraffin dispersants in middle
10 distillates. Furthermore, the terpolymers of the invention in admixture with ethylene-vinyl ester copolymers are suitable for lowering the cloud point (CP) in middle distillates. These mixtures usually contain from 50 to 1,000 ppm, preferably from 50 to 500 ppm, of the terpoly-
15 mers of the invention and from 50 to 1,000 ppm, preferably from 50 to 500 ppm, of ethylene-vinyl ester copolymers. However, in addition to these copolymers, terpolymers which contain further comonomers besides ethylene and vinyl esters can equally be used. The
20 terpolymers of the invention and ethylene-vinyl ester copolymers can also be added individually to middle distillates which already contain one of these components.

Suitable vinyl ester monomers are C_1 - C_{20} -alkylvinyl
25 esters, preferably C_1 - C_{12} -alkylvinyl esters such as vinyl acetate, vinyl propionate, vinyl neodecanoate and vinyl neodecanoate and also vinyl esters of saturated C_{10} - C_{24} fatty acids. Further suitable comonomers are esters of unsaturated carboxylic acids, preferably the C_1 - C_{24} -alkyl
30 esters of acrylic acid, methacrylic acid and fumaric acid, and also C_1 - C_{10} -alkylvinyl esters, diisobutylene, dimethylvinylcarbinol and vinyl methoxyacetate.

Such ethylene-vinyl ester copolymers and terpolymers are described in detail in the patent literature. For
35 example, mention may be made of DE-B-11 47 799



(ethylene-vinyl acetate), DE-A-32 47 753 (ethylene-alkenecarboxylic ester, vinyl carboxylate-vinyl ketone), US-A-4 015 063 (ethylene, dimethylvinylcarbinol, vinyl esters of fatty acids), EP-A-203 554 (ethylene-diisobutylene-vinyl acetate), EP-A-309 897 (ethylene-vinyl methoxyacetate), and DE-A-40 42 206 (ethylene-vinylacetate-vinyl neononanoate or neodecanoate).

Preferred copolymers are those which essentially comprise 80 - 51 % by weight of ethylene and 20 - 49 % by weight of vinyl acetate or vinyl propionate.

Preferred terpolymers comprise 79 - 40 % by weight of ethylene, 20 - 35 % by weight, preferably 1 - 15 % by weight, of vinyl acetate or vinyl propionate, and 1 - 25 % by weight, preferably 1 - 15 % by weight, of diisobutylene, vinyl neononanoate or vinyl neodecanoate.

Furthermore, it has been found that mixtures of the terpolymers of the invention, the above-described ethylene-vinyl ester copolymers and certain quaternary ammonium salts possess an excellent action as paraffin dispersants in middle distillates.

Suitable quaternary ammonium salts possess the formula



where R^{11} may be identical or different and is C_1 - C_{30} -alkyl, preferably C_1 - C_{22} -alkyl, C_1 - C_{30} -alkenyl, preferably C_1 - C_{22} -alkenyl, benzyl or a radical of the formula $-(CH_2-CH_2-O)_n-R^{12}$, where R^{12} is hydrogen or a fatty acid radical of the formula $C(O)-R^{13}$, with R^{13} being C_6 - C_{40} -alkyl or C_6 - C_{40} -alkenyl, n is a number from 1 to 30 and X is halogen, preferably chlorine, or methosulphate.

Examples which may be mentioned of such quaternary ammonium salts are: dihexadecyldimethylammonium chloride, distearyldimethylammonium chloride, quaternization



products of esters of di- and triethanolamine with long-chain fatty acids (lauric acid, myristic acid, palmitic acid, stearic acid, behenic acid, oleic acid and mixtures of fatty acids such as coconut fatty acid, tallow fatty acid, hydrogenated tallow fatty acid and tall oil fatty acid), such as the distearyl ester of N-methyltriethanolammonium chloride, the distearyl ester of N-methyltriethanolammonium methosulphate, the distearyl ester of N,N-dimethyldiethanolammonium chloride, the dioleoyl ester of N-methyltriethanolammonium chloride, the trilauryl ester of N-methyltriethanolammonium methosulphate, the tristearyl ester of N-methyltriethanolammonium methosulphate and mixtures thereof.

These mixtures usually comprise from 50 to 1000 ppm, preferably from 50 to 500 ppm, of the terpolymers of the invention, from 50 to 1000 ppm, preferably from 50 to 500 ppm, of ethylene-vinyl ester copolymers and from 50 to 1000 ppm, preferably from 50 to 500 ppm, of the quaternary ammonium salts.

The invention also provides the petroleum products stabilized against paraffin deposition by means of the paraffin inhibitors of the invention. The terpolymers and terpolymer/coadditive mixtures of the invention improve the low temperature behavior of these oils and thus improve the flow behavior in comparison with the prior art. In particular, the pour point and the viscosity are improved.

The improvement in the flow behavior can be established, for example, by determination of the pour point (in accordance with ASTM standard No. 97 B, Section 6 f) by measurements of the amounts of paraffin precipitated and also by viscosity measurements. The first method in particular, is widely used in practice and is usually matched to the practical conditions used in screening tests (for example, addition of the additive at 50°C (actual pour point)).

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- 21 -

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- 5 The dispersion of the paraffin in middle distillates can be checked by storage of the additive-containing oil samples in a freezer at temperatures between -13 and -20°C (carried out in accordance with M. Feustel et al., Science & Technology, Vol. 43, p. 396, Fig. 2 (1990)) with subsequent visual assessment of the sedimentation behavior and also determination of the CFPP value after separation of the oil sample into an upper and lower phase (EN 116).



Examples

General preparative procedure

The polymerization is carried out in a 2 l five-neck flask (having additional Claisen attachments if desired) fitted with anchor stirrer, reflux condenser, internal thermometer, gas inlet tube and up to 3 (heatable) dropping funnels. The solutions initially charged for polymerization are flushed with nitrogen prior to and during the polymerization. The intrinsic viscosity values K are determined by the method of Ubbelohde in toluene at a polymer concentration of 5 % by weight. IR spectra are obtained from 1 % strength by weight solutions in chloroform.

The allyl methyl polyglycols used are commercial products from Hoechst AG having the following characteristics:
®Polyglycol AM 250: average molecular weight = 250 g/mol
®Polyglycol AM 350: average molecular weight = 350 g/mol.
®Shellsol AB and Solvent Naphtha are commercial aromatic solvent mixtures boiling above 180°C from Shell and Veba Oel respectively.

Example 1: Terpolymer of C_{18} - α -olefin, maleic anhydride and ®Polyglycol AM 350 in toluene

A solution of 277.2 g (1.1 mol) of octadec-1-ene in 50 g of toluene is heated to 100°C while passing in a stream of nitrogen. While stirring vigorously at this temperature, 88.2 g (0.9 mol) of molten maleic anhydride, 35 g (0.1 mol) of ®Polyglycol AM 350 and also an initiator solution comprising 3.5 g of tert-butyl peroxybenzoate and 3.5 g of tert-butyl peroxy-2-ethylhexanoate in 55.8 g of toluene are metered in from separate dropping funnels over a period of 3 hours. The mixture is stirred for a further 2 hours at 100°C. The resulting reddish brown polymer solution has a solids content of 48.2 % and contains no unreacted maleic anhydride. The polymer has an K value of 16. IR bands at 1775 and 1855 cm^{-1} show the



presence of anhydrides.

Example 2: Terpolymer of C_{18} - α -olefin, maleic anhydride and $\textcircled{P}$ olyglycol AM 350 in Shellsol AB

5 A solution of 252 g (1.0 mol) of C_{18} - α -olefin in 115 g of Shellsol AB is heated to 160°C while passing in a stream of nitrogen. Over a period of 2 hours, 98 g (1.0 mol) of molten maleic anhydride, a solution of 3.5 g of di-tert-butyl peroxide and 3.5 g of tert-butyl peroxybenzoate in 85 g of Shellsol AB and also 70 g (0.2 mol) of $\textcircled{P}$ olyglycol AM 350 in 73.7 g of Shellsol AB are continuously added dropwise from separate dropping funnels. The mixture is stirred for a further 2 hours at 180°C. The resulting orange polymer solution has a dry residue of 46.2 %; the resulting polymer has a K value of 17.

15 Example 3: Terpolymer of C_{18} - α -olefin, maleic anhydride and $\textcircled{P}$ olyglycol AM 350 in Shellsol AB

A solution of 302.4 g (1.2 mol) of C_{18} - α -olefin in 115 g of Shellsol AB is heated to 180°C while passing in a stream of nitrogen. Over a period of 2 hours, 88.2 g (0.9 mol) of molten maleic anhydride, a solution of 7 g of di-tert-butyl peroxide in 85 g of Shellsol AB and also 17.5 g (0.05 mol) of $\textcircled{P}$ olyglycol AM 350 in 76.68 g of Shellsol AB are continuously added dropwise. The mixture is stirred for a further 1 hour at 180°C. The resulting polymer solution has a dry residue of 45.9 %; the resulting polymer has a K value of 17.

Example 4: Terpolymer of C_{18} - α -olefin, maleic anhydride and $\textcircled{P}$ olyglycol AM 250 in Shellsol AB

30 302.4 g of octadec-1-ene, 88.2 g of maleic anhydride and 12.5 g of $\textcircled{P}$ olyglycol AM 250 are polymerized at 180°C analogously to Example 3. The resulting polymer has a K value of 15.

Example 5: Terpolymer of C_{14-16} - α -olefin, maleic anhydride and $\textcircled{P}$ olyglycol AM 350 in Shellsol AB

35 252 g of a mixture of tetradecene and hexadecene (1:1),



88.2 g of maleic anhydride and 17.5 g of ®Polyglycol AM 350 are polymerized at 180°C analogously to Example 3. The resulting polymer has a K value of 15.

5 Example 6: Terpolymer of C₂₀₋₂₄-α-olefin, maleic anhydride and ®Polyglycol AM 350 in Shellsol AB

396.6 g (1.2 mol) of a C₂₀₋₂₄-α-olefin, 88.2 g of maleic anhydride and 17.5 g of ®Polyglycol AM 350 are polymerized at 180°C analogously to Example 3. The resulting polymer has a K value of 18.

10 Example 7: Terpolymer of styrene, maleic anhydride and ®Polyglycol AM 350

To a solution of 98 g (1.0 mol) of maleic anhydride in 300 g of Shellsol AB are added dropwise, while stirring and passing in a stream of nitrogen, 99 g (0.95 mol) of
15 styrene, a solution of 4.0 g of di-tert-butyl peroxide in 50 g of Shellsol AB and also a solution of 17.5 g (0.05 mol) of ®Polyglycol AM 350 in 50 ml of Shellsol AB in parallel at 160°C over a period of 4 hours. A pale brown, 35 % strength by weight polymer solution results.

20 Example 8: Terpolymer of C₁₈-α-olefin, maleic anhydride and stearyl ester of allylpolyglycol

277.2 g (1.2 mol) of C₁₈-α-olefin, 88.2 g (0.9 mol) of maleic anhydride and 17.5 g of the stearyl ester of allylpolyglycol (prepared by esterification of stearic
25 acid with an ethoxylate of allyl alcohol containing 6 mol of ethylene oxide) are polymerized at 180°C analogously to Example 3. The resulting polymer has a K value of 18.

Example 9: Terpolymer of C_{14/16}-α-olefin, maleic anhydride and allylbutylpolyglycol

30 334 g of a mixture of tetradecene and hexadecene (1:1), 118 g of maleic anhydride and 107 g of allylbutylpolyglycol (containing 24 mol of ethylene oxide and 8 mol of propylene oxide) in 376 g of Solvent Naphtha are polymerized at 180°C analogously to Example 3. The
35 resulting polymer has a K value of 16.



Example 10: Terpolymer of C_{14/16}- α -olefin, maleic anhydride and allylbutylpolyglycol

334 g of a mixture of tetradecene and hexadecene (1:1),
118 g of maleic anhydride and 107 g of allylbutyl-
5 polyglycol (containing 15 mol of ethylene oxide and 15
mol of propylene oxide) in 376 g of Solvent Naphtha are
polymerized at 180°C analogously to Example 3. The
resulting polymer has a K value of 17.

Example 11: Reaction of the terpolymer of Example 1 with
10 ditallow fatty amine to give the amide-ammonium salt
132.6 g of the polymer solution of Example 3 are admixed
at 80°C with 100 ml of toluene and 190 g of ditallow
fatty amine and stirred for 2 hours at this temperature.
The titratable nitrogen of the 66.5 % strength by weight
15 polymer solution is 0.73 %. The IR spectrum shows no
anhydride bands; bands at 1565 and 1620 cm⁻¹ show the
formation of an amide-ammonium salt.

Example 12: Reaction of the terpolymer of Example 5 with
ditallow fatty amine
20 50 g of the polymer solution of Example 5, containing
0.086 mol of anhydride groups, are admixed at 75°C with
84 g of Shellsol AB and 86 g of ditallow fatty amine and
stirred for 3 hours at this temperature. The titratable
basic nitrogen of the 50 % strength polymer solution is
25 0.8 %.

Example 13: Reaction of the terpolymer of Example 5 with
distearylamine

Analogously to Example 12, 50 g of the polymer solution
of Example 5 are reacted with distearylamine.

Example 14: Reaction of the terpolymer of Example 3 with
30 distearylamine

100 g of the polymer solution of Example 3, containing
0.13 mol of anhydride groups, are admixed at 80°C with a
solution of 130 g (0.26 mol) of distearylamine in 100 g
35 of xylene and stirred for 3 hours at 150°C. The



titratable basic nitrogen of the 50 % strength by weight polymer solution is 0.51 %.

Example 15: Reaction of the terpolymer of Example 3 with dicoconut fatty amine

5 100 g of the polymer solution of Example 3, containing 0.13 mol of anhydride groups, are admixed at 80°C with a solution of 100 g (0.26 mol) of dicoconut fatty amine in 100 g of xylene and stirred for 3.5 hours at 160°C. The titratable basic nitrogen of the 50 % strength by weight
10 polymer solution is 0.62 %.

Example 16: Reaction of the terpolymer of Example 3 with stearylamine and ditallow fatty amine

100 g of a polymer solution of Example 3, containing 0.13 mol of anhydride groups, are admixed at 80°C with
15 33.9 g (0.13 mol) of stearylamine and stirred for 2 hours at this temperature. Subsequently 65 g (0.13 mol) of ditallow fatty amine in 93 g of xylene are added and the mixture is boiled for 3 hours at 150°C on a water separator. The titratable basic nitrogen of the 50 %
20 strength by weight polymer solution is 0.15 %.

Example 17: Reaction of the terpolymer of Example 7 with ditallow fatty amine

To 50 g of the polymer solution of Example 7, containing 0.063 mol of anhydride, is added a solution of 63.2 g
25 (0.126 mol) of ditallow fatty amine in 58.6 g of Shellsol AB at a temperature of 75°C while stirring. The mixture was stirred for a further 2 hours at this temperature. The resulting 50 % strength by weight polymer solution contains 0.78 % of titratable basic nitrogen.

30 Example 18: Reaction of the terpolymer of Example 1 with behenyl alcohol

181.0 g of the polymer solution (corresponding to 0.3 mol of maleic anhydride) of Example 1 and 94.1 g (0.3 mol) of behenyl alcohol are boiled under reflux for 3 hours at
35 150°C. The acid number is 58.



Example 19: Neutralization of the partially esterified terpolymer of Example 18 with distearylamine

The partially esterified terpolymer solution of Example 18 is neutralized at 70°C by addition of 143.6 g (0.3 mol) of molten distearylamine and is stirred for 1 hour at 70°C. The resulting, highly viscous, pale yellow polymer solution has a solids content of 78 % and titratable basic nitrogen of 0.91 %.

Example 20: Amidation of the partially esterified terpolymer of Example 18 with distearylamine

The partially esterified terpolymer solution of Example 18 is admixed with 143.6 g (0.3 mol) of distearylamine and 226 g of toluene and boiled for 3 hours at 130-140°C on a water separator. The resulting 51 % strength polymer solution contains 0.02 % of titratable basic nitrogen. IR bands at 1735 and 1620 cm⁻¹ show the presence of ester and amide groups.

Example 21: Reaction of the terpolymer of Example 1 with benzyl alcohol and subsequent neutralization with distearylamine

216.6 g of the polymer solution of Example 1 and 34.2 g (0.32 mol) of benzyl alcohol are boiled under reflux for 3 hours at 140°C. The acid number of the partially esterified polymer solution is 80. After cooling to 45°C, 155.9 g of molten distearylamine are added, a temperature rise of 3°C occurring. The mixture is stirred for 1 hour at 45°C and subsequently discharged. The 80 % strength by weight, highly viscous product has a titratable basic nitrogen of 0.98 %.

Example 22: Reaction of the terpolymer of Example 1 with distearylamine

To 620 g of the polymer solution of Example 1 are added 467 g (1 mol) of distearylamine at 160°C over a period of 4 hours and the mixture is maintained at this temperature for 1 hour. The titratable basic nitrogen of the 49 % strength by weight polymer solution is 0.27 %. IR bands



at 1620 and 1720 cm^{-1} indicate the presence of amide and carboxylic acid units.

Example 23: Reaction of the terpolymer of Example 9 with distearylamine and dicoconut fatty amine

5 62 g of the polymer solution of Example 9 (corresponding to 0.08 mol of anhydride groups) are admixed at 90°C with a mixture of 39 g (0.078 mol) of distearylamine and 32 g (0.078 mol) of dicoconut fatty amine in 72 g of Solvent Naphtha and the mixture is stirred for 3 hours at this
10 temperature. The titratable basic nitrogen of the 49 % strength polymer solution is 0.64 %.

Example 24: Reaction of the terpolymer of Example 10 with distearylamine and dicoconut fatty amine

15 62 g of the polymer solution of Example 10 (corresponding to 0.08 mol of anhydride groups) are admixed at 90°C with a mixture of 39 g (0.078 mol) of distearylamine and 32 g (0.078 mol) of dicoconut fatty amine in 72 g of Solvent Naphtha and the mixture is stirred for 3 hours at this
20 temperature. The titratable basic nitrogen of the 50 % strength polymer solution is 0.65 %.

Example 25: Preparation of a copolymer of maleic anhydride and C_{18} - α -olefin and subsequent reaction with ditallow fatty amine (comparison)

25 Analogously to Example 1, a solution of 277 g (1.1 mol) of C_{18} - α -olefin in 150 g of toluene is heated to 100°C while passing in nitrogen. While stirring vigorously, 98 g (1 mol) of molten maleic anhydride and a solution of 3.5 g of tert-butyl peroxybenzoate and 3.5 g of tert-butyl peroxy-2-ethylhexanoate in 55.8 g of toluene are
30 metered in over a period of 3 hours. The mixture is stirred for a further 3 hours. The resulting copolymer has a K value of 16. Analogously to Example 9, 85.8 g of the above polymer solution (containing 0.15 mol of anhydride groups) are converted into the amide-ammonium
35 salt with 142 g (0.3 mol) of ditallow fatty amine.

**Applicational testing****1. Pour-point depressor for crude oils**

The effectiveness of the terpolymers of the invention as flow improvers for mineral oils is described by the determination of the pour points in accordance with DIN ISO 3016. In this method, the crude oil samples with and without addition of the terpolymers are tested for flowability under defined conditions after prior heating and subsequent defined cooling. Pour point tests with the terpolymers of the invention were undertaken on two Columbian crude oils which in the untreated state had pour points of 13.5°C (crude oil A) and 6°C (crude oil B).

Product	Amount added	Pour Point	
		Crude Oil A	Crude Oil B
Terpolymer of Example 11	300 ppm	10.3°C	-1.9°C
	500 ppm	8.4°C	-2.1°C
	1000 ppm	5.3°C	-3.5°C
Terpolymer of Example 18	300 ppm	9.5°C	-1.3°C
	500 ppm	7.9°C	-4.1°C
	1000 ppm	3.5°C	-15.2°C

2. Paraffin dispersants for middle distillates

For the following tests, eight typical, representative winter diesel fuels from German refineries were used. These are hereinafter referred to as middle distillate I to VIII.



	Middle distillate I	Middle distillate II	Middle distillate III	Middle distillate IV	Middle distillate V	Middle distillate VI	Middle distillate VII	Middle distillate VIII
Cloud Point (CP) (°C)	-5	-6	-8	-8	-8	-6	-1	+3
CPPP (°C)	-8	-10	-13	-10	-8	-11	-4	+/-0
Density/20°C (g/ml)	0.822	0.817	0.812	0.837	0.822	0.819	0.830	0.827
Initial boiling point (°C)	163	173	167	183	173	169	171	169
20 % boiling point (°C)	207	219	217	225	221	219	252	241
90 % boiling point (°C)	341	362	324	338	333	330	353	361
Final boiling point (°C)	373	382	359	361	358	362	368	384



The flow improvers (FI) are:

- FI (A) ethylene-vinyl acetate copolymer (containing about 27 % of vinyl acetate)
melt viscosity (140°C) of 200 mPa.s
- 5 FI (B) ethylene-vinyl acetate copolymer (containing about 30 % of vinyl acetate)
average molecular weight of about 1500.

Description of the test method

The middle distillates are first tested separately, with
10 flow improver and in combination with paraffin dispersant, for the turbidity and paraffin sedimentation phenomena induced by cold. After placing the samples in a freezer and running through a specific cooling programme (see M. Feustel et al., Science & Technology,
15 Vol. 43, p. 396, Fig. 2 (1990)), the samples are, after 72 hours, assessed at -13°C for dispersion. Middle distillate volumes of 20 ml and 100 ml are used for these tests. In addition, after the visual assessment of the 100 ml samples, the upper phase (50 % by volume) is drawn
20 off from these at low temperature. The cloud point (CP) and the cold filter plugging point (CFPP) are subsequently determined on both the upper and lower phases. The determination of the cloud point (CP) is carried out in accordance with DIN 51597 by cooling the
25 oil sample and optical measurement of the cloud point. The temperature at which the first paraffin precipitation leads to turbidity is the cloud point (CP). The measurement of the cloud point (CP) is carried out in a Herzog CP SC 815 apparatus. The cold filter plugging point
30 (CFPP) is determined in accordance with European Standard EN 116.

It can be seen that paraffin dispersion is achieved by adding the additives of the invention.

Furthermore, a lowering of the cloud point (CP) is
35 achieved (Table IV).



Abbreviations in the following tables:

	FI	=	Middle distillate flow improver
	PD	=	Paraffin dispersant
	PD(1)	=	of Example 11
5	PD(2)	=	of Example 12
	PD(3)	=	of Example 13
	PD(4)	=	of Example 14
	PD(5)	=	of Example 25 (comparative example)
	PD(6)	=	of Example 19
10	QAS	=	quaternary ammonium salt, here the distearyl ester of N-methyltriethanol- ammonium methosulphate

Assessment codes:

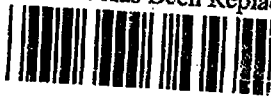
	C	=	clear
15	T	=	turbid
	ST	=	slightly turbid
	S	=	sediment
	D	=	dispersed, hardly any sediment

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Table I

Middle distillate I CP -5°C/CFPP -8°C							
FI	Conc. (ppm)	PD	Conc. (ppm)	QAS (ppm)	Oil phase	Sediment depth (cm)	Volume fraction (%)
FI(A)	100	-	-	-	C	1.6	15
FI(A)	400	-	-	-	C	1.9	17
FI(B)	100	-	-	-	C	1.4	13
FI(B)	400	-	-	-	C	1.7	15
FI(A)	400	PD(1)	200	-	T	0.8	7
FI(A)	400	PD(1)	400	-	T	0.5	5
FI(A)	400	PD(1)	300	200	T	0.0	0
FI(B)	400	PD(1)	300	150	T	0.1	1
Middle distillate II CP -6°C/CFPP -10°C							
FI	Conc. (ppm)	PD	Conc. (ppm)	QAS (ppm)	Oil phase	Sediment depth (cm)	Volume fraction (%)
FI(A)	100	-	-	-	C	1.4	13
FI(B)	100	-	-	-	C	1.0	9
FI(A)	200	-	-	-	C	1.4	13
FI(A)	200	PD(2)	200	-	ST	0.5	5
FI(A)	200	PD(2)	350	-	T	0.3	2
FI(A)	200	PD(2)	500	-	T	0.1	1
FI(A)	200	PD(4)	200	-	T	0.7	6
FI(B)	200	PD(4)	500	-	T	0.2	2

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- 34 -

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Middle distillate III CP -5°C/CFPP -8°C

FI	Conc. (ppm)	PD	Conc. (ppm)	QAS (ppm)	Oil phase	Sediment depth (cm)	Volume fraction (%)
FI(B)	100	-	-	-	C	1.7	15
FI(B)	200	-	-	-	C	1.8	16
FI(B)	200	PD(3)	100	-	C	1.0	9
FI(B)	200	PD(3)	200	-	ST	0.5	5
FI(B)	200	PD(3)	300	-	T	0.2	2
FI(B)	200	PD(3)	500	-	T	0.2	2
FI(B)	2400	PD(3)	200	100	T	0.1	1
FI(B)	200	PD(3)	500	200	T	0.1	1

Table II

Middle distillates I CP -5°C/CFPP -8°C

FI	Conc. (ppm)	PD	Conc. (ppm)	QAS (ppm)	Paraffin sediment (% by volume)	Paraffin in oil phase	Dispersion	Lower phase		Upper phase	
								CP °C	CFPP °C	CP °C	CFPP °C
FI(A)	200	-	-	-	14	C	S	-1	-16	-10	-32
FI(A)	400	-	-	-	19	C	S	-1	-13	-11	-33
FI(A)	400	PD(1)	400	-	4	T	D	-1	-20	-13	-38
FI(A)	400	PD(1)	50	200	7	T	S	-2	-29	-13	-36
FI(A)	400	PD(1)	100	200	5	T	D	-2	-29	-12	-37
FI(A)	400	PD(1)	200	200	2	T	D	-3	-28	-11	-37
FI(A)	400	PD(1)	300	200	1	T	D	-4	-32	-11	-37
FI(A)	400	PD(5)	400	-	7	ST	S	-1	-17	-12	-34

Table III

Middle distillate I CP -5°C/CFPP -8°C

FI	Conc. (ppm)	PD (ppm)	Conc. (ppm)	QAS (ppm)	Paraffin sediment (% by volume)	Paraffin in oil phase	Dispersion	Lower phase		Upper phase	
								CP °C	CFPP °C	CP °C	CFPP °C
FI(B)	200	-	-	-	21	C	S	0	-11	-15	-30
FI(B)	200	PD(2)	250	-	10	C	S	-2	-19	-14	-24
FI(B)	200	PD(2)	200	150	8	ST	S	-2	-21	-14	-31
FI(B)	200	PD(2+3)	200	50	7	ST	D	-3	-28	-14	-31
FI(A)	200	-	-	-	19	C	S	-1	-10	-14	-28
FI(A)	200	PD(2)	250	-	8	ST	S	-2	-23	-12	-29
FI(A)	200	PD(2)	200	150	5	T	D	-3	-26	-12	-30



Table IV

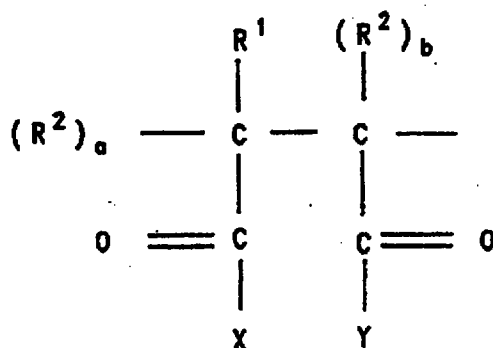
Middle distillate	CP-Value (°C)				Difference (K)	
	Without additive	+ 150 ppm FI (A)	400 ppm PD (6)	800 ppm PD (6)	ΔT_1	ΔT_2
Middle distillate IV	-8.1	-8.1	-10.1	-10.9	2.0	2.0
" V	-8.4	-8.4	-10.7	-10.7	2.1	2.3
" VI	-5.7	-5.7	-7.4	-7.7	1.7	2.0
" VII	-0.9	-0.9	-2.1	-2.4	1.2	1.5
" VIII	+3.0	+3.0	+2.1	+1.2	0.9	1.8



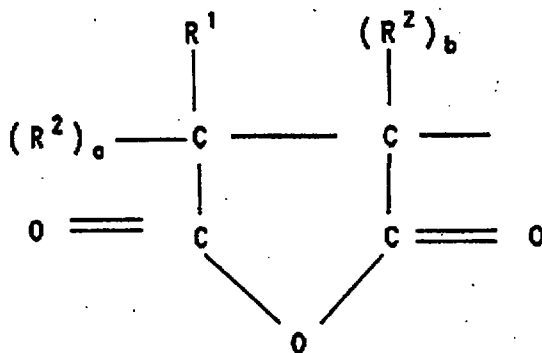
WHAT IS CLAIMED IS:

1. A terpolymer based on α,β -unsaturated dicarboxylic anhydrides, α,β -unsaturated compounds and polyoxyalkylene ethers of lower unsaturated alcohols, which comprises
20-80 mol %, preferably 40-60 mol %, of bivalent structural units A, B and/or C

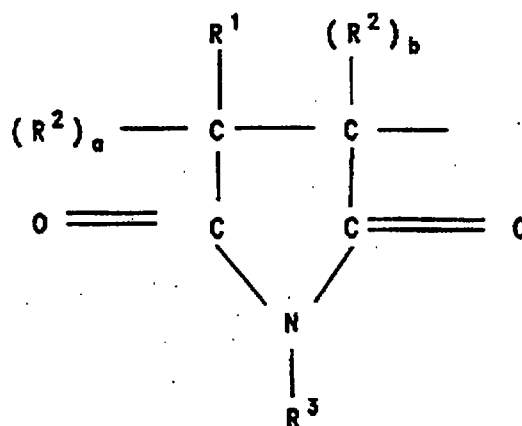
(A)



(B)



(C)



where

 R^1 and R^2 are, independently of one another, hydrogen



or methyl,

a and b are zero or one and $a + b$ is one,

X and Y are identical or different and are the $-N-HR^3$ group,

where R^3 is C_6-C_{40} -alkyl, C_5-C_{20} -cylcoalkyl or C_6-C_{18} -aryl,

the $-N-(R^3)_2$ group,

where R^3 is identical or different and is as defined above,

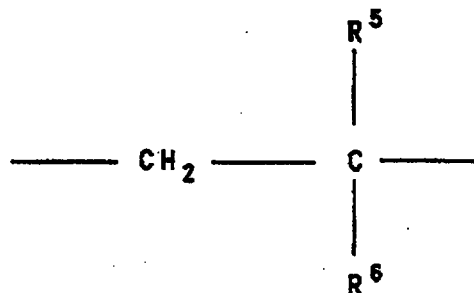
and/or

the $-O-R^4$ group,

where R^4 is hydrogen, a cation of the formula $H_2N^+(R^3)_2$, or $H_3N^+R^3$, C_6-C_{40} -alkyl, C_5-C_{20} -clycoalkyl or C_6-C_{18} -aryl, preferably phenyl,

19-80 mol %, preferably 39-60 mol %, of bivalent structural units D

(D)



in which

R^5 is hydrogen or C_1-C_4 -alkyl and

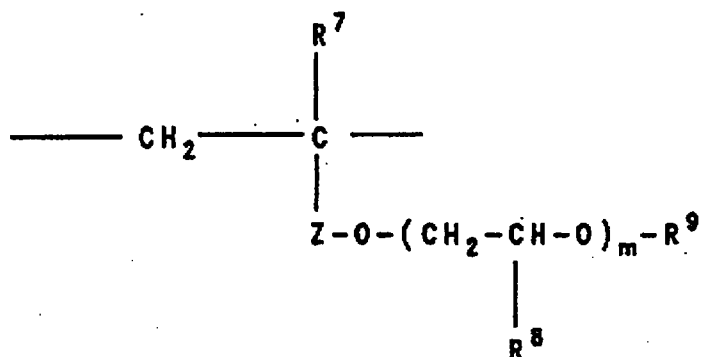
R^6 is C_6-C_{60} -alkyl or C_6-C_{18} -aryl,

and

1-30 mol %, preferably 1-20 mol %, of bivalent structural units E



(E)



in which

R^7 is hydrogen or methyl,

R^8 is hydrogen or $\text{C}_1\text{-C}_4$ -alkyl,

Z is $\text{C}_1\text{-C}_4$ -alkylene,

m is a number from 1 to 100,

R^9 is $\text{C}_1\text{-C}_{24}$ -alkyl, $\text{C}_5\text{-C}_{20}$ -cylcoalkyl, $\text{C}_6\text{-C}_{18}$ -aryl or -C(O)-R^{10} , where

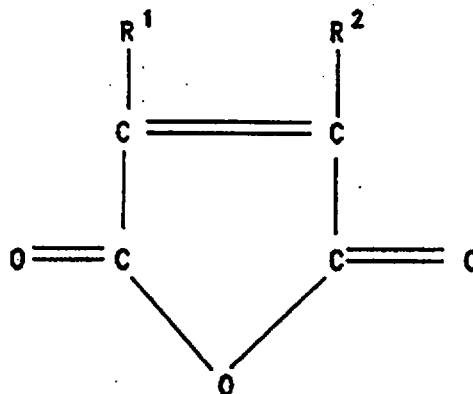
R^{10} is $\text{C}_1\text{-C}_{40}$ -alkyl, $\text{C}_5\text{-C}_{10}$ -cycloalkyl or $\text{C}_6\text{-C}_{18}$ -aryl.

2. A terpolymer as claimed in claim 1, containing bivalent structural units of the formula A, in which X is a group of the formula O-R^4 , with R^4 being $\text{C}_6\text{-C}_{40}$ -alkyl and Y is a group of the formula O-R^4 , where R^4 is a cation of the formula $\text{H}_2\text{N}^+(\text{R}^3)_2$, with R^3 being $\text{C}_6\text{-C}_{40}$ -alkyl.
3. A terpolymer as claimed in claim 1, containing bivalent structural units of the formula A, in which X is a group of the formula $\text{-N(R}^3)_2$, with R^3 being $\text{C}_6\text{-C}_{40}$ -alkyl and Y is a group of the formula O-R^4 , where R^4 is a cation of the formula $\text{H}_2\text{N}^+(\text{R}^3)_2$, with R^3 being $\text{C}_6\text{-C}_{40}$ -alkyl.
4. A terpolymer as claimed in claims 2 or 3, wherein R^3 and R^4 are $\text{C}_6\text{-C}_{24}$ -alkyl.

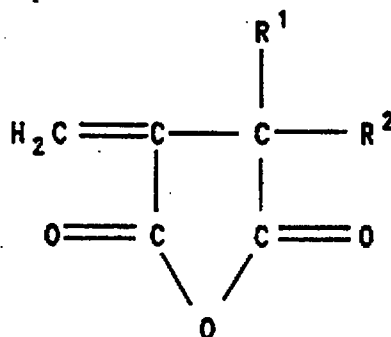


5. A process for preparing the terpolymers as claimed in claim 1, which comprises polymerizing with one other monomers of the formula F and/or G

(F)

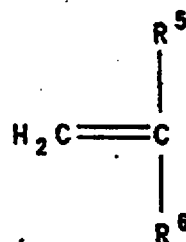


(G)



where R^1 and R^2 are, independently of one another, hydrogen or methyl,
monomers of the formula H

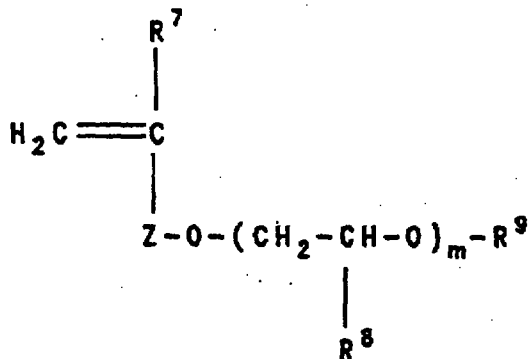
(H)



where R^5 is hydrogen or C_1 - C_4 -alkyl and R^6 is C_6 - C_{60} -alkyl or C_6 - C_{18} -aryl,
and monomers of the formula J

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REPLACED

(J)



in which

R^7 is hydrogen or methyl,

R^8 is hydrogen or C_1 - C_4 -alkyl,

Z is C_1 - C_4 -alkylene,

m is a number from 1 to 100,

R^9 is C_1 - C_{24} -alkyl, C_5 - C_{20} -cycloalkyl, C_6 - C_{18} -aryl or $-C(O)-R^{10}$, where

R^{10} is C_1 - C_{40} -alkyl, C_5 - C_{10} -cycloalkyl or C_6 - C_{18} -aryl,

and subsequently reacting the product with primary and/or secondary amines of the formulae

(N) $-N-HR^3$,

(P) $-N-(R^3)_2$,

where R^3 is C_6 - C_{40} -alkyl, C_5 - C_{20} -cycloalkyl or C_6 - C_{18} -aryl,

and/or alcohols of the formula

(Q) $HO-R^4$,

where R^4 is hydrogen, a cation of the formula $H_2N^+(R^3)_2$, or $H_3N^+R^3$, C_6 - C_{40} -alkyl, C_5 - C_{20} -cycloalkyl or C_6 - C_{18} -aryl, preferably phenyl.

6. The process as claimed in claim 5, wherein the polymerization is carried out in solution, suspension or melt, preferably in solution.
7. The process as claimed in claim 5, wherein the polymerization is carried out in a stirred reactor, a cascade of stirred reactors or a static mixer.



8. The process as claimed in claim 5, wherein the molar ratio between the monomers of the formulae F and/or G, H and J is 1 : 0.5 - 2 : 0.01 - 0.5, preferably 1 : 0.9 - 1.1 : 0.04 - 0.2.
9. The process as claimed in claim 5, wherein the polymerization is carried out in the presence of from 0.1 to 20 % by weight, preferably from 0.2 to 10 % by weight, based on the monomer content, of a free-radical initiator.
10. The process as claimed in claim 5, wherein the polymerization is carried out in the presence of from 0.1 to 10 % by weight, based on the monomer content, of a regulator.
11. The process as claimed in claim 5, wherein the polymerization is carried out at a temperature from 40 to 400°C, preferably from 80 to 250°C and with or without the exclusion of air.
12. The process as claimed in claim 5, wherein the polymerization is carried out in a solvent in which the monomers of the formulae F, G, H and J and the terpolymers claimed in claim 1 are soluble.
13. The process as claimed in claim 5, wherein the reaction with amines of the formulae N and P and/or alcohols of the formula Q is carried out by first reacting the polymer with the alcohol and subsequently reacting the product with the primary and/or secondary amines.
14. Use of a terpolymer as claimed in claim 1 as a paraffin inhibitor for paraffin-containing crude oils and petroleum products.
15. Use of a terpolymer as claimed in claim 14, wherein from 10 to 10,000 ppm of the terpolymer are added to



the paraffin-containing crude oil or petroleum product.

16. A paraffin-containing petroleum or petroleum product which contains a terpolymer as claimed in claim 1.
17. A mixture comprising at least one terpolymer as claimed in claim 1 and at least one ethylene-vinyl ester copolymer.
18. A mixture as claimed in claim 17, which contains ethylene-vinyl ester copolymers derived from copolymers which contain C_1 - C_{20} -alkylvinyl esters, vinyl esters of saturated C_{10} - C_{24} -fatty acids, esters of unsaturated carboxylic acids, diisobutylene, dimethylvinylcarbinol and vinyl methoxyacetate as monomers.
19. A mixture as claimed in claim 17, wherein the ethylene-vinyl ester copolymers comprise
80 - 51 % by weight of ethylene and
20 - 49 % by weight of vinyl acetate or vinyl propionate.
20. A mixture as claimed in claim 17, wherein the ethylene-vinyl ester copolymers comprise
79 - 40 % by weight of ethylene,
20 - 35 % by weight, preferably 1 - 15 % by weight, of vinyl acetate or vinyl propionate and
1 - 25 % by weight, preferably 1 - 15 % by weight, of diisobutylene, vinyl neononanoate or vinyl neodecanoate.
21. Use of a mixture as claimed in claim 17 as a paraffin dispersant in petroleum middle distillates.
22. Use of a mixture as claimed in claim 17 for lowering the cloud point in petroleum middle distillates.



23. Use as claimed in claim 21 or 22, wherein a mixture comprising
from 50 to 1000 ppm, preferably from 50 to 500 ppm,
of terpolymer and
from 50 to 1000 ppm, preferably from 50 to 500 ppm,
of ethylene-vinyl ester copolymer is added to the
paraffin-containing petroleum middle distillate.
24. A paraffin-containing petroleum middle distillate
which contains a mixture as claimed in claim 17.
25. A mixture comprising a mixture as claimed in claim
17 and at least one quaternary ammonium salt of the
formula
- $$^{\circ}\text{N}(\text{R}^{11})_4\text{X}^{\circ}$$
- in which R^{11} is $\text{C}_1\text{-C}_{30}$ -alkyl, preferably $\text{C}_1\text{-C}_{22}$ -alkyl,
 $\text{C}_2\text{-C}_{30}$ -alkenyl, preferably $\text{C}_2\text{-C}_{22}$ -alkenyl, benzyl or a
radical of the formula $-(\text{CH}_2\text{-CH}_2\text{-O})_n\text{-R}^{12}$, where R^{12} is
hydrogen or a fatty acid radical of the formula
 $\text{C}(\text{O})\text{-R}^{13}$, where R^{13} is $\text{C}_6\text{-C}_{40}$ -alkyl or $\text{C}_6\text{-C}_{40}$ -alkenyl,
 n is a number from 1 to 30 and X is halogen, pre-
ferably chlorine, or methosulphate.
26. Use of a mixture as claimed in claim 25 as a paraf-
fin dispersant in petroleum middle distillates.
27. Use as claimed in claim 26, wherein a mixture
comprising
from 50 to 1000 ppm, preferably from 50 to 500 ppm,
of terpolymer as claimed in claim 1,
from 50 to 1000 ppm, preferably from 50 to 500 ppm,
of ethylene-vinyl ester copolymer and
from 50 to 1000 ppm, preferably from 50 to 500 ppm,
of quaternary ammonium salt of the formula $^{\circ}\text{N}(\text{R}^{11})_4\text{X}^{\circ}$
is added to the paraffin-containing petroleum middle
distillate.
28. A paraffin-containing petroleum middle distillate
which contains a mixture as claimed in claim 25.

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Abstract of the disclosure

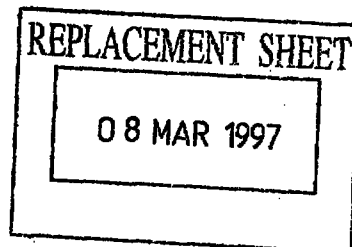
Terpolymers based on α,β -unsaturated dicarboxylic anhydrides, α,β -unsaturated compounds and polyoxyalkylene ethers of lower unsaturated alcohols.

The present invention relates to terpolymers based on α,β -unsaturated dicarboxylic anhydrides, α,β -unsaturated compounds and polyoxyalkylene ethers as defined in claim 1, and also a process for preparing the same as defined in claim 5.

The invention likewise relates to a mixture of at least one terpolymer as defined in claim 1 and at least one ethylene-vinyl ester copolymer.

The terpolymers of the invention, and mixtures thereof, are used as paraffin inhibitors in crude oils and petroleum products.

0-2400
0-50



Description

5 Terpolymers based on α, β -unsaturated dicarboxylic anhydrides, α, β -unsaturated compounds and polyoxyalkylene ethers of lower unsaturated alcohols.

10 Mineral oils and mineral oil distillates, such as diesel fuel or heating oil, generally contain a proportion of dissolved n-paraffins which crystallize out on lowering of the temperature and can thereby lead to a deterioration of the flow properties of these oils or distillates. During transport of mineral oils through pipelines, this can lead to deposits on the wall and in particular cases (for example, while a pipeline is shut down) even lead to complete blockage of the pipeline.

15 Precipitation of paraffins can also lead to complications during the storage and further processing of the mineral oils. In the case of mineral oil distillates, the crystallization can result in blockage of the filters in diesel engines and furnaces.

20 Apart from the classical methods of overcoming these paraffin problems (thermally, mechanically or by means of solvents), which only relate to the removal of the precipitates already formed, recent years have seen the development of a number of chemical additives (paraffin

25 inhibitors) which, by means of physical interaction with the precipitating paraffin crystals, lead to a modification of the shape, size and adhesion properties of the crystals. Here the additives act as additional crystal nuclei and partly crystallize out with the paraffins;

30 part of their action is also explained by dispersion of the crystals. The modified crystals have less tendency to form deposits, are also smaller and possess an altered crystal form. Oils mixed with additives can still be pumped or processed at temperatures which are often more

35 than 20°C lower than for oils not containing additives.

08 MAR 1997

- 2 -

Some copolymers based on maleic anhydride and α,β -unsaturated compounds are known as paraffin inhibitors for crude oils and mineral oil distillates.

5 EP-B-0 154 177 describes reaction products of copolymers based on maleic anhydride and α,β -unsaturated compounds with primary monoalkylamines and/or aliphatic alcohols. These copolymers are particularly suitable as paraffin inhibitors for paraffin-containing petroleum products, for example crude oils and distillation residues from
10 petroleum refining.

EP-A-0 436 151 discloses reaction products of copolymers based on maleic anhydride and α,β -unsaturated compounds such as styrene with dialkylamines. These copolymers are added to petroleum middle distillates in amounts of from
15 50 to 1000 ppm, preferably from 100 to 500 ppm. Such petroleum middle distillates generally already contain flow improvers such as ethylene-vinyl ester copolymers.

EP-A-0 283 293 discloses copolymers derived from the polymerization of an aliphatic olefin with maleic an-
20 hydride, where the copolymer must contain both an ester group and also an amide group, each of which contains an alkyl group having at least 10 carbon atoms, and also copolymers from the reaction of a secondary amine with a polymer containing anhydride groups, where equal amounts
25 of amides and amine salts are produced from the anhydride groups.

The as yet unpublished German Patent Application P 41 23 795.1 relates to copolymers of ethylenically unsaturated carboxylic esters with polyoxyalkylene ethers
30 of lower unsaturated alcohols and also to their use in paraffin-containing oils, such as crude oils, residual oils and oil distillates.

However, the paraffin-inhibiting activity of the known paraffin inhibitors is inadequate, in particular in

middle distillates, so that cooling can result in the formation of paraffin crystals, some large, which form a sediment because of their relatively high density and can lead to a paraffin-rich layer at the bottom and a
5 paraffin-depleted upper layer.

It has now been found that, despite the known difficulties in using allyl compounds as monomers (H.-G. Elias, Makromoleküle [Macromolecules], 4th edition (1981), pp. 571, 581, 585), it is likewise possible to use
10 terpoly-meres based on α,β -unsaturated dicarboxylic anhydrides, α,β -unsaturated compounds and polyoxyalkylene ethers of lower unsaturated alcohols.

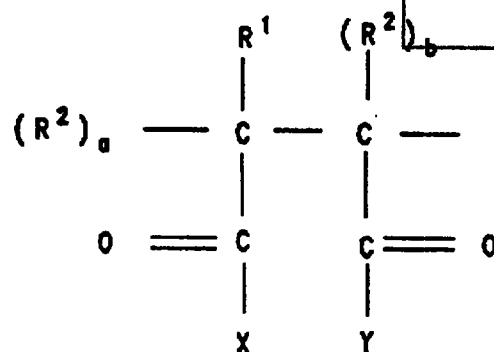
It has likewise been found that addition of alcohol/amine-modified terpolymers based on α,β -unsaturated dicarboxylic anhydrides, α,β -unsaturated compounds
15 and polyoxyalkylene ethers of lower unsaturated alcohols, if desired in admixture with known paraffin inhibitors, preferably copolymers based on ethylene and vinyl acetate, results in the paraffin crystals which precipi-
20 tate on cooling remaining dispersed. As a result of this uniform dispersion, a homogeneously turbid phase is obtained in which the CFPP (cold filter plugging point) value, which is critical for operability, of the upper and lower phases is approximately the same.

25 The invention provides terpolymers based on α,β -unsaturated dicarboxylic anhydrides, α,β -unsaturated compounds and polyoxyalkylene ethers of lower unsaturated alcohols, which comprise
20-80 mol %, preferably 40-60 mol %, of bivalent structural units A, B and/or C
30

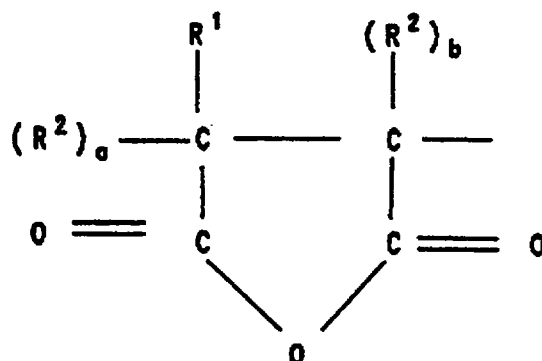
08 MAR 1997

- 4 -

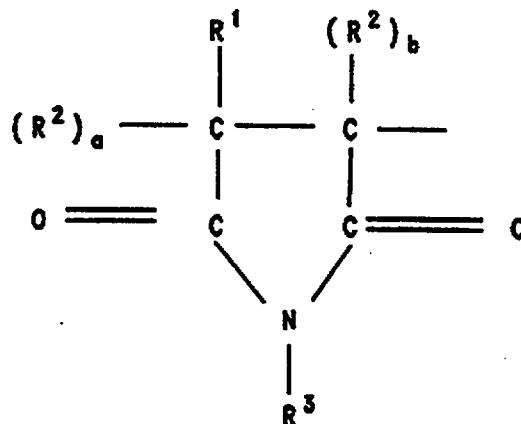
(A)



(B)



(C)



where

R^1 and R^2 are, independently of one another, hydrogen or methyl,

a and b are equals zero or one and $a + b$ is one,

5 X and Y are identical or different and are the $-N-HR^3$, group

where R^3 is C_6 - C_{40} -alkyl, C_5 - C_{20} -cycloalkyl or C_6 - C_{18} -aryl, the $-N-(R^3)_2$, group

where R^3 is identical or different and is as defined

08 MAR 1997

- 5 -

above,

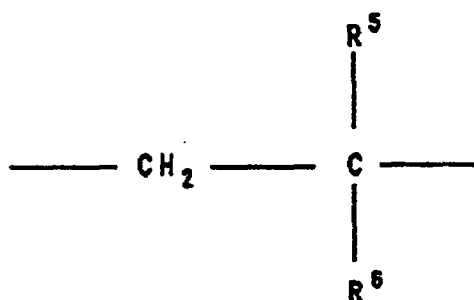
and/or

the $-O-R^4$ group

- where R^4 is hydrogen, a cation of the formula $H_2N^+(R^3)_2$ or $H_3N^+R^3$, C_6-C_{10} -alkyl, C_5-C_{20} -cycloalkyl or C_6-C_{18} -aryl, preferably phenyl,

19-80 mol %, preferably 39-60 mol %, of bivalent structural units D

(D)



in which

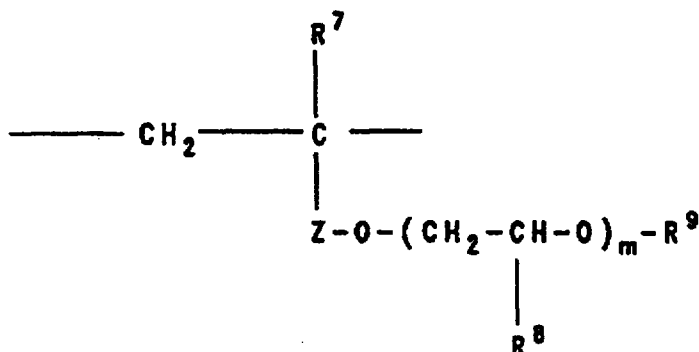
- 10 R^5 is hydrogen or C_1-C_4 -alkyl and

R^6 is C_6-C_{60} -alkyl or C_6-C_{18} -aryl,

and

1-30 mol %, preferably 1-20 mol %, of bivalent structural units E

(E)



- 15 in which

R^7 is hydrogen or methyl,

R^8 is hydrogen or C_1-C_4 -alkyl,

Z is C_1-C_4 -alkylene,

08 MAR 1997

- 6 -

m is a number from 1 to 100,

R⁹ is C₁-C₂₄-alkyl, C₅-C₂₀-cylcoalkyl, C₆-C₁₈-aryl or -C(O)-R¹⁰, where

R¹⁰ is C₁-C₄₀-alkyl, C₅-C₁₀-cycloalkyl or C₆-C₁₈-aryl.

- 5 The abovementioned alkyl, cylcoalkyl and aryl radicals may be unsubstituted or substituted. Suitable substituents of the alkyl and aryl radicals are, for example, (C₁-C₆)-alkyl, halogens such as fluorine, chlorine, bromine and iodine, preferably chlorine, and (C₁-C₆)-
10 alkoxy.

- Alkyl (R³, R⁴) is, according to the invention, generally a straight-chain or branched hydrocarbon radical having 6-40, preferably 10-24, carbon atoms. Individual mention may be made of: n-hexyl, n-octyl, decyl, dodecyl, tetra-
15 decyl, hexadecyl, octadecyl, dodecenyl, tetrapropenyl, tetradecenyl, pentapropenyl, hexadecenyl, octadecenyl and eicosyl or mixtures such as coconut alkyl, tallow alkyl and behenyl.

- Cylcoalkyl (R³, R⁴, R⁹ and R¹⁰) is, according to the
20 invention, generally a cyclic aliphatic radical having 5-20 carbon atoms. Preferred cycloalkyl radicals are cyclopentyl and cyclohexyl.

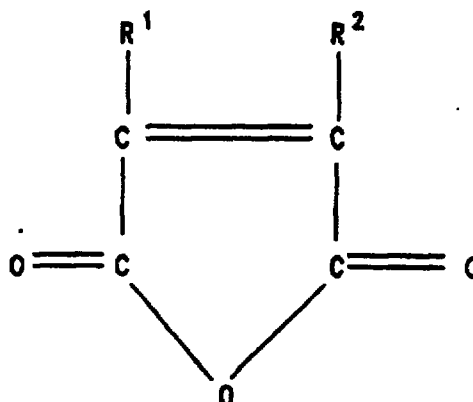
- The terpolymers of the invention comprise the bivalent structural units A, B, and/or C and also D and E. They
25 additionally contain only, in a manner known per se, the terminal groups formed during the polymerization by initiation, inhibition and chain termination.

- In detail, the structural units A, B and C are derived from α,β -unsaturated dicarboxylic anhydrides of the
30 formula F and/or G

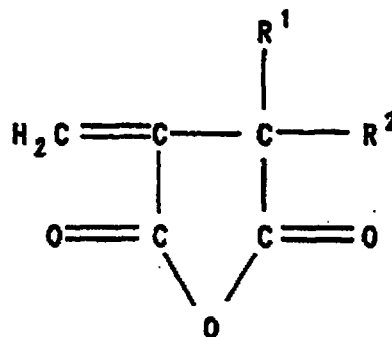
08 MAR 1997

- 7 -

(F)



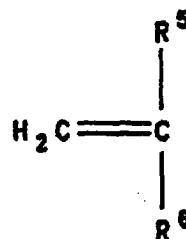
(G)



such as maleic anhydride, itaconic anhydride and citraconic anhydride, preferably maleic anhydride.

The structural units D are derived from the α,β -unsaturated compounds of the formula H.

(H)



- 5 Examples which may be mentioned are the following α,β -unsaturated compounds: styrene, α -methylstyrene, dimethylstyrene, α -ethylstyrene, diethylstyrene, i-propylstyrene, tert-butylstyrene, diisobutylene and

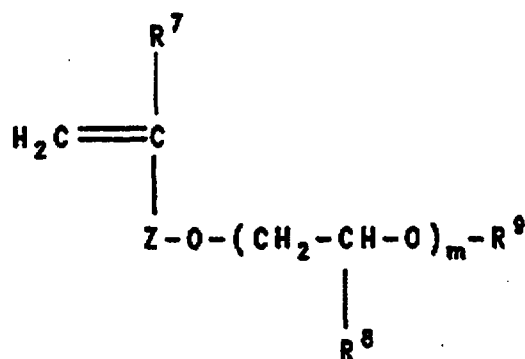
08 MAR 1997

- 8 -

α -olefins such as decene, dodecene, ~~tetradecene~~, pentadecene, hexadecene, octadecene, C_{20} - α -olefin, C_{24} - α -olefin, C_{30} - α -olefin, tripropenyl, tetrapropenyl, pentapropenyl and mixtures thereof. Preference is given to α -olefins having from 10 to 24 carbon atoms and styrene, particularly preference being given to α -olefins having from 12 to 20 carbon atoms.

The structural units E are derived from the polyoxyalkylene ethers of lower unsaturated alcohols of the formula J.

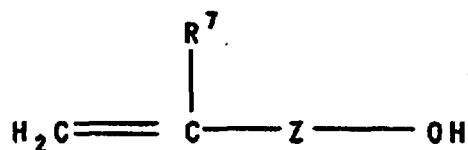
(J)



The monomers of the formula J are etherification products ($R^9 = -C(O)R^{10}$) or esterification products ($R^9 = -C(O)R^{10}$) of polyoxyalkylene ethers ($R^9 = H$).

The polyoxyalkylene ethers ($R^9 = H$) can be prepared by known processes by the addition reaction of α -olefin oxides, such as ethylene oxide, propylene oxide and/or butylene oxide, with polymerizable lower unsaturated alcohols of the formula K

(K)



Such polymerizable lower unsaturated alcohols are, for example, allyl alcohol, methylallyl alcohol, butenols such as but-3-en-1-ol and but-1-en-3-ol, or methyl-

08 MAR 1997

- 9 -

butenols such as 2-methylbut-3-en-1-ol, 2-methylbut-3-en-2-ol and 3-methylbut-3-en-1-ol. Preference is given to addition products of ethylene oxide and/or propylene oxide with allyl alcohol.

- 5 Subsequent etherification of these polyoxyalkylene ethers to form compounds of the formula J where $R^9 = C_1$ to C_{24} -alkyl, cycloalkyl or aryl is carried out by processes known per se. Suitable processes are known, for example, from J. March, Advanced Organic Chemistry, 2nd Edition, 10 p. 357 ff. (1977).

These etherification products of the polyoxyalkylene ethers can also be prepared by the addition reaction of α -olefin oxides, preferably ethylene oxide, propylene oxide and/or butylene oxide, with alcohols of the formula 15 L



in which R^9 is C_1 - C_{24} -alkyl, C_5 - C_{20} -cycloalkyl or C_6 - C_{18} -aryl, by known processes and reaction with polymerizable lower unsaturated halides of the formula M

(M)



- 20 where W is a halogen atom and R^7 and Z are as defined above. Preferred halides are the chlorides and bromides. Suitable methods of preparation are given, for example, in J. March, Advanced Organic Chemistry, 2nd Edition, p. 357 ff. (1977).

- 25 The esterification of the polyoxyalkylene ethers ($R^9 = -C(O)-R^{10}$) is carried out by reaction with common esterifying agents such as carboxylic halides, carboxylic

08 MAR 1997

- 10 -

anhydrides or carboxylic esters with C_1 - C_4 -alcohols. Preference is given to using the halides and anhydrides of C_1 - C_{40} -alkyl-, C_5 - C_{10} -cylcoalkyl- or C_6 - C_{18} -arylcarboxylic acids. The esterification is generally carried out at temperatures of from 0 to 200°C, preferably from 10 to 100°C. The carboxylic acid derivative is generally used in a stoichiometric amount based on the alcohol group of the polyoxyalkylene ether. However, it is possible to add the acid component in excess, for example in an excess from 20 to 100%, and also in a substoichiometric amount. The esterification is expediently carried out in a solvent. Suitable solvents are, for example, aromatic hydrocarbons, for example alkylaromatics such as toluene, xylene, trimethylbenzenes, dimethylethylbenzenes, dimethylnaphthalene, and mixtures of aromatics.

For the monomers of formula J, the index m gives the degree of alkoxylation, i.e. the number of moles of α -olefin oxide adducted per mole of the formula K or L.

The structural unit A contains the groups $-NHR^3$, $-N(R^3)_2$, and/or $-OR^4$, which are derived from primary amines of the formula (N) NH_2R^3 , the secondary amines of the formula (P) and the alcohols of the formula (Q) $HO-R^4$.

Examples which may be mentioned of primary amines are: n-hexylamine, n-octylamine, n-tetradecylamine, n-hexadecylamine, n-stearylamine and N,N-dimethylaminopropylenediamine, cyclohexylamine, dehydroabietylamine and mixtures thereof.

Examples which may be mentioned of secondary amines are: didecylamine, ditetradecylamine, distearylamine, dicoconut fatty amine and ditallow fatty amine, and mixtures thereof.

In the context of the invention, relatively short and/or long-chain alcohols (C_6 - C_{40}) of the formula



are used.

08 MAR 1997

- 11 -

Alcohols of this type are known per se. Examples which may be mentioned are n-butanol, n-hexanol, n-octanol, n-dodecanol and, as relatively long-chain alcohols, stearyl alcohol, behenyl alcohol or the alcohols known as [®]Alfols (Condea) which have a hydrocarbon-chain length of up to 40 carbon atoms.

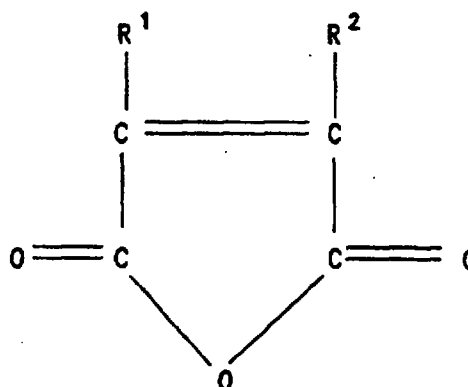
According to the invention, a cation (R^4) is an ammonium cation of the formula $H_2N^+(R^3)_2$ or $H_3N^+R^3$.

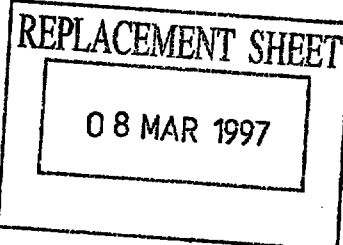
The terpolymers of the invention possess K values (measured by the method of Ubbelohde in 5% strength by weight solution in toluene at 25°C) of from 8 to 100, preferably from 8 to 50, corresponding to average molecular weights ($\bar{M}_w$) of between about 500 and 100,000.

The proportion of the individual bivalent structural units A to E in the terpolymers of the invention is essentially determined by the mixing ratios of the reactants used.

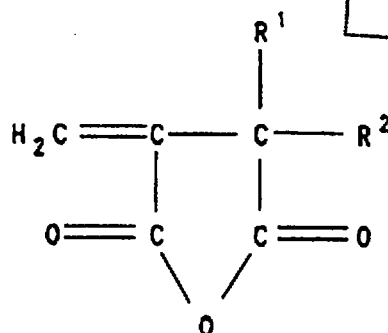
The invention also provides a process for preparing the terpolymers of the invention based on α, β -unsaturated dicarboxylic anhydrides, α, β -unsaturated compounds and polyoxyalkylene ethers of lower unsaturated alcohols, which comprises first polymerizing with one other monomers of the formula F and/or G

(F)



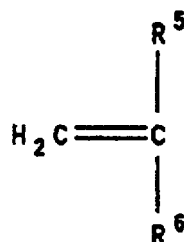


(G)



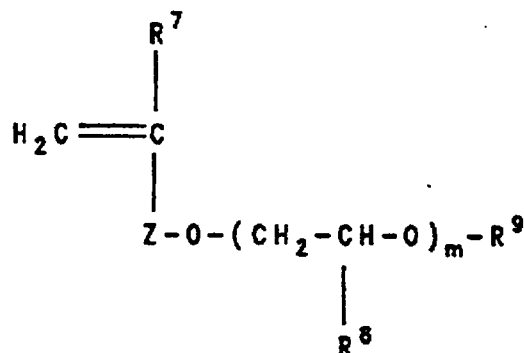
where R^1 and R^2 are, independently of one another, hydrogen or methyl,
monomers of the formula H

(H)



where R^5 is hydrogen or $\text{C}_1\text{-C}_4$ -alkyl and R^6 is $\text{C}_6\text{-C}_{60}$ -alkyl
or $\text{C}_6\text{-C}_{10}$ -aryl,
and monomers of the formula J

(J)



in which

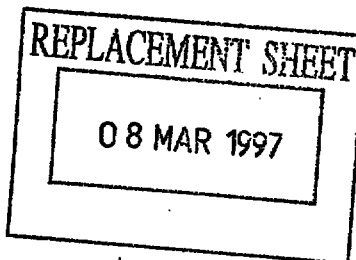
R^7 is hydrogen or methyl,

R^8 is hydrogen or $\text{C}_1\text{-C}_4$ -alkyl,

10 Z is $\text{C}_1\text{-C}_4$ -alkylene,

m is a number from 1 to 100,

R^9 is $\text{C}_1\text{-C}_{24}$ -alkyl, $\text{C}_5\text{-C}_{20}$ -cycloalkyl, $\text{C}_6\text{-C}_{10}$ -aryl or



-C(O)-R¹⁰, where

R¹⁰ is C₁-C₄₀-alkyl, C₅-C₁₀-cycloalkyl or C₆-C₁₈-aryl,

and subsequently reacting the product with primary and/or secondary amines of the formulae

5 (N) -N-HR³,

(P) -N-(R³)₂,

where R³ is C₆-C₄₀-alkyl, C₅-C₂₀-cycloalkyl or C₆-C₁₈-aryl, and/or alcohols of the formula

(Q) HO-R⁴,

10 where R⁴ is hydrogen, a cation of the formula H₂N⁺(R³)₂ or H₃N⁺R³, C₆-C₄₀-alkyl, C₅-C₂₀-cycloalkyl or C₆-C₁₈-aryl, preferably phenyl.

The polymerization is carried out using known batch or continuous polymerization processes, such as bulk,
15 suspension, precipitation or solution polymerization, and initiation by suitable free-radical initiators, for example hydroperoxides, peroxides or azo compounds, such as dilauroyl peroxide, dibenzoyl peroxide, t-butyl
20 peroxide, t-butyl permaleate, t-butyl perbenzoate, dicumyl peroxide, t-butyl cumyl peroxide, di-t-butyl peroxide, cumene hydroperoxide, t-butyl hydroperoxide, 2,2'-azo-bis(2-methylpropanonitril), 2,2'-azobis(2-methylbutyronitril) and mixtures of these. These initiators are generally used in amounts of from 0.1 to 20% by
25 weight, preferably from 0.2 to 10% by weight, based on the monomers.

The molar ratios between the α,β -unsaturated dicarboxylic anhydrides, α,β -unsaturated compounds and polyoxyalkylene ethers of lower unsaturated alcohols are between 1 :
30 0.5 - 2 : 0.01 - 0.5, preferably 1 : 0.9 - 1.1 : 0.04 - 0.2.

The polymerization is generally carried out at temperatures of 40-400°C, preferably 80-250°C, and when α,β -unsaturated compounds or solvents having boiling points
35 below the polymerization temperature are used, it is expediently carried out under pressure. The

polymerization is expediently carried out with the exclusion of air, for example under nitrogen, since oxygen interferes with the polymerization. When selecting the initiator or the initiator system it is expedient to ensure that the half-life of the initiator or the initiator system is less than 3 hours at the selected polymerization temperature.

To obtain low-molecular-weight copolymers it is frequently expedient to carry out the polymerization in the presence of regulators known per se. Suitable regulators are, for example, organic mercapto compounds, such as 2-mercaptoethanol, 2-mercaptopropanol, mercaptoacetic acid, mercaptopropionic acid, tert-butyl mercaptan, n-butyl mercaptan, n-octyl mercaptan, n-dodecyl mercaptan and tert-dodecyl mercaptan, which are generally used in amounts of from 0.1% by weight to 10% by weight.

Suitable apparatuses for the polymerization are, for example, conventional stirred reactors with, for example, anchor, blade, impeller or multistage-impulse counter-current stirrer, and for continuous production, cascades of stirred reactors or static mixers.

A preferred process for preparing the terpolymers of the invention is solution polymerization. It is carried out in solvents in which the monomers and terpolymers formed are soluble. Suitable solvents are all those which fulfil this requirement and do not undergo reaction with the monomers or with the terpolymers formed. For example, these are organic, preferably aromatic, solvents such as cumene, toluene, xylene, ethylbenzene or commercial solvent mixtures such as [®]Solvent Naphtha, [®]Shellsol AB or [®]Solvesso 150, 200, 250.

In the preparation, all the monomers can be initially charged and polymerized by addition of a free-radical initiator and application of heat. However, the solvent and a proportion of the monomers (for example about 5-20%) is

08 MAR 1997

- 15 -

expediently charged initially and the remainder of the monomer mixture metered in with the initiator and any coinitiator and regulator used. Preferably, the solvent and α,β -unsaturated compounds of the formula H, particularly C_4-C_{60} - α -olefins, are initially charged into the polymerization reactor and after the polymerization temperature has been attained the acid anhydride group-containing monomer of the formula F and/or G and also the monomer of the formula J, both dissolved in solvent if desired, and the initiator and also any coinitiator and regulator used are metered in.

The concentration of the monomers to be polymerized is between 20 and 95% by weight, preferably between 50 and 90% by weight.

The solid terpolymer can be isolated by precipitation with suitable non-solvents, such as acetone or methanol, or by evaporation of the solvent. However, it is expedient to select for the polymerization a solvent in which the further reaction with amines and/or alcohols can be carried out. Generally it is an advantage to use the anhydrides of the dicarboxylic acids instead of the free acids for the polymerization, since these react better with olefins and can subsequently be reacted selectively with amines and/or alcohols. The use of the corresponding dicarboxylic acids, is, however, not excluded.

After the polymerization, the reaction with amines of the formula N or P and/or alcohols of the formula Q is carried out.

The reaction of the terpolymers with the primary and/or secondary amines is carried out at temperatures between 30 and 250°C over a period of from 0.5 to 20 hours. The primary and/or secondary amine, preferably fatty amine, is used in amounts from about 1 to 2 mol per mol of copolymerized dicarboxylic anhydride, i.e. about 0.9-2.5

08 MAR 1997

- 16 -

mol per mol. The use of larger or smaller amounts is possible, but gives no advantage.

5 If 2 mol of a secondary amine are used, amide-ammonium salts are obtained at low reaction temperatures (30-120°C). The formation of a second amide group requires temperatures above 120°C, longer residence times and removal of water. If amounts of less than 1 mol are used, complete conversion to the monoamide does not take place. The selection of the reaction conditions/derivative
10 depends on the application.

In the reaction of the terpolymers with primary and/or secondary amines N or P and/or alcohols of the formula Q, the reaction of the terpolymers with the alcohol to give the mono- or diester is expediently carried out first.
15 The degree of reaction of the anhydride groups with the alcohols is generally between 60 and 95 mol %. The entire amount or a proportion of the partially esterified terpolymers are then reacted with the primary and/or secondary amines to give amides, ammonium salts, diamides
20 and/or cyclic imides.

Most expediently, the preparation of the terpolymers of the invention proceeds by first carrying out the reaction with the alcohols of the formula Q in solution, suspension or melt to give the mono- or diesters. To
25 accelerate the di-esterification, which proceeds with elimination of water, catalysts, generally acids such as sulphuric acid or p-toluenesulphonic acid, may be added. To remove the water of reaction, the reaction is preferably carried out either in suspension or solution
30 using a water-immiscible solvent, such as toluene or xylene, and the water of reaction is distilled off azeotropically. If the terpolymer to be reacted is insoluble in the solvent at the beginning of the reaction, it dissolves with increasing degree of esterification so at the end of the reaction a clear solution is
35 formed.

08 MAR 1997

- 17 -

The preferred temperature range for the formation of the mono- or diesters is in the range 60-180°C, preferably 80-140°C.

5 Subsequent to the mono-esterification, the amidation with primary and/or secondary amines of the formulae N and/or P is carried out, preferably in the same solvent, in the temperature range 50-250°C, preferably 100-200°C, the water being likewise removed azeotropically.

10 However, it is also possible to carry out the amidation reaction simultaneously with or prior to the esterification reaction. In the case of simultaneous esterification and amidation, the starting terpolymer is reacted with a mixture of alcohols of the formula Q and/or primary and/or secondary amines of the formulae N
15 and/or P.

The terpolymers of the invention are particularly suitable as paraffin inhibitors for paraffin-containing crude oils and petroleum products which contain paraffin waxes, asphaltenes, resins, etc. Examples of paraffin-containing
20 petroleum products in the context of the invention are crude oils, distillation residues from petroleum refining or other paraffin-containing oils such as middle distillates (cf. for example, Compositions and Properties of Petroleum, F. Enke Publishers, Stuttgart, 1981, pages
25 1-37).

Paraffins here may be straight-chain or branched alkanes having about 10-50 carbon atoms.

The concentrations in which the paraffin inhibitors of the invention are used are generally 10-10,000 ppm, preferably 20-5,000 ppm, particularly preferably 50-1,000
30 ppm, in the petroleum product.

The optimum use concentration for a particular paraffin-containing oil can in each case be determined, for

08 MAR 1997

- 18 -

example, by determination of the pour point (DIN ISO 3016).

5 In the case of crude oils, for example, the addition of the paraffin inhibitors of the invention may take place either in the well or during transport, storage or further processing.

10 It has been found that the terpolymers of the invention in admixture with ethylene-vinyl ester copolymers possess an excellent action as paraffin dispersants in middle distillates. Furthermore, the terpolymers of the invention in admixture with ethylene-vinyl ester copolymers are suitable for lowering the cloud point (CP) in middle distillates. These mixtures usually contain from 50 to 1,000 ppm, preferably from 50 to 500 ppm, of the terpolymers of the invention and from 50 to 1,000 ppm, preferably from 50 to 500 ppm, of ethylene-vinyl ester copolymers. However, in addition to these copolymers, terpolymers which contain further comonomers besides ethylene and vinyl esters can equally be used. The terpolymers of the invention and ethylene-vinyl ester copolymers can also be added individually to middle distillates which already contain one of these components.

25 Suitable vinyl ester monomers are C_1 - C_{20} -alkylvinyl esters, preferably C_1 - C_{12} -alkylvinyl esters such as vinyl acetate, vinyl propionate, vinyl neononanoate and vinyl neodecanoate and also vinyl esters of saturated C_{10} - C_{24} fatty acids. Further suitable comonomers are esters of unsaturated carboxylic acids, preferably the C_1 - C_{24} -alkyl esters of acrylic acid, methacrylic acid and fumaric acid, and also C_1 - C_{10} -alkylvinyl esters, diisobutylene, dimethylvinylcarbinol and vinyl methoxyacetate.

35 Such ethylene-vinyl ester copolymers and terpolymers are described in detail in the patent literature. For example, mention may be made of DE-B-11 47 799

(ethylene-vinyl acetate), DE-A-32 47 753 (ethylene-
 alkenecarboxylic ester, vinyl carboxylate-vinyl ketone),
 US-A-4 015 063 (ethylene, dimethylvinylcarbinol, vinyl
 esters of fatty acids), EP-A-203 554 (ethylene-diiso-
 5 butylene-vinyl acetate), EP-A-309 897 (ethylene-vinyl
 methoxyacetate), and DE-A-40 42 206 (ethylene-
 vinylacetate-vinyl neononanoate or neodecanoate).

Preferred copolymers are those which essentially comprise
 80 - 51 % by weight of ethylene and
 10 20 - 49 % by weight of vinyl acetate or vinyl propionate.

Preferred terpolymers comprise
 79 - 40 % by weight of ethylene,
 20 - 35 % by weight, preferably 1 - 15 % by weight, of
 vinyl acetate or vinyl propionate,
 15 and
 1 - 25 % by weight, preferably 1 - 15 % by weight, of
 diisobutylene, vinyl neononanoate or vinyl neodecanoate.

Furthermore, it has been found that mixtures of the
 terpolymers of the invention, the above-described
 20 ethylene-vinyl ester copolymers and certain quaternary
 ammonium salts possess an excellent action as paraffin
 dispersants in middle distillates.

Suitable quaternary ammonium salts possess the formula



25 where R^{11} may be identical or different and is C_1 - C_{30} -
 alkyl, preferably C_1 - C_{22} -alkyl, C_1 - C_{30} -alkenyl, preferably
 C_1 - C_{22} -alkenyl, benzyl or a radical of the formula
 $-(CH_2-CH_2-O)_n-R^{12}$, where R^{12} is hydrogen or a fatty acid
 radical of the formula $C(O)-R^{13}$, with R^{13} being C_6 - C_{40} -alkyl
 30 or C_6 - C_{40} -alkenyl, n is a number from 1 to 30 and X is
 halogen, preferably chlorine, or methosulphate.

Examples which may be mentioned of such quaternary
 ammonium salts are: dihexadecyldimethylammonium chloride,
 distearyldimethylammonium chloride, quaternization

products of esters of di- and triethanolamine with long-chain fatty acids (lauric acid, myristic acid, palmitic acid, stearic acid, behenic acid, oleic acid and mixtures of fatty acids such as coconut fatty acid, tallow fatty acid, hydrogenated tallow fatty acid and tall oil fatty acid), such as the distearyl ester of N-methyltriethanolammonium chloride, the distearyl ester of N-methyltriethanolammonium methosulphate, the distearyl ester of N,N-dimethyldiethanolammonium chloride, the dioleyl ester of N-methyltriethanolammonium chloride, the trilauryl ester of N-methyltriethanolammonium methosulphate, the tristearyl ester of N-methyltriethanolammonium methosulphate and mixtures thereof.

These mixtures usually comprise from 50 to 1000 ppm, preferably from 50 to 500 ppm, of the terpolymers of the invention, from 50 to 1000 ppm, preferably from 50 to 500 ppm, of ethylene-vinyl ester copolymers and from 50 to 1000 ppm, preferably from 50 to 500 ppm, of the quaternary ammonium salts.

The invention also provides the petroleum products stabilized against paraffin deposition by means of the paraffin inhibitors of the invention. The terpolymers and terpolymer/coadditive mixtures of the invention improve the low temperature behavior of these oils and thus improve the flow behavior in comparison with the prior art. In particular, the pour point and the viscosity are improved.

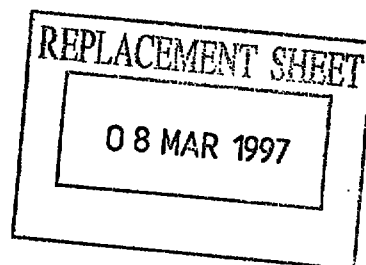
The improvement in the flow behavior can be established, for example, by determination of the pour point (in accordance with ASTM standard No. 97 B, Section 6 f) by measurements of the amounts of paraffin precipitated and also by viscosity measurements. The first method in particular, is widely used in practice and is usually matched to the practical conditions used in screening tests (for example, addition of the additive at 50°C (actual pour point)).

08 MAR 1997

- 21 -

The dispersion of the paraffin in middle distillates can be checked by storage of the additive-containing oil samples in a freezer at temperatures between -13 and -20°C (carried out in accordance with M. Feustel et al., Science & Technology, Vol. 43, p. 396, Fig. 2 (1990))

5 with subsequent visual assessment of the sedimentation behavior and also determination of the CFPP value after separation of the oil sample into an upper and lower phase (EN 116).



Examples

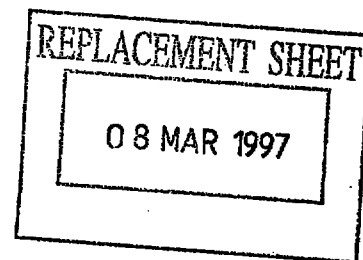
General preparative procedure

The polymerization is carried out in a 2 l five-neck flask (having additional Claisen attachments if desired) fitted with anchor stirrer, reflux condenser, internal thermometer, gas inlet tube and up to 3 (heatable) dropping funnels. The solutions initially charged for polymerization are flushed with nitrogen prior to and during the polymerization. The intrinsic viscosity values K are determined by the method of Ubbelohde in toluene at a polymer concentration of 5 % by weight. IR spectra are obtained from 1 % strength by weight solutions in chloroform.

The allyl methyl polyglycols used are commercial products from Hoechst AG having the following characteristics:
®Polyglycol AM 250: average molecular weight = 250 g/mol
®Polyglycol AM 350: average molecular weight = 350 g/mol.
®Shellsol AB and Solvent Naphtha are commercial aromatic solvent mixtures boiling above 180°C from Shell and Veba Oel respectively.

Example 1: Terpolymer of C_{18} - α -olefin, maleic anhydride and ®Polyglycol AM 350 in toluene

A solution of 277.2 g (1.1 mol) of octadec-1-ene in 50 g of toluene is heated to 100°C while passing in a stream of nitrogen. While stirring vigorously at this temperature, 88.2 g (0.9 mol) of molten maleic anhydride, 35 g (0.1 mol) of ®Polyglycol AM 350 and also an initiator solution comprising 3.5 g of tert-butyl peroxybenzoate and 3.5 g of tert-butyl peroxy-2-ethylhexanoate in 55.8 g of toluene are metered in from separate dropping funnels over a period of 3 hours. The mixture is stirred for a further 2 hours at 100°C. The resulting reddish brown polymer solution has a solids content of 48.2 % and contains no unreacted maleic anhydride. The polymer has an K value of 16. IR bands at 1775 and 1855 cm^{-1} show the



presence of anhydrides.

Example 2: Terpolymer of C_{18} - α -olefin, maleic anhydride and $\textcircled{P}$ olyglycol AM 350 in Shellsol AB

A solution of 252 g (1.0 mol) of C_{18} - α -olefin in 115 g of Shellsol AB is heated to 160°C while passing in a stream of nitrogen. Over a period of 2 hours, 98 g (1.0 mol) of molten maleic anhydride, a solution of 3.5 g of di-tert-butyl peroxide and 3.5 g of tert-butyl peroxybenzoate in 85 g of Shellsol AB and also 70 g (0.2 mol) of $\textcircled{P}$ olyglycol AM 350 in 73.7 g of Shellsol AB are continuously added dropwise from separate dropping funnels. The mixture is stirred for a further 2 hours at 180°C. The resulting orange polymer solution has a dry residue of 46.2 %; the resulting polymer has a K value of 17.

Example 3: Terpolymer of C_{18} - α -olefin, maleic anhydride and $\textcircled{P}$ olyglycol AM 350 in Shellsol AB

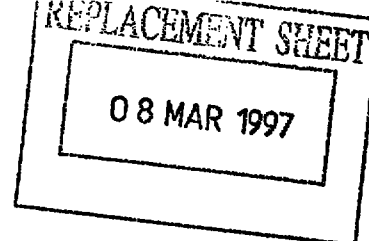
A solution of 302.4 g (1.2 mol) of C_{18} - α -olefin in 115 g of Shellsol AB is heated to 180°C while passing in a stream of nitrogen. Over a period of 2 hours, 88.2 g (0.9 mol) of molten maleic anhydride, a solution of 7 g of di-tert-butyl peroxide in 85 g of Shellsol AB and also 17.5 g (0.05 mol) of $\textcircled{P}$ olyglycol AM 350 in 76.68 g of Shellsol AB are continuously added dropwise. The mixture is stirred for a further 1 hour at 180°C. The resulting polymer solution has a dry residue of 45.9 %; the resulting polymer has a K value of 17.

Example 4: Terpolymer of C_{18} - α -olefin, maleic anhydride and $\textcircled{P}$ olyglycol AM 250 in Shellsol AB

302.4 g of octadec-1-ene, 88.2 g of maleic anhydride and 12.5 g of $\textcircled{P}$ olyglycol AM 250 are polymerized at 180°C analogously to Example 3. The resulting polymer has a K value of 15.

Example 5: Terpolymer of C_{14-16} - α -olefin, maleic anhydride and $\textcircled{P}$ olyglycol AM 350 in Shellsol AB

252 g of a mixture of tetradecene and hexadecene (1:1),



- 24 -

88.2 g of maleic anhydride and 17.5 g of [®]Polyglycol AM 350 are polymerized at 180°C analogously to Example 3. The resulting polymer has a K value of 15.

5 Example 6: Terpolymer of C₂₀₋₂₄-α-olefin, maleic anhydride and [®]Polyglycol AM 350 in Shellsol AB

396.6 g (1.2 mol) of a C₂₀₋₂₄-α-olefin, 88.2 g of maleic anhydride and 17.5 g of [®]Polyglycol AM 350 are polymerized at 180°C analogously to Example 3. The resulting polymer has a K value of 18.

10 Example 7: Terpolymer of styrene, maleic anhydride and [®]Polyglycol AM 350

15 To a solution of 98 g (1.0 mol) of maleic anhydride in 300 g of Shellsol AB are added dropwise, while stirring and passing in a stream of nitrogen, 99 g (0.95 mol) of styrene, a solution of 4.0 g of di-tert-butyl peroxide in 50 g of Shellsol AB and also a solution of 17.5 g (0.05 mol) of [®]Polyglycol AM 350 in 50 ml of Shellsol AB in parallel at 160°C over a period of 4 hours. A pale brown, 35 % strength by weight polymer solution results.

20 Example 8: Terpolymer of C₁₁-α-olefin, maleic anhydride and stearyl ester of allylpolyglycol

25 277.2 g (1.2 mol) of C₁₁-α-olefin, 88.2 g (0.9 mol) of maleic anhydride and 17.5 g of the stearyl ester of allylpolyglycol (prepared by esterification of stearic acid with an ethoxylate of allyl alcohol containing 6 mol of ethylene oxide) are polymerized at 180°C analogously to Example 3. The resulting polymer has a K value of 18.

Example 9: Terpolymer of C_{14/16}-α-olefin, maleic anhydride and allylbutylpolyglycol

30 334 g of a mixture of tetradecene and hexadecene (1:1), 118 g of maleic anhydride and 107 g of allylbutylpolyglycol (containing 24 mol of ethylene oxide and 8 mol of propylene oxide) in 376 g of Solvent Naphtha are polymerized at 180°C analogously to Example 3. The
35 resulting polymer has a K value of 16.

08 MAR 1997

- 25 -

Example 10: Terpolymer of $C_{14/16}$ - α -olefin, maleic anhydride and allylbutylpolyglycol

334 g of a mixture of tetradecene and hexadecene (1:1), 118 g of maleic anhydride and 107 g of allylbutyl-
5 polyglycol (containing 15 mol of ethylene oxide and 15 mol of propylene oxide) in 376 g of Solvent Naphtha are polymerized at 180°C analogously to Example 3. The resulting polymer has a K value of 17.

Example 11: Reaction of the terpolymer of Example 1 with
10 ditallow fatty amine to give the amide-ammonium salt
132.6 g of the polymer solution of Example 3 are admixed at 80°C with 100 ml of toluene and 190 g of ditallow fatty amine and stirred for 2 hours at this temperature. The titratable nitrogen of the 66.5 % strength by weight
15 polymer solution is 0.73 %. The IR spectrum shows no anhydride bands; bands at 1565 and 1620 cm^{-1} show the formation of an amide-ammonium salt.

Example 12: Reaction of the terpolymer of Example 5 with
ditallow fatty amine
20 50 g of the polymer solution of Example 5, containing 0.086 mol of anhydride groups, are admixed at 75°C with 84 g of Shellsol AB and 86 g of ditallow fatty amine and stirred for 3 hours at this temperature. The titratable basic nitrogen of the 50 % strength polymer solution is
25 0.8 %.

Example 13: Reaction of the terpolymer of Example 5 with distearylamine
Analogously to Example 12, 50 g of the polymer solution of Example 5 are reacted with distearylamine.

30 Example 14: Reaction of the terpolymer of Example 3 with distearylamine
100 g of the polymer solution of Example 3, containing 0.13 mol of anhydride groups, are admixed at 80°C with a solution of 130 g (0.26 mol) of distearylamine in 100 g
35 of xylene and stirred for 3 hours at 150°C. The

08 MAR 1997

- 26 -

titratable basic nitrogen of the 50 % strength by weight polymer solution is 0.51 %.

Example 15: Reaction of the terpolymer of Example 3 with dicoconut fatty amine

5 100 g of the polymer solution of Example 3, containing 0.13 mol of anhydride groups, are admixed at 80°C with a solution of 100 g (0.26 mol) of dicoconut fatty amine in 100 g of xylene and stirred for 3.5 hours at 160°C. The titratable basic nitrogen of the 50 % strength by weight
10 polymer solution is 0.62 %.

Example 16: Reaction of the terpolymer of Example 3 with stearylamine and ditallow fatty amine

100 g of a polymer solution of Example 3, containing 0.13 mol of anhydride groups, are admixed at 80°C with
15 33.9 g (0.13 mol) of stearylamine and stirred for 2 hours at this temperature. Subsequently 65 g (0.13 mol) of ditallow fatty amine in 93 g of xylene are added and the mixture is boiled for 3 hours at 150°C on a water separator. The titratable basic nitrogen of the 50 %
20 strength by weight polymer solution is 0.15 %.

Example 17: Reaction of the terpolymer of Example 7 with ditallow fatty amine

To 50 g of the polymer solution of Example 7, containing 0.063 mol of anhydride, is added a solution of 63.2 g
25 (0.126 mol) of ditallow fatty amine in 58.6 g of Shellsol AB at a temperature of 75°C while stirring. The mixture was stirred for a further 2 hours at this temperature. The resulting 50 % strength by weight polymer solution contains 0.78 % of titratable basic nitrogen.

30 Example 18: Reaction of the terpolymer of Example 1 with behenyl alcohol

181.0 g of the polymer solution (corresponding to 0.3 mol of maleic anhydride) of Example 1 and 94.1 g (0.3 mol) of behenyl alcohol are boiled under reflux for 3 hours at
35 150°C. The acid number is 58.

Example 19: Neutralization of the partially esterified terpolymer of Example 18 with distearylamine

The partially esterified terpolymer solution of Example 18 is neutralized at 70°C by addition of 143.6 g (0.3 mol) of molten distearylamine and is stirred for 1 hour at 70°C. The resulting, highly viscous, pale yellow polymer solution has a solids content of 78 % and titratable basic nitrogen of 0.91 %.

Example 20: Amidation of the partially esterified terpolymer of Example 18 with distearylamine

The partially esterified terpolymer solution of Example 18 is admixed with 143.6 g (0.3 mol) of distearylamine and 226 g of toluene and boiled for 3 hours at 130-140°C on a water separator. The resulting 51 % strength polymer solution contains 0.02 % of titratable basic nitrogen. IR bands at 1735 and 1620 cm^{-1} show the presence of ester and amide groups.

Example 21: Reaction of the terpolymer of Example 1 with benzyl alcohol and subsequent neutralization with distearylamine

216.6 g of the polymer solution of Example 1 and 34.2 g (0.32 mol) of benzyl alcohol are boiled under reflux for 3 hours at 140°C. The acid number of the partially esterified polymer solution is 80. After cooling to 45°C, 155.9 g of molten distearylamine are added, a temperature rise of 3°C occurring. The mixture is stirred for 1 hour at 45°C and subsequently discharged. The 80 % strength by weight, highly viscous product has a titratable basic nitrogen of 0.98 %.

Example 22: Reaction of the terpolymer of Example 1 with distearylamine

To 620 g of the polymer solution of Example 1 are added 467 g (1 mol) of distearylamine at 160°C over a period of 4 hours and the mixture is maintained at this temperature for 1 hour. The titratable basic nitrogen of the 49 % strength by weight polymer solution is 0.27 %. IR bands

08 MAR 1997

- 28 -

at 1620 and 1720 cm^{-1} indicate the presence of amide and carboxylic acid units.

Example 23: Reaction of the terpolymer of Example 9 with distearylamine and dicoconut fatty amine

5 62 g of the polymer solution of Example 9 (corresponding to 0.08 mol of anhydride groups) are admixed at 90°C with a mixture of 39 g (0.078 mol) of distearylamine and 32 g (0.078 mol) of dicoconut fatty amine in 72 g of Solvent Naphtha and the mixture is stirred for 3 hours at this
10 temperature. The titratable basic nitrogen of the 49 % strength polymer solution is 0.64 %.

Example 24: Reaction of the terpolymer of Example 10 with distearylamine and dicoconut fatty amine

62 g of the polymer solution of Example 10 (corresponding to 0.08 mol of anhydride groups) are admixed at 90°C with
15 a mixture of 39 g (0.078 mol) of distearylamine and 32 g (0.078 mol) of dicoconut fatty amine in 72 g of Solvent Naphtha and the mixture is stirred for 3 hours at this temperature. The titratable basic nitrogen of the 50 %
20 strength polymer solution is 0.65 %.

Example 25: Preparation of a copolymer of maleic anhydride and C_{18} - α -olefin and subsequent reaction with ditallow fatty amine (comparison)

Analogously to Example 1, a solution of 277 g (1.1 mol)
25 of C_{18} - α -olefin in 150 g of toluene is heated to 100°C while passing in nitrogen. While stirring vigorously, 98 g (1 mol) of molten maleic anhydride and a solution of 3.5 g of tert-butyl peroxybenzoate and 3.5 g of tert-butyl peroxy-2-ethylhexanoate in 55.8 g of toluene are
30 metered in over a period of 3 hours. The mixture is stirred for a further 3 hours. The resulting copolymer has a K value of 16. Analogously to Example 9, 85.8 g of the above polymer solution (containing 0.15 mol of anhydride groups) are converted into the amide-ammonium
35 salt with 142 g (0.3 mol) of ditallow fatty amine.

Applicational testing

1. Pour-point depressor for crude oils

The effectiveness of the terpolymers of the invention as flow improvers for mineral oils is described by the determination of the pour points in accordance with DIN ISO 3016. In this method, the crude oil samples with and without addition of the terpolymers are tested for flowability under defined conditions after prior heating and subsequent defined cooling. Pour point tests with the terpolymers of the invention were undertaken on two Columbian crude oils which in the untreated state had pour points of 13.5°C (crude oil A) and 6°C (crude oil B).

Product	Amount added	Pour Point	
		Crude Oil A	Crude Oil B
Terpolymer of Example 11	300 ppm	10.3°C	-1.9°C
	500 ppm	8.4°C	-2.1°C
	1000 ppm	5.3°C	-3.5°C
Terpolymer of Example 18	300 ppm	9.5°C	-1.3°C
	500 ppm	7.9°C	-4.1°C
	1000 ppm	3.5°C	-15.2°C

2. Paraffin dispersants for middle distillates

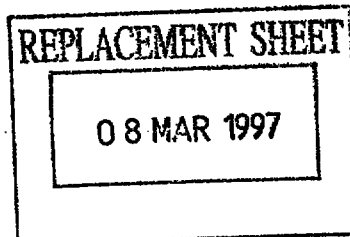
For the following tests, eight typical, representative winter diesel fuels from German refineries were used. These are hereinafter referred to as middle distillate I to VIII.

	Middle distillate I	Middle distillate II	Middle distillate III	Middle distillate IV	Middle distillate V	Middle distillate VI	Middle distillate VII	Middle distillate VIII
Cloud Point (CP) (°C)	-5	-6	-8	-8	-8	-6	-1	+3
CFPP (°C)	-8	-10	-13	-10	-8	-11	-4	+/-0
Density/20°C (g/ml)	0.822	0.817	0.812	0.837	0.822	0.819	0.830	0.827
Initial boiling point (°C)	163	173	167	183	173	169	171	169
20 % boiling point (°C)	207	219	217	225	221	219	252	241
90 % boiling point (°C)	341	362	324	338	333	330	353	361
Final boiling point (°C)	373	382	359	361	358	362	368	384

- 30 -

08 MAR 1997

REPLACEMENT SHEET



The flow improvers (FI) are:

FI (A) ethylene-vinyl acetate copolymer (containing about 27 % of vinyl acetate)
melt viscosity (140°C) of 200 mPa.s

- 5 FI (B) ethylene-vinyl acetate copolymer (containing about 30 % of vinyl acetate)
average molecular weight of about 1500.

Description of the test method

10 The middle distillates are first tested separately, with flow improver and in combination with paraffin dispersant, for the turbidity and paraffin sedimentation phenomena induced by cold. After placing the samples in a freezer and running through a specific cooling programme (see M. Feustel et al., Science & Technology, 15 Vol. 43, p. 396, Fig. 2 (1990)), the samples are, after 72 hours, assessed at -13°C for dispersion. Middle distillate volumes of 20 ml and 100 ml are used for these tests. In addition, after the visual assessment of the 100 ml samples, the upper phase (50 % by volume) is drawn 20 off from these at low temperature. The cloud point (CP) and the cold filter plugging point (CFPP) are subsequently determined on both the upper and lower phases. The determination of the cloud point (CP) is carried out in accordance with DIN 51597 by cooling the 25 oil sample and optical measurement of the cloud point. The temperature at which the first paraffin precipitation leads to turbidity is the cloud point (CP). The measurement of the cloud point (CP) is carried out in a Herzog CP SC 815 apparatus. The cold filter plugging point 30 (CFPP) is determined in accordance with European Standard EN 116.

It can be seen that paraffin dispersion is achieved by adding the additives of the invention.

35 Furthermore, a lowering of the cloud point (CP) is achieved (Table IV).

08 MAR 1997

- 32 -

Abbreviations in the following tables:

	FI	=	Middle distillate flow improver
	PD	=	Paraffin dispersant
	PD(1)	=	of Example 11
5	PD(2)	=	of Example 12
	PD(3)	=	of Example 13
	PD(4)	=	of Example 14
	PD(5)	=	of Example 25 (comparative example)
	PD(6)	=	of Example 19
10	QAS	=	quaternary ammonium salt, here the distearyl ester of N-methyltriethanol- ammonium methosulphate

Assessment codes:

	C	=	clear
15	T	=	turbid
	ST	=	slightly turbid
	S	=	sediment
	D	=	dispersed, hardly any sediment

08 MAR 1997

- 33 -

Table I

Middle distillate I CP -5°C/CFPP -8°C							
FI	Conc. (ppm)	PD	Conc. (ppm)	QAS (ppm)	Oil phase	Sediment depth (cm)	Volume fraction (%)
FI(A)	100	-	-	-	C	1.6	15
FI(A)	400	-	-	-	C	1.9	17
FI(B)	100	-	-	-	C	1.4	13
FI(B)	400	-	-	-	C	1.7	15
FI(A)	400	PD(1)	200	-	T	0.8	7
FI(A)	400	PD(1)	400	-	T	0.5	5
FI(A)	400	PD(1)	300	200	T	0.0	0
FI(B)	400	PD(1)	300	150	T	0.1	1
Middle distillate II CP -6°C/CFPP -10°C							
FI	Conc. (ppm)	PD	Conc. (ppm)	QAS (ppm)	Oil phase	Sediment depth (cm)	Volume fraction (%)
FI(A)	100	-	-	-	C	1.4	13
FI(B)	100	-	-	-	C	1.0	9
FI(A)	200	-	-	-	C	1.4	13
FI(A)	200	PD(2)	200	-	ST	0.5	5
FI(A)	200	PD(2)	350	-	T	0.3	2
FI(A)	200	PD(2)	500	-	T	0.1	1
FI(A)	200	PD(4)	200	-	T	0.7	6
FI(B)	200	PD(4)	500	-	T	0.2	2

Middle distillate III CP -5°C/CFPP -8°C							
FI	Conc. (ppm)	PD	Conc. (ppm)	QAS (ppm)	Oil phase	Sediment depth (cm)	Volume fraction (%)
FI(B)	100	-	-	-	C	1.7	15
FI(B)	200	-	-	-	C	1.8	16
FI(B)	200	PD(3)	100	-	C	1.0	9
FI(B)	200	PD(3)	200	-	ST	0.5	5
FI(B)	200	PD(3)	300	-	T	0.2	2
FI(B)	200	PD(3)	500	-	T	0.2	2
FI(B)	2400	PD(3)	200	100	T	0.1	1
FI(B)	200	PD(3)	500	200	T	0.1	1

REPLACEMENT SHEET

08 MAR 1997

Table II

Middle distillates I CP -5°C/CPFF -8°C

FI	Conc. (ppm)	PD	Conc. (ppm)	QAS (ppm)	Paraffin sediment (% by volume)	Paraffin in oil phase	Dispersion	Lower phase		Upper phase	
								CP °C	CPFF °C	CP °C	CPFF °C
FI(A)	200	-	-	-	14	C	S	-1	-16	-10	-32
FI(A)	400	-	-	-	19	C	S	-1	-13	-11	-33
FI(A)	400	PD(1)	400	-	4	T	D	-1	-20	-13	-38
FI(A)	400	PD(1)	50	200	7	T	S	-2	-29	-13	-36
FI(A)	400	PD(1)	100	200	5	T	D	-2	-29	-12	-37
FI(A)	400	PD(1)	200	200	2	T	D	-3	-28	-11	-37
FI(A)	400	PD(1)	300	200	1	T	D	-4	-32	-11	-37
FI(A)	400	PD(5)	400	-	7	ST	S	-1	-17	-12	-34

- 35 -

08 MAR 1997

REPLACEMENT SHEET

Table III

Middle distillate I CP -5°C/CFPP -8°C

FI	Conc. (ppm)	PD (ppm)	Conc. (ppm)	QAS (ppm)	Paraffin sediment (% by volume)	Paraffin in oil phase	Dispersion	Lower phase		Upper phase	
								CP °C	CFPP °C	CP °C	CFPP °C
FI(B)	200	-	-	-	21	C	S	0	-11	-15	-30
FI(B)	200	PD(2)	250	-	10	C	S	-2	-19	-14	-24
FI(B)	200	PD(2)	200	150	8	ST	S	-2	-21	-14	-31
FI(B)	200	PD(2+3)	200	50	7	ST	D	-3	-28	-14	-31
FI(A)	200	-	-	-	19	C	S	-1	-10	-14	-28
FI(A)	200	PD(2)	250	-	8	ST	S	-2	-23	-12	-29
FI(A)	200	PD(2)	200	150	5	T	D	-3	-26	-12	-30

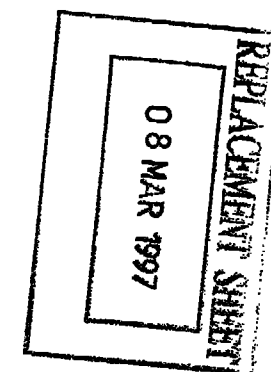
- 36 -

08 MAR 1997

REPLACEMENT SHEET

Table IV

Middle distillate	CP-Value (°C)				Difference (K)	
	Without additive	+ 150 ppm FI (A)	400 ppm PD (G)	800 ppm PD (G)	ΔT_1	ΔT_2
Middle distillate IV	-8.1	-8.1	-10.1	-10.9	2.0	2.0
" V	-8.4	-8.4	-10.7	-10.7	2.1	2.3
" VI	-5.7	-5.7	-7.4	-7.7	1.7	2.0
" VII	-0.9	-0.9	-2.1	-2.4	1.2	1.5
" VIII	+3.0	+3.0	+2.1	+1.2	0.9	1.8





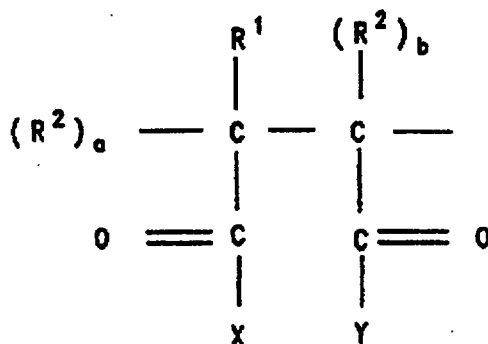
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08 MAR 1997

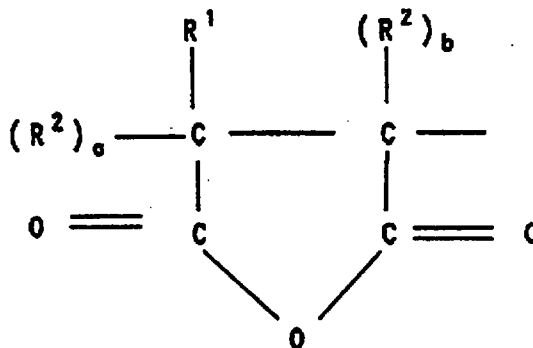
WHAT IS CLAIMED IS:

1. A terpolymer based on α,β -unsaturated dicarboxylic anhydrides, α,β -unsaturated compounds and polyoxyalkylene ethers of lower unsaturated alcohols, which comprises 20-80 mol %, preferably 40-60 mol %, of bivalent structural units A, B and/or C

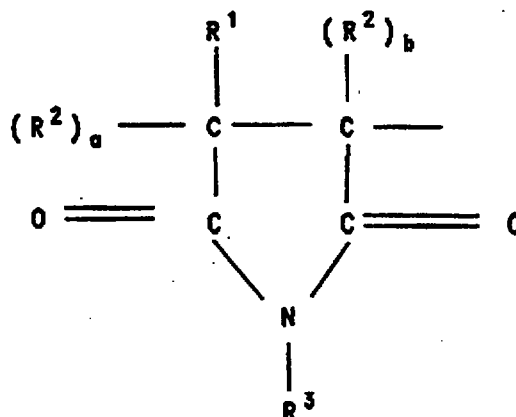
(A)



(B)



(C)



where

 R^1 and R^2 are, independently of one another, hydrogen

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ACEMENT SHEET

08 MAR 1997

- 39 -

or methyl,

a and b are zero or one and $a + b$ is one,

X and Y are identical or different and are

the $-N-HR^3$ group,

where R^3 is C_6-C_{40} -alkyl, C_5-C_{20} -cylcoalkyl or C_6-C_{18} -aryl,

the $-N-(R^3)_2$ group,

where R^3 is identical or different and is as defined above,

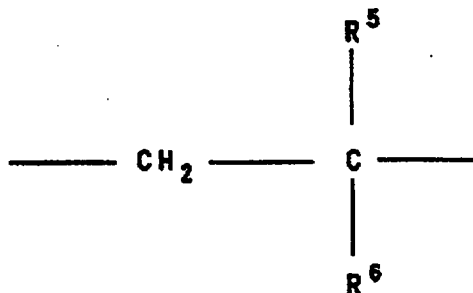
and/or

the $-O-R^4$ group,

where R^4 is hydrogen, a cation of the formula $H_2N^+(R^3)_2$, or $H_3N^+R^3$, C_6-C_{40} -alkyl, C_5-C_{20} -clycoalkyl or C_6-C_{18} -aryl, preferably phenyl,

19-80 mol %, preferably 39-60 mol %, of bivalent structural units D

(D)



in which

R^5 is hydrogen or C_1-C_4 -alkyl and

R_6 is C_6-C_{60} -alkyl or C_6-C_{18} -aryl,

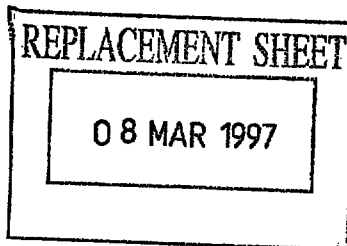
and

1-30 mol %, preferably 1-20 mol %, of bivalent structural units E



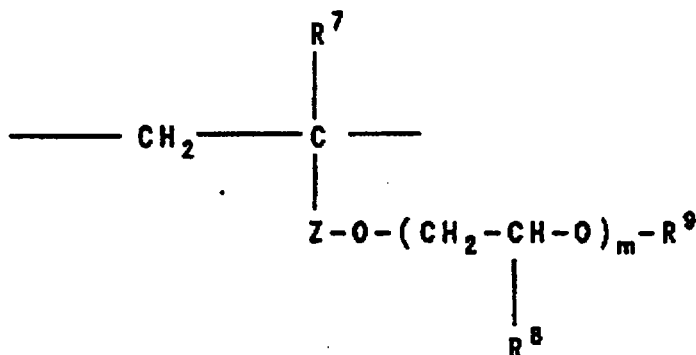
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- 40 -



(E)

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in which

R⁷ is hydrogen or methyl,

R⁸ is hydrogen or C₁-C₄-alkyl,

Z is C₁-C₄-alkylene,

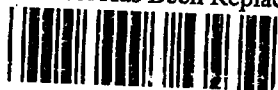
m is a number from 1 to 100,

R⁹ is C₁-C₂₄-alkyl, C₅-C₂₀-cylcoalkyl, C₆-C₁₈-aryl or -C(O)-R¹⁰, where

R¹⁰ is C₁-C₄₀-alkyl, C₅-C₁₈-cycloalkyl or C₆-C₁₈-aryl.

2. A terpolymer as claimed in claim 1, containing bivalent structural units of the formula A, in which X is a group of the formula O-R⁴, with R⁴ being C₆-C₄₀-alkyl and Y is a group of the formula O-R⁴, where R⁴ is a cation of the formula H₂N⁺(R³), with R³ being C₆-C₄₀-alkyl.
3. A terpolymer as claimed in claim 1, containing bivalent structural units of the formula A, in which X is a group of the formula -N(R³), with R³ being C₆-C₄₀-alkyl and Y is a group of the formula O-R⁴, where R⁴ is a cation of the formula H₂N⁺(R³), with R³ being C₆-C₄₀-alkyl.
4. A terpolymer as claimed in claims 2 or 3, wherein R³ and R⁴ are C₆-C₂₄-alkyl.

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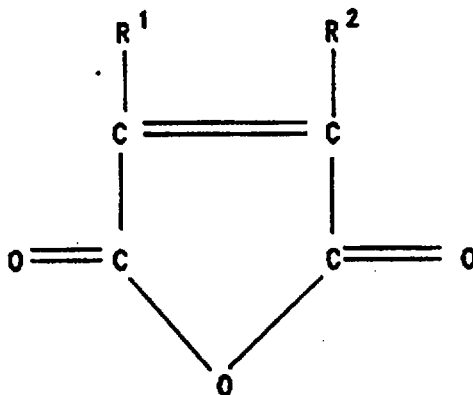
- 41 -

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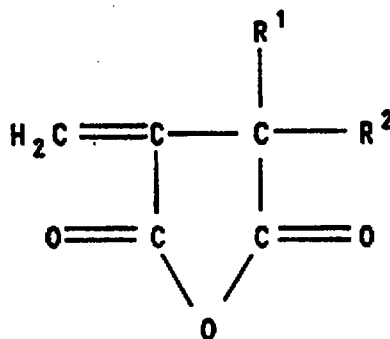
08 MAR 1997

5. A process for preparing the terpolymers as claimed in claim 1, which comprises polymerizing with one other monomers of the formula F and/or G

(F)

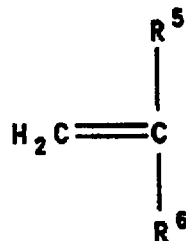


(G)



where R^1 and R^2 are, independently of one another, hydrogen or methyl,
monomers of the formula H

(H)



where R^5 is hydrogen or C_1 - C_4 -alkyl and R^6 is C_6 - C_{60} -alkyl or C_6 - C_{10} -aryl,
and monomers of the formula J



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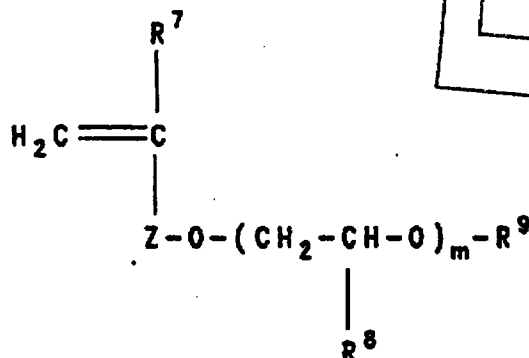
- 42 -

REPLACEMENT SHEET

08 MAR 1997

(J)

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in which

R^7 is hydrogen or methyl,

R^8 is hydrogen or C_1 - C_4 -alkyl,

Z is C_1 - C_4 -alkylene,

m is a number from 1 to 100,

R^9 is C_1 - C_{24} -alkyl, C_5 - C_{20} -cycloalkyl, C_6 - C_{18} -aryl or $-C(O)-R^{10}$, where

R^{10} is C_1 - C_{40} -alkyl, C_5 - C_{10} -cycloalkyl or C_6 - C_{18} -aryl,

and subsequently reacting the product with primary and/or secondary amines of the formulae

(N) $-N-HR^3$,

(P) $-N-(R^3)_2$,

where R^3 is C_6 - C_{40} -alkyl, C_5 - C_{20} -cycloalkyl or C_6 - C_{18} -aryl,

and/or alcohols of the formula

(Q) $HO-R^4$,

where R^4 is hydrogen, a cation of the formula $H_2N^+(R^3)_2$, or $H_3N^+R^3$, C_6 - C_{40} -alkyl, C_5 - C_{20} -cycloalkyl or C_6 - C_{18} -aryl, preferably phenyl.

6. The process as claimed in claim 5, wherein the polymerization is carried out in solution, suspension or melt, preferably in solution.
7. The process as claimed in claim 5, wherein the polymerization is carried out in a stirred reactor, a cascade of stirred reactors or a static mixer.

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REPLACEMENT SHEET

08 MAR 1997

- 43 -

8. The process as claimed in claim 5, wherein the molar ratio between the monomers of the formulae F and/or G, H and J is 1 : 0.5 - 2 : 0.01 - 0.5, preferably 1 : 0.9 - 1.1 : 0.04 - 0.2.



9. The process as claimed in claim 5, wherein the polymerization is carried out in the presence of from 0.1 to 20 % by weight, preferably from 0.2 to 10 % by weight, based on the monomer content, of a free-radical initiator.
10. The process as claimed in claim 5, wherein the polymerization is carried out in the presence of from 0.1 to 10 % by weight, based on the monomer content, of a regulator.
11. The process as claimed in claim 5, wherein the polymerization is carried out at a temperature from 40 to 400°C, preferably from 80 to 250°C and with or without the exclusion of air.
12. The process as claimed in claim 5, wherein the polymerization is carried out in a solvent in which the monomers of the formulae F, G, H and J and the terpolymers claimed in claim 1 are soluble.
13. The process as claimed in claim 5, wherein the reaction with amines of the formulae N and P and/or alcohols of the formula Q is carried out by first reacting the polymer with the alcohol and subsequently reacting the product with the primary and/or secondary amines.
14. Use of a terpolymer as claimed in claim 1 as a paraffin inhibitor for paraffin-containing crude oils and petroleum products.
15. Use of a terpolymer as claimed in claim 14, wherein from 10 to 10,000 ppm of the terpolymer are added to



REPLACEMENT SHEET

08 MAR 1997

- 44 -

the paraffin-containing crude oil or petroleum product.

16. A paraffin-containing petroleum or petroleum product which contains a terpolymer as claimed in claim 1.
17. A mixture comprising at least one terpolymer as claimed in claim 1 and at least one ethylene-vinyl ester copolymer.
18. A mixture as claimed in claim 17, which contains ethylene-vinyl ester copolymers derived from copolymers which contain C_1 - C_{20} -alkylvinyl esters, vinyl esters of saturated C_{10} - C_{24} -fatty acids, esters of unsaturated carboxylic acids, diisobutylene, dimethylvinylcarbinol and vinyl methoxyacetate as monomers.
19. A mixture as claimed in claim 17, wherein the ethylene-vinyl ester copolymers comprise
80 - 51 % by weight of ethylene and
20 - 49 % by weight of vinyl acetate or vinyl propionate.
20. A mixture as claimed in claim 17, wherein the ethylene-vinyl ester copolymers comprise
79 - 40 % by weight of ethylene,
20 - 35 % by weight, preferably 1 - 15 % by weight, of vinyl acetate or vinyl propionate and
1 - 25 % by weight, preferably 1 - 15 % by weight, of diisobutylene, vinyl neononanoate or vinyl neodecanoate.
21. Use of a mixture as claimed in claim 17 as a paraffin dispersant in petroleum middle distillates.
22. Use of a mixture as claimed in claim 17 for lowering the cloud point in petroleum middle distillates.



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- 45 -

REPLACEMENT SHEET

08 MAR 1997

23. Use as claimed in claim 21 or 22, wherein a mixture comprising
from 50 to 1000 ppm, preferably from 50 to 500 ppm,
of terpolymer and
from 50 to 1000 ppm, preferably from 50 to 500 ppm,
of ethylene-vinyl ester copolymer is added to the
paraffin-containing petroleum middle distillate.
24. A paraffin-containing petroleum middle distillate
which contains a mixture as claimed in claim 17.
25. A mixture comprising a mixture as claimed in claim
17 and at least one quaternary ammonium salt of the
formula

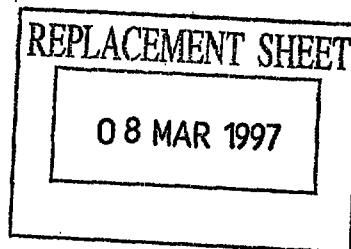


in which R^{11} is C_1 - C_{30} -alkyl, preferably C_1 - C_{22} -alkyl,
 C_2 - C_{30} -alkenyl, preferably C_2 - C_{22} -alkenyl, benzyl or a
radical of the formula $-(CH_2-CH_2-O)_n-R^{12}$, where R^{12} is
hydrogen or a fatty acid radical of the formula
 $C(O)-R^{13}$, where R^{13} is C_1 - C_{40} -alkyl or C_1 - C_{40} -alkenyl,
 n is a number from 1 to 30 and X is halogen, pre-
ferably chlorine, or methosulphate.

26. Use of a mixture as claimed in claim 25 as a paraf-
fin dispersant in petroleum middle distillates.
27. Use as claimed in claim 26, wherein a mixture
comprising
from 50 to 1000 ppm, preferably from 50 to 500 ppm,
of terpolymer as claimed in claim 1,
from 50 to 1000 ppm, preferably from 50 to 500 ppm,
of ethylene-vinyl ester copolymer and
from 50 to 1000 ppm, preferably from 50 to 500 ppm,
of quaternary ammonium salt of the formula $^+N(R^{11})_4X^-$
is added to the paraffin-containing petroleum middle
distillate.
28. A paraffin-containing petroleum middle distillate
which contains a mixture as claimed in claim 25.

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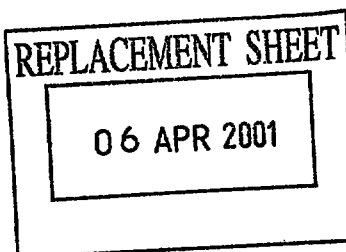
Terpolymers based on α,β -unsaturated dicarboxylic anhydrides, α,β -unsaturated compounds and polyoxyalkylene ethers of lower unsaturated alcohols.

Abstract of the disclosure

The present invention relates to terpolymers based on α,β -unsaturated dicarboxylic anhydrides, α,β -unsaturated compounds and polyoxyalkylene ethers as defined in claim 1, and also a process for preparing the same as defined in claim 5.

The invention likewise relates to a mixture of at least one terpolymer as defined in claim 1 and at least one ethylene-vinyl ester copolymer.

The terpolymers of the invention, and mixtures thereof, are used as paraffin inhibitors in crude oils and petroleum products.



or methyl,

a and b are zero or one and a + b is one,

X and Y are identical or different and are

the -N-HR³ group,

where R³ is C₆-C₄₀-alkyl, C₅-C₂₀-cylcoalkyl or C₆-C₁₈-aryl,

the -N-(R³)₂ group,

where R³ is identical or different and is as defined above,

and/or

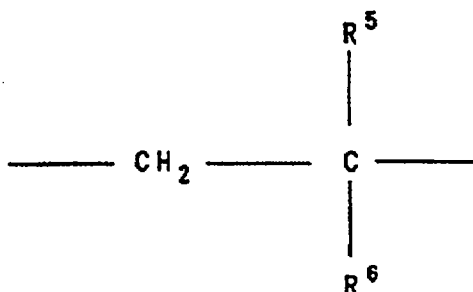
the -O-R⁴ group,

where R⁴ is hydrogen, a cation of the formula H₂N[⊕] R³

or H₂N[⊕](R³)₂, C₆-C₄₀-alkyl, C₅-C₂₀-clycoalkyl or C₆-C₁₈-aryl, preferably phenyl,

19-80 mol %, preferably 39-60 mol %, of bivalent structural units D

(D)



in which

R⁵ is hydrogen or C₁-C₄-alkyl and

R₆ is C₆-C₆₀-alkyl or C₆-C₁₈-aryl,

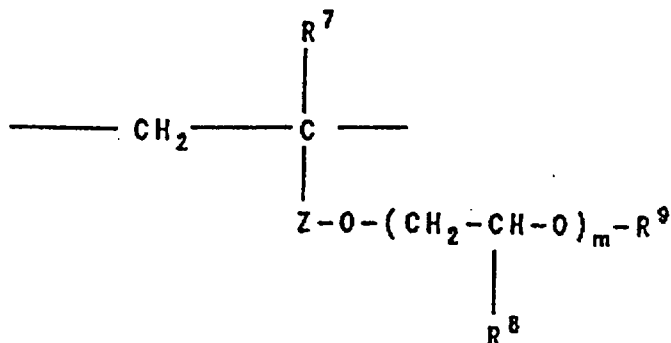
and

1-30 mol %, preferably 1-20 mol %, of bivalent structural units E



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(E)



in which

R⁷ is hydrogen or methyl,

R⁸ is hydrogen or C₁-C₄-alkyl,

Z is C₁-C₄-alkylene,

m is a number from 1 to 100,

R⁹ is C₁-C₂₄-alkyl, C₅-C₂₀-cylcoalkyl, C₆-C₁₈-aryl or -C(O)-R¹⁰, where

R¹⁰ is C₁-C₄₀-alkyl, C₅-C₁₀-cycloalkyl or C₆-C₁₈-aryl and has K values of from 8 to 100 before the reaction with amines and/or alcohols.

2. A terpolymer as claimed in claim 1, containing bivalent structural units of the formula A, in which X is a group of the formula O-R⁴, with R⁴ being C₆-C₄₀-alkyl and Y is a group of the formula O-R⁴, where R⁴ is a cation of the formula H₂N[⊕](R³)₂ with R³ being C₆-C₄₀-alkyl.
3. A terpolymer as claimed in claim 1, containing bivalent structural units of the formula A, in which X is a group of the formula -N(R³)₂, with R³ being C₆-C₄₀-alkyl and Y is a group of the formula O-R⁴, where R⁴ is a cation of the formula H₂N[⊕](R³)₂ with R³ being C₆-C₄₀-alkyl.
4. A terpolymer as claimed in claims 2 or 3, wherein R³ and R⁴ are C₆-C₂₄-alkyl.



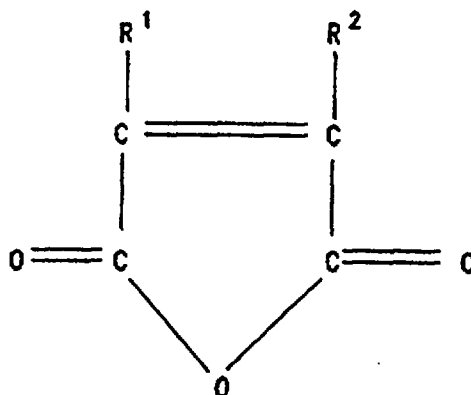
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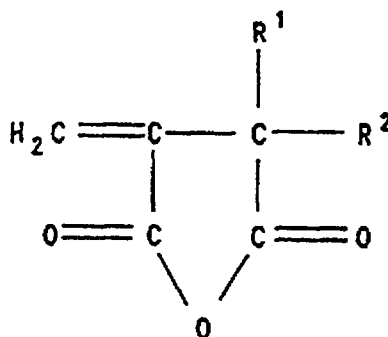
- 41 -

5. A process for preparing the terpolymers as claimed in claim 1, which comprises polymerizing with one another monomers of the formula F and/or G

(F)

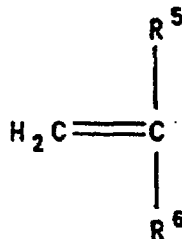


(G)



where R^1 and R^2 are, independently of one another, hydrogen or methyl,
monomers of the formula H

(H)



in which R^5 is hydrogen or C_1 - C_4 -alkyl and R^6 is C_6 - C_{60} -alkyl or C_6 - C_{18} -aryl,
and monomers of the formula J

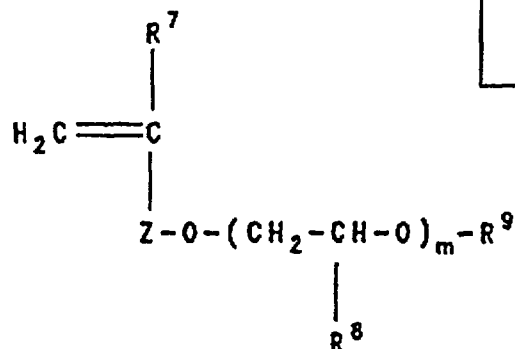


- 42 -

REPLACEMENT SHEET

06 APR 2001

(J)



in which

R^7 is hydrogen or methyl,

R^8 is hydrogen or C_1 - C_4 -alkyl,

Z is C_1 - C_4 -alkylene,

m is a number from 1 to 100,

R^9 is C_1 - C_{24} -alkyl, C_5 - C_{20} -cycloalkyl, C_6 - C_{18} -aryl or $-C(O)-R^{10}$, where

R^{10} is C_1 - C_{40} -alkyl, C_5 - C_{10} -cycloalkyl or C_6 - C_{18} -aryl,

and subsequently reacting the product with primary and/or secondary amines of the formulae

(N) $-N-HR^3$,

(P) $-N-(R^3)_2$,

where R^3 is C_6 - C_{40} -alkyl, C_5 - C_{20} -cycloalkyl or C_6 - C_{18} -aryl,

and/or alcohols of the formula

(Q) $HO-R^4$,

where R^4 is C_6 - C_{40} -alkyl, C_5 - C_{20} -cycloalkyl or C_6 - C_{18} -aryl, preferably phenyl.

6. The process as claimed in claim 5, wherein the polymerization is carried out in solution, suspension or melt, preferably in solution.
7. The process as claimed in claim 5, wherein the polymerization is carried out in a stirred vessel, a cascade of stirred vessels, a stirred reactor or a static mixer.



REPLACEMENT SHEET

06 APR 2001

- 43 -

8. The process as claimed in claim 5, wherein the molar ratio between the monomers of the formulae F and/or G, H and J is 1 : 0.5 - 2 : 0.01 - 0.5, preferably 1 : 0.9 - 1.1 : 0.04 - 0.2.
9. The process as claimed in claim 5, wherein the polymerization is carried out in the presence of from 0.1 to 20 % by weight, preferably from 0.2 to 10 % by weight, based on the monomer content, of a free-radical chain initiator.
10. The process as claimed in claim 5, wherein the polymerization is carried out in the presence of from 0.1 to 10 % by weight, based on the monomer content, of a regulator.
11. The process as claimed in claim 5, wherein the polymerization is carried out at a temperature from 40 to 400°C, preferably from 80 to 250°C and with or without the exclusion of air.
12. The process as claimed in claim 5, wherein the polymerization is carried out in a solvent in which the monomers of the formulae F, G, H and J and the terpolymers as claimed in claim 1 are soluble.
13. The process as claimed in claim 5, wherein the reaction with amines of the formulae N and P and/or alcohols of the formula Q is carried out by first reacting the polymer with the alcohol and subsequently reacting the product with the primary and/or secondary amines.
14. Use of a terpolymer as claimed in claim 1 as a paraffin inhibitor for paraffin-containing crude oils and petroleum products.
15. Use of a terpolymer as claimed in claim 14, wherein from 10 to 10,000 ppm of the terpolymer are added to



- 45 -

REPLACEMENT SHEET

06 APR 2001

23. Use as claimed in claim 21 or 22, wherein a mixture comprising
from 50 to 1000 ppm, preferably from 50 to 500 ppm,
of terpolymer and
from 50 to 1000 ppm, preferably from 50 to 500 ppm,
of ethylene-vinyl ester copolymer is added to the
paraffin-containing petroleum middle distillate.
24. A paraffin-containing petroleum middle distillate
which contains a mixture as claimed in claim 17.
25. A mixture comprising a mixture as claimed in claim
17 and at least one quaternary ammonium salt of the
formula
$$^{\oplus}\text{N}(\text{R}^{11})_4\text{X}^{\ominus}$$

in which R^{11} is $\text{C}_1\text{-C}_{30}$ -alkyl, preferably $\text{C}_1\text{-C}_{22}$ -alkyl,
 $\text{C}_2\text{-C}_{30}$ -alkenyl, preferably $\text{C}_2\text{-C}_{22}$ -alkenyl, benzyl or a
radical of the formula $-(\text{CH}_2\text{-CH}_2\text{-O})_n\text{-R}^{12}$, where R^{12} is
hydrogen or a fatty acid radical of the formula
 $\text{C}(\text{O})\text{-R}^{13}$, where R^{13} is $\text{C}_6\text{-C}_{40}$ -alkyl or $\text{C}_6\text{-C}_{40}$ -alkenyl,
 n is a number from 1 to 30 and X is a halogen, preferably
chlorine, or methosulphate.
26. Use of a mixture as claimed in claim 25 as a paraf-
fin dispersant in petroleum middle distillates.
27. Use as claimed in claim 26, wherein a mixture
comprising
from 50 to 1000 ppm, preferably from 50 to 500 ppm,
of terpolymer as claimed in claim 1,
from 50 to 1000 ppm, preferably from 50 to 500 ppm,
of ethylene-vinyl ester copolymers and
from 50 to 1000 ppm, preferably from 50 to 500 ppm,
of quaternary ammonium salt of the formula $^{\oplus}\text{N}(\text{R}^{11})_4\text{X}^{\ominus}$
is added to the paraffin-containing petroleum middle
distillate.
28. A paraffin-containing petroleum middle distillate
which contains a mixture as claimed in claim 25.