

BENZO[b]PERHYDROHETEROCYCLIC ARYLAMINES AND LUBRICATING OIL COMPOSITIONS

FIELD OF THE INVENTION

[0001] Benzo[b]perhydroheterocyclic arylamines compounds have demonstrated utility in mitigating oxidation in functional fluids. Accordingly, the present invention is directed to substituted and unsubstituted Benzo[b]perhydroheterocyclic arylamines compounds and lubricating compositions containing such.

BACKGROUND OF THE INVENTION

[0002] Diarylamine antioxidants are known and have been widely used to improve the thermal-oxidative stability and/or light induced degradation in numerous products used in engineering; for example, they can improve the performance properties in lubricants, hydraulic fluids, metal working fluids, fuels or polymers, just to name a few.

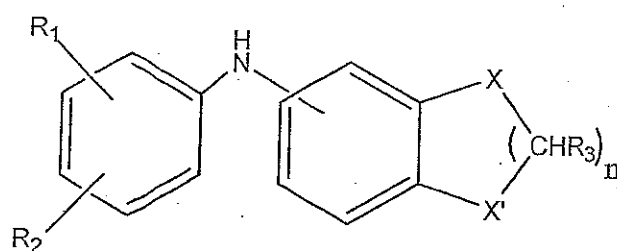
[0003] Commonly, these diarylamines have been alkylated, see for example, U.S. Pat. No. 2,943,112 which discloses an improved process for alkylating diphenylamine and U.S. Pat. No. 3,655,559 which discloses alkylated diphenylamines as stabilizers. Alkaryl substituted diphenylamines and phenylnaphthylamines (such as α -methylstyryl-diphenylamine) are disclosed for example in U.S. Pat. Nos. 3,533,992; 3,452,056 and 3,660,290. Substituted paraphenylene diamines have also been disclosed as antioxidants for lubricants in which iron-catalyzed oxidation reaction can occur, see U.S. Pat. No 5,232,614.

[0004] Additionally, alkyl substituted 1,2-dihydroquinoline and polymers thereof, have been employed as antioxidants, see U.S. Pat. Nos. 3,910,918. While, U.S. Pat. No. 5,310,491 discloses the reaction product of an alkyl substituted 1,2-dihydroquinoline with a diarylamine. Tetrahydroquinones and substituted tetrahydroquinones have also have also been disclosed as antioxidants, see for example U.S. Pat. Nos. 2,794,020; 3,362,929; 4,692,258 and 4,965,006. Likewise decahydroquinolines and substituted decahydroquinolines have been employed as antioxidants, see U.S. Pat. Nos. 2,998,468 and 4,069,195.

[0005] In order to satisfy the more severe operating conditions and new applications which require improved oxidation inhibition, continued development of new compounds to mitigate oxidation is of paramount interest. The compounds of the present invention demonstrate superior performance in an organic substrate and thus may serve the continued need.

SUMMARY OF THE INVENTION

[0005a] In a first aspect, there is provided a compound according to formula I:



Formula I

wherein

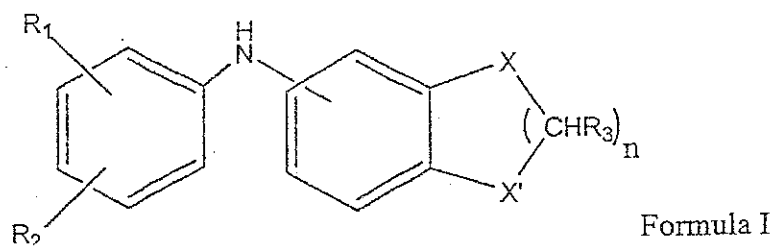
R₁ and R₂ are each independently selected from the group consisting of hydrogen, alkyl from 1 to 20 carbon atoms, -OR, -SR and -NRR', where R and R' are independently hydrogen or alkyl from 1 to 6 carbon atoms, or R₁ and R₂ when adjacent to each other together form a 5 to 6 membered alicyclic or aromatic ring which may be optionally substituted with 1 or 2 alkyl groups each having from 1 to 20 carbon atoms;

each R₃ is hydrogen or alkyl from 1 to 6 carbon atoms,

at least one of X and X' is NR₅, and the other of X and X' is selected from -CHR₄, oxygen, sulfur or NR₅, wherein R₄ and R₅ are independently hydrogen or alkyl from 1 to 6 carbon atoms, with the proviso that at least one of X or X' is a heteroatom positioned *ortho* or *para* to the bridging nitrogen atom, and R₁ or R₂ is not hydroxyl; and

n is an integer from 1 to 2.

[0006] The disclosure is directed in part to compounds which may serve as antioxidants, antiozoants, heat stabilizers and ultraviolet light stabilizers and such compounds are oil soluble, thus particularly suited for use as an antioxidant in a lubricating oil composition. Accordingly, in one embodiment, there is provided a compound according to formula I:



wherein

R_1 and R_2 are each independently selected from the group consisting of hydrogen, alkyl from 1 to 20 carbon atoms, -OR, -SR and -NRR', where R and R' are independently hydrogen or alkyl from 1 to 6 carbon atoms, or R_1 and R_2 when adjacent to each other together form a 5 to 6 membered alicyclic or aromatic ring which may be optionally substituted with 1 or 2 alkyl groups each having from 1 to 20 carbon atoms;

each R_3 is hydrogen or alkyl from 1 to 6 carbon atoms,

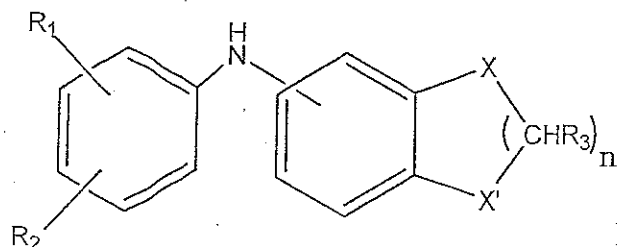
X and X' are independently selected from $-CHR_4-$, oxygen, sulfur or NR_5 , wherein R_4 and R_5 are independently hydrogen or alkyl from 1 to 6 carbon atoms, with the proviso that at least one of X or X' is a heteroatom positioned *ortho* or *para* to the bridging nitrogen atom, and when X or X' are nitrogen then R_1 or R_2 is not hydroxyl; and further provided that when one of X or X' is $-CHR_4-$ then the other may not be oxygen; and n is an integer from 1 to 2.

[0007] The benzo[b]perhydroheterocycle can contain one or two heteroatoms and preferably contains at least one nitrogen or oxygen atom, with nitrogen being particularly preferred, thus in this aspect of the disclosure at least one X or X' is oxygen or NR₅, with -NH- being particularly preferred. The single nitrogen benzo[b]perhydroheterocycle can be characterized as having being unsubstituted on the heterocyclic ring but, optionally substituted on the aryl ring, thus R₁ and R₂ are each independently selected from the group consisting of hydrogen, alkyl from 1 to 20 carbon atoms, -OR, -SR and -NRR', where R and R' are independently hydrogen or alkyl from 1 to 6 carbon atoms, or R₁ and R₂ when adjacent to each other together form a 5 to 6 membered alicyclic or aromatic ring which may be optionally substituted with 1 or 2 alkyl groups each having from 1 to 20 carbon atoms, and more particularly wherein R₁ and R₂ are each independently selected from the group consisting of hydrogen and alkyl from 1 to 20 carbon atoms.

[0008] In one embodiment, X and X' are independently selected from oxygen, sulfur or NR₅, wherein R₅ is hydrogen or alkyl from 1 to 6 carbon atoms. Thus, both X and X' can be oxygen or for example, nitrogen.

[0009] In the compounds of formula I, R₁ and R₂ together with the atoms between them, can form alicyclic or aromatic ring. Thus, one embodiment of the compound is directed to when R₁ and R₂ are adjacent to each other and together form a 5 to 6 membered aromatic ring which may be optionally substituted with 1 or 2 alkyl groups each having from 1 to 20 carbon atoms. Other embodiments are characterized for example, wherein R₁ is hydrogen and R₂ is selected from the group consisting of alkyl from 1 to 20 carbon atoms, -OR, -SR and -NRR', where R and R' are independently hydrogen or alkyl from 1 to 6 carbon atoms, with the tertiary amines being preferred.

[0009a] In a second aspect, there is provided a lubricating composition comprising a major amount of an oil of lubricating viscosity and a compound according to formula I:



Formula I

wherein

R_1 and R_2 are each independently selected from the group consisting of hydrogen, alkyl from 1 to 20 carbon atoms, -OR, -SR and -NRR', where R and R' are independently hydrogen or alkyl from 1 to 6 carbon atoms, or R_1 and R_2 when adjacent to each other together form a 5 to 6 membered alicyclic or aromatic ring which may be optionally substituted with 1 or 2 alkyl groups each having from 1 to 20 carbon atoms;

each R_3 is hydrogen or alkyl from 1 to 6 carbon atoms,
at least one of X and X' is NR_5 , and the other of X and X' is selected from -CHR₄-, oxygen, sulfur or NR_5 , wherein R_4 and R_5 are independently hydrogen or alkyl from 1 to 6 carbon atoms, with the proviso that at least one of X or X' is a heteroatom positioned *ortho* or *para* to the bridging nitrogen atom, and R_1 or R_2 is not hydroxyl; and

n is an integer from 1 to 2.

[0010] In another embodiment, there is provided lubricating compositions comprising a major amount of an oil of lubricating viscosity and a compound of formula I as described herein above.

DETAILED DESCRIPTION OF THE INVENTION

[0011] Inhibition of free radical-mediated oxidation is one of the most important reactions in organic substrates and is commonly used in rubbers, polymers and lubrication oils; namely, since these chemical products may undergo oxidative damage by the autoxidation process. Hydrocarbon oxidation is a three step process

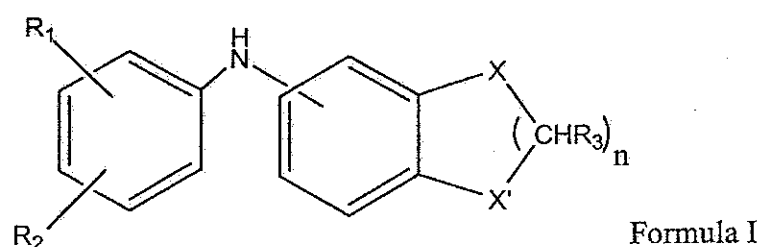
which comprises: initiation, propagation and termination. Oxidative degradation and the reaction mechanisms are dependent upon the specific hydrocarbons, temperatures, operating conditions, catalysts such as metals, etc., which more detail can be found in Chapter 4 of Mortier R.M. et al., 1992, "Chemistry and Technology of Lubricants Initiation", VCH Publishers, Inc.; incorporated herein by reference in its entirety. Initiation involves the reaction of oxygen or nitrogen oxides (NO_x) on a hydrocarbon molecule. Typically, initiation starts by the abstraction of hydrocarbon proton. This may result in the formation of hydrogen peroxide (ROOH) and radicals such as alkyl radicals ($\text{R}^\bullet$) and peroxy radicals ($\text{ROO}^\bullet$). During the propagation stage, hydroperoxides may decompose, either on their own or in the presence of catalysts such as metal ions, to alkoxy radicals ($\text{RO}^\bullet$) and peroxy radicals. These radicals can react with the hydrocarbons to form a variety of additional radicals and reactive oxygen containing compounds such as alcohols, aldehydes, ketones and carboxylic acids; which again can further polymerize or continue chain propagation. Termination results from the self termination of radicals or by reacting with oxidation inhibitors.

[0012] The uncatalyzed oxidation of hydrocarbons at temperatures of up to about 120°C primarily leads to alkyl-hydroperoxides, dialkylperoxides, alcohols, ketones; as well as the products which result from cleavage of dihydroperoxides such as diketones, keto-aldehydes hydroxyketones and so forth. At higher temperatures (above 120°C) the reaction rates are increased and cleavage of the hydroperoxides plays a more important role. Additionally, at the higher temperatures, the viscosity of the bulk medium increases as a result of the polycondensation of the difunctional oxygenated products formed in the primary oxidation phase. Further polycondensation and polymerization reaction of these high molecular weight intermediates results in products which are no longer soluble in the hydrocarbon and form varnish like deposits and sludge.

[0013] Since autoxidation is a free-radical chain reaction, it therefore, can be inhibited at the initiation and/or propagation steps. Typical oxidation inhibition by diarylamines, such as dialkyldiphenylamine and N-phenyl- α -naphthylamine, also involves radical scavenging. The transfer of hydrogen from the NH group of the amine to the peroxide radicals results in the formation of a diarylamino radical which is resonance stabilized, thus prevents new chains from forming. A secondary peroxy

radical or hydroperoxide can react with the diarylamino radical to form the nitroxy radical, which is also a very potent inhibitor. Increased demands have been placed on many functional fluids which have in-turn placed emphasis on new inhibitors.

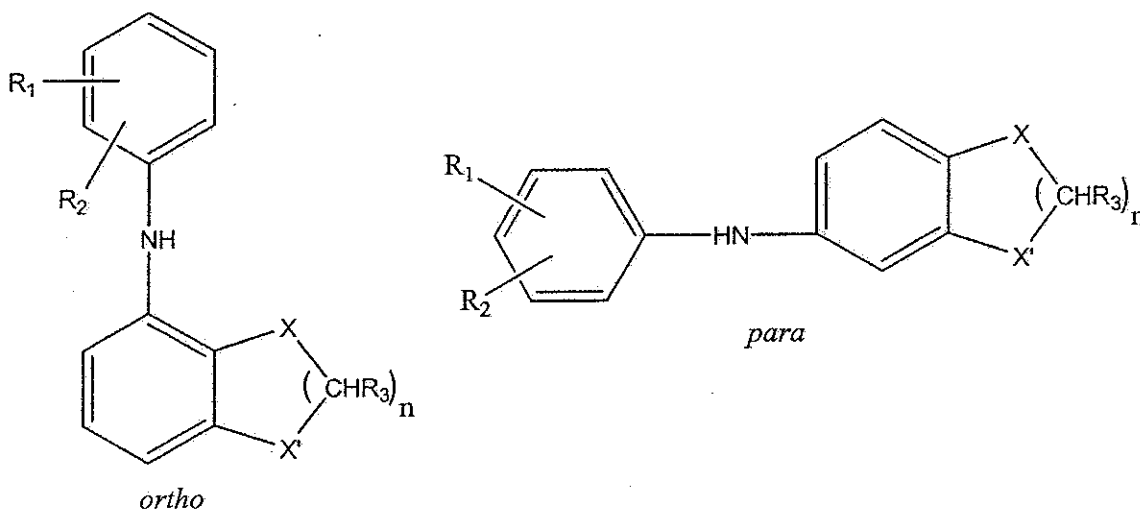
[0014] The present invention is directed in part to aryl-amino bridged benzo[b]perhydroheterocyclic compounds particularly useful as stabilizers. The compounds may serve as antioxidants, antiozoants, heat stabilizers and ultraviolet light stabilizers and such compounds are oil soluble, thus particularly suited for use as an antioxidant in a lubricating oil composition. Disclosed are particularly suited resonance stabilized inhibitor compounds according to formula I:



wherein: R_1 and R_2 are each independently selected from the group consisting of hydrogen, alkyl from 1 to 20 carbon atoms, $-OR$, $-SR$ and $-NRR'$, where R and R' are independently hydrogen or alkyl from 1 to 6 carbon atoms, or R_1 and R_2 when adjacent to each other together form a 5 to 6 member ring, said ring is selected from a 5 to 6 membered alicyclic ring and a 5 to 6 membered aromatic ring, wherein said ring may be unsubstituted or substituted with 1 or 2 alkyl groups each having from 1 to 20 carbon atoms; each R_3 is hydrogen or alkyl from 1 to 6 carbon atoms, X and X' are independently selected from $-CHR_4-$, oxygen, sulfur or NR_5 , wherein R_4 and R_5 are independently hydrogen or alkyl from 1 to 6 carbon atoms, with the proviso that at least one of X or X' is a heteroatom positioned *ortho* or *para* to the bridging nitrogen atom, and further provided that when one of X or X' is $-CHR_4-$ then the other may not be oxygen, and when X or X' are nitrogen then R_1 or R_2 is not hydroxyl; and n is an integer from 1 to 2. Nitrogen is a particularly preferred heteroatom, which is more preferred than oxygen, which both are more preferred than sulfur. Improved resonance stabilization may be accomplished by substituents on the rings, thus particularly preferred groups are electron donating groups, more so when positioned *ortho* and *para* positions to the bridging nitrogen atom, thereby stabilizing this amino

radical. Therefore, one aspect of the present invention is directed to where at least one R_1 and R_2 is -OR, -SR or -NRR' with -NRR' being preferred. In another aspect, there is only a single substituent on the aryl group, thus R_1 is hydrogen with R_2 selected from -OR, -SR or -NRR' with -NRR' being preferred; wherein R and R' are defined herein above and even more preferred, R is alkyl from 1 to 6 carbon atoms.

[0015] By way of an example, when X is selected to be the heteroatom, the *ortho* and *para* positions of X to the bridging nitrogen atom are depicted below.



The requirement for the *ortho* and *para* position are more prevalent when X' is CHR_4 - which is a preferred embodiment. Additionally, R_1 and R_2 , when other than hydrogen, are preferably positioned so that at least one is in the *ortho* or *para* position to the bridging nitrogen atom.

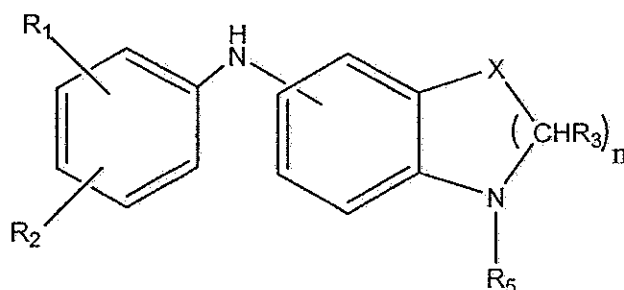
[0016] In one preferred aspect, R_1 is hydrogen and R_2 is selected from the group consisting of alkyl from 1 to 20 carbon atoms, -OR, -SR and -NRR', where R and R' are independently hydrogen or alkyl from 1 to 6 carbon atoms; also preferred in the above, is where R is alkyl from 1 to 6. Preferably in the above, R_2 is positioned in the *ortho* or *para* position to the bridging nitrogen atom. Alkyl chains have demonstrated improved oil solubility in the resulting compound, therefore straight and branched chain alkyl from 3 to 18 carbon atoms are particularly preferred when the compounds are employed in lubricating oil compositions. Nitrogen and oxygen heterocycles have demonstrated robust properties and thus, preferably at least one X or X' contains a nitrogen or oxygen atom, with nitrogen being particularly preferred, with single nitrogen atom heterocycles even more preferred.

[0017] In another preferred aspect, R_1 and R_2 are each independently selected from the group consisting of alkyl from 1 to 20 carbon atoms, -OR, -SR and -NRR', where R is alkyl from 1 to 6 carbon atoms and R' is hydrogen or alkyl from 1 to 6 carbon atoms. In another aspect, when R_1 and R_2 are located on adjacent carbon atoms, R_1 and R_2 together can form a 5 to 6 membered alicyclic or aromatic ring which may be unsubstituted or substituted with 1 or 2 alkyl groups each having from 1 to 20 carbon atoms, preferably alkyl for 3 to 18 carbon atoms. Preferably at least one X or X' contains a nitrogen or oxygen atom, with nitrogen being particularly preferred, with single nitrogen atom heterocycles even more preferred.

[0018] In formula I, particularly preferred compounds are depicted when at least one X and X' is selected from nitrogen or oxygen and even more preferred is when at least one X and X' is nitrogen. These nitrogen containing

benzo[b]perhydroheterocyclic compounds are further defined according to formula II.

[0019] Accordingly, particularly preferred compounds are depicted by the Formula II below:



[0020]

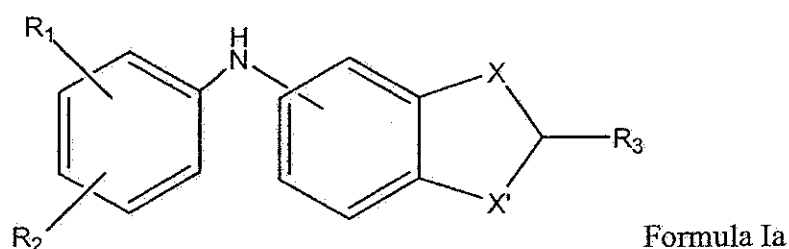
Formula II

[0021] wherein R_1 , R_2 , R_3 , R_5 , X and n, are defined herein above, with the proviso the heterocyclic nitrogen is positioned *ortho* or *para* to the bridging nitrogen atom and further providing that when X is -CHR₄- then R_1 and R_2 are not hydroxyl. As stated above, alkyl substituents have been employed to improve oil solubility and are particularly useful when there is greater than two heteroatoms in the compound. Preferably, if the compound is to contain alkyl groups, the alkyl groups are characterized in regard with R_1 or R_2 . Thus preferably at least one R_1 and R_2 are alkyl from 1 to 20 carbon atoms, -OR, -SR and -NRR', where R is alkyl from 1 to 6 carbon atoms and R' is defined above. Additionally, solubility may be increased in respect to R_1 and R_2 when R_1 and R_2 are adjacent to each other and can form a 5 to 6 membered alicyclic or aromatic ring which is substituted with 1 or 2 alkyl groups each having

from 1 to 20 carbon atoms. Even more preferred is that each R_3 and R_4 when selected are all hydrogen.

[0022] Particularly preferred compounds of Formula II are depicted when n is equal to two. Even more preferred are the tetrahydro-quinolines, thus X is $-\text{CHR}_4-$ and the bridging ring nitrogen is attached at the 6 or 8 position.

[0023] In Formula I, when $n = 1$, the compounds can be depicted by Formula Ia below:



[0024] wherein: R_1 and R_2 are each independently selected from the group consisting of hydrogen, alkyl from 1 to 20 carbon atoms, $-\text{OR}$, $-\text{SR}$ and $-\text{NRR}'$, where R and R' are independently hydrogen or alkyl from 1 to 6 carbon atoms, or R_1 and R_2 when adjacent to each other together form a 5 or 6 membered alicyclic or aromatic ring which may be unsubstituted or substituted with 1 or 2 alkyl groups each having from 1 to 6 carbon atoms; R_3 is hydrogen or alkyl from 1 to 6 carbon atoms; X is oxygen, sulfur, $-\text{NH}-$ or $-\text{N}(\text{alk})-$ where alk is alkyl from 1 to 6 carbon atoms with the proviso that the X heteroatom is positioned *ortho* or *para* to the bridging nitrogen atom; X' is selected from $-\text{CHR}_4-$, oxygen, sulfur or NR_5 , wherein R_4 and R_5 are independently hydrogen or alkyl from 1 to 6 carbon atoms, with the proviso that when X is oxygen then X' is oxygen, sulfur or NR_5 . Particularly suited benzo[b]perhydeoheterocyclic moieties include substituted and unsubstituted: 2,3-dihydro-indole, 2,3-dihydro-benzo[b]thiophene, 2,3-dihydro-benzoimidazole including alkyl and dialkyl substituted dihydro-benzoimidazoles, 2,3dihydro-benzooxazole, 2,3-dihydro-benzothiazole, benzo[1,3]dithiole, benzo[1,3]oxathiole and benzo[1,3]dioxole.

[0025] In Formula I, when $n = 2$, particularly useful heterocyclic rings are selected from substituted and unsubstituted heterocyclic rings consisting of the group: 1,2,3,4-tetrahydroquinoline; 1,2,3,4-tetrahydroquinoxaline; 3,4-dihydro-2H-benzo[1,4]thiazine; 3,4-dihydro-2H-benzo[1,4]oxazine; thiochroman, 2,3-dihydro-

benzo[1,4]dithiine; 2,3-dihydro-benzo[1,4]oxathiine; 2,3-dihydro-benzo[1,4]dioxine and chroman.

[0026] Particularly suited compounds of the present invention are exemplified herein below, therefore, another aspect of the present invention is directed to the compounds comprising: phenyl-(1,2,3,4-tetrahydro-quinolin-6-yl)-amine; -(4-*tert*-butylphenyl)-1,2,3,4-tetrahydroquinolin-8-amine; *N*-2-naphthyl-1,2,3,4-tetrahydroquinolin-6-amine; *N*-2-naphthyl-1,2,3,4-tetrahydroquinolin-8-amine; *N*-(4-*tert*-butylphenyl)-2,3-dihydro-1-benzofuran-5-amine; *N'*-(2,3-dihydro-1-benzofuran-5-yl)-*N,N*-diethylbenzene-1,4-diamine; *N*-(4-*tert*-butylphenyl)-2,3-dihydro-1,4-benzodioxin-6-amine; *N*-(4-butylphenyl)-1,2,3,4-tetrahydroquinolin-8-amine.

[0027] The compounds of Formula I are particularly useful when employed in a lubricating composition comprising the compound of Formula I with an oil of lubricating viscosity.

[0028] The lubricant compositions of this invention include a major amount of base oil of lubricating viscosity. Base Oil as used herein is defined as a base stock or blend of base stocks which is a lubricant component that is produced by a single manufacturer to the same specifications (independent of feed source or manufacturer's location): that meets the same manufacturer's specification; and that is identified by a unique formula, product identification number, or both. Base stocks may be manufactured using a variety of different processes including but not limited to distillation, solvent refining, hydrogen processing, oligomerization, esterification, and rerefining. Rerefined stock shall be substantially free from materials introduced through manufacturing, contamination, or previous use. The base oil of this invention may be any natural or synthetic lubricating base oil fraction particularly those having a kinematic viscosity at 100 degrees Centigrade (C) and about 5 centistokes (cSt) to about 20 cSt, preferably about 7 cSt to about 16 cSt, more preferably about 9 cSt to about 15 cSt. Hydrocarbon synthetic oils may include, for example, oils prepared from the polymerization of ethylene, i.e., polyalphaolefin or PAO, or from hydrocarbon synthesis procedures using carbon monoxide and hydrogen gases such as in a Fisher-Tropsch process. A preferred base oil is one that comprises little, if any, heavy fraction; e.g., little, if any, lube oil fraction of viscosity 20 cSt or higher at 100 degrees C.

[0029] The base oil may be derived from natural lubricating oils, synthetic lubricating oils or mixtures thereof. Suitable base oil includes base stocks obtained by isomerization of synthetic wax and slack wax, as well as hydrocrackate base stocks produced by hydrocracking (rather than solvent extracting) the aromatic and polar components of the crude. Suitable base oils include those in all API categories I, II, III, IV and V as defined in API Publication 1509, 14th Edition, Addendum I, December 1998. Saturates levels and viscosity indices for Group I, II and III base oils are listed in Table 1. Group IV base oils are polyalphaolefins (PAO). Group V base oils include all other base oils not included in Group I, II, III, or IV. Although Group II, III and IV base oils are preferred for use in this invention, these preferred base oils may be prepared by combining one or more of Group I, II, III, IV and V base stocks or base oils.

TABLE I
Saturates, Sulfur and Viscosity Index of Group I, II and III Base Stocks

Group	Saturates (As determined by ASTM D 2007) Sulfur (As determined by ASTM D 2270)	Viscosity Index (As determined by ASTM D 4294, ASTM D 4297 or ASTM D 3120)
I	Less than 90 % saturates and/or Greater than to 0.03 % sulfur	Greater than or equal to 80 and less than 120
II	Greater than or equal to 90 % saturates and less than or equal to 0.03 % sulfur	Greater than or equal to 80 and less than 120
III	Greater than or equal to 90 % saturates and less than or equal to 0.03% sulfur	Greater than or equal to 120

[0030] Natural lubricating oils may include animal oils, vegetable oils (e.g., rapeseed oils, castor oils and lard oil), petroleum oils, mineral oils, and oils derived from coal or shale.

[0031] Synthetic oils may include hydrocarbon oils and halo-substituted hydrocarbon oils such as polymerized and inter-polymerized olefins, alkylbenzenes, polyphenyls, alkylated diphenyl ethers, alkylated diphenyl sulfides, as well as their derivatives, analogues and homologues thereof, and the like. Synthetic lubricating oils also include alkylene oxide polymers, interpolymers, copolymers and derivatives thereof wherein the terminal hydroxyl groups have been modified by esterification, etherification, etc. Another suitable class of synthetic lubricating oils comprises the esters of dicarboxylic acids with a variety of alcohols. Esters useful as synthetic oils also include those made from C₅ to C₁₂ monocarboxylic acids and polyols and polyol ethers. Tri-alkyl phosphate ester oils such as those exemplified by tri-n-butyl phosphate and tri-iso-butyl phosphate are also suitable for use as base oils.

[0032] Silicon-based oils (such as the polyakyl-, polyaryl-, polyalkoxy-, or polyaryloxy-siloxane oils and silicate oils) comprise another useful class of synthetic lubricating oils. Other synthetic lubricating oils include liquid esters of phosphorus-containing acids, polymeric tetrahydrofurans, polyalphaolefins, and the like.

[0033] The base oil may be derived from unrefined, refined, rerefined oils, or mixtures thereof. Unrefined oils are obtained directly from a natural source or synthetic source (e.g., coal, shale, or tar sand bitumen) without further purification or treatment. Examples of unrefined oils include a shale oil obtained directly from a retorting operation, a petroleum oil obtained directly from distillation, or an ester oil obtained directly from an esterification process, each of which may then be used without further treatment. Refined oils are similar to the unrefined oils except that refined oils have been treated in one or more purification steps to improve one or more properties. Suitable purification techniques include distillation, hydrocracking, hydrotreating, dewaxing, solvent extraction, acid or base extraction, filtration, and percolation, all of which are known to those skilled in the art. Rerefined oils are obtained by treating used oils in processes similar to those used to obtain the refined oils. These rerefined oils are also known as reclaimed or reprocessed oils and often are additionally processed by techniques for removal of spent additives and oil breakdown products.

[0034] Base oil derived from the hydroisomerization of wax may also be used, either alone or in combination with the aforesaid natural and/or synthetic base oil. Such wax isomerase oil is produced by the hydroisomerization of natural or synthetic waxes or mixtures thereof over a hydroisomerization catalyst.

[0035] It is preferred to use a major amount of base oil in the lubricating oil of this invention. A major amount of base oil as defined herein comprises 40 wt. % or more. Preferred amounts of base oil comprise about 40 wt. % to about 97 wt. % of at least one of Group II, III and IV base oil or preferably greater than about 50 wt. % to about 97 wt. % of at least one of Group II, III and IV base oil or more preferably about 60 wt. % to about 97 wt. % of at least one of Group II, III and IV base oil. (When wt. % is used herein, it is referring to wt. % of the lubricating oil unless otherwise specified.) A more preferred embodiment of this invention may comprise an amount of base oil that comprises about 85 wt. % to about 95 wt. % of the lubricating oil.

[0036] The amount of benzo[b]perhydroheterocyclic compounds of the present invention in the lubricating oil composition will be in a minor amount compared to the base oil of lubricating viscosity. Generally, it will be in an amount from about 0.01 to 10 wt %, preferably from about 0.1 to about 2.0 wt %, more preferably from about 0.3 to about 1.8 wt % and even more preferably from about 0.5 to about 1.5 wt %, based on the total weight of the lubricating oil composition.

[0037] The following additive components are examples of components that can be favorably employed in combination with the lubricating additive of the present invention. These examples of additives are provided to illustrate the present invention, but they are not intended to limit it.

[0038] (A) Ashless dispersants: alkenyl succinimides, alkenyl succinimides modified with other organic compounds such as ethylene carbonate, polysuccinimides, and alkenyl succinimides modified with boric acid, alkenyl succinic ester.

[0039] (B) Oxidation inhibitors:

[0040] 1) Phenol type phenolic oxidation inhibitors: 4,4'-methylenebis(2,6-di-tert-butylphenol), 4,4'-bis(2,6-di-tert-butylphenol), 4,4'-bis(2-methyl-6-tert-butylphenol), 2,2'-(methylenebis(4-methyl-6-tert-butyl-phenol)), 4,4'-butylidenebis(3-methyl-6-tert-butylphenol), 4,4'-isopropylidenebis(2,6-di-tert-butylphenol), 2,2'-methylenebis(4-methyl-6-nonylphenol), 2,2'-isobutylidene-bis(4,6-dimethylphenol), 2,2'-

methylenebis(4-methyl-6-cyclohexylphenol), 2,6-di-tert-butyl-4-methylphenol, 2,6-di-tert-butyl-4-ethylphenol, 2,4-dimethyl-6-tert-butyl-phenol, 2,6-di-tert- α -dimethylamino-p-cresol, 2,6-di-tert-4(N,N' dimethylaminomethylphenol), 4,4'-thiobis(2-methyl-6-tert-butylphenol), 2,2'-thiobis(4-methyl-6-tert-butylphenol), bis(3-methyl-4-hydroxy-5-tert-butylbenzyl)-sulfide, and bis(3,5-di-tert-butyl-4-hydroxybenzyl).

[0041] 2) Other types: metal dithiocarbamate (e.g., zinc dithiocarbamate), and methylenebis (dibutyldithiocarbamate).

[0042] (C) Rust inhibitors (Anti-rust agents):

[0043] 1) Nonionic polyoxyethylene surface active agents: polyoxyethylene lauryl ether, polyoxyethylene higher alcohol ether, polyoxyethylene nonylphenyl ether, polyoxyethylene octylphenyl ether, polyoxyethylene octyl stearyl ether, polyoxyethylene oleyl ether, polyoxyethylene sorbitol monostearate, polyoxyethylene sorbitol mono-oleate, and polyethylene glycol monooleate.

[0044] 2) Other compounds: stearic acid and other fatty acids, dicarboxylic acids, metal soaps, fatty acid amine salts, metal salts of heavy sulfonic acid, partial carboxylic acid ester of polyhydric alcohol, and phosphoric ester.

[0045] (D) Demulsifiers: addition product of alkylphenol and ethyleneoxide, polyoxyethylene alkyl ether, and polyoxyethylene sorbitane ester.

[0046] (E) Extreme pressure agents (EP agents):, sulfurized oils, diphenyl sulfide, methyl trichlorostearate, chlorinated naphthalene, benzyl iodide, fluoroalkylpolysiloxane, and lead naphthenate.

[0047] (F) Friction modifiers: fatty alcohol, fatty acid, amine, borated ester, and other esters

[0048] (G) Multifunctional additives: sulfurized oxymolybdenum dithiocarbamate, sulfurized oxymolybdenum organo phosphorodithioate, oxymolybdenum monoglyceride, oxymolybdenum diethylate amide, amine-molybdenum complex compound, and sulfur-containing molybdenum complex compound

[0049] (H) Viscosity Index improvers: polymethacrylate type polymers, ethylene-propylene copolymers, styrene-isoprene copolymers, hydrated styrene-isoprene copolymers, polyisobutylene, and dispersant type viscosity index improvers.

[0050] (I) Pour point depressants: polymethyl methacrylate.

[0051] (K) Foam Inhibitors: alkyl methacrylate polymers and dimethyl silicone polymers.

[0052] (L) Wear inhibitors: zinc dialkyldithiophosphate (Zn-DTP, primary alkyl type & secondary alkyl type).

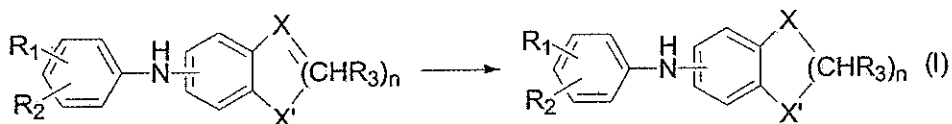
[0053] General Synthetic Procedures

[0054] The benzo[b]perhydroheterocyclic arylamines of this invention may be prepared by the following general methods and procedures. It should be appreciated that where typical or preferred process conditions (e.g., reaction temperatures, times, mole ratios of reactants, solvents, pressures, etc.) are given; other process conditions may also be used unless otherwise stated. Optimum reaction conditions may vary with the particular reactants or solvents used, but such conditions can be determined by one skilled in the art by routine optimization procedures.

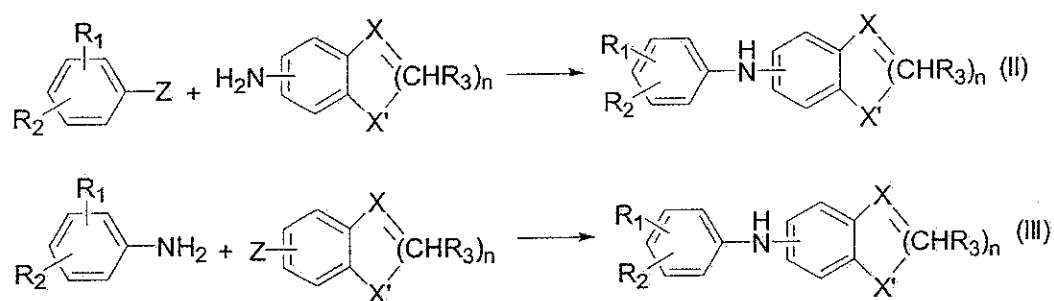
[0055] Those skilled in the art will also recognize that it may be necessary to block or protect certain functional groups while conducting the following synthetic procedures. In such cases, the protecting group will serve to protect the functional group from undesired reactions or to block its undesired reaction with other functional groups or with the reagents used to carry out the desired chemical transformations. The proper choice of a protecting group for a particular functional group will be readily apparent to one skilled in the art. Various protecting groups and their introduction and removal are described, for example, in T. W. Greene and P. G. M. Wuts, *Protective Groups in Organic Synthesis*, Second Edition, Wiley, New York, 1991, and references cited therein.

[0056] Synthesis

[0057] The benzo[b]perhydroheterocyclic arylamines of the present invention are prepared by reduction of benzo[b]heterocyclic arylamines as illustrated in sequence (I).



[0058] The benzo[b]heterocyclic arylamines may be prepared by the reaction sequences depicted in (II) and (III)



[0059] wherein R₁, R₂, R₃, n, X and X' are as defined herein and Z is -OH, -NH₂, Cl, Br or I.

[0060] The coupling reactions shown in (II) and (III) are known in the art for the synthesis of diphenylamines. These coupling methods are applicable to the synthesis of benzo[b]heterocyclic arylamines. Particularly noteworthy coupling reactions for the synthesis of anilinoquinolines are described by Buu-Hoi, Royer and Hubert-Habart, *J. Chem. Soc.*, **1956**, 2048-2051 and Okada, Suzuki, Hirose, Toda and Ozawa, *Chem. Commun.*, **2001**, 2492-2493. Buchwald and Hartwig have developed a palladium catalyzed coupling of aromatic amines and aromatic halides which is applicable to the synthesis of benzo[b]heterocyclic arylamines (Wolfe, Wagaw, Marcoux and Buchwald, *Acc. Chem. Res.*, **1998**, 805-818 and references cited therein and J. C. Peters, S. B. Harkins, S. D. Brown and M. DW. Day, *Inorg. Chem.*, **2001**, 40, 5083-5091). A copper catalyzed method has been developed by Patil, Kelkar, Nabi, and Chaudhari, *Chem. Commun.*, **2003**, 2460-2461.

[0061] There are several methods to reduce the benzo[b]heterocyclic arylamines to benzo[b]perhydroheterocyclic arylamines. The methods that can be employed are the same as those for the reduction of quinoline to tetrahydroquinoline provided that any functionality which is sensitive towards reduction is protected. Hydrogenation can be used as described for quinolines in Rylander, *Catalytic Hydrogenation in Organic Synthesis*, **1979**, 213-230, Academic Press. Hydrogenation of quinolines to tetrahydroquinolines as well as other methods of reduction is described in Hudlicky, *Reductions in Organic Chemistry Second Edition*, **1996**, 72-74, American Chemical Society. 6-aminoquinoline has been hydrogenated to 6-aminotetrahydroquinoline with a platinum oxide catalyst in Example 2 of WO 92/05173. The reduction of quinolines to tetrahydroquinolines with sodium borohydride – nickelous chloride is described by Nose and Kudo, *Chem. Pharm. Bull.*, **1984**, 32, 2421-2425. The reduction of

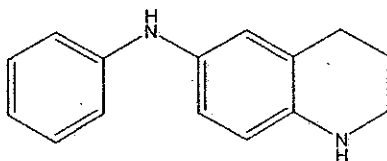
quinolines to tetrahydroquinolines with sodium borohydride in acidic media is described by Gribble and Heald, *Synthesis*, **1975**, 650-652.

EXAMPLES

[0062] The invention is further illustrated by the following examples, which are not to be considered as limitative of its scope. A further understanding of the invention can be had in the following nonlimiting Preparations and Examples. Wherein unless expressly stated in the contrary, all temperatures and temperatures ranges refer to the Centigrade system and the term "ambient" or "room temperature" refers to about 20 to 25° C. The term "percent or %" refers to weight percent, and the term "mole" or "moles" refers to gram moles. The term "equivalent" refers to a quantity of reagent equal in moles, to the moles of the preceding or succeeding reactant recited in that example in terms of finite moles or finite weight or volume. Where given, proton-magnetic resonance spectrum (p.m.r. or n.m.r) were determined at 300 MHz, signals are assigned as singlets(s), broad singlets (bs), doublets (d), double doublets (dd), triplets (t), double triplets (dt), quartets (q), and multiplets (m), and cps refers to cycles per second.

Example 1

[0063] Preparation of Phenyl-(1,2,3,4-tetrahydro-quinolin-6-yl)-amine

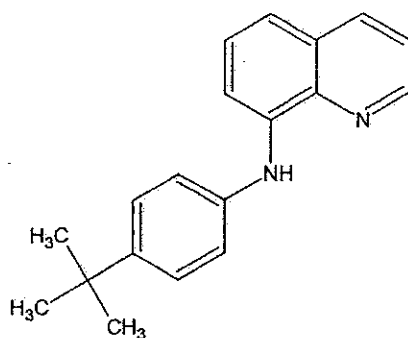


[0064] A solution of 20.4 grams of 6-anilinoquinoline (prepared as described in Buu-Hoi, Royer and Hubert-Habart, *J. Chem. Soc.*, **1956**, 2048-2051) in 400 mL of acetic acid containing 1.3 grams of platinum(IV) oxide was hydrogenated at 30 psi for 4.2 hours on a Parr low-pressure hydrogenator. The solution was filtered; and the filtrate was neutralized with 6N aqueous sodium hydroxide. The aqueous phase was extracted three times with dichloromethane. The combined dichloromethane layers were washed with 6N aqueous sodium hydroxide followed by brine. The dichloromethane layer was dried over anhydrous magnesium sulfate, filtered and concentrated *in vacuo* to yield 20.4 grams of a dark residue. The dark residue was

recrystallized from 95% ethanol to yield 15.2 grams of the desired product as a grey solid. ^1H NMR (CDCl_3) δ 7.2 (m, 2H), 6.8 (m, 4H), 6.45 (d, 1H), 5.35 (bs, 1H), 3.4 (bs, 1H), 3.25 (t, 2H), 2.75 (t, 2H), 1.95 (p, 2H).

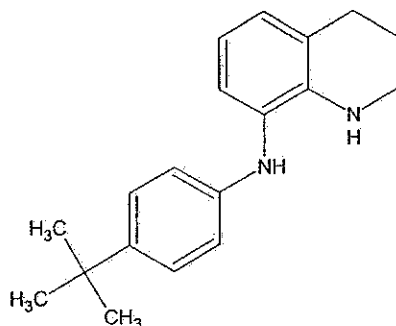
Example 2

[0065] Step A - Preparation of *N*-(4-*tert*-butylphenyl)quinolin-8-amine



[0066] To a flask equipped with a magnetic stirrer, reflux condensor, and nitrogen inlet was added 8-aminoquinoline (14.4 grams, 0.10 moles), 4-*tert*-butyl bromobenzene (21.3 grams, 0.10 moles), *tris*(dibenzylideneacetone)dipalladium (0) (1.8 grams, 0.002 moles), *rac*-2,2'-*bis*(diphenylphosphino)-1,1'-binaphthyl (2.5 grams, 0.004 moles), sodium *tert*-butoxide (19.4 grams, 0.20 moles) and anhydrous toluene (150 mL). The contents of the flask were refluxed for four days; cooled to room temperature; and filtered through a pad of silica gel. The silica gel pad was then eluted with dichloromethane (240 mL). The combined organic layers were concentrated *in vacuo* to yield a dark blue solid. The solid was chromatographed on silica gel, eluting with hexane/ethyl acetate (20:1) to afford 23 grams of the desired product as a yellow solid. ^1H NMR (CDCl_3) δ 8.8 (m, 1H), 8.2 (bs, 1H), 8.1 (d, 1H), 7.1-7.5 (m, 9H), 1.35 (s, 9H).

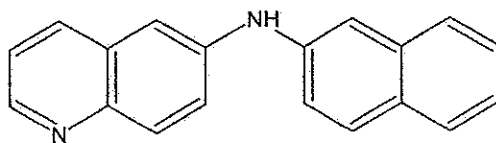
[0067] Step B - Preparation of *N*-(4-*tert*-butylphenyl)-1,2,3,4-tetrahydroquinolin-8-amine



[0068] A solution of 2.46 grams of *N*-(4-*tert*-butylphenyl)quinolin-8-amine from Step A in 100 mL of acetic acid containing 0.15 grams of platinum(IV) oxide was hydrogenated at 45 psi for 1.5 hours on a Parr low-pressure hydrogenator. The solution was filtered through diatomaceous earth; concentrated *in vacuo*; and neutralized with 3N aqueous sodium hydroxide. The aqueous phase was diluted with water and extracted three times with ethyl acetate. The combined ethyl acetate layers were washed with brine; dried over anhydrous magnesium sulfate, filtered and concentrated *in vacuo* to yield 2.5 grams of dark blue oil. The oil was chromatographed on silica gel, eluting with hexane/ethyl acetate (20:1) to afford 2.0 grams of the desired product as a yellow oil. ¹H NMR (CDCl₃) δ 7.2 (d, 2H), 6.5-6.95 (m, 5H), 4.95 (bs, 1H), 3.3 (t, 2H), 2.8 (t, 2H), 1.9 (p, 2H), 1.3 (s, 9H).

Example 3

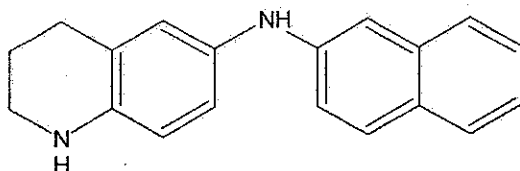
[0069] Step A - Preparation of *N*-2-naphthylquinolin-6-amine



[0070] To a flask equipped with a magnetic stirrer, reflux condensor, and nitrogen inlet was added 6-aminoquinoline (6.69 grams, 46.4 mmol), 2-bromonaphthalene (9.15 grams, 44.2 mmol), *tris*(dibenzylideneacetone)dipalladium (0) (0.80 grams, 0.87 mmol), *rac*-2,2'-*bis*(diphenylphosphino)-1,1'-binaphthyl (1.10 grams, 1.77 mmol), sodium *tert*-butoxide (8.49 grams, 88.3 mmol) and anhydrous toluene (90 mL). The contents of the flask were refluxed for five hours; cooled to room temperature; and filtered through a pad of silica gel. The silica gel pad was then eluted with tetrahydrofuran (135 mL). The combined organic layers were

concentrated *in vacuo* to yield a brown solid. The solid was recrystallized from ethanol to afford 8.6 grams of the desired product as a yellow solid. ^1H NMR (DMSO- d_6 /D $_2$ O) δ 8.9 (d, 1H), 8.65 (d, 1H), 8.2 (d, 1H), 7.25-8.05 (m, 10H).

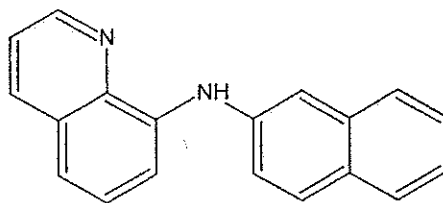
[0071] Step B - Preparation of *N*-2-naphthyl-1,2,3,4-tetrahydroquinolin-6-amine



[0072] A solution of 7.00 grams of *N*-2-naphthylquinolin-6-amine from above in acetic acid (60 mL) and ethyl acetate (10 mL) containing 0.55 grams of platinum(IV) oxide was hydrogenated at 45 psi for 6.0 hours on a Parr low-pressure hydrogenator. The solution was filtered through diatomaceous earth; concentrated *in vacuo*; and neutralized with 3N aqueous sodium hydroxide. The aqueous phase was diluted with water and extracted three times with ethyl acetate. The combined ethyl acetate layers were washed with brine; dried over anhydrous magnesium sulfate, filtered and concentrated *in vacuo* to yield 5.5 grams solid. The solid was chromatographed on silica gel, eluting with hexane/ethyl acetate gradient to afford 3.5 grams of the desired product as a yellow solid. ^1H NMR (CDCl $_3$ /D $_2$ O) δ 6.4-7.8 (m, 10H), 3.1-3.5 (m, 2H), 2.6-2.9 (m, 2H), 1.95 (p, 2H).

Example 4

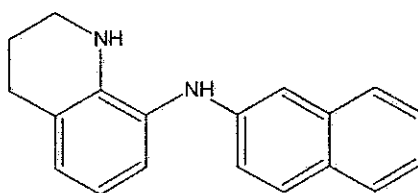
[0073] Step A - Preparation of *N*-2-naphthylquinolin-8-amine



[0074] To a flask equipped with a magnetic stirrer, reflux condensor, and nitrogen inlet was added 8-aminoquinoline (6.81 grams, 47.2 mmol), 2-bromonaphthalene (9.58 grams, 46.3 mmol), *tris*(dibenzylideneacetone)dipalladium (0) (0.84 grams, 0.92 mmol), *rac*-2,2'-*bis*(diphenylphosphino)-1,1'-binaphthyl (0.6 grams, 0.92

mmoles), sodium *tert*-butoxide (8.86 grams, 92.2 mmoles) and anhydrous toluene (90 mL). The contents of the flask were refluxed for sixteen hours; cooled to room temperature; and filtered through a pad of silica gel. The silica gel pad was then eluted with dichloromethane (135 mL). The combined organic layers were concentrated *in vacuo* to yield a yellow solid. The solid was chromatographed on silica gel, eluting with a hexane/ethyl acetate gradient to afford 6.6 grams of the desired product as a yellow solid. ^1H NMR (CDCl_3) δ 8.75 (d, 1H), 8.4 (bs, 1H), 8.05 (d, 1H), 7.6-7.9 (m, 5H), 7.25-7.5 (m, 5H), 7.2 (d, 1H).

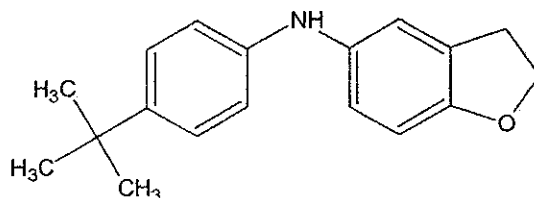
[0075] Step B - Preparation of *N*-2-naphthyl-1,2,3,4-tetrahydroquinolin-8-amine



[0076] A solution of 4.08 grams of *N*-2-naphthylquinolin-8-amine from above in acetic acid (10 mL) and ethyl acetate (150 mL) containing 0.24 grams of platinum(IV) oxide was hydrogenated at 45 psi for four hours on a Parr low-pressure hydrogenator. The solution was filtered through diatomaceous earth; concentrated *in vacuo*; and neutralized with 3N aqueous sodium hydroxide. The aqueous phase was diluted with water and extracted three times with ethyl acetate. The combined ethyl acetate layers were washed with brine; dried over anhydrous magnesium sulfate, filtered and concentrated *in vacuo* to yield 4.2 grams of the desired product as a purple oil. ^1H NMR ($\text{CDCl}_3/\text{D}_2\text{O}$) δ 7.7 (m, 2H), 7.6 (d, 1H), 7.35 (t, 1H), 7.25 (m, 1H), 7.05 (m, 2H), 6.9 (m, 2H), 6.6 (t, 1H), 3.3 (t, 2H), 2.85 (t, 2H), 1.95 (p, 2H).

Example 5

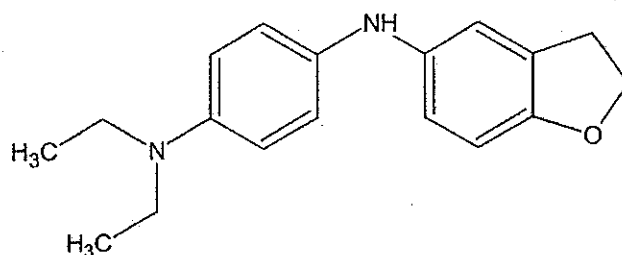
[0077] Preparation of *N*-(4-*tert*-butylphenyl)-2,3-dihydro-1-benzofuran-5-amine



[0078] To a flask equipped with a magnetic stirrer, reflux condensor, and nitrogen inlet was added 2,3-dihydro-1-benzofuran-5-amine (11.6 grams, 85.8 mmols, prepared as in Example 23 of U.S. Pat. No. 20040029932), 4-*tert*-butyl bromobenzene (18.1 grams, 85 mmols), *tris*(dibenzylideneacetone)dipalladium (0) (1.6 grams, 1.7 mmols), *rac*-2,2'-*bis*(diphenylphosphino)-1,1'-binaphthyl (2.1 grams, 3.4 mmols), sodium *tert*-butoxide (16.4 grams, 0.17 moles) and anhydrous toluene (100 mL). The contents of the flask were refluxed for three days; cooled to room temperature; and filtered through a pad of silica gel. The silica gel pad was then eluted with dichloromethane (150 mL). The combined organic layers were concentrated *in vacuo* to yield a dark solid. The solid was chromatographed on silica gel, eluting with hexane/ethyl acetate (20:1) to afford 10 grams of the desired product as a white solid. ¹H NMR (CDCl₃) δ 7.25 (d, 2H), 6.95 (s, 1H), 6.85 (d, 3H), 6.7 (d, 1H), 5.4 (bs, 1H), 4.5 (t, 2H), 3.15 (t, 2H), 1.3 (s, 9H).

Example 6

[0079] Preparation of *N'*-(2,3-dihydro-1-benzofuran-5-yl)-*N,N*-diethylbenzene-1,4-diamine

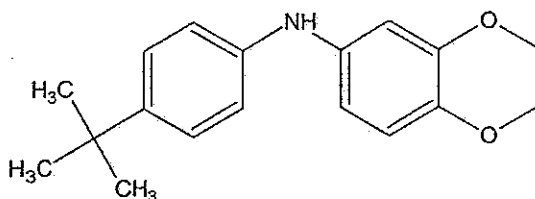


[0080] To a flask equipped with a magnetic stirrer, reflux condensor, and nitrogen inlet was added *N,N*-diethyl-1,4-phenylenediamine (3.35 grams, 20.4 mmols), 5-bromo-2,3-dihydrobenzofuran (3.4 grams, 17.1 mmols), *tris*(dibenzylideneacetone)dipalladium (0) (0.39 grams, 0.43 mmols), *rac*-2,2'-*bis*(diphenylphosphino)-1,1'-binaphthyl (2.1 grams, 3.4 mmols), sodium *tert*-butoxide (0.71 grams, 1.28 mmols) and anhydrous toluene (90 mL). The contents of the flask were heated to 80°C for two days; cooled to room temperature; and filtered through a pad of silica gel. The silica gel pad was then eluted with dichloromethane (200 mL). The combined organic layers were concentrated *in vacuo* to yield a dark blue oil. The

oil was chromatographed on silica gel, eluting with a hexane/ethyl acetate gradient to afford 4.2 grams of the desired product as a brown oil. ^1H NMR (CDCl_3) δ 6.6-7.0 (m, 7H), 5.15 (bs, 1H), 4.5 (t, 2H), 3.05-3.2 (m, 6H), 1.1 (t, 6H).

Example 7

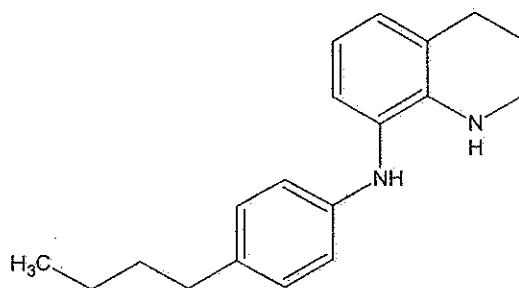
[0081] Preparation of *N*-(4-*tert*-butylphenyl)-2,3-dihydro-1,4-benzodioxin-6-amine



[0082] To a flask equipped with a magnetic stirrer, reflux condensor, and nitrogen inlet was added 1,4-benzodioxin-6-amine (5.26 grams, 34.8 mmol), 4-*tert*-butyl bromobenzene (6.83 grams, 32.1 mmol), *tris*(dibenzylideneacetone)dipalladium (0) (0.58 grams, 0.6 mmol), *rac*-2,2'-*bis*(diphenylphosphino)-1,1'-binaphthyl (0.79 grams, 1.2 mmol), sodium *tert*-butoxide (6.08 grams, 63.0 mmol) and anhydrous toluene (70 mL). The contents of the flask were refluxed for three days; cooled to room temperature; and filtered through a pad of silica gel. The silica gel pad was then eluted with dichloromethane (300 mL). The combined organic layers were concentrated *in vacuo* to yield a dark solid. The solid was chromatographed on silica gel, eluting with a hexane/ethyl acetate gradient to afford 5 grams of the desired product as a white solid. ^1H NMR (CDCl_3) δ 7.25 (d, 2H), 6.9 (d, 2H), 6.75 (d, 1H), 6.5-6.7 (m, 2H), 5.4 (bs, 1H), 4.2 (s, 4H), 1.3 (s, 9H).

Example 8

[0083] Preparation of *N*-(4-butylphenyl)-1,2,3,4-tetrahydroquinolin-8-amine



[0084] To a flask equipped with a magnetic stirrer, reflux condensor, and nitrogen inlet was added 8-hydroxyquinoline (20.0 grams, 0.14 moles), 4-butyl aniline (24.0 grams, 0.16 moles) and iodine (0.52 grams, 2.0 mmoles). The contents of the flask were refluxed for eight days; cooled to room temperature; and diluted with toluene. The toluene solution was filtered through diatomaceous earth and further diluted with dichloromethane. The solution was washed with 5% aqueous sodium hydroxide three times and water three times. The organic layer was dried over magnesium sulfate, filtered and concentrated *in vacuo* to yield a dark brown oil. The oil was chromatographed on silica gel, eluting with hexane/ethyl acetate (10:1) to afford 3.7 grams a brown oil.

[0085] The oil in 70 mL of acetic acid containing 0.22 grams of platinum (IV) oxide was hydrogenated at 35 psi for 4.5 hours on a Parr low-pressure hydrogenator. The solution was filtered; and the filtrate was neutralized with 6N aqueous sodium hydroxide. The aqueous phase was extracted three times with dichloromethane. The combined dichloromethane layers were washed with 6N aqueous sodium hydroxide followed by brine. The dichloromethane layer was dried over anhydrous magnesium sulfate, filtered and concentrated *in vacuo* to yield 3.9 grams of a dark brown oil. The oil was chromatographed on silica gel, eluting with a hexane/ethyl acetate gradient to afford 2.1 grams of the desired product as a yellow oil ^1H NMR (CDCl_3) δ 7.05 (d, 2H), 6.95 (d, 1H), 6.80 (d, 1H), 6.70 (d, 2H), 6.6 (t, 1H), 4.95 (bs, 1H), 4.05 (bs, 1H), 3.3 (t, 2H), 2.8 (t, 2H), 2.5 (t, 2H), 1.95 (p, 2H), 1.55 (p, 2H), 1.35 (h, 2H), 0.95 (t, 3H).

Performance Examples

[0086] Oxidation studies of the products of selected Examples were carried out in a bulk oil oxidation bench test as described by E. S. Yamaguchi et al. in *Tribology Transactions*, Vol. 42(4), 895—901 (1999). In this test the rate of oxygen uptake at

constant pressure by a given weight of oil was monitored. The time required (induction time) for rapid oxygen uptake per 25 grams of sample was measured at 171°C under 1.0 atmosphere of oxygen pressure. The sample was stirred at 1000 revolutions per minute. The results are reported, however, as time for rapid oxygen uptake per 100 grams of sample. The oil contained a catalyst added as oil soluble naphthenates to provide 26 ppm iron, 45 ppm copper, 512 ppm lead, 2.3 ppm manganese, and 24 ppm tin.

[0087] The screening formulation was a fully formulation lubricating oil composition and contained in a Group 2+ base oil, 7.0 mmol/kg dialkyl zinc dithiophosphate, 4.0% polyisobutenyl succinimide, 0.5% dinonyldiphenylamine, 0.25% polyisobutenyl succinimide containing 5.5% molybdenum, 48.5 mmol/kg overbased calcium sulfonate detergent and 0.3% V.I. improver. This baseline screening formulation was tested in the oxidation bench and had a result of 14.1 hours to rapid O₂ uptake. To the baseline screening formulation was top treated with an additional compound and tests were performed at two concentrations. The compounds and results of the oxidation bench test are presented in Table 1.

Table 1
Oxidation Bench Test of Benzo[b]perhydroheterocyclic compounds

<u>Performance Example</u>	<u>Compound of Example #</u>	<u>Test Results (Hr to Rapid)O₂ uptake (Concentration of Antioxidant)</u>	
		<u>(0.5 wt %)</u>	<u>(1.0 wt %)</u>
1	1	55.5	125.0
2	2	52.9	94.5
3	3	68.2	146.5
4	4	80.8	152.0
5	5	49.0	62.0
6	6	33.1	61.0
7	7	44.0	68.0
8	8	85.0	111.0
Comparative A	A ¹	32.5	41.0
Comparative B	B ²	41.9	83.5

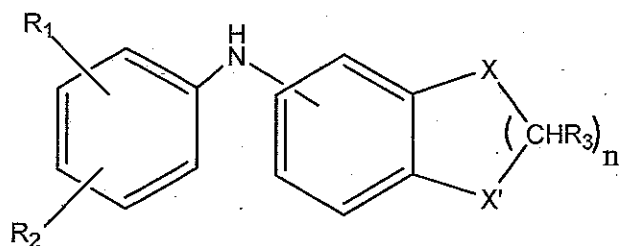
A¹- Irganox® L57 (diphenylamine alkylated with 2,4,4-trimethylpentene) available commercially from Ciba-Geigy

B²- 4-(2-octylamino)diphenylamine available from TCI America

[0088] The excellent oxidation inhibition performance of Examples 1-8 is demonstrated at 0.5 wt% addition to the base line screening formulation and a 1.0 wt % addition to the base line screening formulation. As can be seen from the Table, there is a dramatic improvement by the addition of a small amount of the compounds of the present invention over the base line screening formulation. More dramatically, is when the compounds in Performance Examples 1-8 is compared to Comparative Example A (a commercially available product) an alkylated diphenylamine, which shows up to a 3X improvement in performance, as shown in the Table. The benzo[b]perhydroheterocyclic amines of the Performance Examples 1-4 and 8 also perform better than the non cyclic amine in Comparative Example B (a commercially available product). The advantages on oxidation inhibition can be seen when constraining a heteroatom into a ring.

WHAT IS CLAIMED IS:

1. A compound according to formula I:



Formula I

wherein

R_1 and R_2 are each independently selected from the group consisting of hydrogen, alkyl from 1 to 20 carbon atoms, -OR, -SR and -NRR', where R and R' are independently hydrogen or alkyl from 1 to 6 carbon atoms, or R_1 and R_2 when adjacent to each other together form a 5 to 6 membered alicyclic or aromatic ring which may be optionally substituted with 1 or 2 alkyl groups each having from 1 to 20 carbon atoms;

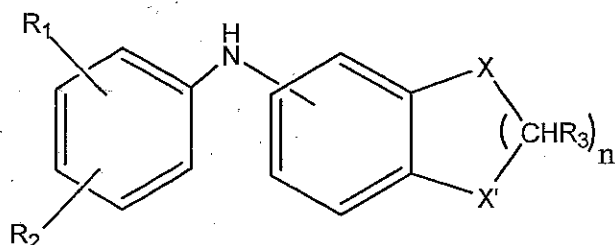
each R_3 is hydrogen or alkyl from 1 to 6 carbon atoms,

at least one of X and X' is NR_5 , and the other of X and X' is selected from - CHR_4 -, oxygen, sulfur or NR_5 , wherein R_4 and R_5 are independently hydrogen or alkyl from 1 to 6 carbon atoms, with the proviso that at least one of X or X' is a heteroatom positioned *ortho* or *para* to the bridging nitrogen atom, and R_1 or R_2 is not hydroxyl; and

n is an integer from 1 to 2.

2. The compound according to claim 1, wherein X is - CHR_4 - and X' is NR_5 .

3. The compound according to any one of the preceding claims, wherein n is 2.
4. The compound according to any one of the preceding claims, wherein R₃, R₄ and R₅ are each hydrogen.
5. The compound according to any one of the preceding claims, wherein R₁ and R₂ are each independently selected from the group consisting of hydrogen, alkyl from 1 to 20 carbon atoms, or R₁ and R₂ when adjacent to each other together form a 5 to 6 membered alicyclic or aromatic ring which may be optionally substituted with 1 or 2 alkyl groups each having from 1 to 20 carbon atoms.
6. The compound according to any one of the preceding claims, wherein at least one of X and X' is sulfur.
7. The compound according to any one of the preceding claims, wherein X and X' are independently selected from oxygen, sulfur or NR₅, wherein R₅ is hydrogen or alkyl from 1 to 6 carbon atoms.
8. The compound according to any one of the preceding claims, wherein R₃ is hydrogen.
9. The compound according to any one of the preceding claims, wherein R₁ is hydrogen and R₂ is selected from the group consisting of alkyl from 1 to 20 carbon atoms, -OR, -SR and -NRR', where R and R' are independently hydrogen or alkyl from 1 to 6 carbon atoms.
10. The compound according to Claim 9, wherein R₂ is -NRR' where R and R' are alkyl from 1 to 6.
11. A lubricating composition comprising a major amount of an oil of lubricating viscosity and a compound according to formula I:



Formula I

wherein

R_1 and R_2 are each independently selected from the group consisting of hydrogen, alkyl from 1 to 20 carbon atoms, -OR, -SR and -NRR', where R and R' are independently hydrogen or alkyl from 1 to 6 carbon atoms, or R_1 and R_2 when adjacent to each other together form a 5 to 6 membered alicyclic or aromatic ring which may be optionally substituted with 1 or 2 alkyl groups each having from 1 to 20 carbon atoms;

each R_3 is hydrogen or alkyl from 1 to 6 carbon atoms,

at least one of X and X' is NR_5 , and the other of X and X' is selected from - CHR_4 -, oxygen, sulfur or NR_5 , wherein R_4 and R_5 are independently hydrogen or alkyl from 1 to 6 carbon atoms, with the proviso that at least one of X or X' is a heteroatom positioned *ortho* or *para* to the bridging nitrogen atom, and R_1 or R_2 is not hydroxyl; and

n is an integer from 1 to 2.

12. The lubricating composition according to claim 11, wherein X is - CHR_4 - and X' is NR_5 .
13. The lubricating composition according to any one of claims 11 to 12, wherein n is 2.

14. The lubricating composition according to any one of claims 11 to 13, wherein R_3 , R_4 and R_5 are each hydrogen.
15. The lubricating composition according to any one of claims 11 to 14, wherein R_1 and R_2 are each independently selected from the group consisting of hydrogen, alkyl from 1 to 20 carbon atoms, or R_1 and R_2 when adjacent to each other together form a 5 to 6 membered alicyclic or aromatic ring which may be optionally substituted with 1 or 2 alkyl groups each having from 1 to 20 carbon atoms.
16. The lubricating composition according to any one of claims 11 to 15, wherein at least one of X and X' is sulfur.
17. The lubricating composition according to any one of claims 11 to 16, wherein X and X' are independently selected from oxygen, sulfur or NR_5 , wherein R_5 is hydrogen or alkyl from 1 to 6 carbon atoms.
18. The lubricating composition according to any one of claims 11 to 17, wherein R_3 is hydrogen.
19. The lubricating composition according to any one of claims 11 to 18, wherein R_1 is hydrogen and R_2 is selected from the group consisting of alkyl from 1 to 20 carbon atoms, -OR, -SR and -NRR', where R and R' are independently hydrogen or alkyl from 1 to 6 carbon atoms.
20. The lubricating composition according to any one of claims 11 to 19, wherein R_2 is -NRR' where R and R' are alkyl from 1 to 6.