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01 **MODIFIED HIGH MOLECULAR WEIGHT SUCCINIMIDES**

02

03 **BACKGROUND OF THE INVENTION**

04

05 1. **Field of the Invention**

06

07 This invention relates to additives which are compatible
 08 with fluorocarbon seals and are useful as dispersants and/or
 09 detergents in lubricating oils. In particular, this
 10 invention is directed toward modified polyamino alkenyl or
 11 alkyl succinimides which are the reaction product of an
 12 alkenyl- or alkyl-substituted succinic anhydride and a
 13 polyalkylene polyamine, wherein the reaction product is
 14 post-treated with a cyclic carbonate. The modified
 15 polyamino alkenyl or alkyl succinimides of this invention
 16 have been found to be compatible with fluorocarbon seals
 17 and, for concentration levels at which fluorocarbon seal
 18 compatibility is achieved, to possess improved dispersancy
 19 and/or detergency properties when employed in a lubricating
 20 oil. These modified succinimides are also useful as
 21 detergents and/or dispersants in fuels.

22

23 2. **Prior Art**

24

25 It is known in the art that alkenyl- or alkyl-substituted
 26 succinic anhydrides have been used as dispersants and/or
 27 detergents in lubricating oils and fuels. Such alkenyl- or
 28 alkyl-substituted succinic anhydrides have been prepared by
 29 three well-known processes: a thermal process (see, e.g.,
 30 U.S. Patent No. 3,361,673), a chlorination process (see,
 31 e.g., U.S. Patent No. 3,172,892) and a combination of the
 32 thermal and chlorination processes (see, e.g., U.S. Patent
 33 No. 3,912,764). The polyisobutenyl succinic anhydride
 34 ("PIBSA") produced by the thermal process has been

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0 172 892

01 characterized as a monomer containing a double bond in the
02 product. Although the exact structure of chlorination PIBSA
03 has not been definitively determined, the chlorination
04 process PIBSA materials have been characterized as monomers
05 containing either a double bond, a ring other than succinic
06 anhydride ring and/or chlorine in the product. [(See
07 J. Weill and B. Sillion, "Reaction of Chlorinated
08 Polyisobutene with Maleic Anhydride: Mechanism Catalysis by
09 Dichloramaleic Anhydride", Revue de l'Institut Francais du
10 Petrole, Vol. 40, No. 1, pp. 77-89 (January-February,
11 1985).] Such compositions include one-to-one monomeric
12 adducts (see, e.g., U.S. Patents Nos. 3,219,666; 3,381,022)
13 as well as "multiply adducted" products, adducts having
14 alkenyl-derived substituents adducted with at least
15 1.3 succinic groups per alkenyl-derived substituent (see,
16 e.g., U.S. Patent No. 4,234,435).

17

18 Alkenyl or alkyl succinimides formed by the reaction of an
19 alkenyl- or alkyl-substituted succinic anhydride and a
20 polyamine are also well known as lubricating oil dispersant
21 and/or detergent additives. See, e.g., U.S. Patent
22 Nos. 3,361,673 and 3,018,250.

23

24 As taught in U.S. Patent No. 4,612,132 ("the '132 patent"),
25 alkenyl or alkyl succinimides may be modified such that one
26 or more of the nitrogens of the polyamine moiety is
27 substituted with a hydrocarbyl oxycarbonyl, a
28 hydroxyhydrocarbyl oxycarbonyl or a hydroxy
29 poly(oxyalkylene) oxycarbonyl. These modified succinimides,
30 which impart improved dispersancy and/or detergency
31 properties when employed in lubricating oils, are obtained
32 by reacting the product of an alkyl or alkenyl succinic
33 anhydride and a polyamine with a cyclic carbonate, a linear
34 mono- or poly carbonate, or a chloroformate. The '132



01 patent discloses succinimide alkenyl or alkyl groups
02 containing from 10 to 300 carbon atoms; most preferred are
03 alkenyl or alkyl groups having from 20 to 100 carbon atoms.
04 However, the highest molecular weight alkenyl or alkyl group
05 specifically taught in the Examples has a molecular weight
06 of 1300. Furthermore, the '132 patent fails to teach
07 anything about the fluorocarbon seal compatibility of the
08 modified succinimides it discloses.

09
10 U.S. Patent No. 4,747,965 discloses modified succinimides
11 similar to those disclosed in the '132 patent, except that
12 the modified succinimides disclosed in this patent are
13 derived from succinimides having an average of greater than
14 1.0 succinic groups per alkenyl-derived substituent.

15
16 While it is known in the art that succinimide additives
17 useful in controlling engine sludge and varnish may be
18 substituted with alkenyl or alkyl groups ranging in number
19 average molecular weight ("Mn") from approximately 300 to
20 5000, no reference teaches that substituents having a Mn of
21 2000-2700 perform better than those having a Mn of about
22 1300. Two references which discuss the effect of the
23 alkenyl-derived substituent's molecular weight on the
24 performance of succinimides as lubricating oil additives are
25 "The Mechanism of Action of Polyisobutenyl Succinimide
26 Lubricating Oil Additives," by E.S. Forbes and E.L.
27 Neustadter (Tribology, Vol. 5, No. 2, pp. 72-77 (April,
28 1972)), and U.S. Patent No. 4,234,435 ("the '435 patent").

29
30 The Forbes and Neustadter article discusses, in part, the
31 effect of polyisobutenyl Mn on the detergency properties of
32 a polyisobutenyl succinimide. However, as shown in Figure 1
33 on page 76 of their article, the results of the tests Forbes
34 and Neustadter conducted indicate that succinimides having a



01 1300 Mn polyisobutenyl substituent are more effective as
02 detergents than those having a polyisobutenyl substituent
03 with a Mn of 2000 or greater. In showing the effect of
04 polyisobutenyl molecular weight on succinimide detergency,
05 this article teaches that maximum detergency performance is
06 obtained when the polyisobutenyl group has a Mn of about
07 1300.

08
09 The '435 patent teaches a preferred polyalkene-derived
10 substituent group with a Mn in the range of 1500-3200. For
11 polybutenes, an especially preferred Mn range is 1700-2400.
12 However, the '435 patent also teaches that the succinimides
13 must have a succinic ratio of at least 1.3, that is at least
14 1.3 succinic groups per equivalent weight of polyalkene-
15 derived substituent group. Most preferred are succinimides
16 having a succinic ratio of 1.5-2.5. The '435 patent teaches
17 that succinimides must have both a high Mn
18 polyalkylene-derived substituent and a high succinic ratio.

19
20 The succinimide additives disclosed in the '435 patent are
21 not only dispersants and/or detergents, but also viscosity
22 index improvers. That is, the '435 additives impart
23 fluidity modifying properties to lubricant compositions
24 containing them. However, viscosity index improving
25 properties are not always desirable for the succinimide, as
26 in the case of single-grade oil formulations, for example.

27
28 Polyamino alkenyl or alkyl succinimides and other additives
29 useful as dispersants and/or detergents, such as Mannich
30 bases, contain basic nitrogen. While basicity is an
31 important property to have in the dispersant/detergent
32 additive, it is believed that the initial attack on
33 fluorocarbon elastomer seals used in some engines involves
34 attack by the basic nitrogen. This attack leads to the loss



01 of fluoride ions, and eventually results in cracks in the
02 seals and loss of other desirable physical properties in the
03 elastomer.

04

05 One approach towards solving the elastomer problem is
06 described in U.S. Patent No. 4,873,009 to Ronald L.
07 Anderson. This patent is also concerned, in part, with the
08 use of succinimides as lube oil additives. Anderson
09 recognizes in Col. 2, lines 28 et seq. that lube additives
10 prepared from "long chain aliphatic polyamines",
11 i.e., succinimides, "are excellent lube oil additives."
12 Anderson teaches such succinimides are "inferior to
13 additives where the alkylene polyamine is hydroxyalkylated"
14 (Col. 2, lines 31-32). Such hydroxyalkylated polyamine-
15 based succinimides, however, "have the drawback that they
16 tend to attack engine seals particularly those of the
17 fluorocarbon polymer type" (Col. 2, lines 35-37).

18

19 Anderson solves his fluorocarbon polymer seal compatibility
20 problem by directly borating his hydroxyalkylated polyamine
21 based succinimides. Furthermore, according to Anderson, it
22 would be desirable for the additive to have a relatively
23 high concentration of N-hydroxyalkyl moieties because the
24 more N-hydroxyalkyl substituents, the cleaner the engine.
25 However, Anderson also teaches that the more amino groups in
26 the polyamine, the greater the degradation of fluorocarbon
27 seal, and that alkylene amines containing more than 2 amino
28 groups cannot be utilized (Col. 2, lines 50-62).

29

30 Accordingly, there exists a need in the art for a
31 succinimide lubricating oil additive which is effective in
32 controlling engine sludge and varnish, but which does not
33 require boration to achieve fluorocarbon seal compatibility.

34

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SUMMARY OF THE INVENTION

A unique class of modified polyamino alkenyl or alkyl succinimide compounds has now been found to be simultaneously compatible with fluorocarbon seals and, at concentration levels for which fluorocarbon seal compatibility is achieved, effective in controlling engine sludge and varnish. These modified polyamino alkenyl or alkyl succinimides are prepared from the succinimide reaction product of 1) an alkenyl- or alkyl-substituted succinic anhydride derived from a polyolefin having a Mn of about 2000 to about 2700 and a weight average molecular weight (Mw) to Mn ratio of about 1 to about 5; and 2) a polyalkylene polyamine having greater than 4 nitrogen atoms per mole. The modified succinimides of the present invention are obtained by post-treating the succinimide reaction product with a cyclic carbonate.

Among other factors, the present invention is based on the finding that a unique class of succinimides is effective in controlling engine sludge and varnish at concentration levels for which the succinimides are simultaneously compatible with engine fluorocarbon seals. Generally, known succinimides useful as dispersants and/or detergents are not always compatible with fluorocarbon seals when present in lubricating oil compositions at concentration levels necessary to be effective in controlling engine sludge and varnish. Accordingly, the present invention also relates to a lubricating oil composition containing these modified polyamino alkenyl or alkyl succinimides.

Among other factors, the present invention is also based on the finding that a unique class of modified polyamino alkenyl or alkyl succinimides wherein the alkenyl or alkyl



01 substituent has a Mn in the range of 2000-2700 possess both
02 superior fluorocarbon seal compatibility and superior
03 dispersancy and/or detergency properties compared to those
04 wherein the alkenyl or alkyl substituent has a Mn of less
05 than about 2000.

06
07 In addition to lubricating oil compositions, the present
08 invention also relates to fuel compositions comprising a
09 major portion of a hydrocarbon boiling in a gasoline or
10 diesel range and an amount of a modified polyamino alkenyl
11 or alkyl succinimide, compatible with fluorocarbon seals,
12 sufficient to provide dispersancy and/or detergency.

13
14 DETAILED DESCRIPTION OF THE INVENTION

15
16 The modified polyamino alkenyl or alkyl succinimides of this
17 invention are prepared by post-treating a polyamino alkenyl
18 or alkyl succinimide with a cyclic carbonate. The polyamino
19 alkenyl or alkyl succinimides are typically prepared by
20 reaction of an alkenyl or alkyl succinic anhydride with a
21 polyamine.

22
23 Alkenyl or alkyl succinimides are disclosed in numerous
24 references and are well known in the art. Certain
25 fundamental types of succinimides and related materials
26 encompassed by the term of art "succinimide" are taught in
27 U.S. Patent Nos. 2,992,708; 3,018,291; 3,024,237; 3,100,673;
28 3,219,666; 3,172,892; and 3,272,746, the disclosures of
29 which are hereby incorporated by reference. The term
30 "succinimide" is understood in the art to include many of
31 the amide, imide and amidine species which are also formed
32 by this reaction. The predominant product, however, is
33 succinimide and this term has been generally accepted as
34 meaning the product of a reaction of an alkenyl- or



01 alkyl-substituted succinic acid or anhydride with a
02 polyamine.

03

04 THE SUCCINIC ANHYDRIDE REACTANT

05

06 Various methods for the preparation of alkenyl- or
07 alkyl-substituted succinic anhydride involving the reaction
08 of a polyolefin and maleic anhydride have been described in
09 the art. As mentioned above, such methods include a thermal
10 process and a chlorination process. The thermal process is
11 characterized by the thermal reaction of a polyolefin with
12 maleic anhydride. The chlorination process is characterized
13 by the reaction of a halogenated polyolefin, such as a
14 chlorinated polyolefin, with maleic anhydride.

15 Alternatively, the alkenyl- or alkyl-substituted succinic
16 anhydride may be prepared as described in U.S. Patents
17 Nos. 4,388,471 and 4,450,281, which are totally incorporated
18 herein by reference. Other examples of the preparation of
19 alkenyl- or alkyl-substituted succinic anhydride are taught
20 in U.S. Patents Nos. 3,018,250 and 3,024,195, which are
21 totally incorporated herein by reference.

22

23 In the case of the unique class of polyamino alkenyl or
24 alkyl succinimide compounds of this invention, the alkenyl
25 or alkyl succinic anhydride reactant is derived from a
26 polyolefin having a Mn from about 2000 to about 2700 and a
27 Mw/Mn ratio of about 1 to about 5. In a preferred
28 embodiment, the alkenyl or alkyl group of the succinimide
29 has a Mn value from about 2100 to about 2400. Most
30 preferred are alkenyl or alkyl substituents having a Mn of
31 about 2200.

32

33 Suitable polyolefin polymers for reaction with maleic
34 anhydride include polymers comprising a major amount of C₂

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01 to C₅ monoolefin, e.g., ethylene, propylene, butylene,
02 iso-butylene and pentene. The polymers can be homopolymers
03 such as polyisobutylene as well as copolymers of 2 or more
04 such olefins such as copolymers of: ethylene and propylene,
05 butylene, and isobutylene, etc. Other copolymers include
06 those in which a minor amount of the copolymer monomers,
07 e.g., 1 to 20 mole percent, is a C₄ to C₈ nonconjugated
08 diolefin, e.g., a copolymer of isobutylene and butadiene or
09 a copolymer of ethylene, propylene and 1,4-hexadiene, etc.
10

11 A particularly preferred class of olefin polymers for
12 reaction with maleic anhydride comprises the polybutenes,
13 which are prepared by polymerization of one or more of
14 1-butene, 2-butene and isobutene. Especially desirable are
15 polybutenes containing a substantial proportion of units
16 derived from isobutene. The polybutene may contain minor
17 amounts of butadiene which may or may not be incorporated in
18 the polymer. These polybutenes are readily available
19 commercial materials well known to those skilled in the art.
20 Disclosures thereof will be found, for example, in U.S.
21 Patents Nos. 3,215,707; 3,231,587; 3,515,669; 3,579,450; and
22 3,912,764, as well as U.S. Patent Nos. 4,152,499 and
23 4,605,808. The above are incorporated by reference for
24 their disclosures of suitable polybutenes.
25

26 Suitable succinic anhydride reactants also include
27 copolymers having alternating polyalkylene and succinic
28 groups, such as those taught in U.S. Patent No. 5,112,507,
29 which is hereby incorporated by reference.
30

31 As used herein, the term "succinic ratio" refers to the
32 average number of succinic groups per polyolefin group in
33 the alkenyl or alkyl succinic anhydride reaction product of
34



01 maleic anhydride and polyolefin. For example, a succinic
02 ratio of 1.0 indicates an average of one succinic group per
03 polyolefin group in the alkenyl or alkyl succinic anhydride
04 product. Likewise, a succinic ratio of 1.35 indicates an
05 average of 1.35 succinic groups per polyolefin group in the
06 alkenyl or alkyl succinic anhydride product, and so forth.

07

08 The succinic ratio can be calculated from the saponification
09 number (mg KOH per gram of sample), the actives content of
10 the alkenyl or alkyl succinic anhydride product and the
11 molecular weight of the starting polyolefin. The actives
12 content of the alkenyl or alkyl succinic anhydride product
13 is measured in terms of the actives fraction, wherein an
14 actives fraction of 1.0 is equivalent to 100 weight percent
15 actives. Accordingly, an actives fraction of 0.5 would
16 correspond to 50 weight percent actives.

17

18 The succinic ratio of the alkenyl or alkyl succinic
19 anhydride product of maleic anhydride and polyolefin can be
20 calculated in accordance with the following equation:

21

22 Succinic ratio =
$$\frac{M_{po} \times P}{(C \times A) - (M_{ma} \times P)}$$

23

24
25 wherein P = saponification number of the alkenyl or alkyl
26 succinic anhydride sample (mg KOH/g)

27

28 A = actives fraction of the alkenyl or alkyl
29 succinic anhydride sample

30

31 M_{po} = number average molecular weight of the
32 starting polyolefin

33

34

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01 $M_{ma} = 98$ (molecular weight of maleic anhydride)

02
03 $C =$ conversion factor = 112220 (for conversion of
04 gram-moles of alkenyl or alkyl succinic
05 anhydride per gram of sample to milligrams of
06 KOH per gram of sample)
07

08 The saponification number, P , can be measured using known
09 procedures, such as the procedure described in ASTM D94.
10

11 The actives fraction of the alkenyl or alkyl succinic
12 anhydride can be determined from the percent of unreacted
13 polyolefin according to the following procedure. A 5.0 gram
14 sample of the reaction product of maleic anhydride and
15 polyolefin is dissolved in hexane, placed in a column of
16 80.0 grams of silica gel (Davisil 62, a 140 angstrom pore
17 size silica gel), and eluted with 1 liter of hexane. The
18 percent unreacted polyolefin is determined by removing the
19 hexane solvent under vacuum from the eluent and weighing the
20 residue. Percent unreacted polyolefin is calculated
21 according to the following formula:
22

23
$$\text{Percent Unreacted Polyolefin} = \frac{\text{Net Weight of Residue}}{\text{Sample Weight}} \times 100$$

25

26 The weight percent actives for the alkenyl or alkyl succinic
27 anhydride product is calculated from the percent unreacted
28 polyolefin using the formula:
29

30
$$\text{Weight Percent Actives} = 100 - \text{Percent Unreacted Polyolefin}$$

31
32
33
34



01 The actives fraction of the alkenyl or alkyl succinic
02 anhydride is then calculated as follows:

03

04
$$\text{Actives Fraction} = \frac{\text{Weight Percent Actives}}{100}$$

05

06

07 The percent conversion of polyolefin is calculated from the
08 weight percent actives as follows:

09

10

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$$\text{Percent Conversion} = \frac{\text{wt. \% actives} \times \left[\frac{M_{po}}{M_{po} + [M_{ma} \times SR]} \right]}{\left[\text{wt. \% actives} \times \left[\frac{M_{po}}{M_{po} + [M_{ma} \times SR]} \right] \right] + [100 - \text{wt. \% actives}]}$$

wherein M_{po} = number average molecular weight of the
starting polyolefin

M_{ma} = 98 (molecular weight of maleic anhydride)

SR = succinic ratio of alkenyl or alkyl succinic
anhydride product

It is, of course, understood that alkenyl or alkyl succinic
anhydride products having high succinic ratios can be
blended with other alkenyl succinic anhydrides having lower
succinic ratios, for example, ratios of around 1.0, to
provide an alkenyl succinic anhydride product having an
intermediate succinic ratio.



01 In general, suitable succinic ratios for the alkenyl or
02 alkyl succinic anhydride reactants employed in preparing the
03 additives of this invention are greater than about 1 but
04 less than about 2. Succinic anhydrides with succinic ratios
05 of about 2, when reacted with amines having greater than
06 4 nitrogen atoms per mole and post-treated with a cyclic
07 carbonate, form gels. Accordingly, succinic ratios of about
08 1.7 or less are preferred.

09

10 The Polyamine Reactant

11

12 The polyamine to be reacted with the alkenyl or alkyl
13 succinic anhydride in order to produce the polyamino alkenyl
14 or alkyl succinimide employed in this invention is generally
15 a polyalkylene polyamine. Preferably, the polyalkylene
16 polyamine has greater than 4 amine nitrogen atoms per mole,
17 up to a maximum of about 12 amine nitrogen atoms per mole.
18 Most preferred are polyamines having from about 5 to about
19 7 nitrogen atoms per mole. The number of amine nitrogen
20 atoms per mole of polyamine is calculated as follows:

21

$$\begin{array}{l} \text{number of nitrogen atoms} \\ \text{per mole of polyamine} \end{array} = \frac{\% N \times M_{pa}}{14 \times 100}$$

24

25 wherein % N = percent nitrogen in polyamine or polyamine
26 mixture

27

28 M_{pa} = number average molecular weight of the
29 polyamine or polyamine mixture

30

31 Preferred polyalkylene polyamines also contain from about 4
32 to about 40 carbon atoms, there being preferably from 2 to 3
33 carbon atoms per alkylene unit. The polyamine preferably

34



01 has a carbon-to-nitrogen ratio of from about 1:1 to about
02 10:1.

03

04 The polyamine is so selected so as to provide at least one
05 basic amine per succinimide. Since the reaction of the
06 polyamino alkenyl or alkyl succinimide with a cyclic
07 carbonate is believed to efficiently proceed through a
08 primary or secondary amine, at least one of the basic amine
09 atoms of the polyamino alkenyl or alkyl succinimide must
10 either be a primary amine or a secondary amine.

11 Accordingly, in those instances in which the succinimide
12 contains only one basic amine, that amine must either be a
13 primary amine or a secondary amine.

14

15 The polyamine portion of the polyamino alkenyl or alkyl
16 succinimide may be substituted with substituents selected
17 from (A) hydrogen, (B) hydrocarbyl groups of from 1 to about
18 10 carbon atoms, (C) acyl groups of from 2 to about 10
19 carbon atoms, and (D) monohydroxy, mononitro, monocyano,
20 lower alkyl and lower alkoxy derivatives of (B) and (C).
21 "Lower", as used in terms like lower alkyl or lower alkoxy,
22 means a group containing from 1 to about 6 carbon atoms. At
23 least one of the substituents on one of the amines of the
24 polyamine is hydrogen, e.g., at least one of the basic
25 nitrogen atoms of the polyamine is a primary or secondary
26 amino nitrogen atom.

27

28 Examples of suitable polyamines that can be used to form the
29 compounds of this invention include the following:
30 tetraethylene pentamine, pentaethylene hexamine, Dow E-100®
31 heavy polyamine (number average MW=303, available from Dow
32 Chemical Company, Midland, MI.), and Union Carbide HPA-X
33 heavy polyamine (number average MW=275, available from Union
34 Carbide Corporation, Danbury, CT.). Such amines encompass



01 isomers such as branched-chain polyamines and the previously
02 mentioned substituted polyamines, including
03 hydrocarbyl-substituted polyamines. HPA-X heavy polyamine
04 ("HPA-X") contains an average of approximately 6.5 nitrogen
05 atoms per mole, and is a preferred polyamine.

06
07 In addition, the polyamine used as a reactant in the
08 production of succinimides of the present invention need not
09 be a single compound. Instead, the polyamine may be a
10 mixture in which one or several compounds predominate with
11 the average composition indicated. For example,
12 tetraethylene pentamine prepared by the polymerization of
13 aziridine or the reaction of dichloroethylene and ammonia
14 will have both lower and higher amine members,
15 e.g., triethylene tetramine, substituted piperazines and
16 pentaethylene hexamine, but the composition will be largely
17 tetraethylene pentamine and the empirical formula of the
18 total amine composition will closely approximate that of
19 tetraethylene pentamine.

20
21 Other examples of suitable polyamines include admixtures of
22 amines of various sizes, provided that the overall mixture
23 contains greater than 4 nitrogen atoms per mole. Included
24 within these suitable polyamines are mixtures of diethylene
25 triamine ("DETA") and heavy polyamine. A preferred
26 polyamine admixture reactant is a mixture containing 20% by
27 weight DETA and 80% by weight HPA-X; as determined by the
28 method described above, this preferred polyamine reactant
29 contains an average of about 5.2 nitrogen atoms per mole.

30
31 Methods of preparation of polyamines and their reactions are
32 detailed in Sidgewick's "The Organic Chemistry of Nitrogen",
33 Clarendon Press, Oxford, 1966; Noller's "Chemistry of
34 Organic Compounds", Saunders, Philadelphia, 2nd Ed., 1957;



01 and Kirk-Othmer's "Encyclopedia of Chemical Technology", 2nd
02 Ed., especially Volumes 2, pp. 99-116.

03

04 The reaction of a polyamine with an alkenyl or alkyl
05 succinic anhydride to produce polyamino alkenyl or alkyl
06 succinimides is well known in the art and is disclosed in
07 U.S. Patents Nos. 2,992,708; 3,018,291; 3,024,237;
08 3,100,673; 3,219,666; 3,172,892 and 3,272,746. The above
09 are incorporated herein by reference for their disclosures
10 of preparing alkenyl or alkyl succinimides.

11

12 Generally, a suitable molar charge of polyamine to alkenyl
13 or alkyl succinic anhydride for making the compounds of this
14 invention is from about 0.35:1 to about 0.6:1; although
15 preferably from about 0.4:1 to about 0.5:1.

16

17 As used herein, the phrase "molar charge of polyamine to
18 alkenyl or alkyl succinic anhydride" means the ratio of the
19 number of moles of polyamine to the number of moles of
20 succinic groups in the succinic anhydride reactant. The
21 number of moles of succinic groups in the succinic anhydride
22 reactant is determined as follows:

23

24 number of moles $= \frac{P}{C}$ x weight of alkenyl or alkyl succinic
25 of succinic groups anhydride sample (g)

26

27 wherein P and C are as defined above.

28

29 POST-TREATMENT OF THE POLYAMINO ALKENYL
30 OR ALKYL SUCCINIMIDE WITH A CYCLIC CARBONATE

31

32 The polyamino alkenyl or alkyl succinimides formed as
33 described above are then reacted with a cyclic carbonate.
34 The resulting modified polyamino alkenyl succinimide has one



01 or more nitrogens of the polyamino moiety substituted with a
02 hydroxy hydrocarbyl oxycarbonyl, a hydroxy poly(oxyalkylene)
03 oxycarbonyl, a hydroxyalkylene, hydroxyalkylenepoly-
04 (oxyalkylene), or mixture thereof. The products so produced
05 are compatible with fluorocarbon seals and are effective
06 dispersant and detergent additives for lubricating oils and
07 for fuels.

08

09 The reaction of a polyamino alkenyl or alkyl succinimide
10 with a cyclic carbonate is conducted at a temperature
11 sufficient to cause reaction of the cyclic carbonate with
12 the polyamino alkenyl or alkyl succinimide. In particular,
13 reaction temperatures of from about 0°C to about 250°C are
14 preferred with temperatures of from about 100°C to 200°C
15 being more preferred and temperatures of from 150°C to 180°C
16 are most preferred.

17

18 The reaction may be conducted neat, wherein both the alkenyl
19 or alkyl succinimide and the cyclic carbonate are combined
20 in the proper ratio, either alone or in the presence of a
21 catalyst (such as an acidic, basic or Lewis acid catalyst),
22 and then stirred at the reaction temperature. Examples of
23 suitable catalysts include, for instance, phosphoric acid,
24 boron trifluoride, alkyl or aryl sulfonic acid, alkali or
25 alkaline carbonate.

26

27 Alternatively, the reaction may be conducted in a diluent.
28 For example, the reactants may be combined in a solvent such
29 as toluene, xylene, oil or the like, and then stirred at the
30 reaction temperature. After reaction completion, volatile
31 components may be stripped off. When a diluent is employed,
32 it is preferably inert to the reactants and products formed
33 and is generally used in an amount sufficient to insure
34 efficient stirring.



01 Water, which can be present in the polyamino alkenyl or
02 alkyl succinimide, may be removed from the reaction system
03 either before or during the course of the reaction via
04 azeotroping or distillation. After reaction completion, the
05 system can be stripped at elevated temperatures (100°C to
06 250°C) and reduced pressures to remove any volatile
07 components which may be present in the product.
08

09 Alternatively, a continuous system may be employed in which
10 the alkenyl or alkyl succinic anhydride and polyamine are
11 added at the front end of the system while the organic
12 carbonate is added further downstream in the system. In
13 such a continuous system, the organic carbonate may be added
14 at any time after mixing of the alkenyl or alkyl succinic
15 anhydride with the polyamine has occurred. Preferably, the
16 organic carbonate is added within two hours after mixing of
17 the alkenyl or alkyl succinic anhydride with the polyamine,
18 preferably after the major portion of the amine has reacted
19 with the anhydride.
20

21 In a continuous system, the reaction temperature may be
22 adjusted to maximize reaction efficiency. Accordingly, the
23 temperature employed in the reaction of the alkenyl or alkyl
24 succinic anhydride with a polyamine may be the same as or
25 different from that which is maintained for the reaction of
26 this resulting product with the cyclic carbonate. In such a
27 continuous system, the reaction temperature is generally
28 between 0°C to 250°C; preferably between 125°C to 200°C; and
29 most preferably between 150°C to 180°C.
30

31 The reaction of polyamino alkenyl or alkyl succinimides with
32 cyclic carbonates is known in the art and is described in
33 U.S. Patent 4,612,132, which is totally incorporated herein
34 by reference.



01 A particularly preferred cyclic carbonate is 1,3-dioxolan-2-
02 one (ethylene carbonate). Ethylene carbonate is
03 commercially available or may be prepared by methods
04 well-known in the art.

05

06 The molar charge of cyclic carbonate employed in the post-
07 treatment reaction is based upon the theoretical number of
08 basic nitrogens contained in the polyamino substituent of
09 the succinimide. Thus, when 1 equivalent of tetraethylene
10 pentamine ("TEPA") is reacted with two equivalents of
11 succinic anhydride, the resulting bis succinimide will
12 theoretically contain 3 basic nitrogens. Accordingly, a
13 molar charge of 2 would require that two moles of cyclic
14 carbonate be added for each basic nitrogen or in this case
15 6 moles of cyclic carbonate for each mole of bis succinimide
16 prepared from TEPA. Mole ratios of the cyclic carbonate to
17 the basic amine nitrogen of the polyamino alkenyl
18 succinimide employed in the process of this invention are
19 generally in the range of from about 1.5:1 to about 4:1;
20 although preferably from about 2:1 to about 3:1.

21

22 As described in U.S. Patent No. 4,612,132, cyclic carbonates
23 may react with the primary and secondary amines of a
24 polyamino alkenyl or alkyl succinimide to form two types of
25 compounds. In the first instance, strong bases, including
26 unhindered amines such as primary amines and some secondary
27 amines, react with an equivalent of cyclic carbonate to
28 produce a carbamic ester. In the second instance, hindered
29 bases, such as hindered secondary amines, may react with an
30 equivalent of the same cyclic carbonate to form a
31 hydroxyalkyleneamine linkage. Unlike the carbamate
32 products, the hydroxyalkyleneamine products retain their
33 basicity.

34



01 Accordingly, the reaction of a cyclic carbonate with a
02 polyamino alkenyl or alkyl succinimide may yield a mixture
03 of products. When the molar charge of the cyclic carbonate
04 to the basic nitrogen of the succinimide is about 1 or less,
05 it is anticipated that a large portion of the primary and
06 secondary amines of the succinimide will have been converted
07 to hydroxy hydrocarbyl carbamic esters with some
08 hydroxyhydrocarbylamine derivatives also being formed. As
09 the mole ratio is raised above 1, poly(oxyalkylene) polymers
10 of the carbamic esters and the hydroxyhydrocarbylamine
11 derivatives are expected.

12
13 The modified succinimides of this invention can also be
14 reacted with boric acid or a similar boron compound to form
15 borated dispersants having utility within the scope of this
16 invention. In addition to boric acid (boron acid), examples
17 of suitable boron compounds include boron oxides, boron
18 halides and esters of boric acid. Generally from about 0.1
19 equivalents to 10 equivalents of boron compound to the
20 modified succinimide may be employed.

21
22 LUBRICATING OIL COMPOSITIONS AND CONCENTRATES
23 CONTAINING MODIFIED SUCCINIMIDES

24
25 The modified polyamino alkenyl or alkyl succinimides of this
26 invention are compatible with fluorocarbon seals. At
27 concentration levels for which the additives of this
28 invention are compatible with fluorocarbon seals, they are
29 effective as detergent and dispersant additives when
30 employed in lubricating oils. When employed in this manner,
31 the modified polyamino alkenyl or alkyl succinimide additive
32 is usually present in from about 1 to about 5 percent by
33 weight (on a dry polymer basis) to the total composition and
34



01 preferably less than about 3 percent by weight (on a dry
02 polymer basis).

03

04 As used herein, the phrase "dry polymer basis" indicates
05 that only the modified succinimide compounds of this
06 invention are considered when determining the amount of the
07 additive relative to the remainder of a composition (e.g.,
08 lube oil composition, lube oil concentrate, fuel composition
09 or fuel concentrate). Diluents and any other inactives are
10 excluded.

11

12 The lubricating oil used with the additive compositions of
13 this invention may be mineral oil or synthetic oils of
14 lubricating viscosity and preferably suitable for use in the
15 crankcase of an internal combustion engine. Crankcase
16 lubricating oils ordinarily have a viscosity of about 1300
17 cSt at 0°F to 22.7 cSt at 210°F (99°C). The lubricating
18 oils may be derived from synthetic or natural sources.
19 Mineral oil for use as the base oil in this invention
20 includes paraffinic, naphthenic and other oils that are
21 ordinarily used in lubricating oil compositions. Synthetic
22 oils include both hydrocarbon synthetic oils and synthetic
23 esters. Useful synthetic hydrocarbon oils include liquid
24 polymers of alpha olefins having the proper viscosity.
25 Especially useful are the hydrogenated liquid oligomers of
26 C₆ to C₁₂ alpha olefins such as 1-decene trimer. Likewise,
27 alkyl benzenes of proper viscosity such as didodecyl benzene
28 can be used. Useful synthetic esters include the esters of
29 both monocarboxylic acid and polycarboxylic acids as well as
30 monohydroxy alkanols and polyols. Typical examples are
31 didodecyl adipate, pentaerythritol tetracaprate,
32 di-2-ethylhexyl adipate, dilaurylsebacate and the like.
33 Complex esters prepared from mixtures of mono and
34

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01 dicarboxylic acid and mono and dihydroxy alkanols can also
02 be used.

03

04 Blends of hydrocarbon oils with synthetic oils are also
05 useful. For example, blends of 10 to 25 weight percent
06 hydrogenated 1-decene trimer with 75 to 90 weight percent
07 150 SUS (100°F) mineral oil gives an excellent lubricating
08 oil base.

09

10 Other additives which may be present in the formulation
11 include detergents (overbased and non-overbased), rust
12 inhibitors, foam inhibitors, corrosion inhibitors, metal
13 deactivators, pour point depressants, antioxidants, wear
14 inhibitors, zinc dithiophosphates and a variety of other
15 well-known additives.

16

17 It is also contemplated the modified succinimides of this
18 invention may be employed as dispersants and detergents in
19 hydraulic fluids, marine crankcase lubricants and the like.
20 When so employed, the modified succinimide is added at from
21 about 0.1 to 5 percent by weight (on a dry polymer basis) to
22 the oil, and preferably at from 0.5 to 5 weight percent (on
23 a dry polymer basis).

24

25 Additive concentrates are also included within the scope of
26 this invention. The concentrates of this invention usually
27 include from about 90 to 10 weight percent of an oil of
28 lubricating viscosity and from about 10 to 90 weight percent
29 (on a dry polymer basis) of the additive of this invention.
30 Typically, the concentrates contain sufficient diluent to
31 make them easy to handle during shipping and storage.
32 Suitable diluents for the concentrates include any inert
33 diluent, preferably an oil of lubricating viscosity, so that
34 the concentrate may be readily mixed with lubricating oils



01 to prepare lubricating oil compositions. Suitable
02 lubricating oils which can be used as diluents typically
03 have viscosities in the range from about 35 to about 500
04 Saybolt Universal Seconds (SUS) at 100°F (38°C), although an
05 oil of lubricating viscosity may be used.

06

07 FUEL COMPOSITIONS AND CONCENTRATES
08 CONTAINING MODIFIED SUCCINIMIDES

09

10 When used in fuels, the proper concentration of the additive
11 necessary in order to achieve the desired detergency is
12 dependent upon a variety of factors including the type of
13 fuel used, the presence of other detergents or dispersants
14 or other additives, etc. Generally, however, and in the
15 preferred embodiment, the range of concentration of the
16 additive in the base fuel is 10 to 10,000 weight parts per
17 million, preferably from 30 to 2,000 weight parts per
18 million, of the modified succinimide per part of base fuel.
19 If other detergents are present, a lesser amount of the
20 modified succinimide may be used.

21

22 The modified succinimide additives of this invention may
23 also be formulated as a fuel concentrate, using an inert
24 stable oleophilic organic solvent boiling in the range of
25 about 150°F to 400°F. Preferably, an aliphatic or an
26 aromatic hydrocarbon solvent is used, such as benzene,
27 toluene, xylene or higher-boiling aromatics or aromatic
28 thinners. Aliphatic alcohols of about 3 to 8 carbon atoms,
29 such as isopropanol, isobutylcarbinol, n-butanol and the
30 like, in combination with hydrocarbon solvents are also
31 suitable for use with the fuel additive. In the fuel
32 concentrate, the amount of the additive will be ordinarily
33 at least 10 percent by weight and generally not exceed

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01 70 percent by weight and preferably from 10 to 25 weight
02 percent (all on a dry polymer basis).

03

04 The following examples are offered to specifically
05 illustrate this invention. These examples and illustrations
06 are not to be construed in any way as limiting the scope of
07 this invention.

08

09

EXAMPLES

10

11 Example 1. Preparation of PIBSA 2200 (succinic ratio = 1.1)

12

13 A 35.186 Kg, 16 mol., sample of Parapol 2200 (a 2200 Mn
14 polybutene available from Exxon Chemical Company) was
15 charged to a reactor and heated to 232°C. During this
16 time, the reactor was pressurized to 40 psig with
17 nitrogen and then vented three times to remove oxygen.
18 The reactor was pressurized to 24.7 psia. Then 1500 g
19 maleic anhydride was added over a thirty-minute period.
20 Then 4581 g maleic anhydride was added over a 4-hour
21 period. The total charge mole ratio (CMR) of maleic
22 anhydride to polybutene was 3.88. After the maleic
23 anhydride addition was completed, the reaction was held
24 at 232°C for 1.5 hour. Then the reaction was cooled
25 and the pressure reduced to 0.4 psia to remove any
26 unreacted maleic anhydride. To this was then added a
27 light neutral diluent oil. This was heated to 160°C
28 for 24 hours and was then filtered. This product was
29 found to contain 37.68 wt. % actives and had a
30 saponification number of 19.7 mg KOH/g sample. The
31 succinic ratio was 1.1 based on a polybutene molecular
32 weight of 2246 determined by GPC.

33

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01 Example 2. Preparation of PIBSA 1300 (succinic ratio = 1.1)

02

03 The procedure of Example 1 was repeated except that
04 Parapol 1300 (a 1300 Mn polybutene available from Exxon
05 Chemical Company) was used instead of Parapol 2200.
06 After dilution with diluent oil and filtration, this
07 product was found to contain 49.6 wt. % actives and a
08 saponification number of 42.2 mg KOH/g sample. The
09 succinic ratio was 1.1 based on a polybutene molecular
10 weight of 1300.

11

12 Example 3. Preparation of PIBSA 2200 (succinic ratio = 1.5)

13

14 Parapol 2200, 42.8 Kg, 19.45 mol, was charged to a
15 reactor and the temperature was increased to 150°C.
16 During this time, the reactor was pressurized to 40
17 psig with nitrogen and then vented three times to
18 remove oxygen. Then at 150°C, maleic anhydride, 4294
19 g, 43.82 mol, and di-t-butylperoxide, 523 g, 3.58 mol,
20 was added. The first 25% was added over 30 minutes.
21 The remainder was then added over 11.5 hours. The CMR
22 of maleic anhydride to polybutene was 2.25. The
23 reaction was held at 150°C for one hour. Then the
24 reactor was heated to 190°C for 1 hour to destroy any
25 remaining di-t-butylperoxide. Then vacuum was applied
26 to the reactor and the unreacted maleic anhydride was
27 removed. This material was then diluted with a light
28 neutral oil and filtered. The product after filtration
29 had a saponification number of 31.6 mg KOH/g sample and
30 contained 45.62 wt. % actives. The succinic ratio was
31 1.5 for this material based on a polybutene molecular
32 weight of 2200.

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01 Example 4A. Preparation of PIBSA 1300 (succinic
02 ratio = 1.9)

03

04 Parapol 1300, 6.9 Kg, 47.6 mol, was charged to a
05 reactor and the temperature was increased to 150°C.
06 During this time, the reactor was pressurized to
07 40 psig with nitrogen and then vented three times to
08 remove oxygen. Then at 150°C, maleic anhydride,
09 9332.66 g (95.23 mol), and di-t-butylperoxide, 1280 g
10 (8.77 mol) was added over 5 hours. Then the reaction
11 was maintained at 150°C for an additional 2 hours. The
12 reaction was then heated to 190°C for 1 hour to destroy
13 any residual peroxide. The pressure was then reduced
14 to 0.4 psia and the excess maleic anhydride was
15 removed. The product was found to contain 65.4 wt. %
16 actives and had a saponification number of 94.5 mg
17 KOH/g sample. The succinic ratio was 1.9 for this
18 material based on a polybutene molecular weight of
19 1300.

20

21 Example 4B. Preparation of PIBSA 1300 (succinic
22 ratio = 1.5)

23

24 In order to produce a PIBSA with a succinic ratio of
25 1.5, the product from Example 4A, 629.1 g (succinic
26 ratio 1.9), was blended with diluent oil, 786.1 g. and
27 the PIBSA 1300 (succinic ratio = 1.1) from Example 2,
28 962.8 g (succinic ratio 1.1). This gave 2388 g of
29 PIBSA 1300 (succinic ratio = 1.5) with a saponification
30 number of 40.1 and wt. % actives of 35.4 and a succinic
31 ratio of 1.5.

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01 Example 5. Preparation of BIS HPA-X PIBSA 2200 Succinimide
02 (succinic ratio = 1.1)
03

04 To a 22 L three-necked flask equipped with a Dean Stark
05 trap was added 7655 g (1.34 mol) of PIBSA from
06 Example 1. This was heated to 130°C under nitrogen
07 with stirring and to this was added HPA-X, 162.2 g
08 (0.59 mol) over 2 hours. The temperature was increased
09 to 165°C. The amine/PIBSA CMR was 0.44. The reaction
10 was heated an additional 4 hours at 165°C. A total of
11 25 cc water was removed. This product was analyzed and
12 found to contain 0.74 %N, 17.0 TBN, 1.08 TAN, a
13 viscosity at 100°C of 427.6 cSt and a specific gravity
14 at 15°C of 0.9106. This product contained about 40%
15 active material.
16

17 Examples 6-10, 13 and 14. Preparation of Other Succinimides
18

19 A number of other succinimides were prepared from a
20 variety of PIBSA's and amines using the procedure
21 reported in Example 5. The analytical data for these
22 products are reported in Table I.
23

24 Example 11. Preparation of Ethylene Carbonate-Treated BIS
25 HPA-X PIBSA 1300 (succinic ratio = 1.1)
26

27 The product from Example 8, BIS HPA-X PIBSA 1300
28 (succinic ratio = 1.1), 146.2 Kg, was charged to a
29 reactor and the temperature was heated to 100°C. To
30 this was added 20.4 Kg of ethylene carbonate over
31 thirty minutes. The temperature was increased to 165°C
32 over 2.5 hours and then maintained at this temperature
33 for 2 hours. A total of 14 Kg of product was obtained.
34 This product was analyzed and found to contain 1.51 %N,



01 20.3 TBN, a viscosity at 100°C of 446.6 cSt, and a
02 specific gravity at 15°C of 0.9393. The analytical
03 data for this material is contained in Table I.
04

05 Examples 12, 13 and 15-19. Preparation of Other Ethylene
06 Carbonate-Treated Succinimides
07

08 A number of other post-treated succinimides were
09 prepared from a variety of succinimides prepared from a
10 variety of PIBSA's and amines using the procedures
11 reported in the previous examples. These materials are
12 reported in Table I.
13

14 Example 20. Preparation of a Bis HPA-X Succinimide from
15 PIBSA 1300 (succinic ratio = 1.9)
16

17 PIBSA 1300 prepared as in Example 4A (succinic
18 ratio = 1.9), 13051 g, was mixed with 10281 g diluent
19 oil. This was heated to 75°C and to this was added
20 with stirring 1512 g HPA-X, 5.5 mol. The amine/PIBSA
21 CMR was 0.5 and the wt. % actives were calculated to be
22 about 40%. The temperature was heated to 169°C over
23 two hours and kept there for an additional two hours.
24 Vacuum was applied to help remove the water. Upon
25 cooling, a gel formed. So the reaction was reheated to
26 165°C under full vacuum for one additional hour. The
27 product had 1.94 %N, TBN = 34.2, viscosity at 100°C of
28 1267 cSt, and specific gravity at 15°C of 0.9320. Then
29 2638 g of this product was charged to a reactor and
30 heated to 165°C. To this was added 459.6 g ethylene
31 carbonate (5.2 mol). The ethylene carbonate to basic
32 nitrogen ratio was 2.0. When about half of the
33 ethylene carbonate was added, massive amounts of a gel
34 were formed. This could not be redissolved by



01 prolonged heating or by the addition of 500 g diluent
02 oil. The reaction was stopped. This reaction
03 indicates that there is a gel problem when using PIBSA
04 1300 with a succinic ratio of 1.9.
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TABLE I - (Analytical Data For Examples 5-19)

Compound of Example No.:	DESCRIPTION	MEASURED			
		η_{sp}	TBN	VIS 100 (cSt)	SpGr (15°C)
5	bis HPA-X PIBSA 2200 (SR=1.1; A/P=0.44)	0.74	17	428	0.9106
6	bis TETA PIBSA 1300 (SR=1.1; A/P=0.5)	0.99	15	278	0.9300
7	bis HPA-X PIBSA 2200 (SR=1.5; A/P=0.5)	1.05	25	1688	0.9219
8	bis HPA-X PIBSA 1300 (SR=1.1; A/P=0.5)	1.55	36	272	0.9214
9	bis TETA PIBSA 2200 (SR=1.5; A/P=0.5)	0.64	10	1554	0.9339
10	bis TETA PIBSA 2200 (SR=1.1; A/P=0.44)	0.41	5	491	0.9093
11	EC bis HPA-X PIBSA 1300 (SR=1.1; A/P=0.5; EC/BN=2.0)	1.51	20	447	0.9393
12	EC bis TETA PIBSA 1300 (SR=1.5; A/P=0.5; EC/BN=2.0)	0.96	8	305	0.9282
13	bis TETA PIBSA 1300 (SR=1.5; A/P=0.5)	0.87	15	145	0.9120
14	bis HPA-X PIBSA 1300 (SR=1.5; A/P=0.5)	1.52	37	165	0.9142
15	EC bis TETA PIBSA 1300 (SR=1.5; A/P=0.5; EC/BN=2.0)	0.99	11	136	0.9156
16	EC bis HPA-X PIBSA 1300 (SR=1.5; A/P=0.5; EC/BN=2.0)	1.46	19	402	0.9330
17	EC bis HPA-X PIBSA 2200 (SR=1.1; A/P=0.44; EC/BN=2.0)	0.63	9	660	0.9188
18	EC bis HPA-X/DETA PIBSA 2200 (SR=1.1; A/P=0.40; EC/BN=2.4)	0.44	6	485	0.9132
19	EC bis HPA-X/DETA PIBSA 1300 (SR=1.1; A/P=0.5; EC/BN=2.0)	1.18	9.7	287	

Note: SR = succinic ratio
A/P = amine/PIBSA CMR
EC/BN = ethylene carbonate/basic
nitrogen CMR

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01 Blending of Samples on an Equal Basis

02

03 We chose to blend and test the additives in Examples 5-19 on
04 an equal wt. % actives basis. This was because we were
05 trying to compare products from four different PIBSA's with
06 different molecular weights and different succinic ratios,
07 and two different amines with and without ethylene carbonate
08 treatment. In order to do this, we calculated the %N and
09 TBN that was expected for these compounds from the molecular
10 formulas for a product that contained 40 wt. % actives.
11 These data are reported in Table II. The succinimides from
12 Examples 5-18 were then blended into the finished oil for
13 testing at a concentration of 7.5% of the 40 wt. % actives
14 material or at 3% on a dry polymer basis. The amounts of
15 succinimides were adjusted to take into account the
16 differences between the %N of the particular batch and the
17 %N expected for the example. For Example 19, a 5% blend of
18 50 wt. % actives material or 3% on a dry polymer basis was
19 made.

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TABLE II - THEORETICAL %N AND TBN

Compound of Example No.:	DESCRIPTION	% ACTIVE	%N	TBN
5	bis HPA-X PIBSA 2200	40	0.72	17
6	bis TETA PIBSA 1300	40	0.77	12
7	bis HPA-X PIBSA 2200	40	1.00	25
8	bis HPA-X PIBSA 1300	40	1.14	26
9	bis TETA PIBSA 2200	40	0.67	10
10	bis TETA PIBSA 2200	40	0.48	5
11	EC bis HPA-X PIBSA 1300	40	1.14	15
12	EC bis TETA PIBSA 1300	40	0.77	6
13	bis TETA PIBSA 1300	40	1.07	16
14	bis HPA-X PIBSA 1300	40	1.57	38
15	EC bis TETA PIBSA 1300	40	1.07	12
16	EC bis HPA-X PIBSA 1300	40	1.57	20
17	EC bis HPA-X PIBSA 2200	40	0.72	10
18	EC bis HPA-X/DETA PIBSA 2200	40	0.59	7
19	EC bis HPA-X/DETA PIBSA 1300	50	1.18	10

The additive compounds prepared in accordance with preceding Examples 5-19 were tested for fluorocarbon seal compatibility using the Volkswagen PV-3344 test procedure for seal testing of motor oils. The results are displayed in Table III. The PV-3344 test procedure is a revised version of the earlier PV-3334 test procedure. This test procedure measures the change in physical properties of elastomer seals after they have been suspended in an oil



01 solution. Tensile strength (TS) and elongation (EL) of the
02 elastomer seals are measured. In addition, the seals are
03 also visually inspected for cracks (CR) after they are
04 removed from the test oil. Details of the PV-3344 test
05 procedure are available from Volkswagon.

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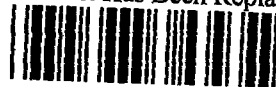


TABLE III - (PV-3344 TEST RESULTS)

Additive Compound of Example No.	Concentration of Additive (Wt. %)	TS (Pass ≥ 8.0)	EL (Pass ≥ 160)	CR (Pass = N)
5	1.6	10.0	203	N
	2.0	9.4	189	N
	2.4	8.8	196	N
	2.4	8.0	175	Y
	2.8	7.8	176	Y
	3.2	7.2	167	Y
6	1.6	10.8	218	N
	2.4	9.6	197	N
7	1.6	10.9	220	N
8	1.6	6.5	155	Y
	2.4	6.0	146	Y
9	1.6	11.7	232	N
10	1.6	12.5	244	N
	3.2	11.7	240	N
11	1.6	6.0	139	Y
	2.8	5.8	141	Y
12	1.6	10.9	216	N
13	1.6	11.2	224	N
	2.4	9.4	196	N
14	1.6	6.9	160	Y
	2.4	5.6	137	Y
15	1.6	11.7	233	N
	2.4	10.7	207	N
16	1.6	6.8	153	Y
	2.4	6.4	148	Y
17	1.6	9.0	188	N
	2.0	8.8	180	N
	2.4	8.8	196	N
	2.8	7.5	172	Y
	3.2	7.9	169	Y
18	1.6	12.1	238	N
	2.0	11.6	233	N
	2.4	11.1	220	N
	2.8	10.7	220	N
	3.2	10.0	206	N
19	1.6	10.1	186	N
	2.8	8.3	150	Y

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01 The detergency properties of the additive compounds were
02 then tested using the Sequence VE engine test procedure, as
03 defined in ASTM Proposed Method:212. This test measures,
04 among other things, average engine sludge (AES) and average
05 engine varnish (AEV). The AES and AEV results for the
06 compounds of Examples 5-19 are shown in Table IV. A dosage
07 or treat rate level of 3.0% (on a dry polymer basis) was
08 chosen as an appropriate concentration level for the Seq. VE
09 test since treat rate levels exceeding 3% are generally too
10 high for the resulting additive package to be priced
11 competitively in the marketplace. Examples 17 and 18 were
12 each run at concentration levels of 2.0 and 1.5% (on a dry
13 polymer basis).

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TABLE IV - (SEQ. VE TEST RESULTS)

Compound of Example No.	Dose (Wt. %)	AES (Pass $\geq$ 9.0)	AEV (Pass $\geq$ 5.0)
5	3.0	9.4	5.6
6	3.0	8.0	3.4
7	3.0	9.5	6.0
8	3.0	7.7	4.6
9	3.0	9.3	5.6
10	3.0	8.9	4.0
11	3.0	9.1	5.9
12	3.0	8.7	4.1
13	3.0	9.1	5.1
14	3.0	9.3	5.4
15	3.0	9.4	5.3
16	3.0	9.4	6.4
17	2.0	9.4	5.9
	1.5	9.2	5.3
18	2.0	9.3	5.1
	1.5	8.7	4.4
19	3.0	8.9	4.7

Tables V-VII examine the effect of three structural parameters on PV-3344 and Seq. VE test performance. TS data (@ a concentration level of 1.6 wt. %) is used as an indication of PV-3344 test performance. AES and AEV data are used as an indication of Seq. VE test performance. Table V shows the effect of the polybutene substituent's molecular weight on the additive's performance in both tests; Table VI shows the effect of the number of amine nitrogen atoms per mole on the additive's performance in both tests; and Table VII shows the effect of post-treatment

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01 with ethylene carbonate on the additive's performance in
02 both tests.

03

04 In Tables V-VII, the compounds are listed in pairs. For
05 each pair, the compounds differ only by the feature examined
06 in the respective table. For instance, the first pair of
07 compounds listed in Table V (effect of polybutene Mn)
08 compares Examples 6 and 10. Example 6 has a succinic ratio
09 of 1.1, is made from a TETA polyamine, is not post-treated
10 with ethylene carbonate, and contains a 1300 Mn polybutene
11 substituent. Example 10 likewise has a succinic ratio of
12 1.1, is made from a TETA polyamine, and is not post-treated
13 with ethylene carbonate. However, Example 10 contains a
14 2200 Mn polyisobutene substituent.

15

16 TABLE V - (EFFECT OF POLYBUTENE Mn)

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Compound of Example No.:	Succinic Ratio	Amine Type	Ethylene Carbonate Post- Treatment	Polybutene Mn	PV-3344 TS	Seq. VE AES	Seq. VE AEV
6	1.1	TETA	No	1300	10.8	8.0	3.4
10	1.1	TETA	No	2200	12.5	8.9	4.0
8	1.1	HPA-X	No	1300	6.5	7.7	4.6
5	1.1	HPA-X	No	2200	10.0	9.4	5.6
11	1.1	HPA-X	Yes	1300	6.0	9.1	5.9
17	1.1	HPA-X	Yes	2200	9.0	9.4	5.9
14	1.5	HPA-X	No	1300	6.9	9.3	5.4
7	1.5	HPA-X	No	2200	10.9	9.5	6.0
13	1.5	TETA	No	1300	11.2	9.1	5.1
9	1.5	TETA	No	2200	11.7	9.3	5.6
Average	-	-	-	1300	8.3	8.6	4.9
Average	-	-	-	2200	10.8	9.3	5.4

Table V demonstrates that a polyisobutene Mn of 2200 gives better PV-3344 and better Seq. VE results than a polyisobutene Mn of 1300.



TABLE VI - (EFFECT OF AMINE TYPE)

Compound of Example No.:	Polybutene Mn	Succinic Ratio	Ethylene Carbonate Post- Treatment	Amine Type	PV-3344 TS	Seq. VE AES	Seq. VE AEV
6	1300	1.1	No	TETA	10.8	8.0	3.4
8	1300	1.1	No	HPA-X	6.5	7.7	4.6
10	2200	1.1	No	TETA	12.5	8.9	4.0
5	2200	1.1	No	HPA-X	10.0	9.4	5.6
9	2200	1.5	No	TETA	11.7	9.3	5.6
7	2200	1.5	No	HPA-X	10.9	9.5	6.0
12	1300	1.1	Yes	TETA	10.9	8.7	4.1
11	1300	1.1	Yes	HPA-X	6.0	9.1	5.9
13	1300	1.5	No	TETA	11.2	9.1	5.1
14	1300	1.5	No	HPA-X	6.9	9.3	5.4
15	1300	1.5	Yes	TETA	11.7	9.4	5.3
16	1300	1.5	Yes	HPA-X	6.8	9.4	6.4
Average	-	-	-	TETA	11.5	8.9	4.6
Average	-	-	-	HPA-X	7.9	9.1	5.6

17	2200	1.1	Yes	HPA-X	9.0	9.4	5.9
18	2200	1.1	Yes	DETA/HPA-X	12.1	9.3	5.1
11	1300	1.1	Yes	HPA-X	6.0	9.1	5.9
19	1300	1.1	Yes	DETA/HPA-X	10.1	8.9	4.7
Average	-	-	-	HPA-X	7.5	9.25	5.9
Average	-	-	-	DETA/HPA-X	11.1	9.1	4.9

When comparing TETA (4 N atoms per mole) and HPA-X (avg. of 6.5 N atoms per mole) polyamines, Table VI shows better PV-3344 performance for TETA. The Seq. VE (AES) results for HPA-X were slightly better than for TETA. Also, Seq. VE (AEV) results were significantly better for the HPA-X polyamine than for TETA. While TETA appears to be the best amine type for PV-3344 performance, it is unacceptable for Seq. VE performance. The concentration levels of additives containing a TETA amine necessary to achieve suitable Seq. VE performance (AEV in particular) are generally



unacceptable because they are too high to allow for a competitive treat rate.

The comparison of HPA-X and an admixture of DETA/HPA-X in Table VI shows that the DETA/HPA-X polyamine gave significantly better PV-3344 results. This comparison also shows that HPA-X was slightly better than the DETA/HPA-X admixture for Seq. VE (AES) results. Also, the Seq. VE (AEV) results were better for HPA-X than for the DETA/HPA-X admixture.

TABLE VII - (EFFECT OF POST-TREATMENT WITH ETHYLENE CARBONATE)

Compound of Example No.:	Poly-butene Mn	Succinic Ratio	Amine Type	Ethylene Carbonate Post-Treatment	PV-3344 TS	Seq. VE AES	Seq. VE AEV
5	2200	1.1	HPA-X	No	10.0	9.4	5.6
17	2200	1.1	HPA-X	Yes	9.0	9.4	5.9
6	1300	1.1	TETA	No	10.8	8.0	3.4
12	1300	1.1	TETA	Yes	10.9	8.7	4.1
8	1300	1.1	HPA-X	No	6.5	7.7	4.6
11	1300	1.1	HPA-X	Yes	6.0	9.1	5.9
13	1300	1.5	TETA	No	11.2	9.1	5.1
15	1300	1.5	TETA	Yes	11.7	9.4	5.3
14	1300	1.5	HPA-X	No	6.9	9.3	5.4
16	1300	1.5	HPA-X	Yes	6.8	9.4	6.4
Average	-	-	-	No	9.1	8.7	4.8
Average	-	-	-	Yes	8.9	9.2	5.5

Table VII shows that post-treatment with ethylene carbonate gives slightly poorer PV-3344 performance than without post-treatment. However, those succinimides which were modified by post-treatment with ethylene carbonate performed significantly better in the Seq. VE test (both AES and AEV).



The conclusions that can be drawn from the above Tables are summarized in Table VIII.

TABLE VIII (CONCLUSIONS)

	Better PV-3344 Performance	Better Seq. VE (AES) Performance	Better Seq. VE (AEV) Performance
A. Polyisobutene Mn (1300 or (2200)	2200	2200	2200
B. Post-Treatment (Yes or No) with ethylene carbonate	No (slightly)	Yes	Yes
C. Amine type 1. TETA or HPA-X	TETA	HPA-X (slightly)	HPA-X
2. HPA or DETA/HPA-X	DETA/HPA-X	HPA-X (slightly)	HPA-X

Table VIII shows that the most desirable additives contain a 2200 Mn substituent, are derived from a polyamine having greater than 4 nitrogen atoms per mole, and are post-treated with ethylene carbonate.

While TETA appears to be the best amine type for PV-3344 performance, the concentration levels required for this amine type to achieve suitable Seq. VE performance (AEV results in particular) are unacceptable because they are too high to allow for a competitive treat rate. Accordingly, the amine should have greater than 4 nitrogen atoms per mole.

For multi-grade oil applications, the succinimide additive may be derived from a succinic anhydride having a succinic ratio of approximately 1.5. However, the viscosity index improvement which accompanies succinimides having succinic ratios of about 1.3 or greater is not always desirable. Instead, for some applications, such as single-grade oil



01 formulation, a succinic ratio less than about 1.3,
02 preferably closer to 1, is more desirable. Furthermore,
03 Example 20 (made from the PIBSA of Example 4A) shows that
04 succinic ratios of about 1.9 are unacceptable because gels
05 are formed. Accordingly, succinic ratios greater than 1 but
06 less than about 2 are acceptable, with succinic ratios less
07 than about 1.7 preferred.

08

09 Succinimide additives having a 2200 Mn alkenyl or alkyl
10 group which are derived from an amine having greater than 4
11 nitrogen atoms per mole, and which are post-treated with
12 ethylene carbonate, are compatible with fluorocarbon seals
13 at concentration levels for which they are excellent
14 detergent additives. Such additive compounds (Examples 17
15 and 18) pass the Seq. VE test at low concentration levels
16 and are desirable because less of the additive is needed in
17 additive packages, thereby resulting in lower-cost oil
18 formulations.

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01 WHAT IS CLAIMED IS:

02

03 1. A modified polyamino alkenyl or alkyl succinimide
04 comprising the succinimide reaction product of:

05

06 (i) an alkenyl- or alkyl-substituted succinic
07 anhydride derived from a polyolefin having a Mn
08 of about 2000 to about 2700 and a Mw/Mn ratio of
09 about 1 to about 5; and

10

11 (ii) a polyalkylene polyamine having greater than
12 4 nitrogen atoms per mole;

13

14 wherein the succinimide reaction product is
15 post-treated with a cyclic carbonate.

16

17 2. A modified polyamino alkenyl or alkyl succinimide
18 according to Claim 1 wherein the charge mole ratio of
19 (ii) to (i) is from about 0.35:1 to about 0.6:1; and
20 the charge mole ratio of cyclic carbonate to basic
21 amine nitrogen in the succinimide reaction product is
22 from about 1.5:1 to about 4:1.

23

24 3. A modified polyamino alkenyl or alkyl succinimide
25 according to Claim 1 wherein the polyolefin has a Mn
26 value of about 2100 to about 2400.

27

28 4. A modified polyamino alkenyl or alkyl succinimide
29 according to Claim 3 wherein the polyolefin has a Mn
30 value of about 2200.

31

32 5. A modified polyamino alkenyl or alkyl succinimide
33 according to Claim 1 wherein the polyolefin is
34 polybutene.





- 01 6. A modified polyamino alkenyl or alkyl succinimide
02 according to Claim 5 wherein the polybutene is
03 polyisobutene.
04
- 05 7. A modified polyamino alkenyl or alkyl succinimide
06 according to Claim 1 wherein the polyalkylene polyamine
07 has greater than 4 to about 12 nitrogen atoms per mole.
08
- 09 8. A modified polyamino alkenyl or alkyl succinimide
10 according to Claim 7 wherein the polyalkylene polyamine
11 has from about 5 to about 7 nitrogen atoms per mole.
12
- 13 9. A modified polyamino alkenyl or alkyl succinimide
14 according to Claim 8 wherein the polyalkylene polyamine
15 is Union Carbide HPA-X heavy polyamine.
16
- 17 10. A modified polyamino alkenyl or alkyl succinimide
18 according to Claim 8 wherein the polyalkylene polyamine
19 comprises 20% by weight diethylene triamine and 80% by
20 weight heavy polyamine.
21
- 22 11. A modified polyamino alkenyl or alkyl succinimide
23 according to Claim 1 wherein the succinic anhydride has
24 a succinic ratio from about 1 to less than about 2.
25
- 26 12. A modified polyamino alkenyl or alkyl succinimide
27 according to Claim 11 wherein the succinic anhydride
28 has a succinic ratio from about 1 to less than about
29 1.3.
30
- 31 13. A modified polyamino alkenyl or alkyl succinimide
32 according to Claim 11 wherein the succinic anhydride
33 has a succinic ratio from about 1.3 to about 1.7.
34





- 01 14. A modified polyamino alkenyl succinimide according to
02 Claim 1 wherein the cyclic carbonate is ethylene
03 carbonate.
04
- 05 15. A modified polyamino alkenyl or alkyl succinimide
06 according to Claim 1 wherein the polyolefin is
07 polyisobutene having a Mn of about 2200, the succinic
08 anhydride has a succinic ratio from about 1 to about
09 1.7, the polyalkylene polyamine comprises Union Carbide
10 HPA-X heavy polyamine, the charge mole ratio of (ii) to
11 (i) is from about 0.4:1 to about 0.5:1, the cyclic
12 carbonate is ethylene carbonate, and the charge mole
13 ratio of cyclic carbonate to basic amine nitrogen in
14 the succinimide reaction product is from about 2:1 to
15 about 3:1.
16
- 17 16. A modified polyamino alkenyl or alkyl succinimide
18 according to Claim 1 wherein the polyolefin is
19 polyisobutene having a Mn of about 2200, the succinic
20 anhydride has a succinic ratio from about 1 to about
21 1.7, the polyalkylene polyamine comprises 20% by weight
22 diethylene triamine and 80% by weight Union Carbide
23 HPA-X heavy polyamine, the charge mole ratio of (ii) to
24 (i) is from about 0.4:1 to about 0.5:1, the cyclic
25 carbonate is ethylene carbonate, and the charge mole
26 ratio of cyclic carbonate to basic amine nitrogen in
27 the succinimide reaction product is from about 2:1 to
28 about 3:1.
29
- 30 17. A lubricating oil composition comprising a major amount
31 of an oil of lubricating viscosity and an effective
32 amount of a modified polyamino alkenyl or alkyl
33 succinimide sufficient to be compatible with
34 fluorocarbon seals and simultaneously control engine





- 01 sludge and varnish, wherein the modified succinimide
02 comprises the succinimide reaction product of:
03
04 (i) an alkenyl- or alkyl-substituted succinic
05 anhydride derived from a polyolefin having a Mn
06 of about 2000 to about 2700 and a Mw/Mn ratio of
07 about 1 to about 5; and
08
09 (ii) a polyalkylene polyamine having greater than
10 4 nitrogen atoms per mole;
11
12 wherein the succinimide reaction product is
13 post-treated with a cyclic carbonate.
14
- 15 18. A lubricating oil composition according to Claim 17
16 wherein the charge mole ratio of (ii) to (i) is from
17 about 0.35:1 to about 0.6:1; and the charge mole ratio
18 of cyclic carbonate to basic amine nitrogen in the
19 succinimide reaction product is from about 1.5:1 to
20 about 4:1.
21
- 22 19. A lubricating oil composition according to Claim 17
23 wherein the polyolefin has a Mn of about 2100 to about
24 2400.
25
- 26 20. A lubricating oil composition according to Claim 19
27 wherein the polyolefin has a Mn of about 2200.
28
- 29 21. A lubricating oil composition according to Claim 17
30 wherein the polyolefin is polybutene.
31
- 32 22. A lubricating oil composition according to Claim 21
33 wherein the polybutene is polyisobutene.
34





- 01 23. A lubricating oil composition according to Claim 17
02 wherein the polyalkylene polyamine has greater than 4
03 to about 12 nitrogen atoms per mole.
04
- 05 24. A lubricating oil composition according to Claim 23
06 wherein the polyalkylene polyamine has from about 5 to
07 about 7 nitrogen atoms per mole.
08
- 09 25. A lubricating oil composition according to Claim 24
10 wherein the heavy polyamine is Union Carbide HPA-X
11 heavy polyamine.
12
- 13 26. A lubricating oil composition according to Claim 24
14 wherein the polyalkylene polyamine comprises 20% by
15 weight diethylene triamine and 80% by weight heavy
16 polyamine.
17
- 18 27. A lubricating oil composition according to Claim 17
19 wherein the succinic anhydride has a succinic ratio
20 from about 1 to less than about 2.
21
- 22 28. A lubricating oil composition according to Claim 27
23 wherein the succinic anhydride has a succinic ratio
24 from about 1 to less than about 1.3.
25
- 26 29. A lubricating oil composition according to Claim 27
27 wherein the succinic anhydride has a succinic ratio
28 from about 1.3 to about 1.7.
29
- 30 30. A lubricating oil composition according to Claim 17
31 wherein the cyclic carbonate is ethylene carbonate.
32
- 33 31. A lubricating oil composition according to Claim 17
34 wherein the amount of the modified polyamino alkenyl or





01 alkyl succinimide is from about 1 to about 5 weight
02 percent on a dry polymer basis.

03

04 32. A lubricating oil composition according to Claim 31
05 wherein the amount of the modified polyamino alkenyl or
06 alkyl succinimide is less than about 3 weight percent
07 on a dry polymer basis.

08

09 33. A lubricating oil composition according to Claim 17
10 wherein the amount of the modified polyamino alkenyl or
11 alkyl succinimide is less than about 3 weight percent
12 on a dry polymer basis and wherein the polyolefin is
13 polyisobutene having a Mn of about 2200, the succinic
14 anhydride has a succinic ratio from about 1 to about
15 1.7, the polyalkylene polyamine comprises Union Carbide
16 HPA-X heavy polyamine, the charge mole ratio of (ii) to
17 (i) is from about 0.4:1 to about 0.5:1, the cyclic
18 carbonate is ethylene carbonate, and the charge mole
19 ratio of cyclic carbonate to basic amine nitrogen in
20 the succinimide reaction product is from about 2:1 to
21 about 3:1.

22

23 34. A lubricating oil composition according to Claim 17
24 wherein the amount of the modified polyamino alkenyl or
25 alkyl succinimide is less than about 3 weight percent
26 on a dry polymer basis and wherein the polyolefin is
27 polyisobutene having a Mn of about 2200, the succinic
28 anhydride has a succinic ratio from about 1 to about
29 1.7, the polyalkylene polyamine comprises 20% by weight
30 diethylene triamine and 80% by weight Union Carbide
31 HPA-X heavy polyamine, the charge mole ratio of (ii) to
32 (i) is from about 0.4:1 to about 0.5:1, the cyclic
33 carbonate is ethylene carbonate, and the charge mole
34 ratio of cyclic carbonate to basic amine nitrogen in





01 the succinimide reaction product is from about 2:1 to
02 about 3:1.

03

04 35. A lubricating oil concentrate comprising from about 90
05 to about 10 weight percent of an oil of lubricating
06 viscosity and from about 10 to about 90 weight percent
07 on a dry polymer basis of a modified polyamino alkenyl
08 or alkyl succinimide comprising the succinimide
09 reaction product of:

10

11 (i) an alkenyl- or alkyl-substituted succinic
12 anhydride derived from a polyolefin having a Mn
13 of about 2000 to about 2700 and a Mw/Mn ratio of
14 about 1 to about 5; and

15

16 (ii) a polyalkylene polyamine having greater than 4
17 nitrogen atoms per mole;

18

19 wherein the succinimide reaction product is
20 post-treated with a cyclic carbonate.

21

22 36. A lubricating oil concentrate according to Claim 35
23 wherein the polyolefin is polyisobutene having a Mn of
24 about 2200, the succinic anhydride has a succinic ratio
25 from about 1 to about 1.7, the polyalkylene polyamine
26 comprises Union Carbide HPA-X heavy polyamine, the
27 charge mole ratio of (ii) to (i) is from about 0.4:1 to
28 about 0.5:1, the cyclic carbonate is ethylene
29 carbonate, and the charge mole ratio of cyclic
30 carbonate to basic amine nitrogen in the succinimide
31 reaction product is from about 2:1 to about 3:1.

32

33 37. A lubricating oil concentrate according to Claim 35
34 wherein the polyolefin is polyisobutene having a Mn of





01 about 2200, the succinic anhydride has a succinic ratio
02 from about 1 to about 1.7, the polyalkylene polyamine
03 comprises 20% by weight diethylene triamine and 80% by
04 weight Union Carbide HPA-X heavy polyamine, the charge
05 mole ratio of (ii) to (i) is from about 0.4:1 to about
06 0.5:1, the cyclic carbonate is ethylene carbonate, and
07 the charge mole ratio of cyclic carbonate to basic
08 amine nitrogen in the succinimide reaction product is
09 from about 2:1 to about 3:1.
10

11 38. A fuel composition comprising a hydrocarbon boiling in
12 the gasoline or diesel range and from about 10 to about
13 10,000 weight parts per million on a dry polymer basis
14 of a modified polyamino alkenyl or alkyl succinimide
15 comprising the succinimide reaction product of:
16

17 (i) an alkenyl- or alkyl-substituted succinic
18 anhydride derived from a polyolefin having a Mn
19 of about 2000 to about 2700 and a Mw/Mn ratio of
20 about 1 to about 5; and
21

22 (ii) a polyalkylene polyamine having greater than
23 4 nitrogen atoms per mole;
24

25 wherein the succinimide reaction product is
26 post-treated with a cyclic carbonate.
27

28 39. A fuel concentrate comprising an inert stable
29 oleophilic organic solvent boiling in the range of
30 150°F to 400°F and from about 10 to about 70 weight
31 percent on a dry polymer basis of a modified polyamino
32 alkenyl or alkyl succinimide comprising the succinimide
33 reaction product of:
34





(i) an alkenyl- or alkyl-substituted succinic anhydride derived from a polyolefin having a M_n of about 2000 to about 2700 and a M_w/M_n ratio of about 1 to about 5; and

(ii) a polyalkylene polyamine having greater than 4 nitrogen atoms per mole;

wherein the succinimide reaction product is post-treated with a cyclic carbonate.

