

Etheramines based on alkoxylated glycerine or trimethylolpropane.

5 This invention relates to etheramines based on glycerine or trimethylolpropane, wherein the etheramines contain at least one linear or branched C₄-alkylene group.

10 Due to the increasing popularity of easy-care fabrics made of synthetic fibers as well as the ever increasing energy costs and growing ecological concerns of detergent users, the once popular hot water wash has now taken a back seat to washing fabrics in cold water. Many commercially available laundry detergents are even advertised as being suitable for washing fabrics at 40°C or 30°C or even at room temperature. To achieve satisfactory washing result at such low temperatures, results comparable to those obtained with hot water washes, the demands on low-temperature detergents are especially high.

15 It is known to include certain additives in detergent compositions to enhance the detergent power of conventional surfactants so as to improve the removal of grease stains at temperatures of 60°C and below.

20 There is also a continuous need for cleaning compositions that remove grease stains from fabrics and other soiled materials, as grease stains are challenging stains to remove. Conventional cleaning compositions directed to grease removal frequently utilize various amine compounds which tend to show strong negative impacts on whiteness. As a consequence there is still a continual need for improved amine compositions which provide improved grease removal from fabrics and other soiled materials and at the same time do not negatively impact the clay cleaning. These amine compositions should also have a suitable toxicological profile so that they can be used in household applications.

25 DE 1 643 426 A1 reads on a process for the manufacture of a polyoxyalkylene polyamine wherein a polyalcohol with 3 to 8 hydroxyl groups is reacted with C₁-C₁₈ alkyleneoxide and afterwards aminated in the presence of a catalyst.

30 EP 1 502 913 A1 describes a process for producing polyoxyalkylene triamine by bringing a polyoxyalkylene triol into contact with ammonia and hydrogen in the presence of a catalyst. The polyoxyalkylene triol contains alkylene groups having 2 to 6 carbon atoms.

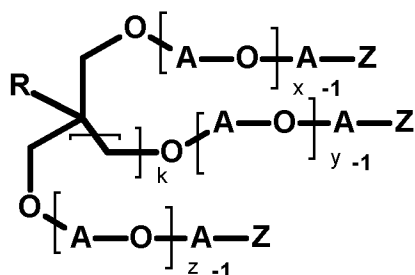
35 WO 01/76729 A2 relates to a composition comprising a multifunctional polyetheramine with at least two amine groups per molecule, wherein the polyetheramine contains alkylene groups having 2 and 3 carbon atoms.

US 4,609,683 describes a quasi-propolymer prepared by the reaction of aromatic isocyanates with polyoxyalkylene triamines and an isatoic anhydride.

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It was an object of the present invention to provide compounds which would improve the washing performance of detergents at low temperatures, i.e. at temperatures as low as 30°C or even lower.

10 This goal was achieved with an etheramine of formula (I),



Formula (I)

wherein

R = H or ethyl, k = 0 or 1

15 A represents a linear or branched alkylene group having C₂-C₁₈ carbon atoms,

A may be the same as or different from one another,

at least one A represents a linear or branched C₄-alkylene group,

the sum of x, y and z lies in the range of 3 to 100,

x ≥ 1, y ≥ 1 and z ≥ 1, Z = NH₂ or OH but at least two Z per molecule are NH₂, preferably Z is

20 NH₂

In a preferred embodiment at least three A represent a linear or branched C₄-alkylene group, in another preferred embodiment all A groups represent a linear or branched C₄-alkylene group.

Preferably the sum of x, y and z lies in the range of 3 to 30, even more preferably in the range

25 of 3 to 10 and even more preferably in the range of 5 to 10.

The etheramine of formula (I) is obtained by a process comprising the following steps:

a) reacting glycerine or 1,1,1-trimethylolpropane with C₄-alkylene oxide and optionally with C₂-C₁₈ alkylene oxide, wherein the molar ratio of glycerine to C₄ alkylene oxide is in the range of

30 1: 3 to 1: 10,

b) aminating the alkoxyated glycerine with ammonia.

Alkoxylation

In a preferred embodiment the molar ratio of glycerine or 1,1,1-trimethylolpropane to C₂-C₁₈ alkylene oxide and in particular of butylene oxide is in the range of 1:3 to 1:6.

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Alkoxylated triols are obtained by reaction of glycerine or 1,1,1-trimethylolpropane with alkylene oxides and can be affected according to general alkoxylation procedures known in the art.

The alkoxylated glycerine or 1,1,1-trimethylolpropane may be prepared in a known manner by reaction of glycerine or 1,1,1-trimethylolpropane with alkylene oxides. Suitable alkylene oxides are C₂-C₁₈ alkylene oxides like ethylene oxide, propylene oxide, butylene oxide, pentene oxide, hexene oxide, decene oxide, dodecene oxide etc.

Preferably the C₂-C₁₈ alkylene oxide is ethylene oxide, propylene oxide or a mixture thereof.

15 The glycerine or 1,1,1-trimethylolpropane are reacted with one single alkylene oxide or combinations of two or more different alkylene oxides. Using two or more different alkylene oxides, the resulting alkoxylate can be obtained as a block-wise structure or a random structure.

The molar ratio of glycerine or 1,1,1-trimethylolpropane to C₄-alkylene oxide and optionally C₂-C₁₈ alkylene oxides at which the alkoxylation reaction is carried out lies in the range of 1:3 to 1:10, preferably in the range of 1:3 to 1:6. In another embodiment, the molar ratio of glycerine or 1,1,1-trimethylolpropane to C₄-alkylene oxide and optionally C₂-C₁₈ alkylene oxides at which the alkoxylation reaction is carried out lies in the range of 1:5 to 1:10.

This reaction is undertaken generally in the presence of a catalyst in an aqueous solution at a reaction temperature from about 70 to about 200°C and preferably from about 80 to about 160°C. This reaction may be affected at a pressure of up to about 10 bar, and in particular up to about 8 bar.

Examples of suitable catalysts are basic catalysts such as alkali metal and alkaline earth metal hydroxides such as sodium hydroxide, potassium hydroxide and calcium hydroxide, alkali metal alkoxides, in particular sodium and potassium C₁-C₄-alkoxides, such as sodium methoxide, sodium ethoxide and potassium tert-butoxide, alkali metal and alkaline earth metal hydrides such as sodium hydride and calcium hydride, and alkali metal carbonates such as sodium carbonate and potassium carbonate. Preference is given to alkali metal hydroxides, particular preference being given to potassium hydroxide and sodium hydroxide. Typical use amounts for the base are from 0.05 to 10% by weight, in particular from 0.1 to 2% by weight, based on the total amount of polyalkyleneimine and alkylene oxide.

Amination

The amination is carried out in the presence of copper-, nickel- or cobalt-containing catalyst.

- 5 The catalytically active material of the catalysts, before the reduction thereof with hydrogen, comprises oxygen compounds of aluminum, of copper, of nickel and of cobalt, and is in the range from 0.2 to 5.0% by weight of oxygen compounds of tin, calculated as SnO.

10 Etheramines according to Formula (I) are obtained by reductive amination of the alkoxyated glycerine or 1,1,1-trimethylolpropane with ammonia in presence of hydrogen and a catalyst containing nickel. Suitable catalysts are described in WO 2011/067199 A1 and in WO2011/067200 A1, and in EP0696572 B1. Preferred catalysts are supported copper-, nickel- and cobalt-containing catalysts, wherein the catalytically active material of the catalysts, before the reduction thereof with hydrogen, comprises oxygen compounds of aluminium, of copper, of nickel and
15 of cobalt, and in the range from 0.2 to 5.0% by weight of oxygen compounds of tin, calculated as SnO. Other preferred catalysts are supported copper-, nickel- and cobalt-containing catalysts, wherein the catalytically active material of the catalysts, before the reduction thereof with hydrogen, comprises oxygen compounds of aluminium, of copper, of nickel, of cobalt and of tin, and in the range from 0.2 to 5.0% by weight of oxygen compounds of yttrium, of lanthanum, of
20 cerium and/or of hafnium, each calculated as Y_2O_3 , La_2O_3 , Ce_2O_3 and Hf_2O_3 respectively. Another preferred catalyst is a zirconium, copper, nickel catalyst, wherein the catalytically active composition comprises from 20 to 85 % by weight of oxygen-containing zirconium compounds, calculated as ZrO_2 , from 1 to 30% by weight of oxygen-containing compounds of copper, calculated as CuO, from 30 to 70 % by weight of oxygen-containing compounds of nickel, calculated
25 as NiO, from 0.1 to 5 % by weight of oxygen-containing compounds of aluminium and/ or manganese, calculated as Al_2O_3 and MnO_2 respectively.

For the reductive amination step as well supported as non-supported catalyst can be used. The supported catalyst e.g. is obtained by deposition of the metallic components of the catalyst compositions onto support materials known to those skilled in the art, using techniques that are
30 well-known in the art including without limitation, known forms of alumina, silica, charcoal, carbon, graphite, clays, mordenites; and molecular sieves, to provide supported catalysts as well. When the catalyst is supported, the support particles of the catalyst may have any geometric shape, for example the shape of spheres, tablets or cylinders in a regular or irregular version. The process can be carried out in a continuous or discontinuous mode, e.g. in an autoclave,
35 tube reactor or fixed-bed reactor. The reactor design is also not narrowly critical. The feed

thereto may be upflowing or downflowing, and design features in the reactor which optimize plug flow in the reactor may be employed.

By-products which contain secondary or tertiary amino functions may be formed under amination reaction conditions. Secondary amines are e.g. obtained from a reaction of a fully or partially aminated diol with another fully and/or partially aminated diol. Tertiary amines are formed e.g. via a reaction of a secondary amine with another fully or partially aminated diol.

The degree of amination is between 67 to 100% and most preferably from 85 to 100%.

10 The degree of amination is calculated from the total amine value (AZ) divided by sum of the total acetylables value (AC) and tertiary amine value (tert. AZ) and multiplied by 100 ($\text{Total AZ} \times 100 / (\text{AC} + \text{tert. AZ})$).

The total amine value (AZ) is determined according to DIN 16945.

The total acetylables value (AC) is determined according to DIN 53240.

15 The secondary and tertiary amine are determined according to ASTM D2074-07.

The hydroxyl value is calculated from (total acetylables value + tertiary amine value) - total amine value.

20 In another preferred embodiment, the etheramines of the invention can also be further reacted with an acid. The acid may be selected from the group consisting of citric acid, lactic acid, sulfuric acid, methanesulfonic acid, hydrogen chloride, phosphoric acid, formic acid, acetic acid, propionic acid, valeric acid, oxalic acid, succinic acid, adipic acid, sebacic acid, glutaric acid, glucaric acid, tartaric acid, malic acid, benzoic acid, salicylic acid, phthalic acid, oleic acid, stearic acid and mixtures thereof. In an alternative embodiment, the etheramines of the invention may, 25 in protonated form, have a surfactant as a counter ion, as obtained from e.g. linear alkyl benzene sulphonic acid.

Applications:

30 The inventive etheramine mixtures may be used in personal care, especially in shampoo and body wash formulations as well as in cleaning compositions.

They may also be used as curing agent for epoxy resins or as a reactant in the production of polymers but also in polyurethanes, polyureas, epoxy resins, polyamides.

35 The inventive etheramines have proved to be effective for removal of stains, particularly grease, from soiled material. Cleaning compositions with inventive etheramines also do not have the cleaning negatives seen with conventional, amine cleaning compositions for hydrophilic bleachable stains, such as coffee, tea, wine, or particulates. Additionally, for stain removal from white

fabric, cleaning compositions with inventive etheramines do not cause the whiteness negatives that commercially available, amine cleaning compositions cause.

A further advantage of cleaning compositions comprising the inventive etheramines is their ability to remove grease stains in cold water cleaning solutions followed by cold water washing.

5 Without being limited by theory, cold water solutions have the effect of causing greases to harden or solidify, making greases more resistant to removal, especially from fabric. Cleaning compositions with etheramine mixtures according to Formula (I), however, are surprisingly effective when used in cold water cleaning.

10 As used herein the phrase "cleaning composition" includes compositions and formulations designed for cleaning soiled material. Such compositions include but are not limited to, laundry cleaning compositions and detergents, fabric softening compositions, fabric enhancing compositions, fabric freshening compositions, laundry prewash, laundry pretreat, laundry additives, spray products, dry cleaning agent or composition, laundry rinse additive, wash additive, post-
15 rinse fabric treatment, ironing aid, unit dose formulation, delayed delivery formulation, liquid hand dishwashing composition, detergent contained on or in a porous substrate or nonwoven sheet, automatic dish-washing agent, hard surface cleaner, and other suitable forms that may be apparent to one skilled in the art in view of the teachings herein.. Such compositions may be used as a pre-laundering treatment, a post-laundering treatment, may be added during the rinse
20 or wash cycle of the laundering operation, or used in homecare cleaning applications. The cleaning compositions may have a form selected from liquid, powder, single-phase or multi-phase unit dose, pouch, tablet, gel, paste, bar, or flake.

The cleaning compositions described herein may include from about 0.1% to about 10%, in
25 some examples, from about 0.2% to about 5%, and in other examples, from about 0.5% to about 3%, by weight the composition, of an etheramine of Formula I.

Surfactant System

The cleaning compositions comprise a surfactant system in an amount sufficient to provide de-
30 sired cleaning properties. In some embodiments, the cleaning composition comprises, by weight of the composition, from about 1% to about 70% of a surfactant system. In other embodiments, the liquid cleaning composition comprises, by weight of the composition, from about 2% to about 60% of the surfactant system. In further embodiments, the cleaning composition comprises, by weight of the composition, from about 5% to about 30% of the surfactant system.

The surfactant system may comprise a deterative surfactant selected from anionic surfactants, nonionic surfactants, cationic surfactants, zwitterionic surfactants, amphoteric surfactants, ampholytic surfactants, and mixtures thereof. Those of ordinary skill in the art will understand that a deterative surfactant encompasses any surfactant or mixture of surfactants that provide cleaning, stain removing, or laundering benefit to soiled material.

Adjunct Cleaning Additives

The cleaning compositions of the invention may also contain adjunct cleaning additives. Suitable adjunct cleaning additives include builders, structurants or thickeners, clay soil removal/anti-redeposition agents, polymeric soil release agents, polymeric dispersing agents, polymeric grease cleaning agents, enzymes, enzyme stabilizing systems, bleaching compounds, bleaching agents, bleach activators, bleach catalysts, brighteners, dyes, hueing agents, dye transfer inhibiting agents, chelating agents, suds suppressors, softeners, and perfumes.

Methods of Use

The present invention includes methods for cleaning soiled material. As will be appreciated by one skilled in the art, the cleaning compositions of the present invention are suited for use in laundry pretreatment applications, laundry cleaning applications, and home care applications. Such methods include, but are not limited to, the steps of contacting cleaning compositions in neat form or diluted in wash liquor, with at least a portion of a soiled material and then optionally rinsing the soiled material. The soiled material may be subjected to a washing step prior to the optional rinsing step.

For use in laundry pretreatment applications, the method may include contacting the cleaning compositions described herein with soiled fabric. Following pretreatment, the soiled fabric may be laundered in a washing machine or otherwise rinsed.

Machine laundry methods may comprise treating soiled laundry with an aqueous wash solution in a washing machine having dissolved or dispensed therein an effective amount of a machine laundry cleaning composition in accord with the invention. An "effective amount" of the cleaning composition means from about 20g to about 300g of product dissolved or dispersed in a wash solution of volume from about 5L to about 65L. The water temperatures may range from about 5°C to about 100°C. The water to soiled material (e.g., fabric) ratio may be from about 1:1 to about 20:1. In the context of a fabric laundry composition, usage levels may also vary depending not only on the type and severity of the soils and stains, but also on the wash water temperature, the volume of wash water, and the type of washing machine (e.g., top-loading, front-loading, top-loading, vertical-axis Japanese-type automatic washing machine).

The cleaning compositions herein may be used for laundering of fabrics at reduced wash temperatures. These methods of laundering fabric comprise the steps of delivering a laundry cleaning composition to water to form a wash liquor and adding a laundering fabric to said wash liquor, wherein the wash liquor has a temperature of above 0°C to about 30°C, or to about 25°C, or to about 15°C. The fabric may be contacted to the water prior to, or after, or simultaneous with, contacting the laundry cleaning composition with water.

Another method includes contacting a nonwoven substrate impregnated with an embodiment of the cleaning composition with soiled material. As used herein, "nonwoven substrate" can comprise any conventionally fashioned nonwoven sheet or web having suitable basis weight, caliper (thickness), absorbency, and strength characteristics. Non-limiting examples of suitable commercially available nonwoven substrates include those marketed under the tradenames SONTARA® by DuPont and POLYWEB® by James River Corp.

Hand washing methods, and combined handwashing with semiautomatic washing machines, are also included.

Machine Dishwashing Methods

Methods for machine-dishwashing or hand dishwashing soiled dishes, tableware, silverware, or other kitchenware, are included. One method for machine dishwashing comprises treating soiled dishes, tableware, silverware, or other kitchenware with an aqueous liquid having dissolved or dispensed therein an effective amount of a machine dishwashing composition in accord with the invention. By an effective amount of the machine dishwashing composition it is meant from about 8g to about 60g of product dissolved or dispersed in a wash solution of volume from about 3L to about 10L.

One method for hand dishwashing comprises dissolution of the cleaning composition into a receptacle containing water, followed by contacting soiled dishes, tableware, silverware, or other kitchenware with the dishwashing liquor, then hand scrubbing, wiping, or rinsing the soiled dishes, tableware, silverware, or other kitchenware. Another method for hand dishwashing comprises direct application of the cleaning composition onto soiled dishes, tableware, silverware, or other kitchenware, then hand scrubbing, wiping, or rinsing the soiled dishes, tableware, silverware, or other kitchenware. In some examples, an effective amount of cleaning composition for hand dishwashing is from about 0.5 ml. to about 20 ml. diluted in water.

Packaging for the Compositions

The cleaning compositions described herein can be packaged in any suitable container including those constructed from paper, cardboard, plastic materials, and any suitable laminates. An optional packaging type is described in European Application No. 94921505.7.

Multi-Compartment Pouch Additive

The cleaning compositions described herein may also be packaged as a multi-compartment cleaning composition.

5 Synthesis Examples

In the examples, the following abbreviations are used:

BuO butylene oxide

10 PO propylene oxide

Example 1: 1 mole Glycerine + 3 mole BuO + 3 mole PO, aminated

a) 1 mole Glycerine + 3 mole BuO + 3 mole PO

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In a 3.5 L autoclave 95.0 g glycerine and 1.0 g potassium tert.-butoxide were mixed. The autoclave was purged three times with nitrogen and heated to 140°C. 223.0 g butylene oxide was added within 90 minutes. The mixture was allowed to post-react for 5 hours at 140°C. Then, 179.7 g propylene oxide was added in portions within 1 hour. To complete the reaction, the mixture was allowed to post-react for additional 3 hours at 140°C. The reaction mixture was stripped with nitrogen and volatile compounds were removed in vacuo at 80°C. The catalyst was removed by adding 4.9 g synthetic magnesium silicate (Macrosorb MP5plus, Ineos Silicas Ltd.) stirring at 100°C for 2 hours and filtration.

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A yellowish oil was obtained (490.0 g, hydroxy value: 314.5 mgKOH/g).

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b) 1 mole Glycerine + 3 mole BuO + 3 mole PO, aminated

In a 9 L autoclave 350 mL of the resulting triol mixture from example 1-a, 1200 mL THF and 1500 g ammonia were mixed in presence of 200 mL of a solid catalyst as described in EP0696572B1. The catalyst containing nickel, cobalt, copper, molybdenum and zirconium was in the form of 3x3 mm tablets. The autoclave was purged with hydrogen and the reaction was started by heating the autoclave. The reaction mixture was stirred for 15 h at 205°C, the total pressure was maintained at 280 bar by purging hydrogen during the entire reductive amination step. After cooling down the autoclave the final product was collected, filtered, vented of excess ammonia and stripped in a rotary evaporator to remove light amines and water. A total of 350-

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400 grams of a low-color etheramine mixture was recovered. The analytical results thereof are shown in Table 1.

Table 1. Analytical results of etheramine of example 1

Total amine-value	Total acetylatables	Secondary and tertiary amine value	Tertiary amine-value	Hydroxyl value	Grade of amination	Primary Amine in % of total amine
mg KOH/g	mg KOH/g	mg KOH/g	mg KOH/g	mg KOH/g	in %	amine
352.30	357.43	3.43	0.75	5.88	98.77	99.03

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Example 2: 1 mole Glycerine + 3 mole PO + 3 mole BuO, aminated

a) 1mole Glycerine + 3 mole PO + 3 mole BuO

10 In a 3.5 L autoclave 88.1 g glycerine and 0.9 g potassium tert.-butylate were mixed. The autoclave was purged three times with nitrogen and heated to 140°C. 166.6 g propylene oxide was added within 1 hour. The mixture was allowed to post-react for 3 hours at 140°C. Then, 206.8 g butylene oxide was added in portions within 1 hours. To complete the reaction, the mixture was allowed to post-react for additional 3 hours at 140°C. The reaction mixture was stripped with
 15 nitrogen and volatile compounds were removed in vacuo at 80°C. The catalyst was removed by adding 4.4 g Macrosorb MP5plus, stirring at 100°C for 2 hours and filtration.
 A yellowish oil was obtained (410.0 g, hydroxy value: 336.5 mgKOH/g).

b) 1 mole Glycerine + 3 mole PO + 3 mole BuO, aminated

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In a 9 L autoclave 350 mL of the resulting triol mixture from example 2-a, 1200 mL THF and 1500 g Ammonia were mixed in presence of 200 mL of a solid catalyst as described in EP0696572B1. The catalyst containing nickel, cobalt, copper, molybdenum and zirconium was in the form of 3x3 mm tablets. The autoclave was purged with hydrogen and the reaction was
 25 started by heating the autoclave. The reaction mixture was stirred for 15 h at 205°C, the total pressure was maintained at 280 bar by purging hydrogen during the entire reductive amination step. After cooling down the autoclave the final product was collected, filtered, vented of excess ammonia and stripped in a rotary evaporator to remove light amines and water. A total of 300-

350 grams of a low-color etheramine mixture was recovered. The analytical results thereof are shown in Table 2.

Table 2. Analytical results of etheramine of example 2

Total amine-value	Total acetylatables	Secondary and tertiary amine value	Tertiary amine-value	Hydroxyl value	Grade of amination	Primary Amine in % of total amine
mg KOH/g	mg KOH/g	mg KOH/g	mg KOH/g	mg KOH/g	in %	
373.88	377.50	1.33	0.66	4.28	99.21	99.64

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Example 3: 1 mole Glycerine + 6 mole BuO, aminated

a) 1 mole Glycerine + 6 mole BuO

- 10 In a 3.5 L autoclave 103.4 g glycerine and 1.2 g potassium tert.-butylate were mixed. The autoclave was purged three times with nitrogen and heated to 140°C. 485.5 g butylene oxide was added within 2 hours. To complete the reaction, the mixture was allowed to post-react for additional 7 hours at 140°C. The reaction mixture was stripped with nitrogen and volatile compounds were removed in vacuo at 80°C. The catalyst was removed by adding 5.9 g Macrosorb
- 15 MP5plus, stirring at 100°C for 2 hours and filtration.
A yellowish oil was obtained (589.0 g, hydroxy value: 285.0 mgKOH/g).

a)Glycerine + 6 mole BuO, aminated

- 20 In a 9 L autoclave 500 g of the resulting triol mixture from example 3-a, 1200 mL THF and 1500 g Ammonia were mixed in presence of 200 mL of a solid catalyst as described in EP0696572B1. The catalyst containing nickel, cobalt, copper, molybdenum and zirconium was in the form of 3x3 mm tablets. The autoclave was purged with hydrogen and the reaction was started by heating the autoclave. The reaction mixture was stirred for 15 h at 205°C, the total
- 25 pressure was maintained at 280 bar by purging hydrogen during the entire reductive amination step. After cooling down the autoclave the final product was collected, filtered, vented of excess ammonia and stripped in a rotary evaporator to remove light amines and water. A total of 450

grams of a low-color etheramine mixture was recovered. The analytical results thereof are shown in Table 3.

Table 3. Analytical results of etheramine of example 3.

Total amine-value	Total acetylatables	Secondary and tertiary amine value	Tertiary amine-value	Hydroxyl value	Grade of amination	Primary Amine in % of total amine
mg KOH/g	mg KOH/g	mg KOH/g	mg KOH/g	mg KOH/g	in %	
313.30	327.30	1.54	0.22	14.22	95.66	99.51

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Example 4: 1 mole Glycerine + 4.2 mole PO + 1.8 mole BuO, aminated

a) 1 mole Glycerine + 4.2 mole PO + 1.8 mole BuO

In a 3.5 L autoclave 88.9 g glycerine and 0.9 g potassium tert.-butylate were mixed. The autoclave was purged three times with nitrogen and heated to 140°C. 235.4 g propylene oxide was added within 1.5 hour. The mixture was allowed to post-react for 3 hours at 140°C. Then, 125.2 g butylene oxide was added in portions within 1 hour. To complete the reaction, the mixture was allowed to post-react for additional 5 hours at 140°C. The reaction mixture was stripped with nitrogen and volatile compounds were removed in vacuo at 80°C. The catalyst was removed by adding 4.7 g Macrosorb MP5plus, stirring at 100°C for 2 hours and filtration.

A yellowish oil was obtained (470.0 g, hydroxy value: 312.1 mgKOH/g).

b) 1 mole Glycerine + 4.2 mole PO + 1.8 mole BuO, aminated

In a 9 L autoclave 350 mL of the resulting triol mixture from example 4-a, 1200 mL THF and 1500 g Ammonia were mixed in presence of 200 mL of a solid catalyst as described in EP0696572B1. The catalyst containing nickel, cobalt, copper, molybdenum and zirconium was in the form of 3x3 mm tablets. The autoclave was purged with hydrogen and the reaction was started by heating the autoclave. The reaction mixture was stirred for 15 h at 205°C, the total pressure was maintained at 280 bar by purging hydrogen during the entire reductive amination step. After cooling down the autoclave the final product was collected, filtered, vented of excess ammonia and stripped in a rotary evaporator to remove light amines and water. A total of 350-400 grams of a low-color etheramine mixture was recovered. The analytical results thereof are shown in Table 4.

Table 4. Analytical results of etheramine of example 4.

Total amine- value	Total acetylatables	Secondary and tertiary amine value	Tertiary amine- value	Hydroxyl value	Grade of amination	Primary Amine in % of total amine
mg KOH/g	mg KOH/g	mg KOH/g	mg KOH/g	mg KOH/g	in %	
343.96	347.12	3.26	0.76	3.92	99.31	99.05

Example 5 (comparative): 1 mole Glycerine + 6 mole PO, aminated

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a) 1 mole Glycerine + 6 mole PO

In a 2 L autoclave 276.3 g glycerine and 2.6 g potassium tert.-butylate were mixed. The autoclave was purged three times with nitrogen and heated to 140°C. 1044.0 g propylene oxide was added within 10 hours. The mixture was allowed to post-react for 9.5 hours at 140°C. The reaction mixture was stripped with nitrogen and volatile compounds were removed in vacuo at 80°C. The catalyst was removed by adding 21.1 g Macrosorb MP5plus, stirring at 100°C for 2 hours and filtration.

A light yellow oil was obtained (1300.0 g, hydroxy value: 320.2 mgKOH/g).

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b) 1 mole Glycerine + 6 mole PO, aminated

In a 9 L autoclave 750 mL of the resulting polyol mixture from example 5-a, 1000 mL THF and 1500 g ammonia were mixed in presence of 200 mL of a solid catalyst as described in EP0696572B1. The catalyst containing nickel, cobalt, copper, molybdenum and zirconium was in the form of 3x3 mm tablets. The autoclave was purged with hydrogen and the reaction was started by heating the autoclave. The reaction mixture was stirred for 15 h at 205°C, the total pressure was maintained at 250 bar by purging hydrogen during the entire reductive amination step. After cooling down the autoclave the final product was collected, filtered, vented of excess ammonia and stripped in a rotary evaporator to remove light amines and water. 720 g of a low-color etheramine mixture was recovered. The analytical results thereof are shown in Table 5.

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Table 5.

Total amine-value	Total acetylatables	Secondary and tertiary amine value	Tertiary amine-value	Hydroxyl value	Grade of amination	Primary Amine in % of total amine
mg KOH/g	mg KOH/g	mg KOH/g	mg KOH/g	mg KOH/g	in %	
368.70	380.00	2.85	0.00	11.30	97.03	99.23

Use as additives in laundry detergents

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Technical stain swatches of blue knitted cotton containing Beef Fat, Pork Fat, Sausage Fat, Bacon Grease and Anchor Butter were purchased from Warwick Equest Ltd. and washed in conventional western European washing machines (Miele Waschmaschine Softronic W 2241), selecting a 59 min washing cycle without heating (wash at 18 °C) and using 75 g of liquid detergent composition LA1 (table 8) together with or without 1.25 g of etheramine additive and some hydrochloric acid to readjust the pH after addition of the etheramine. Water hardness was 2.5 mM (Ca²⁺ : Mg²⁺ was 3:1). Standard colorimetric measurement was used to obtain L*, a* and b* values for each stain before and after the washing. From L*, a* and b* values the stain level was calculated.

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Stain removal from the swatches was calculated as follows:

$$\text{Stain Removal Index (SRI)} = (\Delta E_{\text{initial}} - \Delta E_{\text{washed}}) * 100 / \Delta E_{\text{initial}}$$

20 $\Delta E_{\text{initial}}$ = Stain level before washing ΔE_{washed} = Stain level after washing

Six replicates for each stain type have been carried out. Given below are the averaged values. Stain level corresponds to the amount of grease on the fabric. The stain level of the fabric before the washing ($\Delta E_{\text{initial}}$) is high, in the washing process stains are diminished and the stain level after washing is smaller (ΔE_{washed}). The better the stains have been removed the lower the value for ΔE_{washed} will be and the higher the difference will be to $\Delta E_{\text{initial}}$. Therefore the value of stain removal index increases with better washing performance.

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Table 8: liquid detergent composition LA1

Ingredients of liquid detergent composition LA1	percentage by weight
Alkyl Benzene sulfonate ¹	7.50%
AE3S ²	2.60%
AE9 ³	0.40%
NI 45-7 ⁴	4.40%
Citric Acid	3.20%
C1218 Fatty acid	3.10%
Amphiphilic polymer ⁵	0.50%
Zwitterionic dispersant ⁶	1.00%
Ethoxylated Polyethyleneimine ⁷	1.51%
Protease ⁸	0.89%
Enymes ⁹	0.21%
Chelant ¹⁰	0.28%
Brightener ¹¹	0.09%
Solvent	7.35%
Sodium Hydroxide	3.70%
Fragrance & Dyes	1.54%
Water, filler, stucturant	To Balance

¹ Linear alkylbenenesulfonate having an average aliphatic carbon chain length C11-C12 supplied by Stepan, Northfield Illinois, USA

² AE3S is C12-15 alkyl ethoxy (3) sulfate supplied by Stepan, Northfield, Illinois,USA

³ AE9 is C12-14 alcohol ethoxylate, with an average degree of ethoxylation of 9, supplied by Huntsman, Salt Lake City, Utah, USA

⁴ NI 45-7 is C14-15 alcohol ethoxylate, with an average degree of ethoxylation of 7, supplied by Huntsman, Salt Lake City, Utah, USA

⁵ Random graft copolymer is a polyvinyl acetate grafted polyethylene oxide copolymer having a polyethylene oxide backbone and multiple polyvinyl acetate side chains. The molecular weight of the polyethylene oxide backbone is about 6000 and the weight ratio of the polyethylene oxide to polyvinyl acetate is about 40 to 60 and no more than 1 grafting point per 50 ethylene oxide units.

⁶ A compound having the following general structure: bis((C₂H₅O)(C₂H₄O)_n)(CH₃)-N⁺-C_xH_{2x}-N⁺-(CH₃)-bis((C₂H₅O)(C₂H₄O)_n), wherein n = from 20 to 30, and x = from 3 to 8, or sulphated or sulphonated variants thereof

⁷ Polyethyleneimine (MW = 600) with 20 ethoxylate groups per -NH

5 ⁸ Proteases may be supplied by Genencor International, Palo Alto, California, USA (e.g. Purafect Prime®) or by Novozymes, Bagsvaerd, Denmark (e.g. Liquanase®, Coronase®).

⁹ Natalase®, Mannaway® are all products of Novozymes, Bagsvaerd, Denmark.

10 ¹⁰ Suitable chelants are, for example, diethylenetetraamine pentaacetic acid (DTPA) supplied by Dow Chemical, Midland, Michigan, USA or Hydroxyethane di phosphonate (HEDP) or diethylene triamine penta(methyl phosphonic) acid supplied by Solutia, St Louis, Missouri, USA;

¹¹ Fluorescent Brightener 1 is Tinopal® AMS, Fluorescent Brightener 2 supplied by Ciba Specialty Chemicals, Basel, Switzerland

Table 9: results

15

Stain	A	B	C	D
Beef Fat	75.3	80.2	78.8	75.1
Pork Fat	70.2	77.7	77.7	72.7
Sausage Fat	72.9	79.5	77.0	75.9
Bacon Grease	74.5	79.1	80.3	75.3
Anchor Butter	60.6	69.1	66.9	63.6

A: liquid detergent composition LA1 (table 8) without additional etheramine additive

B: liquid detergent composition LA1 (table 8) with the etheramine described in Example 1 (1 mole Glycerine + 3 mole BuO + 3 mole PO, aminated)

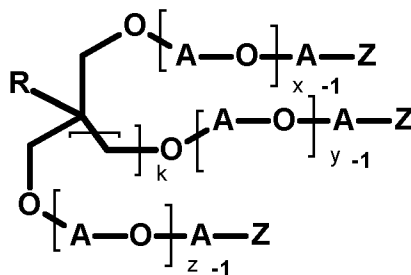
20 C: liquid detergent composition LA1 (table 8) with the etheramine described in Example 3 (1 mole Glycerine + 6 mole BuO, aminated)

D: liquid detergent composition LA1 (table 8) with the etheramine described in comparative Example 5 (1 mole Glycerine + 6 mole PO, aminated)

25 All three etheramines in the test have a molecular ratio of alkylene oxide : glycerol of 6:1. For all the five grease stains a superior cleaning effect of the butylene-oxide containing etheramines (B and C) over the non-butylene oxide containing etheramine (D) and over the liquid detergent composition without etheramine (A) is seen.

Claims:

1. An etheramine of formula (I),



Formula (I)

wherein

R = H or ethyl, k = 0 or 1

A represents a linear or branched alkylene group having C₂-C₁₈ carbon atoms,

A may be the same as or different from one another,

at least one A represents a linear or branched C₄-alkylene group,

the sum of x, y and z lies in the range of 3 to 100,

x ≥ 1, y ≥ 1 and z ≥ 1,

Z = NH₂ or OH but at least two Z per molecule are NH₂.

2. The etheramine according to Claim 1, wherein at least three A represent a linear or branched C₄-alkylene group.

3. The etheramine according to Claim 1 or 2, wherein all A groups represent a linear or branched C₄-alkylene group.

4. The etheramine according to Claim 1 to 3, wherein the sum of x, y and z lies in the range of 3 to 30.

5. The etheramine according to any one of Claims 1 to 4, wherein the sum of x, y and z lies in the range of 3 to 10.

6. The etheramine according to any one of Claims 1 to 5, wherein Z is NH₂.

7. The etheramine according to any one of Claims 1 to 6, wherein the etheramine of formula (I) is reacted with an acid.

8. A process for the manufacture of an etheramine of formula (I) comprising the following steps:

a) reacting glycerine or 1,1,1-trimethylolpropane with C₄-alkylene oxide and optionally with C₂-C₁₈ alkylene oxide, wherein the molar ratio of glycerine or 1,1,1-trimethylolpropane to C₄ al-

kylene oxide is in the range of 1: 3 to 1: 10,

b) aminating the alkoxylated glycerine or alkoxylated 1,1,1-trimethylolpropane with ammonia.

9. The process according to claim 8, wherein the molar ratio of glycerine or 1,1,1-trimethylolpropane to C₄ alkylene oxide is in the range of 1:3 to 1:6.

10. The process according to claim 8 or 9, wherein the C₂-C₁₈ alkylene oxide is ethylene oxide, propylene oxide or a mixture thereof.

11. The process according to any one of claims 8 to 10, wherein the amination is carried out in the presence of copper-, nickel- or cobalt-containing catalyst.

12. The process according to any one of claims 8 to 11, wherein the catalytically active material of the catalysts, before the reduction thereof with hydrogen, comprises oxygen compounds of aluminum, of copper, of nickel and of cobalt, and is in the range from 0.2 to 5.0% by weight of ox-ygen compounds of tin, calculated as SnO.

13. Use of the polyetheramine of Claims 1 to 7 in personal care.

14. Use of the polyetheramine of Claims 1 to 7 in shampoo and body wash formulations.

15. Use of the polyetheramine of Claims 1 to 7 as curing agent for epoxy resins or as a reactant in the production of polymers.

16. Use of the polyetheramine of Claims 1 to 7 in polyurethanes, polyureas, and as thermoplastic polyamide adhesives.