

the alkaline earth metal present in the corresponding normal material. For this reason overbased alkaline earth metal hydrocarbyl-substituted salts have a greater capability for neutralising acidic matter than do the corresponding normal alkaline earth metal hydrocarbyl-substituted salts, though not necessarily an increased detergency power. It is with the normal or low based salts that the present invention is concerned.

The prior art teaches many methods for preparing normal or low-based metal hydrocarbyl-substituted salts. One such method comprises reacting a hydrocarbyl-substituted acid, in the presence or absence of sulphur, lubricating oil, a metal hydroxide (in an equivalent ratio of the alkaline earth metal moiety to the acid moiety of up to 1) followed by a heading distillation (to remove unreacted hydroxylic compound) and filtration.

Phenols, sulphonic acids, naphthenic acids and salicylic acids are relatively expensive materials. We have found that normal or low based detergents having improved performance result when a proportion of the phenols, sulphonic acids, naphthenic acids and salicylic acids used in the preparation of individual or mixed, sulphurised or sulphur-free salts is replaced by defined amounts of certain comparatively cheaper carboxylic acids or derivatives thereof. Moreover, the aforesaid low based detergents may be produced in a similar manner using a pre-formed salt as a proportion of the starting material.

The use of organic carboxylic acids in the production of alkaline earth metal hydrocarbyl-substituted salts is not new. Thus, US-A-4,328,111 discloses the reaction product of a basic compound comprising an overbased metal sulphonate, phenate, or mixtures, thereof, with acidic compounds comprising organic carboxylic acids comprising about 1 to about 100 carbon atoms or an organic carboxylic acid anhydride comprising about 4 to about 100 carbon atoms, or a mixture thereof. However, it is stated that not all organic carboxylic acids or anhydrides or mixtures thereof improve the properties of the resulting salt. Generally, it is stated to be preferable to react the basic compound with the acidic

compound after overbasing is complete, though it is possible to react the acidic compound with intermediate overbased materials. Nevertheless, the acidic compound is always reacted with an overbased basic compound.

5 US-A-3,055,828 discloses a method of forming metal complex-containing concentrates comprising heating a metal carboxylate, a basic reacting inorganic metal compound in a lubricating oil in the presence of a dispersant at a temperature ranging from 325 to 550°F, blowing with an oxygen-containing gas
10 during said heating for a time sufficient to effect decomposition of the carboxylate and to obtain a concentrate containing a dispersant, metal carboxylate and the dispersed products of the decomposition of metal carboxylate. At column 3, lines 61-67 it is stated that the metal compound should at least be present in an amount in excess of
15 the stoichiometric quantity theoretically required for neutralization and saponification of the carboxylic acid compound and other materials present. Generally, amounts of at least about 10 percent and particularly within the range of from 20 to 400 percent in excess are said to be applicable. In this important
20 respect at least the disclosure differs from the invention described and claimed herein.

Accordingly the present invention provides a process for the production of a lubricating oil additive concentrate which process comprises reacting at elevated temperature

25 component (A) at least one compound or sulphurised derivative thereof, said compound being (i) a hydrocarbyl-substituted phenol, (ii) a hydrocarbyl-substituted sulphonic acid, (iii) a hydrocarbyl-substituted salicylic acid, or (iv) a hydrocarbyl-substituted naphthenic acid,

30 component (B) a calcium base added either in a single addition or in a plurality of additions at intermediate points during the reaction,

component (C) at least one compound which is (i) water, (ii) a polyhydric alcohol having 2 to 4 carbon atoms, (iii) a di-
35 (C₃ or C₄) glycol, (iv) a tri-(C₂-C₄) glycol, (v) a mono- or

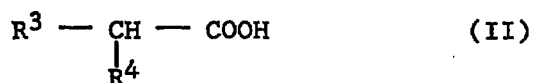
poly-alkylene glycol alkyl ether of the formula (I)



wherein R is a C₁ to C₆ alkyl group, R¹ is an alkylene group, R² is hydrogen or a C₁ to C₆ alkyl group and x is an integer from 1 to 6,
 5 (vi) a C₁ to C₂₀ monohydric alcohol, (vii) a ketone having up to 20 carbon atoms, (viii) a carboxylic acid ester having up to 10 carbon atoms, or (ix) an ether having up to 20 carbon atoms,

component (D) a lubricating oil,

10 component (E) from 5 to 35% by weight based on the weight of the concentrate of at least one compound which is (i) a carboxylic acid or an acid anhydride, acid chloride or ester thereof, said acid having the formula (II)



15

wherein R³ is a C₁₀ to C₂₄ alkyl or alkenyl group and R⁴ is hydrogen, a C₁ to C₄ alkyl group or a CH₂COOH group, or (ii) a di- or poly-carboxylic acid containing from 36 to 100 carbon atoms or an acid anhydride, acid chloride or ester thereof, the amount of
 20 component (E) being up to 60% by weight of the total weight of component (A) and component (E), said total weight of component (A) and component (E) being that required to satisfy an equivalent ratio of component (B) to component (A) plus component (E) of not greater than one.

25 Component (A) is a hydrocarbyl-substituted phenol, sulphonic acid, salicylic acid or naphthenic acid or mixtures thereof. In addition a proportion of the acid as component (A) may be replaced by a pre-formed salt of any of the aforementioned acids, preferably a calcium salt. The aforementioned acids and/or salts may be
 30 sulphurised. Alternatively component (A) may comprise a non-sulphurised acid and/or salt, and a source of sulphur, for example elemental sulphur, a sulphur monohalide or a sulphur dihalide.

35 The hydrocarbyl substituent of the aforementioned hydrocarbyl-substituted salts and acids and their sulphurised

derivatives may contain up to 125 aliphatic carbon atoms. Examples of suitable substituents include alkyl radicals, for example hexyl, cyclohexyl, octyl, isooctyl, decyl, tridecyl, hexadecyl, eicosyl and tricosyl, radicals derived from the polymerisation of both terminal and internal olefins, for example ethene, propene, 1-butene, isobutene, 1-hexene, 1-octene, 2-butene, 2-pentene, 3-pentene and 4-octene. Preferably the hydrocarbyl substituent is one derived from a monoolefin, more preferably from a monoolefin which is either propene, 1-butene or isobutene.

Component (B) is a calcium base. The calcium may be added for example in the form of quick lime (CaO) or in the form of slaked lime (Ca(OH)_2). Component (B) may be added in whole to the initial reactants, or in part to the initial reactants and the remainder in one or more portions at a subsequent stage or stages in the process. It is preferred that component (B) is added in a single addition.

As component (C) there may be used one or more polar organic compounds or water, or mixtures thereof; preferably a polar organic compound.

Suitable compounds having the formula (I) include the monomethyl or dimethyl ethers of (a) ethylene glycol, (b) diethylene glycol, (c) triethylene glycol or (d) tetraethylene glycol. A particularly suitable compound is methyl diglycol ($\text{CH}_3\text{OCH}_2\text{CH}_2\text{OCH}_2\text{CH}_2\text{OH}$). Mixtures of glycol ethers of formula (I) and glycols may also be employed. Using a glycol ether of formula (I) or a glycol as component (C) it is preferred to use in combination therewith an inorganic halide, for example ammonium chloride, and a lower, i.e. C_1 to C_4 , carboxylic acid, for example acetic acid. The polyhydric alcohol may suitably be either a dihydric alcohol, for example ethylene glycol or propylene glycol, or a trihydric alcohol, for example glycerol. The di- (C_3 or C_4) glycol may suitably be dipropylene glycol, the tri- (C_2 to C_4) glycol may suitably be triethylene glycol. Preferably the component (C) is either ethylene glycol or methyl diglycol, the latter in combination with ammonium chloride and acetic acid.

Component (C), may also suitably be a C₁ to C₂₀ monohydric alcohol, a ketone having up to 20 carbon atoms, a carboxylic acid ester having up to 10 carbon atoms or an ether having up to 20 carbon atoms which may be aliphatic, alicyclic or aromatic. Examples
5 are methanol, acetone, 2-ethyl hexanol, cyclohexanol, cyclohexanone, benzyl alcohol, ethyl acetate and acetophenone, preferably 2-ethyl hexanol. In the preferred method of producing the concentrate of the present invention, there may be used in combination (i) component (C) as defined above and (ii) a solvent.

10 As the solvent (ii) there may suitably be used an inert hydrocarbon, which may be aliphatic or aromatic. Examples of suitable solvents (ii) include toluene, xylene, naphtha and aliphatic paraffins, for example hexane, and cycloaliphatic paraffins.

15 A particularly preferred combination of (i) and (ii) is methanol and toluene. An advantage of using a combination of (i) and (ii) is that the use of ethylene glycol can be avoided. Residual ethylene glycol in the lubricating oil additive may result in corrosion of an engine in which the concentrate is used.

20 Component (D) is a lubricating oil. The lubricating oil is suitably an animal, vegetable or mineral oil. Suitably the lubricating oil is a petroleum-derived lubricating oil, such as a naphthenic base, paraffin base or mixed base oil. Solvent neutral oils are particularly suitable. Alternatively, the lubricating oil
25 may be a synthetic lubricating oil. Suitable synthetic lubricating oils include synthetic ester lubricating oils, which oils include diesters such as di-octyl adipate, di-octyl sebacate and tri-decyladipate, or polymeric hydrocarbon lubricating oils, for example liquid polyisobutenes and poly-alpha olefins. The
30 lubricating oil may suitably comprise from 10 to 90%, preferably from 10 to 70%, by weight of the concentrate.

Component (E) is either (i) a carboxylic acid of formula (II), or (ii) a di- or polycarboxylic acid containing from 36 to 100 carbon atoms, or an acid anhydride, an acid chloride or ester of (i)
35 or (ii). As regards (i), this is a carboxylic acid having the

formula (II) or an acid anhydride, acid chloride or ester thereof. Preferably R^3 is an unbranched alkyl or alkenyl group. Preferred acids of formula (II) are those wherein R^4 is hydrogen and R^3 is a C_{10} to C_{24} , more preferably C_{18} to C_{24} unbranched alkyl group.

- 5 Examples of suitable saturated carboxylic acids of formula (II) include capric, lauric, myristic, palmitic, stearic, isostearic, arachidic, behenic and lignoceric acids. Examples of suitable unsaturated acids of formula (II) include lauroleic, myristoleic, palmitoleic, oleic, gadoleic, erucic, ricinoleic, linoleic and
10 linolenic acids. Mixtures of acids may also be employed, for example rape top fatty acids. Particularly suitable mixtures of acids are those commercial grades containing a range of acids, including both saturated and unsaturated acids. Such mixtures may be obtained synthetically or may be derived from
15 natural products, for example tall, cotton, ground nut, coconut, linseed, palm kernel, olive, corn, palm, castor, soyabean, sunflower, herring and sardine oils and tallow. Sulphurised acids and acid mixtures may also be employed. Instead of, or in addition to, the carboxylic acid there may be used the acid anhydride, the acid
20 chloride or the ester derivatives of the acid, preferably the acid anhydride. It is preferred however to use a carboxylic acid or a mixture of carboxylic acids. A preferred carboxylic acid of formula (II) is stearic acid.

- Instead of, or in addition to (i), component (E) may be (ii) a
25 di- or polycarboxylic acid containing from 36 to 100 carbon atoms or an acid anhydride, acid chloride or ester derivative thereof, preferably an acid anhydride thereof; (ii) is preferably a polyisobutene succinic acid or a polyisobutene succinic anhydride.

- Component (E) is used to replace a proportion of component (A)
30 in concentrates comprising normal or low-based salts i.e. where the stoichiometric equivalent ratio of (B) to (A) is not greater than 1. Up to 60% by weight of component (A) can be replaced by component (E) according to the present invention.

- Suitably the concentrate may have a viscosity measured at 100°C
35 of less than $1000\text{mm}^2\text{S}^{-1}$ (cSt), preferably less than $750\text{mm}^2\text{S}^{-1}$ (cSt),

more preferably less than $500\text{mm}^2\text{S}^{-1}$ (cSt).

Preferably the reaction is carried out in the presence of component (F). As component (F) there may be used (i) an inorganic halide which may suitably be either a hydrogen, an ammonium or a metal halide. Suitably the metal moiety of the metal halide may be zinc, aluminium or an alkaline earth metal, preferably calcium. Of the halides, the chloride is preferred. Suitable chlorides include hydrogen chloride, calcium chloride, ammonium chloride, aluminium chloride and zinc chloride, preferably calcium chloride.

Alternatively, component (F) may be (ii) an ammonium alkanoate or a mono-, di-, tri- or tetra-alkyl ammonium formate or alkanoate, preferably an ammonium alkanoate, more preferably ammonium acetate.

Mixtures of (i) and (ii) may be used. However, when component (F) is (ii) above, component (E) is not an acid chloride.

Suitably the amount of component (F) employed may be up to 2.0% by weight based on the weight of the concentrate.

Typically, the amount of component (E) incorporated is 10% to 35%, more preferably 12 to 20%, for example about 16% by weight based on the weight of the concentrate.

Suitably the amount of total alkaline earth metal present in the concentrate is 10 to 20% by weight based on the weight of the concentrate.

The alkaline earth metal hydrocarbyl-substituted salt and/or acid in the final product may be either sulphurised or non-sulphurised, preferably non-sulphurised. Where they are sulphurised, sulphur may be present in the concentrate in an amount of from 1 to 6%, preferably from 1.5 to 3% by weight based on the weight of the concentrate.

The addition of carbon dioxide is optional, though it is preferred that it is not added. If carbon dioxide is added, it is preferably added after the addition of component (B).

The carbon dioxide may be added in the form of a gas or a solid, preferably in the form of a gas. In gaseous form it may suitably be blown through the reaction mixture.

Suitably carbon dioxide in a combined form may be present in

the concentrate in an amount in the range from 5 to 20, preferably from 9 to 15% by weight based on the weight of the concentrate.

~~Preferably the TBN of the concentrate is from 0 to 200.~~

Suitably the reaction of components (A) - (E) and also the carbonation reaction (if any) may be carried out from 15 to 200, preferably 60 to 150°C, though the actual temperatures chosen for various stages of the reaction may differ if desired. The pressure may be atmospheric, subatmospheric or superatmospheric.

The concentrate may be recovered by conventional means, for example by distillative stripping of component (C), or the solvent (if any).

Finally, it is preferred to filter the concentrate so-obtained.

Alternatively, the concentrate can be centrifuged.

A final aspect of the present invention provides a finished lubricating oil composition which composition comprises a lubricating oil and a lubricating oil additive concentrate prepared as hereinbefore described,

The finished lubricating oil composition may also contain effective amounts of one or more other types of conventional lubricating oil additives, for example viscosity index improvers, anti-wear agents, antioxidants, dispersants, rust inhibitors, pour-point depressants, or the like, which may be incorporated into the finished lubricating oil composition either directly or through the intermediacy of the concentrate composition.

In addition to their use as additives for incorporation into lubricating oil compositions, the additive concentrates of the present invention may also find application as fuel additives.

The invention will now be further illustrated by reference to the following Examples. In all the Examples the term "TBN" (Total Base Number) is used. TBN is expressed in mg KOH/g as measured by the method of ASTM D2896. In the examples where lime is used, it is in the form of slaked lime Ca(OH)_2 . Viscosities were measured by the method of ASTM D445.

Comparison Test 1 (CTI) (Conventional low based sulphonate

preparation)

Charge

	SA157 (A hydrocarbyl-substituted, sulphonic acid 66% active, MW = 480, commercially available from Paramins).	= 270 g
5	Lubricating oil (SN 100)	= 140 g
	Calcium chloride	= 1.0 g

Method

- (a) Lime (25 g) was added at 120°C/9.322 x 10⁴Pa (700 mmHg).
- (b) Ethylene glycol (70 g) was added at 145-165°C/9.322 x 10⁴Pa (700 mmHg).
- (c) The mixture was held at 165°C for 1 hour.
- (d) The mixture was stripped at 200°C/1.333 x 10³Pa (10 mmHg) over 1 hour.
- (e) The product was filtered.

15 Product Weights

Crude product	- 466g
Distillate	- 36g

Product Composition after Filtration

	Ca	= 2.89% w/w
20	S	= 2.94% w/w
	Ca as sulphonate	= 2.02% w/w
	TBN	= 25 mg KOH/g
	V ₁₀₀	= 145 mm ² S ⁻¹ (cSt)
	Carboxylic acid	= 0

- 25 This is not an example according to the present invention because no carboxylic acid was used in the preparation.

Example 1

Charge

	SA 157	= 219.6 g
30	Stearic acid (95%) pure)	= 21.9 g
	Lubricating oil (SN 100)	= 181 g
	Calcium chloride	= 1.3 g

Method

- (a) Lime (25.4 g) was added at 120°C/9.322 x 10⁴Pa (700 mmHg).
- 35 (b) Ethylene glycol (71.7 g) was added at 145°C-165°C/9.322 x 10⁴Pa

(700 mmHg).

(c) The mixture was held at 165°C for 1 hour.

(d) The mixture was stripped at 200°C/1.333 x 10³Pa (10 mmHg) over 1 hour.

5 (e) The product was filtered.

Product Weights

Crude product - 325 g (some losses during stripping)

Distillate - 145 g

Product Composition after Filtration

10	Ca	=	3.7% w/w
	S	=	3.2% w/w
	Ca as sulphonate	=	2.2% w/w
	TBN	=	53 mg KOH/g
	V ₁₀₀	=	58.7 mm ² S ⁻¹ (cSt)
15	V ₄₀	=	1008 mm ² S ⁻¹ (cSt)
	VI	=	113
	Stearic acid	=	5% w/w

Example 2

Charge

20	SA 157	=	167.7 g
	Stearic acid (95% pure)	=	44.6 g
	Lubricating oil (SN 100)	=	216 g
	Calcium chloride	=	1.4 g

Method

- 25 (a) Lime (25.9 g) was added at 120°C/9.322 x 10⁴Pa (700 mmHg). Ethylene glycol (75 g) was added at 145°C-165°C/9.322 x 10⁴Pa (700 mmHg).
- (b) mmHg).
- (c) The mixture was held at 165°C for 1 hour.
- (d) The mixture was stripped at 200°C/1.333 x 10³Pa (10 mmHg) over 30 1 hour.
- (e) The product was filtered.

Product Weights

Crude product - 450 g

Distillate - 80.6 g

35 Product Composition after Filtration

	Ca	=	2.82% w/w
	S	=	1.96% w/w
	Ca as sulphonate	=	1.4% w/w
	TBN	=	56 mg KOH/g
5	V ₁₀₀	=	25.8 mm ² S ⁻¹ (cSt)
	V ₄₀	=	243 mm ² S ⁻¹ (cSt)
	VI	=	136
	Stearic acid	=	9.91% w/w

Example 3 Charge

10	SA 157	=	118.1 g
	Stearic acid (95%) pure)	=	70.7 g
	Lubricating oil (SN 100)	=	265 g
	Calcium chloride	=	1.4 g

Method

- 15 (a) Lime (27.4 g) was added at 120°C/9.322 x 10⁴Pa (700 mmHg).
- (b) Ethylene glycol (79.4 g) was added at 145°C-165°C/9.322 x 10⁴Pa (700 mmHg).
- (c) The mixture was held at 165°C for 1 hour.
- (d) The mixture was stripped at 200°C/1.333 x 10³Pa (10 mmHg) over
- 20 1 hour.
- (e) The product was filtered.

Product Weights

Crude product	-	454 g
Distillate	-	94.7 g

Product Composition after Filtration

25	Ca	=	2.94% w/w
	S	=	1.54% w/w
	Ca as sulphonate	=	0.91% w/w
	TBN	=	62 mg KOH/g
30	V ₁₀₀	=	56.6 mm ² S ⁻¹ (cSt)
	V ₄₀	=	481.6 mm ² S ⁻¹ (cSt)
	VI	=	186
	Stearic acid	=	15.57% w/w

Example 4

Charge

	SA 157	= 167.7 g
	Stearic acid (70%) pure)	= 44.6 g
	Lubricating oil (SN 100)	= 216 g
5	Calcium chloride	= 1.4 g

Method

- (a) Lime (25.9 g) was added at 120°C 9.322 x 10⁴Pa (700mmHg).
- (b) Ethylene glycol (15.0 g) was added at 145°C-165°C/9.322 x 10⁴Pa (700 mmHg).
- 10 (c) The mixture was held at 165°C for 1 hour.
- (d) The mixture was stripped at 200°C/1.333 x 10³Pa (10 mmHg) over 1 hour.
- (e) The product was filtered.

Product Weights

15	Crude product - 415.3 g
	Distillate - 71.0 g

Product Composition after Filtration

	Ca	= 3.08% w/w
	S	= 2.23% w/w
20	Ca as sulphonate	= 1.4% w/w
	TBN	= 54 mg KOH/g
	V ₁₀₀	= 21.3mm ² S ⁻¹ (cSt)
	V ₄₀	= 187.2mm ² S ⁻¹ (cSt)
	VI	= 135
25	Stearic acid	= 10.74% w/w

Example 5

Charge

	SA 157	= 220 g
	Pre-sulphurised rape top fatty acid	= 25 g
30	Lubricating oil (SN 100)	= 181 g
	Calcium chloride	= 2.0 g

Method

- (a) Lime (25.4 g) was added at 120°C/9.322 x 10⁴Pa (700 mmHg).
- (b) Ethylene glycol (72.0 g) was added at 145°C-165°C/9.322 x 10⁴Pa (700 mmHg).
- 35

- (c) The mixture was held at 165°C for 1 hour.
 (d) The mixture was stripped at 200°C/1.333 x 10³Pa (10 mmHg) over 1 hour.
 (e) The product was filtered.

5 Product Weights

Crude product - 446.1 g
 Distillate - 85.3 g

Product Composition after Filtration

	Ca	=	3.13% w/w
10	S	=	3.33% w/w
	Ca as sulphonate	=	1.87% w/w
	TBN	=	44.8 mg KOH/g
	V ₁₀₀	=	54.1mm ² S ⁻¹ (cSt)
	V ₄₀	=	809 mm ² S ⁻¹ (cSt)
15	VI	=	122
	Sulphurised fatty acid	=	5.6% w/w

Example 6

Charge

	SA 157	=	226.6 g
20	Rape top fatty acid	=	23.0 g
	Lubricating oil (SN 100)	=	175 g
	Calcium chloride	=	2.0 g

Method

- (a) Lime (26 g) was added at 120°C/9.322 x 10⁴Pa (700 mmHg).
 25 (b) Ethylene glycol (74.0 g) was added at 145°C-165°C/9.322 x 10⁴Pa (700 mmHg).
 (c) The mixture was held at 165°C for 1 hour.
 (d) The mixture was stripped at 200°C/1.333 x 10³Pa (10 mmHg) over 1 hour.
 30 (e) The product was filtered.

Product Weights

Crude product - 359 g (losses during stripping)
 Distillate - 138.5 g

Product Composition after Filtration

35	Ca	=	2.42% w/w
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	S	=	3.91% w/w
	Ca as sulphonate	=	2.2% w/w
	TBN	=	47.2 mg KOH/g
	V ₁₀₀	=	48.3 mm ² S ⁻¹ (cSt)
5	V ₄₀	=	1220 mm ² S ⁻¹ (cSt)
	VI	=	79.5 g
	Rape Top Fatty Acid	=	6.41% w/w

Example 7

Charge

10	SA 157	=	171 g
	Rape top fatty acid	=	45 g
	Lubricating oil (SN 100)	=	204 g
	Calcium chloride	=	10.3 g

Method

- 15 (a) Lime (26 g) was added at 120°C/9.322 x 10⁴Pa (700 mmHg).
- (b) Ethylene glycol (74 g) was added at 145°C-165°C/9.322 x 10⁴Pa (700 mmHg).
- (c) The mixture was held at 165°C for 1 hour.
- (d) The mixture was stripped at 200°C/1.333 x 10³Pa (10 mmHg) over
20 1 hour.
- (e) The product was filtered.

Product Weights

Not determined

Product Composition after Filtration

25	Ca	=	3.1% w/w
	S	=	3.08% w/w
	Ca as sulphonate	=	1.4% w/w
	TBN	=	47 mg KOH/g
	V ₁₀₀	=	27.9 mm ² S ⁻¹ (cSt)
30	V ₄₀	=	322 mm ² S ⁻¹ (cSt)
	VI	=	117

Example 8

Charge

	SA 157	=	176 g
35	ADX 100 (C ₁₂ -alkylphenol, commercially	=	14.1 g

available from Adibis).

	Rape top fatty acid	= 32.5 g
	Lubricating oil (SN 100)	= 205 g
	Sulphur	= 10.5 g
5	Calcium chloride	= 2.6 g

Method

- (a) Lime (26 g) was added at 120°C/9.322 x 10⁴Pa (700 mmHg).
- (b) Ethylene glycol (74.9 g) was added at 145°C-165°C/9.322 x 10⁴Pa (700 mmHg).
- 10 (c) The mixture was held at 165°C for 1 hour.
- (d) The mixture was stripped at 200°C/1.333 x 10³Pa (10 mmHg) over 1 hour.
- (e) The product was filtered.

Product Weights

15	Crude product - 402 g
	Distillate - 105 g

Product Composition after Filtration

	Ca	= 3.14% w/w
	S	= 2.87% w/w
20	Ca as sulphonate	= 1.56% w/w
	TBN	= 54.2 mg KOH/g
	V ₁₀₀	= 36.8 mm ² S ⁻¹ (cSt)
	V ₄₀	= 588.8 mm ² S ⁻¹ (cSt)
	VI	= 98
25	Rape top fatty acid	= 8.08% w/w
	C ₁₂ alkylphenol	= 3.51% w/w

Comparison Test 2 (Conventional low based phenate preparation)

Charge

	ADX 100	= 203 g
30	Lubricating oil (SN 100)	= 183 g
	Sulphur	= 32 g
	Calcium chloride	= 5 g

Method

- (a) Lime (22 g) was added at 120°C/9.322 x 10⁴Pa (700 mmHg).
- 35 (b) Ethylene glycol (50 g) was added at 145°C-165°C/9.322 x 10⁴Pa

(700 mmHg).

(c) The mixture was held at 165°C for 1 hour.

(d) The mixture was stripped at 200°C/1.333 x 10³Pa (10 mmHg) over a period of one hour.

5 (e) The product was filtered.

Product Weights

Crude product - 403.4 g

Distillate - 66.3 g

Product Composition after Filtration

10	Ca	=	3.08% w/w
	S	=	4.3% w/w
	TBN	=	71 mg KOH/g
	V ₁₀₀	=	31.9mm ² S ⁻¹ (cSt)
	V ₄₀	=	692 mm ² S ⁻¹ (cSt)
15	VI	=	67
	Carboxylic acid	=	0% w/w

Example 9

Charge

	ADX 100	=	163 g
20	Stearic acid (70% pure)	=	40 g
	Lubricating oil (SN 100)	=	183 g
	Sulphur	=	26 g
	Calcium chloride	=	5 g

Method

25 (a) Lime (22 g) was added at 120°C/9.322 x 10⁴Pa (700 mmHg).

(b) Ethylene glycol (50 g) was added at 145°C-165°C/9.322 x 10⁴Pa (700 mmHg).

(c) The mixture was held at 165°C for 1 hour.

(d) The mixture was stripped at 200°C/1.333 x 10³Pa (10 mmHg) over a period of one hour.

30 (e) The product was filtered.

Product Weights

Crude product - 415.3 g

Distillate - 69.2 g

35 Product Composition after Filtration

	Ca	=	2.99% w/w
	S	=	3.71% w/w
	TBN	=	74.5 mg KOH/g
	V ₁₀₀	=	30.9 mm ² S ⁻¹ (cSt)
5	V ₄₀	=	491.8 mm ² S ⁻¹ (cSt)
	VI	=	92
	Stearic acid	=	9.63% w/w

Example 10Charge

10	ADX 100	=	123.6 g
	Stearic acid (70% pure)	=	81.0 g
	Lubricating oil (SN 100)	=	185.4 g
	Sulphur	=	19.7 g
	Calcium chloride	=	5.1 g

15 Method

- (a) Lime (22 g) was added at 120°C/9.322 x 10⁴Pa (700 mmHg).
- (b) Ethylene glycol (50 g) was added at 145°C-165°C/9.322 x 10⁴Pa (700 mmHg).
- (c) The mixture was held at 165°C for 1 hour.
- 20 (d) The mixture was stripped at 200°C/1.333 x 10³Pa (10 mmHg) over a period of one hour.
- (e) The product was filtered.

Product Weights

	Crude product	-	398.1 g
25	Distillate	-	155.5 g

Product Composition after Filtration

	Ca	=	3.14% w/w
	S	=	2.50% w/w
	TBN	=	82.6 mg KOH/g
30	V ₁₀₀	=	575 mm ² S ⁻¹ (cSt)
	V ₄₀	=	10680 mm ² S ⁻¹ (cSt)
	VI	=	225
	Stearic acid	=	20.3% w/w

Example 1135 Charge

	ADX 100	= 123.6 g
	Stearic acid (70% pure)	= 81.0 g
	Lubricating oil (SN 100)	= 185.4 g
	Sulphur	= 19.7 g
5	Calcium chloride	= 5.1 g

Method

- (a) Lime (22 g) was added at $120^{\circ}\text{C}/9.322 \times 10^4 \text{Pa}$ (700 mmHg).
- (b) Ethylene glycol (50 g) was added at 145°C – $165^{\circ}\text{C}/9.322 \times 10^4 \text{Pa}$ (700 mmHg).
- 10 (c) The mixture was held at 165°C for 1 hour.
- (d) The mixture was stripped at $200^{\circ}\text{C}/1.333 \times 10^3 \text{Pa}$ (10 mmHg) over a period of one hour.
- (e) The product was filtered.

Product Weights

15	Crude product	- 409.9 g
	Distillate	- 59.8 g

Product Composition after Filtration

	Ca	= 3.02% w/w
	S	= 2.65% w/w
20	TBN	= 78 mg KOH/g
	V ₁₀₀	= $285.5 \text{ mm}^2 \text{S}^{-1} (\text{cSt})$
	V ₄₀	= $4300 \text{ mm}^2 \text{S}^{-1} (\text{cSt})$
	VI	= 205
	Stearic acid	= 19.8% w/w

25. Example 12

Performance Test Results on Low Based Detergents

1. The low-based detergents of Examples 1 to 3 and 5 to 8 were blended into a test formulation comprising:-
 - 3.9% dispersant
 - 2.6% overbased phenate
 - 1.3% zinc dialkyldithiophosphate
 - 0.72% overbased sulphonate
 - 0.01% foam inhibitor
 - 0.15% pour point depressant
 - 35 low-based detergent (added in an amount that

contains 10 millimoles of calcium).

Made up to 100% with mixture of SN 150 (20%) and SN 500 (80%).

2. The formulations were evaluated in the Roxana Panel Coker Test using a panel temperature of 325°C over a period of 4 hours.

5 3. The results are given in the accompanying Table.

Comparison Tests 3 and 4

Example 12 was repeated except that instead of the low-based detergents of the Examples there was used commercially available low-based sulphonates produced in a very similar manner to

10 Comparison Test 1. The results are given in the accompanying Table.

Table

Low-based detergent of Example:-	Deposit wt (mg)
Comparison Test 3	64
Comparison Test 4	100.4
1	58
2	49.2
3	25.2
5	54.8/42.4
6	47.3/61.0
7	47.9/55.3
8	46.9/41.6

All the low-based detergents according to the invention gave lower weights of deposits in the Panel Coker Test than the commercial products.

Claims:

1. A process for the production of a lubricating oil additive concentrate which process comprises reacting at elevated temperature

component (A) at least one compound or sulphurised derivative thereof, said compound being (i) a hydrocarbyl-substituted phenol, (ii) a hydrocarbyl-substituted sulphonic acid, (iii) a hydrocarbyl-substituted salicylic acid, or (iv) a hydrocarbyl-substituted naphthenic acid,

component (B) a calcium base added either in a single addition or in a plurality of additions at intermediate points during the reaction,

component (C) at least one compound which is (i) water, (ii) a polyhydric alcohol having 2 to 4 carbon atoms, (iii) a di- (C₃ or C₄) glycol, (iv) a tri- (C₂-C₄) glycol, (v) a mono- or poly-alkylene glycol alkyl ether of the formula (I)

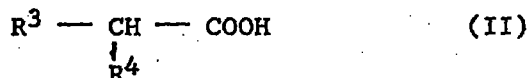


wherein R is a C₁ to C₆ alkyl group, R¹ is an alkylene group, R² is hydrogen or a C₁ to C₆ alkyl group and x is an integer from 1 to 6, (vi) a C₁ to C₂₀ monohydric alcohol, (vii) a ketone having up to 20 carbon atoms, (viii) a carboxylic acid ester having up to 10 carbon atoms, or (ix) an ether having up to 20 carbon atoms,

component (D) a lubricating oil,

component (E) from 5 to 35% by weight based on the weight of the concentrate of at least one compound which is (i) a carboxylic acid or an acid anhydride, acid chloride or ester thereof, said acid

having the formula (II)



wherein R^3 is a C_{10} to C_{24} alkyl or alkenyl group and R^4 is
 5 hydrogen, a C_1 to C_4 alkyl group or a CH_2COOH group, or (ii) a di-
 or poly-carboxylic acid containing from 36 to 100 carbon atoms or an
 acid anhydride, acid chloride or ester thereof, the amount of
 component (E) being up to 60% by weight of the total weight of
 component (A) and component (E), said total weight of component (A)
 10 and component (E) being that required to satisfy an equivalent ratio
 of component (B) to component (A) plus component (E) of not greater
 than one.

2. A process as claimed in claim 1 wherein the process is carried
 out in the presence of component (F) at least one compound which
 15 is (i) an inorganic halide or (ii) an ammonium alkanoate or a mono-,
 di-, tri- or tetra-alkyl ammonium formate or alkanoate provided
 that, when component (F) is (ii), component (E) is not an acid
 chloride.

3. A process as claimed in claim 2 wherein component (F) is an
 20 inorganic halide which is a metal halide, preferably a metal
 chloride.

4. A process as claimed in claim 3 wherein said inorganic halide
 is calcium chloride.

5. A process as claimed in claim 1 wherein component (F) is an
 25 ammonium alkanoate or a mono-, di-, tri-, or tetra-alkyl ammonium
 formate or alkanoate.

6. A process as claimed in claim 5 wherein said ammonium alkanoate
 is ammonium acetate.

7. A process as claimed in claim 1 wherein component (C) is a
 30 mono- or poly-alkylene glycol alkyl ether of the formula (I) as
 defined in claim 1 and component (F) is an inorganic halide and said
 process is carried out in the presence of a C_1 - C_4 carboxylic acid.

8. A process as claimed in claim 7 wherein component (C) is methyl
 diglycol, said inorganic halide is ammonium chloride, and said C_1 - C_4
 35 carboxylic acid is acetic acid.