

LIQUID LAUNDRY DETERGENT COMPOSITION
AND METHOD OF USE

The present invention relates to liquid laundry detergent compositions. More particularly, the present invention relates to non-aqueous liquid laundry detergent compositions which are easily pourable and which do not gel when added to water and to the use of these

5. compositions for cleaning soiled fabrics.

Liquid non-aqueous heavy duty laundry detergent compositions are well known in the art. For instance, compositions of that type may comprise a liquid non-ionic surfactant in which are dispersed particles of a
10. builder, as shown for instance in the U.S. Patents Nos. 4,316,812; 3,630,929; 4,264,466; and British Patents Nos. 1,205,711, 1,270,040 and 1,600,981.

- Liquid detergents are often considered to be more convenient to employ than dry powdered or particulate
15. products and, therefore, have found substantial favour with consumers. They are readily measurable, speedily dissolved in the wash water, capable of being easily applied in concentrated solutions or dispersions to soiled areas on garments to be laundered and are
20. non-dusting, and they usually occupy less storage space. Additionally, the liquid detergents may have incorporated in their formulations materials which could not stand drying operations without deterioration, which materials are often desirably
25. employed in the manufacture of particulate detergent products. Although they are possessed of many

30.

advantages over unitary or particulate solid products, liquid detergents often have certain inherent disadvantages too, which have to be overcome to produce acceptable commercial detergent products. Thus, some such products separate out on storage and others separate out on cooling and are not readily redispersed. In some cases the product viscosity changes and it becomes either too thick to pour or so thin as to appear watery. Some clear products become cloudy and others gel on standing.

5. The present inventors have been extensively involved in studying the rheological behaviour of non-ionic liquid surfactant systems with and without particulate matter suspended therein. Of particular interest has been non-aqueous built laundry liquid detergent compositions and the problems of gelling associated with non-ionic surfactants as well as settling of the suspended builder and other laundry additives. These considerations have an impact on, for example, product pourability, dispersibility and stability.
10. The rheological behaviour of the non-aqueous built liquid laundry detergents can be compared by analogy to the rheological behaviour of paints in which the suspended builder particles correspond to the inorganic pigment and the non-ionic liquid surfactant corresponds to the non-aqueous paint vehicle. For simplicity, in the following discussion, the suspended particles, e.g. detergent builder, will sometimes be referred to as the "pigment".
- 15.
- 20.

- 25.
- 30.

It is known that one of the major problems with paints and built liquid laundry detergents is their physical stability. This problem stems from the fact that the density of the solid pigment particles is higher than the density of the liquid matrix. Therefore, the particles tend to separate out or sediment according to Stoke's law. Two basic techniques exist to solve the sedimentation problem: liquid matrix viscosity and reducing solid particle size.

For instance, it is known that such suspensions can be stabilised against settling by adding inorganic or organic thickening agents or dispersants, such as, for example, very high surface area inorganic materials, e.g. finely divided silica or clays, or organic thickeners, such as the cellulose ethers, acrylic and acrylamide polymers or polyelectrolytes. However, such increases in suspension viscosity are naturally limited by the requirement that the liquid suspension be readily pourable and flowable, even at low temperature.

Furthermore, these additives do not contribute to the cleaning performance of the formulation. Grinding to reduce the particle size is more advantageous and provides two major consequences;

1. The pigment specific surface area is increased, and, therefore, particle wetting by the non-aqueous vehicle (liquid nonionic) is proportionately improved.

2. The average distance between pigment particles is reduced with a proportionate increase in particle-to-particle interaction. Each of these effects contributes

30.

to increase the rest-gel strength and the suspension yield stress while at the same time, grinding significantly reduces plastic viscosity.

5. The non-aqueous liquid suspensions of the detergent builders, such as the polyphosphate builders, especially sodium tripolyphosphate (TPP) in non-ionic surfactant are found to behave, rheologically, substantially according to the Casson equation:

$$\sigma^{1/2} = \sigma_0^{1/2} + \eta_\infty^{1/2} \gamma^{1/2}$$

10. where γ is the shear rate,
 σ is the shear stress,
 σ_0 is the yield stress (or yield value),
 and η_∞ is the "plastic viscosity" (apparent viscosity at infinite shear rate).
15. The yield stress is the minimum stress necessary to induce a plastic deformation (flow) of the suspension. Thus, visualising the suspension as a loose network of pigment particles, if the applied stress is lower than the yield stress, the suspension behaves like an elastic
20. gel and no plastic flow will occur. Once the yield stress is overcome, the network breaks at some points and the sample begins to flow, but with a very high apparent viscosity. If the shear stress is much higher than the yield stress, the pigments are partially shear-
25. deflocculated and the apparent viscosity decreases. Finally, if the shear stress is ^{very} much higher than the yield stress value, the pigment particles are completely shear-deflocculated and the apparent viscosity is very low, as if no particle interaction were present. There-
- 30.

- fore, the higher the yield stress of the suspension, the higher the apparent viscosity at low shear rate and the better is the physical stability of the product. In addition to the problem of settling or phase separation the non-aqueous liquid laundry detergents based on
5. liquid non-ionic surfactants suffer from the drawback that the non-ionics tend to gel when added to cold water. This is a particularly important problem in the ordinary use of European household automatic washing machines where the user places the laundry detergent
10. composition in a dispensing unit (e.g. a dispensing drawer) of the machine. During the operation of the machine the detergent in the dispenser is subjected to a stream of cold water to transfer it to the main body of wash solution. Especially during the winter months when
15. the detergent composition and water fed to the dispenser are particularly cold, the detergent viscosity increases markedly and a gel forms. As a result some of the composition is not flushed completely off the dispenser during operation of the machine, and a deposit of the
20. composition builds up with repeated wash cycles, eventually requiring the user to flush the dispenser with hot water.

- The gelling phenomenon can also be a problem whenever it is desired to carry out washing using cold
25. water as may be recommended for certain synthetic and delicate fabrics or fabrics which can shrink in warm or hot water.

- Partial solutions to the gelling problem in aqueous, substantially builder-free compositions have
- 30.

been proposed and include, for example, diluting the liquid non-ionic with certain viscosity controlling solvents and gel-inhibiting agents, such as lower alkanols, e.g. ethyl alcohol (see U.S. Patent 3,953,380), alkali metal formates and adipates (see 5 U.S. Patent 4,368,147), hexylene glycol or polyethylene glycol.

In addition, these two patents each disclose the use of up to at most about 2.5% of the lower alkyl (C_1 - C_4) etheric derivatives of the lower (C_2 - C_3) polyols, 10 e.g. ethylene glycol, in these aqueous liquid builder-free detergents in place of a portion of the lower alkanol, e.g. ethanol, as a viscosity control solvent. To similar effect are U.S. Patents 4,111,855 and 15 4,201,686. However, there is no disclosure or suggestion in any of these patents that these compounds, some of which are commercially available under the trade name Cellosolve (Registered Trade Mark), could function effectively as viscosity control 20 and gel-preventing agents for non-aqueous liquid non-ionic surfactant compositions, especially such compositions containing suspended builder salts, such as the polyphosphate compounds, and especially particularly such compositions which do not depend on or require the lower alkanol solvents as viscosity 25 control agents. Furthermore, British Patent Specification No. 1,600,981 mentions that in non-aqueous non-ionic detergent compositions containing builders suspended therein with the aid of certain dispersants for the builder, such as finely divided 30 silica and/or polyether group containing compounds having molecular weights of at least 500, it

- may be advantageous to use mixtures of non-ionic surfactants, one of which fulfills a surfactant function and the other of which both fulfills a surfactant function and reduces the pour point of the compositions. The former is exemplified by C₁₂-C₁₅ fatty alcohols
5. with 5 to 15 moles of ethylene and/or propylene oxide per mole. The other surfactant is exemplified by linear C₆-C₈ or branched C₈-C₁₁ fatty alcohols with 2 to 8 moles ethylene and/or propylene oxide per mole. Again, there is no teaching that these low carbon chain
10. compounds could control the viscosity and prevent gelation of the heavy duty non-aqueous liquid non-ionic surfactant compositions with builder suspended in the non-ionic liquid surfactant.

- It is also known to modify the structure of non-ionic surfactants to optimise their resistance to gelling upon contact with water, particularly cold water. As an example of non-ionic surfactant
15. modification one particularly successful result has been achieved by acidifying the hydroxyl moiety end group of the non-ionic molecule. The advantages of introducing a
20. carboxylic acid at the end of the non-ionic include gel inhibition upon dilution; decreasing the non-ionic pour point; and formation of an anionic surfactant when neutralised in the washing liquor. Non-ionic structure
25. optimisation for minimising gelation is also known, for example, controlling the chain length of the hydrophobic-lipophilic moiety and the number and make-up of alkylene oxide (e.g. ethylene oxide) units of the hydrophilic moiety. For example, it has been found that a C₁₃ fatty
- 30.

alcohol ethoxylated with 8 moles of ethylene oxide presents only a limited tendency to gel formation.

- Nevertheless, still further improvements are desired in the stability, viscosity control and gel inhibition of non-aqueous liquid detergent compositions.
- 5.

The present invention aims to provide non-aqueous liquid laundry detergents which do not or have reduced tendency to gel when contacted with or when added to water, especially cold water.

10.

The present invention also aims to provide non-aqueous liquid built laundry detergent compositions which are storage stable, easily pourable and dispersible in cold, warm or hot water.

15. The present invention further aims to formulate highly built heavy duty non-aqueous liquid non-ionic surfactant laundry detergent compositions which can be poured at a wide range of temperatures and which can be repeatedly dispensed from the dispensing unit of European style automatic laundry washing machines without fouling or plugging of the dispenser even during the winter months.
- 20.

One aspect of the present invention provides a liquid heavy duty laundry composition comprising by weight a suspension of 10 to 60% of a detergent builder salt in a liquid non-ionic surfactant, the said composition containing an amount of a mono- or poly-(C₂ to C₃) alkylene glycol mono (C₁ to C₅) alkyl ether sufficient to decrease the viscosity of the said suspension both in the absence of water and upon the contacting of the composition with water, the amount of liquid non-ionic surfactant and alkylene glycol mono-alkyl ether being in the range 30 to 70% of the total

25.

30.

composition, the ratio of non-ionic surfactant to glycol ether being in the range from 50:1 to 3.4:1.

5. In another aspect a liquid heavy duty laundry composition comprises a suspension of a detergent builder salt in a liquid non-ionic surfactant, the said composition containing an amount of a mono- or poly-(C₂ to C₃) alkylene glycol mono (C₁ to C₅) alkyl ether sufficient to decrease the viscosity of the said suspension both in the absence of water and upon
10. contacting of the composition with water, and which further comprises a polyether carboxylic acid, the amount of the said polyether carboxylic acid being sufficient to further lower the temperature at which the liquid non-ionic surfactant forms a gel with water.

15. In a further aspect a liquid heavy duty laundry composition comprises a suspension of a detergent builder salt in a liquid non-ionic surfactant, the said composition containing an amount of a mono- or poly-(C₂ to C₃) alkylene glycol mono(C₁ to C₅) alkyl ether sufficient to decrease the viscosity of the said suspension both in the absence of water and upon
20. contacting of the composition with water, and which further comprises an acidic organic phosphorus compound having an acidic -POH group which compound is present
25. in an amount to increase the stability of the suspension of the detergent builder in the liquid non-ionic surfactant.

30. In an additional aspect the invention affords a non-aqueous liquid laundry composition which is pourable at temperatures below about 5°C and which does not gel when added to water at temperatures below about 20°C, the said composition comprising a liquid non-ionic surfactant and a mono- or poly(C₂ to C₃) alkylene

8b.

glycol mono(C₁-C₅) alkyl ether and being substantially free of water, the ratio of non-ionic surfactant to glycol ether being in the range from 50:1 to 3.4:1, the liquid non-ionic surfactant being a C₁₀ to C₁₈ primary alcohol ethoxylated with from about 3 to 12 ethylene oxide groups and the glycol ether is diethylene glycol monobutyl ether.

In a more specific embodiment, the present invention provides a non-aqueous liquid laundry

10.

15.

20.

25.

30.

composition which remains pourable at temperatures below about 5°C and which does not gel when added to water at temperatures below about 20°C, the said composition comprising a liquid non-ionic surfactant and a mono- or poly- (C₂ to C₃ alkylene) glycol mono(C₁ to C₅)alkyl ether and being substantially free of water.

According to another aspect, the invention provides a method for dispensing a liquid non-ionic laundry detergent composition into and/or with cold water without undergoing gelation. In particular, a method is provided for filling a container with a non-aqueous liquid laundry detergent composition in which the detergent is composed, at least predominantly, of a liquid non-ionic surface active agent and for dispensing the composition from the container into a water bath in which the said laundry is to be washed, in which the said dispensing is effected by directing a stream of unheated tap water onto the said composition in the said container whereby the said composition is carried by the said stream of water into the said water bath, the improvement comprising including in the said non-aqueous composition an amount of a mono- or poly- (C₂ to C₃) alkylene glycol mono(lower)(C₁ to C₅)alkyl ether such that the composition can be easily poured into the said container even when the said composition is at a temperature below room temperature, and whereby the composition does not undergo gelation when contacted by the said stream of water and readily disperses upon entry into the said water bath.

The non-ionic synthetic organic detergents employed in the practice of the invention may be any of a wide variety of such compounds, which are well known

and, for example, are described at length in the text Surface Active Agents, Vol. II, by Schwartz, Perry and Berch, published in 1958 by Interscience Publishers, and in McCutcheon's Detergents and Emulsifiers, 1969 Annual. Usually, the non-ionic detergents are poly-lower alkoxyated lipophiles wherein the desired hydrophile-lipophile balance is obtained by addition of a hydrophilic poly-lower alkoxy group to a lipophilic moiety. A preferred class of the non-ionic detergent employed is the poly-lower alkoxyated higher alkanol wherein the alkanol is of 10 to 18 carbon atoms and wherein the number of mols of lower alkylene oxide (of 2 or 3 carbon atoms) is from 3 to 12. Of such materials it is preferred to employ those wherein the higher alkanol is a higher fatty alcohol of 10 to 11 or 12 to 15 carbon atoms and which contain from 5 to 8 or 5 to 9 lower alkoxy groups per mol. Preferably, the lower alkoxy is ethoxy but in some instances, it may be desirably mixed with propoxy, the latter, if present, usually being a minor (less than 50%) proportion. Exemplary of such compounds are those wherein the alkanol is of 12 to 15 carbon atoms and which contain about 7 ethylene oxide groups per mole, e.g. Neodol (Registered Trade Mark) 25-7 and Neodol 23-6.5, which products are made by Shell Chemical Company, Inc. The former is a condensation product of a mixture of higher fatty alcohols averaging about 12 to 15 carbon atoms, with about 7 mols of ethylene oxide and the latter is a corresponding mixture wherein the carbon atom content of the higher fatty alcohol is 12 to 13 and the number of ethylene oxide groups present averages about 6.5. The higher alcohols are primary alkanols. Other examples of such detergents include Tergitol

- (Registered Trade Mark) 15-S-7 and Tergitol 15-S-9, both of which are linear secondary alcohol ethoxylates made by Union Carbide Corp. The former is a mixed ethoxylation product of 11 to 15 carbon atoms linear secondary alkanol with seven mole of ethylene oxide and the latter is a similar product but with nine mols of ethylene oxide being reacted.

- Also useful in the composition of the present invention as a component of the non-ionic detergent are
10. higher molecular weight non-ionics, such as Neodol 45-11, which are similar ethylene oxide condensation products of higher fatty alcohols, with the higher fatty alcohol being of 14 to 15 carbon atoms and the number of ethylene oxide groups per mol being about 11.
 15. Such products are also made by Shell Chemical Company. Other useful non-ionics are represented by the Plurafac (Registered Trade Mark) series from BASF Chemical Company which are the reaction product of a higher linear alcohol and a mixture of ethylene and propylene
 20. oxides, containing a mixed chain of ethylene oxide and propylene oxide, terminated by a hydroxyl group. Examples include Plurafac RA30 (a C_{13} - C_{15} fatty alcohol condensed with propylene oxide and ethylene oxide), Plurafac D25 (a C_{13} - C_{15} fatty alcohol condensed with 5
 25. moles propylene oxide and 10 moles ethylene oxide), and Plurafac B26. Another group of liquid non-ionics are available from Shell Chemical Company, Inc. under the Dobanol (Registered Trade Mark) trade mark: Dobanol 91-5 is an ethoxylated C_9 - C_{11} fatty alcohol with an
 30. average of 5 moles ethylene oxide; and Dobanol 25-7 is an ethoxylated C_{12} - C_{15} fatty alcohol with an average of 7 moles ethylene oxide.

In the preferred poly-lower alkoxylated higher

alkanols, to obtain the best balance of hydrophilic and lipophilic moieties the number of lower alkoxies will usually be from 40% to 100% of the number of carbon atoms in the higher alcohol, preferably 40 to 60% thereof and the non-ionic detergent will preferably contain at least 50% of such preferred poly-lower alkoxy higher alkanol. Higher molecular weight alkanols and various other normally solid non-ionic detergents and surface active agents may be contributory to gelation of the liquid detergent and consequently, will preferably _____

- be omitted or limited in quantity in the composition of the present invention, although minor proportions thereof may be employed for their cleaning properties. With respect to both preferred and less preferred non-ionic detergents the alkyl groups present therein are
5. generally linear although branching may be tolerated, such as at a carbon next to or two carbons removed from the terminal carbon of the straight chain and away from the ethoxy chain, if such branched alkyl is not more than three carbons in length. Normally, the proportion
10. of carbon atoms in such a branched configuration will be minor rarely exceeding 20% of the total carbon atom content of the alkyl group. Similarly, although linear alkyls which are terminally joined to the ethylene oxide chains are highly preferred and are considered to result
15. in the best combination of detergency, biodegradability and non-gelling characteristics, medial or secondary joinder to the ethylene oxide in the chain may occur. It is usually in only a minor proportion of such alkyls, generally less than 20% but, as is in the case of the
20. mentioned Tegitols, may be greater. Also, when propylene oxide is present in the lower alkylene oxide chain, it will usually be less than 20% thereof and preferably less than 10% thereof.

- When greater proportions of non-terminally
25. alkoxyated alkanols, propylene oxide-containing poly-lower alkoxyated alkanols and less hydrophile-lipophile balanced non-ionic detergent than mentioned above are employed and when other non-ionic detergents are used instead of the preferred non-ionics recited herein, the
- 30.

- product resulting may not have as good detergency, stability, viscosity and non-gelling properties as the preferred compositions but use of the viscosity and gel controlling compounds of the present invention can also improve the properties of the detergents based on such non-ionics. In some cases, as when a higher molecular weight poly lower alkoxyated higher alkanol is employed, often for its detergency, the proportion thereof will be regulated or limited as in accordance with the results of various experiments, to obtain the desired detergency and still have the product non-gelling and of desired viscosity. Also, it has been found that it is only rarely necessary to utilise the higher molecular weight non-ionics for their detergent properties since the preferred non-ionics described herein are excellent detergents and additionally, permit the attainment of the desired viscosity in the liquid detergent without gelation at low temperatures. Mixtures of two or more of these liquid non-ionics can also be used and in some cases advantages can be obtained by the use of such mixtures.

- As mentioned above, the structure of the liquid non-ionic surfactant may be optimised with regard to their carbon chain length and configuration (e.g. linear versus branched chains) and their content and distribution of alkylene oxide units. Extensive research has shown that these structural characteristics can and do have profound effect on such properties of the non-ionic as pour point, cloud point, viscosity, gelling tendency, as well, of course, as on detergency.

- Typically, most commercially available non-ionics have a relatively large distribution of ethylene oxide (EO) and propylene oxide (PO) units and of the lipophilic hydrocarbon chain length, the reported EO and PO contents and hydrocarbon chain lengths being overall averages. This "polydispersity" of the hydrophilic chains and lipophilic chains can have great importance on the product properties as can the specific values of the average values. The relationship between "polydispersity" and specific chain lengths with product properties for a well-defined non-ionic can be shown by the following data for the "Surfactant T" series of non-ionics available from British Petroleum. The Surfactant T non-ionics are obtained by ethoxylation of secondary C₁₃ fatty alcohols having a narrow EO distribution and have the physical characteristics given in Table 1 below:

TABLE 1

	EO Content	Pour Point (°C)	Cloud Point (1% soln.) (°C)
20.			
	Surfactant T5	5	<-2
	Surfactant T7	7	<25
	Surfactant T9	9	38
	Surfactant T12	12	58
25.			
	Surfactant T5	5	20
	Surfactant T7	7	88
	Surfactant T9	9	
	Surfactant T12	12	

To assess the impact of EO distribution, a "Surfactant T8" was artificially prepared in two ways:

- a) 1:1 mixture of T7 and T9 (T8a);

b) 4:3 mixture of T5 and T12 (T8b).

The following properties given in Table 2 below were found:

TABLE 2

5.

	EO Content	Pour Point (°C)	Cloud Point (1% soln.) (°C)
	Surfactant T8a	8	2
10.	Surfactant T8b	8	15
			48
			<20

From these results, the following general observations can be made:

15.

1. T8a corresponds closely to an actual surfactant T8 as it interpolates well between T7 and T9 for both pour point and cloud point.

20.

2. T8b is highly polydisperse and would be generally unsatisfactory in view of its high pour point and low cloud point temperatures.

25.

3. The properties of T8a are basically additive between T7 and T9 whereas for T8b the pour point is close to the long EO chain (T12) while the cloud point is close to the short EO chain (T5).

30.

The viscosities of the Surfactant T non-ionics were measured at 20%, 30%, 40%, 50%, 60%, 80% and 100% non-ionic concentrations for T5, T7, T7/T9 (1:1), T9 and T12 at 25°C with the following results given in Table 3 below (when a gel is obtained, the viscosity is the

Bingham viscosity):

TABLE 3

	Non-ionic type	Viscosity (mPa.s)				
		T5	T7	T7/T9	T9	T12
5.	Non-ionic %					
	100	36	63	61	149	
	80	65		104	112	165
10.	60	750	78	188	239	32200
	50	4000	123	233	634	89100
	40	2050	96	149	211	187
	30	630	58		38	27
	20	170	78		28	100

15.

From these results, it may be concluded that Surfactant T7 is less gel-sensitive than T5, and T9 is less gel-sensitive than T12; moreover, the mixture of T7 and T9 (T8) does not gel, and its viscosity does not exceed ²³³225 m Pa.s. T5 and T12 do not form the same gel structure.

20.

Although not wishing to be bound by any particular theory, it is presumed that these results may be accounted for by the following hypothesis:

25.

For T5: with only 5 EO, the hydrodynamic volume of the EO chain is almost the same as the hydrodynamic volume of the fatty chain. Surfactant molecules can accordingly arrange themselves to form a lamellar structure.

30.

For T12: with 12 EO, the hydrodynamic volume of the EO chain is greater than that of the fatty chain. When molecules try to arrange themselves together, an interface curvature occurs and rods are obtained. The superstructure is then hexagonal; with a longer EO chain, or with a higher hydration, the interface curvature can be such that actual spheres are obtained, and the arrangement of the lowest energy is a face-centered cubic lattice.

From T5 to T7 (and T8), the interface curvature increases, and the energy of the lamellar structure increases. As the lamellar structure loses stability, its melting temperature is reduced.

From T12 to T9 (and T8), the interface curvature decreases, and the energy of the hexagonal structure increases (rods become bigger and bigger). As the loss in stability occurs, the structure melting temperature is also reduced.

Surfactant T8 appears to be at the critical point at which the lamellar structure is destabilised, i.e. the hexagonal structure is not yet stable enough and no gel is obtained during dilution. In fact, a 50% solution of T8 will finally gel after two days, but the superstructure formation is delayed long enough to allow easy water dispersibility.

The effects of the molecular weight on physical properties of the non-ionics were also considered. Surfactant T8 (1:1 mixture of T7 to T9) exhibits a good compromise between the lipophilic chain (C_{13}) and the hydrophilic chain (EO8), although the pour point and

maximum viscosity on dilution at 25°C are still high.

The equivalent EO compromise for C10 and C8 lipophilic chains was also determined using the Dobanol 91-x series from Shell Chemical Co. which are ethoxylated derivatives of C₉-C₁₁ fatty alcohols (average: C₁₀); and Alfonic (Registered Trade Mark) 610-y series from Conoco which are ethoxylated derivatives of C₆-C₁₆ fatty alcohols (average C₈); and x and y represent the EO weight percentage.

The next Table 4 reports the physical characteristics of the Alfonic 610-y and Dobanol 91-x series;

TABLE 4

		EO	Pour Point	Cloud	Max.
		Content	(°C)	P ^o int	viscosity
		(Avg.)		(°C)	on dilu-
					tion (%)
					at 25°C
					(mPa.s)
15	Non-ionic				
20	Alfonic 610-5OR	3	-15		Gel (60%)
	Alfonic 610-60	4.4	-4	41	36 (60%)
	Dobanol 91-5	5	-3	33	Gel (70%)
	Dobanol 91-5T	6	+2	55	126 (50%)
	Dobanol 91-8	8	+6	81	Gel (50%)

Dobanol 91-5 and Dobanol 91-8 are commercially available products; Dobanol 91-5 topped (T) is a lab sacle product: it is Dobanol 91-5 from which free alcohol has been removed. As the lowest ethoxylation members are also removed, the average EO number is 6. Dobanol 91-5T provides the best results of C₁₀ lipophile chain as it does not gel at 25°C. The 1% cloud point (55°C)

is higher than for surfactant T8 (48°C). This is presumably due to the lower molecular weight since the mixture entropy is higher. Alfonic 610-60 provides the best results of the C₈ lipophile chain series.

5. A summary of the best EO contents for each tested lipophilic chain length is provided in the following Table 5:

TABLE 5

	Non-ionic	C No.	EO No.	Pour Point (°C)	Cloud Point (1% soln.) (°C)	Max. viscosity on dilution (%) at 25°C (mPa.s)
10.	Surfactant T8	13	8	+2	48	223 (50%)
	Dobanol 91-5T	10	6	+2	55	126 (50%)
15.	Alfonic 610-60	8	4.4	-4	41	36 (60%)

From this data, the following conclusions were reached:

20. Pour points: as the non-ionic molecular weight decreases, its pour point decreases too. The relatively high pour point of Dobanol 91-5T can be accounted for by the higher polydispersity. This was also noticed for T8a and T8b, i.e. the chain polydispersity increases the pour point.

25. Cloud points: theoretically, as the number of molecules increases (if the molecular weight decreases), the mixing entropy is higher, so the cloud point would increase as the molecular weight decreases. It is actually the case from Surfactant T8 to Dobanol 91-5T but it has not been confirmed with Alfonic 610-60. Here

30.

it is presumed that the lipophilic hydrocarbon chain polydispersity is responsible for the theoretically too low cloud point. The relatively large amount of C10-EO present reduces the solubility.

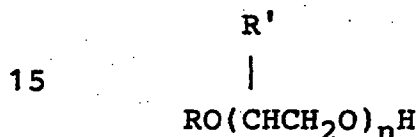
- Maximum viscosity on dilution at 25°C: none of
5. these non-ionics gel at 25°C when they are diluted with water. The maximum viscosity decreases sharply with the molecular weight. As the non-ionic molecular weight decreases, the less efficient become the hydrogen bridges. Unfortunately, too low molecular weight non-
10. ionics are not suitable for laundry washing: their micellar critical concentration (MCC) is too high, and a true solution, with only a limited detergency would be obtained under practical laundry conditions.

- With this information, the present inventors
15. continued their studies on the effects of the low molecular weight amphiphilic compounds on the rheological properties of liquid non-ionic detergent cleaning compositions. These studies revealed that while it is possible to lower the pour point of the
20. composition and obtain some degree of gel inhibition by using a short chain hydrocarbon, e.g. about C₈, with a short chain ethylene oxide substitution, e.g. about 4 moles, as amphiphilic additive, such as Alfonic 610-60, these additives do not significantly contribute to the
25. overall laundry cleaning performance and still do not exhibit overall satisfactory viscosity control over all normal usage conditions.

- The present invention is, therefore, based, at least in part, on the discovery that the low molecular
- 30.

weight amphiphilic compounds which can be considered to be analogous in chemical structure to the ethoxylated and/or propoxylated fatty alcohol non-ionic surfactants but which have short hydrocarbon chain lengths (C_1-C_5) and a low content of alkylene oxide, i.e. ethylene oxide and/or propylene oxide (about 1 to 4 EO/PO units per molecule) function effectively as viscosity control and gel-inhibiting agents for the liquid non-ionic surface active cleaning agents.

The viscosity-controlling and gel-inhibiting amphiphilic compounds used in the present invention can be represented by the following general formula:



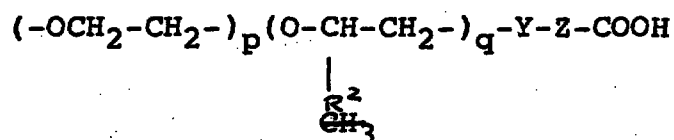
where, R represents a C_1-C_5 , preferably C_2-C_5 , especially preferably C_2 to C_4 , and particularly C_4 alkyl group, R' represents a hydrogen atom or a methyl group, preferably a hydrogen atom, and n is a number of from about 1 to 4, preferably 2 to 4 on average.

Preferred examples of suitable amphiphilic compounds include ethylene glycol monoethyl ether ($C_2H_5-O-CH_2CH_2OH$), and diethylene glycol monobutyl ether ($C_4H_9-O-(CH_2CH_2O)_2H$). Diethylene glycol monobutyl ether is especially preferred and, as will be shown below, is uniquely effective to control viscosity.

While the amphiphilic compound, particularly diethylene glycol monobutyl ether, can be the only viscosity control and gel inhibiting additive in the compositions of the present invention further improve-

- ments in the rheological properties of the anhydrous liquid non-ionic surfactant compositions can be obtained by including in the composition a small amount of a non-ionic surfactant which has been modified to
5. convert a free hydroxyl group thereof to a moiety having a free carboxyl group, such as a partial ester of a non-ionic surfactant and a polycarboxylic acid and/or an acidic organic phosphorus compound having an acidic-POH group, such as a partial ester of
 10. phosphorous acid and an alkanol.

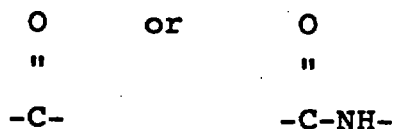
- As disclosed in the co-pending British Patent Application No. 8509084, Serial No. 2158454, the free carboxyl group modified non-ionic surfactants, which may be broadly characterised as polyether carboxylic
15. acids, function to lower the temperature at which the liquid non-ionic forms a gel with water. The acidic polyether compound can also decrease the yield stress of such dispersions, aiding in their dispensibility, without a corresponding decrease in their stability
 20. against settling. Suitable polyether carboxylic acids contain a grouping of the formula:



25.

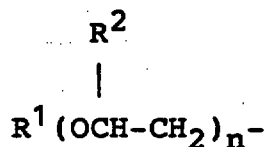
- where R^2 represents a hydrogen atom or a methyl group, Y represents oxygen or sulphur, Z represents an organic linkage, p is a positive number of from about 3 to
30. about 50 and q is zero or a positive number of up to 10. Specific examples include the half-ester of Plurafac RA30 with succinic anhydride, the half ester of Dobanol 25-7 with succinic anhydride, and the half

- ester of Dobanol 91-5 with succinic anhydride. Instead of a succinic acid anhydride, other polycarboxylic acids or anhydrides may be used, e.g. maleic acid, maleic anhydride, glutaric acid, malonic acid, succinic acid, phthalic acid, phthalic anhydride, or citric acid. Furthermore, other linkages may be used, such as ether, thioether or urethane linkages, formed by conventional reactions. For instance, to form an ether linkage, the non-ionic surfactant may be treated with a strong base (to convert its OH group to an ONa group for instance) and then reacted with a halocarboxylic acid such as chloroacetic acid or chloropropionic acid or the corresponding bromo compound. Thus, the resulting carboxylic acid may have the formula R-Y-ZCOOH, where R is the residue of a non-ionic surfactant (on removal of a terminal OH), Y represents oxygen or sulphur and Z represents an organic linkage such as a hydrocarbon group of, say, one to ten carbon atoms which may be attached to the oxygen (or sulphur) of the formula directly or by means of an intervening linkage such as an oxygen containing linkage, e.g. a



25. linkage.

The polyether carboxylic acid may be produced from a polyether which is not a non-ionic surfactant, e.g. it may be made by reaction with a polyalkoxy compound such as polyethylene glycol or a monoester or monoether thereof which does not have the long alkyl chain characteristic of the non-ionic surfactants. Thus, R may have the formula:



5. where, R^2 represents a hydrogen atom or a methyl group, R^1 represents an alkylphenyl or alkyl or other chain terminating group and "n" is at least 3, such as 5 to 25. When the alkyl group of R^1 is a higher alkyl group, R is a residue of a non-ionic surfactant. As
10. ~~indicated above~~ R^1 may instead be hydrogen or lower alkyl (e.g. methyl, ethyl, propyl, butyl) or lower acyl (e.g. acetyl). The acidic polyether compound if present in the detergent composition, is preferably added dissolved in the non-ionic surfactant.
15. As disclosed in the co-pending British Patent Application No. 8509083, Serial No. 2158453, the acidic organic phosphorus compound having an acidic -POH group can increase the stability of the suspension of builder, especially polyphosphate builders, in the non-
20. aqueous liquid non-ionic surfactant.
The acidic organic phosphorus compound may be, for instance, a partial ester of phosphoric acid and an alcohol such as an alkanol which has a lipophilic character, having, for instance, more than 5 carbon
25. atoms, e.g. 8 to 20 carbon atoms.
A specific example is a partial ester of phosphoric acid and a C_{16} to C_{18} alkanol (Empiphos (Registered Trade Mark) 5632 from Marchon); it is made up of about 35% monoester and 65% diester.
30. The inclusion of quite small amounts of the acidic organic phosphorus compound makes the suspension significantly more stable against settling on standing but remains pourable, presumably, as a result of increasing

- the yield value of the suspension, but decreases its plastic viscosity. It is believed that the use of the acidic phosphorus compound may result in the formation of a high energy physical bond between the -POH portion of the molecule and the surfaces of the inorganic polyphosphate builder so that these surfaces take on an organic character and become more compatible with the non-ionic surfactant.
- 5.

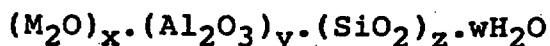
- The acidic organic phosphorus compound may be selected from a wide variety of materials, in addition to the partial ester of phosphoric acid and alkanols mentioned above. Thus, one may employ a partial ester of phosphoric or phosphorous acid with a mono or polyhydric alcohol such as hexylene glycol, ethylene glycol, di- or tri-ethylene glycol or higher polyethylene glycol, polypropylene glycol, glycerol, sorbitol or mono or diglycerides of fatty acids, in which one, two or more of the alcoholic OH groups of the molecule may be esterified with the phosphorous acid. The alcohol may be _____
- 10.
- 15.
- 20.

- a non-ionic surfactant such as an ethoxylated or ethoxylated-propoxylated higher alkanol, higher alkyl phenol, or higher alkyl amide. The -POH group need not be bonded to the organic portion of the molecule through an ester linkage; instead it may be directly bonded to
5. carbon (as in a phosphonic acid, such as a polystyrene in which some of the aromatic rings carry phosphonic acid or phosphinic acid groups; or an alkylphosphonic acid, such as propyl or laurylphosphonic acid) or may be connected
 10. to the carbon through other intervening linkage (such as linkages through O, S or N atoms). Preferably, the carbon:phosphorus atomic ratio in the organic phosphorus compound is at least about 3:1, such as 5:1, 10:1, 20:1, 30:1 or 40:1.

- The detergent composition of the present invention
15. may also and preferably does include water soluble detergent builder salts. Typical suitable builders include, for example, those disclosed in U.S. Patents 4,316,812, 4,264,466 and 3,630,929. Water-soluble inorganic alkaline builder salts which can be used alone
 20. with the detergent compound or in admixture with other builders are alkali metal carbonates, borates, phosphates, polyphosphates, bicarbonates and silicates. (Ammonium or substituted ammonium salts can also be used.) Specific examples of such salts are sodium
 25. tripolyphosphate, sodium carbonate, sodium tetraborate, sodium pyrophosphate, potassium pyrophosphate, sodium bicarbonate, potassium tripolyphosphate, sodium hexametaphosphate, sodium sesquicarbonate, sodium mono and diorthophosphate, and potassium bicarbonate. Sodium
 - 30.

- tripolyphosphate (TPP) is especially preferred. The alkali metal silicates are useful builder salts which also function to make the composition anticorrosive to washing machine parts. Sodium silicates of $\text{Na}_2\text{O}/\text{SiO}_2$ ratios of from 1.6/1 to 1/3.2 especially about 1/2 to 1/2.8 are preferred. Potassium silicates of the same ratios can also be used.

- Another class of builders useful herein are the water-insoluble aluminosilicates, both of the crystalline and amorphous type. Various crystalline zeolites (i.e. alumino-silicates) are described in British Patent 1,504,168, U.S. Patent 4,409,136 and Canadian Patents 1,072,835 and 1,087,477. An example of amorphous zeolites useful herein can be found in Belgian Patent 835,351. The zeolites generally have the formula:



- wherein, x is 1, y is from 0.8 to 1.2 and preferably 1, z is from 1.5 to 3.5 or higher and preferably 2 to 3 and w is from 0 to 9, preferably 2.5 to 6 and M is preferably sodium. A typical zeolite is type A or similar structure, with type 4A particularly preferred.
- The preferred aluminosilicates have calcium ion exchange capacities of about 200 milliequivalents per gram or greater, e.g. 400 meq/g.

Other materials such as clay, particularly of the

30.

- water insoluble types, may be useful adjuncts in compositions of the present invention. Particularly useful is bentonite. This material is primarily montmorillonite which is a hydrated aluminium silicate in which about 1/6th of the aluminium atoms may be replaced
5. by magnesium atoms and with which varying amounts of hydrogen, sodium, potassium and calcium, may be loosely combined. The bentonite in its more purified form (i.e. free from any grit, sand or the like) suitable for detergents invariably contains at least 50%
 10. montmorillonite and thus its cation exchange capacity is at least about 50 to 75 meq. per 100 g of bentonite. Particularly preferred bentonites are the Wyoming or Western U.S. bentonites which have been sold as Thixojels 1, 2, 3 and 4 by Georgia Kaolin Co. These
 15. bentonites are known to soften textiles as described in British Patent 401,413 to Marriott and British Patent 461,221 to Marriott and Dugan.

- Examples of organic alkaline sequestrant builder salts which can be used alone with the detergent or in admixture with other organic and inorganic builders are
20. alkali metal, ammonium or substituted ammonium, aminopolycarboxylates, e.g. sodium and potassium ethylene diaminetetraacetate (EDTA), sodium and potassium
 25. nitrilotriacetates (NTA) and triethanolammonium N-(2-hydroxyethyl)nitrilodiacetates. Mixed salts of these polycarboxylates are also suitable.

- Other suitable builders of the organic type include carboxymethylsuccinates, tartronates and glycollates. Of special value are the polyacetal carboxylates. The
- 30.

polyacetal carboxylates and their use in detergent compositions are described in U.S.P. 4,144,226; 4,315,092 and 4,146,495. Other U.S. patents on similar builders include 4,141,676; 4,169,934; 4,201,858; 5. 4,204,852; 4,224,420; 4,225,685; 4,226,960; 4,233,423; 4,302,564 and 4,303,777. Also relevant are European Patent Application Nos. 0015024; 0021491 and 0063399.

Since the compositions of the present invention are generally highly concentrated, and, therefore, may 10. be used at relatively low dosages, it is desirable to supplement any phosphate builder (such as sodium tri-polyphosphate) with an auxiliary builder such as a polymeric carboxylic acid having high calcium binding capacity to inhibit incrustation which could otherwise 15. be caused by formation of an insoluble calcium phosphate. Such auxiliary builders are also well known in the art.

Various other detergent additives or adjuvants may be present in the detergent product to give it addi- 20. tional desired properties, either of functional or aesthetic nature. Thus, there may be included in the formulation, minor amounts of soil suspending or anti-redeposition agents, e.g. polyvinyl alcohol, fatty amides, sodium carboxymethyl cellulose, hydroxypropyl 25. methyl cellulose; optical brighteners, e.g. cotton, polyamide and polyester brighteners, for example, stilbene, triazole and benzidine sulphone compositions, especially sulphonated substituted triazinyl stilbene, sulphonated naphthotriazole stilbene or benzidine 30. sulphone, most preferred are stilbene and triazole combinations.

Bluing agents such as ultramarine blue; enzymes, preferably proteolytic enzymes, such as subtilisin,

- bromelin, papain, trypsin and pepsin, as well as amylase type enzymes, lipase type enzymes, and mixtures thereof; bactericides, e.g. tetrachlorosalicylanilide, hexachlorophene; fungicides, dyes; pigments (water dispersible); preservatives; ultraviolet absorbers;
5. anti-yellowing agents, such as sodium carboxymethyl cellulose, complex of C_{12} to C_{22} alkyl alcohol with C_{12} to C_{18} alkylsulphate; pH modifiers and pH buffers; colour safe bleaches, perfume and anti-foam agents or
 10. suds-suppressors, e.g. silicone compounds can also be used.

- The bleaching agents are classified broadly, for convenience, as chlorine bleaches and oxygen bleaches. Chlorine bleaches are typified by sodium hypochlorite
15. (NaOCl), potassium dichloroisocyanurate (59% available chlorine), and trichloroisocyanuric acid. Oxygen bleaches are represented by sodium and potassium perborates, percarbonates and perphosphates, and potassium monopersulphate. The oxygen bleaches are
 20. preferred and the perborates, particularly sodium perborate monohydrate is especially preferred.

- The peroxygen compound is preferably used in admixture with an activator therefor. Suitable activators are those disclosed in U.S. Patent 4,264,466
25. or in column 1 of U.S. Patent 4,430,244. Polyacylated compounds are preferred activators; among these, compounds such as tetraacetyl ethylene diamine ("TAED") and pentaacetyl glucose are particularly preferred.

- The activator usually interacts with the peroxygen
30. compound to form a peroxyacid bleaching agent in the wash water. It is preferred to include a sequestering

agent of high complexing power to inhibit any undesired reaction between such peroxyacid and hydrogen peroxide in the wash solution in the presence of metal ions. Preferred sequestering agents are able to form a complex with Cu^{2+} ions, such that the stability constant (pK) of the complexation is equal to or greater than 6, at 25°C, in water, of an ionic strength of 0.1 mole/litre, pK being conventionally defined by the formula: $\text{pK} = -\log K$, where K represents the equilibrium constant. Thus, for example, the pK values for complexation of copper ion with NTA and EDTA at the stated conditions are 12.7 and 18.8, respectively. Suitable sequestering agents include for example, in addition to those mentioned above, diethylene triamine pentaacetic acid (DETPA); diethylene triamine penta-methylene phosphonic acid (DTPMP); and ethylene diamine tetramethylene phosphonic acid (EDITEMPA).

The composition may also contain an inorganic insoluble thickening agent or dispersant of very high surface area such as finely divided silica of extremely fine particle size (e.g. of 5-100 millimicrons diameters such as sold under the name Aerosil) or the other highly voluminous inorganic carrier materials disclosed in U.S. Patent 3,630,929, in proportions of 0.1-10%, e.g. 1 to 5%. It is preferable, however, that compositions which form peroxyacids in the wash bath (e.g. compositions containing peroxygen compound and activator therefor) be substantially free of such compounds and of other silicates; it has been found, for instance, that silica _____

and silicates promote the undesired decomposition of the peroxyacid.

- In a preferred form of the invention, the mixture of liquid non-ionic surfactant and solid ingredients is subjected to an attrition type of mill in which the
5. particle sizes of the solid ingredients are reduced to less than about 10 microns, e.g. to an average particle size of 2 to 10 microns or even lower (e.g. 1 micron). Compositions whose dispersed particles are of such small size have improved stability against separation or
10. settling on storage.

- In the grinding operation, it is preferred that the proportion of solid ingredients be high enough (e.g. at least about 40% such as about 50%) that the solid particles are in contact with each other and are not
15. substantially shielded from one another by the non-ionic surfactant liquid. Mills which employ grinding balls (ball mills) or similar mobile grinding elements have given very good results. Thus, one may use a laboratory batch attritor having 8 mm diameter steatite grinding
20. balls. For larger scale work a continuously operating mill in which there are 1 mm or 1.5 mm diameter grinding balls working in a very small gap between a stator and a rotor operating at a relatively high speed (e.g. a CoBall mill) may be employed; when using such a mill, it is
25. desirable to pass the blend of non-ionic surfactant and solids first through a mill which does not effect such fine grinding (e.g. a colloid mill) to reduce the particle size to less than 100 microns (e.g. to about 40 microns) prior to the step of grinding to an average

30.

particle diameter below about 10 microns in the continuous ball mill.

- In the preferred heavy duty liquid detergent compositions of the present invention, typical proportions (based on the total composition, unless otherwise specified) of the ingredients are as follows:
- 5.

Suspended detergent builder, within the range of about 10 to 60% such as about 20 to 50%, e.g. about 25 to 40%;

10. Liquid phase comprising non-ionic surfactant and dissolved amphiphilic viscosity-controlling and gel-inhibiting compound, within the range of about 30 to 70%, such as about 40 to 60%; this phase may also include minor amounts of diluent such as a glycol, e.g. polyethylene glycol (e.g. "PEG (Registered Trade Mark) 400"), or hexylene glycol, such as up to 10%, preferably up to 5%, for example 0.5 to 2%; the weight ratio of non-ionic surfactant to amphiphilic compound is in the range of from 50:1 to 3.4:1, preferably from about 25:1 to 3.4:1, especially preferably, from about 19:1 to 4:1;
- 15.
- 20.

25. Polyether carboxylic acid gel-inhibiting compound, in an amount to supply in the range of about 0.5 to 10 parts (e.g. about 1 to 6 parts, such as about 2 to 5 parts) of -COOH (M.W. 45) per 100 parts of blend of such acid compound and non-ionic surfactant. Typically, the amount of the polyether carboxylic acid compound is in the range of about 0.01 to 1 part per part of non-ionic surfactant, such as about 0.05 to 0.6 part, e.g. about 0.2 to 0.5 part;
- 30.

Acidic organic phosphoric acid compound, as anti-

settling agent: up to 5%, for example, in the range of 0.01 to 5%, such as about 0.05 to 2%, e.g. about 0.1 to 1%.

- Suitable ranges of other optional detergent additives are: enzymes - 0 to 2%, especially 0.7 to 1.3%; corrosion inhibitors - about 0 to 40%, and preferably 5 to 30%; anti-foam agents and suds-suppressors - 0 to 15%, preferably 0 to 5%, for example 0.1 to 3%; thickening agents and dispersants - 0 to 15%, for example 0.1 to 10%, preferably 1 to 5%; soil suspending ^{and} or anti-redeposition agents and anti-yellowing agents - 0 to 10%, preferably 0.5 to 5%; colourants, perfumes, ^{optical} brighteners and bluing agents total weight 0% to about 2% and preferably 0% to about 1%; pH modifiers and pH buffers - 0 to 5%, preferably 0 to 2%; bleaching agents - 0% to about 40% and preferably 0% to about 25%, for example 2 to 20%; bleach stabilisers and bleach activators 0 to about 15%, preferably 0 to 10%, for example, 0.1 to 8%; sequestering agents of high complexing power, in the range of up to about 5%, preferably about 0.25 to 3%, such as about 0.5 to 2%. In the selection of the adjuvants, they will be chosen to be compatible with the main constituents of the detergent composition.

- The invention may be put into practice in various ways and a number of specific embodiments will be described by way of example with reference to the accompanying drawings, in which:

Figure 1 is three graphs of viscosity plotted against total surfactant concentration in water for the compositions of Example 2;

Figures 2A and 2B are five graphs of viscosity plotted against total surfactant concentration in water for the compositions of Example 3; and

Figure 3 is three graphs of viscosity plotted against total surfactant concentration in water for the compositions of Example 4.

5.

All proportions and percentages are by weight unless otherwise indicated.

EXAMPLE 1

10. A heavy duty built non-aqueous liquid non-ionic cleaning composition having the formula given in Table 6 below is prepared:

15.

TABLE 6

	<u>Ingredient</u>	<u>Weight %</u>
	Surfactant T7	17.0
	Surfactant T8	17.0
5	Dobanol 91-5 Acid ¹	5.0
	Diethylene glycol monobutyl ether	10.0
	Dequest 2066 ²	1.0
	TPP NW (sodium tripolyphosphate)	29.0925
	Sokolan CP5 ³ (Calcium sequestering agent)	4.0
10	Perborate H ₂ O (sodium perborate monohydrate)	9.0
	T.A.E.D. (tetraacetylene diamine)	4.5
	Emphiphos 5632 ⁴	0.3
	Stilbene 4 (optical brightener)	0.5
15	Esperase (Registered Trade Mark) (proteolytic enzyme)	1.0
	Duet 787 ⁵	0.6
	Relatin DM 4050 ⁶ (anti-redeposition agent)	1.0
20	Blue Foulant Sandolane (dye)	0.0075

Notes on Table 6

25 1) The esterification product of Dobanol 91-5 (a C₉-C₁₁ fatty alcohol ethoxylated with 5 moles ethylene oxide) with succinic anhydride - the half-ester.

2) Dequest 2066 is the sodium salt of diethylene triamine pentamethylene phosphoric acid.

30 3) A copolymer of about equal moles of methacrylic acid and maleic anhydride, completely neutralized to form the sodium salt thereof.

4) Partial ester of phosphoric acid and a C₁₆ to C₁₈ alkanol (about 1/3 monoester and 2/3 diester).

5) DUET 787 is a fragrance.

6) Mixture of sodium carboxymethyl cellulose and hydroxymethylcellulose.

This composition is a stable, free-flowing, built, non-gelling, liquid non-ionic cleaning composition in which the polyphosphate builder is stably suspended in the liquid non-ionic surfactant phase.

EXAMPLES 2, 3 and 4

In order to demonstrate the effects of the viscosity control and gel-inhibiting agents, the various compositions set out in Table 7 were prepared using the above described Surfactant T8 (C13, EO8) 50/50 weight mixture of Surfactant T7 and Surfactant T9) ((S) in Table 7) as the non-aqueous liquid non-ionic surface active cleaning agent. Formulations containing 5%, 10%, 15% or 20% of amphiphilic additive were prepared and were tested at 5°, 10°, 15° or 20° and 25°C for different dilutions with water, i.e. 100%, 83%, 67%, 50% and 33% total non-ionic Surfactant T8 plus additive concentrations, i.e. after dilution in water. The additives tested were _____

Alfonic 610-60 (C8-EO4.4) ((A1) in Table 7), ethylene glycol monoethyl ether (C2-EO1) ((A2) in Table 7), and diethylene glycol monobutyl ether (C4-EO2) ((A3) in Table 7).

5.

TABLE 7

		Additive	
Example	S	type	%
2A	95	A1	5
10. 2B	90	A1	10
2C	85	A1	15
2D	80	A1	20
3A	95	A2	5
3B	90	A2	10
15. 3C	85	A2	15
3D	80	A2	20
4A	95	A3	5
4B	90	A3	10
4C	85	A3	15
20. 4D	80	A3	20

The results of viscosity behaviour on dilution of each tested composition at each temperature is illustrated in the graphs attached as Figures 1-3.

25. Figure 1 gives 3 plots at 5°C, 15°C and 25°C for the Example 2 formulations. Figures 2A and 2B give 5 plots at 5°C, 10°C, 15°C, 20°C and 25°C for the Example 3 formulations. Figure 3 gives 3 plots at 5°C, 10°C and 25°C for the Example 4 formulations. The X axis plots
30. the total surfactant content and the Y axis the viscosity

in each graph.

- Referring to Figure 1 for Alfonic 610-60, 5% addition was sufficient to inhibit gelation at 25°C; however, in the plot of viscosity vs. concentration of non-ionic a sharp viscosity maximum was observed at about 67% concentration and a shoulder was observed at about 55% to 35% non-ionic concentration. At 5°C, 15% addition was necessary to avoid gel formation. The viscosity decreased to a minimum at a non-ionic concentration of about 83% at all levels of additive addition at 5°C whereas at the higher temperature, viscosity minimums were observed for the non-diluted formulations, i.e. 100% non-ionic concentrations. At each temperature and for each tested concentration of additive (except at 20% additive at 25°C) a relatively sharp peak is seen in the viscosity existing between 75 to 50% concentration of non-ionic (i.e. 25 to 50% dilution).

- Referring to Figures 2A and 2B, for ethylene glycol monoethyl ether 5% additive was capable of inhibiting gel formation even at 5°C. However, sharp peaks and/or maxima of viscosity were again observed at each temperature and additive concentration, although the effects were not as pronounced as for Alfonic 610-60, and for some applications the maximum viscosities, especially at higher additive concentrations and/or higher temperatures could be acceptable for commercial use.

- Referring to Figure 3 on the other hand, there were no sharp peaks in viscosity observed for diethylene glycol monobutyl ether at any temperature down to 5°C at the 20% additive level. Even at the lower additive

levels the viscosity peaks and the viscosity values at substantially all dilutions (concentrations of non-ionics) were lower than for either the C8-EO4.4 or C2-EO1 additive.

5. The following Table 8 is representative of the results which were obtained for the different additive concentrations, dilutions, and temperatures, but are given for 20% additive and 5°C temperature:

TABLE 8

10.	Ex. Compositions	Viscosity at 5°C (Pa.sec)		Pour Point (°C)
		No water	50% water	
	5 Surfactant T8 only	1.140	1.240	5
	3D 80% Surfactant T8+20%A	0.086	0.401	-10
15.	4D 80% Surfactant T8+20%B	0.195	0.218	-2
	2D 80% Surfactant T8+20%C	0.690	0.936	3

Notes on Table 8

A = ethylene monoethyl ether (A2)

20. B = diethylene glycol monobutyl ether (A3)

C = Alfonic 610-60 (C8-4.4EO) (A3)

(Pa. sec = 10 poises (e.g. 0.218 Pa.sec = 218 centi-poises).

25.

CLAIMS

5. 1. A liquid heavy duty laundry composition comprising by weight a suspension of 10 to 60% of a detergent builder salt in a liquid non-ionic surfactant, the said composition containing an amount of a mono- or poly-(C₂ to C₃) alkylene glycol mono(C₁ to C₅) alkyl ether sufficient to decrease the viscosity of the said suspension both in the absence of water and upon contacting of the composition with water, the amount of liquid non-ionic surfactant and alkylene glycol monoalkyl ether being in the range 30 to 70% of the total composition, the ratio of non-ionic surfactant to glycol ether being in the range from 50:1 to 3.4:1.
10. 2. A composition as claimed in Claim 1 in which the ratio of non-ionic surfactant to glycol ether is in the range 25:1 to 3.4:1.
15. 3. A composition as claimed in Claim 1 in which the ratio of non-ionic surfactant to glycol ether is in the range 19:1 to 4:1.
20. 4. A composition as claimed in Claim 1, 2 or 3 in which the glycol ether is a mono or dialkylene glycol ether.
25. 5. A composition as claimed in Claim 1, 2, 3 or 4, in which the alkylene glycol monoalkyl ether is diethylene glycol monobutyl ether.
- 30.



6. A composition as claimed in Claim 1, 2, 3, 4 or 5, in which the liquid non-ionic surfactant is a C_{10} to C_{18} fatty alcohol alkoxyated with from 3 to 12 moles of a C_2 to C_3 alkylene oxide per mole of fatty alcohol.
- 5.

7. A liquid heavy duty laundry composition comprising a suspension of a detergent builder salt in a liquid non-ionic surfactant, the said composition
10. containing an amount of a mono- or poly- $(C_2$ to $C_3)$ alkylene glycol mono $(C_1$ to $C_5)$ alkyl ether sufficient to decrease the viscosity of the said suspension both in the absence of water and upon contacting of the composition with water, and which further comprises a
15. polyether carboxylic acid, the amount of the said polyether carboxylic acid being sufficient to further lower the temperature at which the liquid non-ionic surfactant forms a gel with water.

20. 8. A composition as claimed in Claim 7, in which the polyether carboxylic acid is a half ester of a dicarboxylic acid and a non-ionic surfactant.

9. A liquid heavy duty laundry composition
25. comprising a suspension of a detergent builder salt in a liquid non-ionic surfactant, the said composition containing an amount of a mono- or poly- $(C_2$ to $C_3)$ alkylene glycol mono $(C_1$ to $C_5)$ alkyl ether sufficient to decrease the viscosity of the said suspension both
30. in the absence of water and upon contacting of the composition with water, and which further comprises an acidic organic phosphorus compound having an acidic -POH group which compound is present in an amount to



increase the stability of the suspension of the detergent builder in the liquid non-ionic surfactant.

5. 10. A composition as claimed in any one of Claims 1 to 8, which further comprises an acidic organic phosphorus compound having an acidic -POH group in an amount to increase the stability of the suspension of the detergent builder in the liquid non-ionic surfactant.

10.

- 7 11. A composition as claimed in any one of Claims 1 to 10, which comprises from about 30 to about 70% of the liquid non-ionic surfactant and the alkylene glycol monoalkyl ether at a weight ratio of non-ionic surfactant to glycol ether in the range of from about 50:1 to 3.4:1, and from about 10 to about 60% of the suspended detergent builder.

20. 12. A composition as claimed in any one of Claims 1 to 11, which further comprises a polyether carboxylic acid gel inhibiting compound in an amount of from about 0.5 to 10 parts of -COOH group thereof per 100 parts of the polyether carboxylic acid and the liquid non-ionic surfactant; an acidic organic phosphoric acid compound, as an anti-settling agent, in an amount in the range of from about 0.01 to 5%, and optionally, one or more detergent additives selected from the group consisting of enzymes, corrosion inhibitors, anti-foam agents, suds suppressors, thickening agents, dispersants, soil suspending agents, anti-redeposition agents, anti-yellowing agents, colourants, perfumes, optical brighteners, pH modifiers, pH buffers, bleaching agents, bleach stabilisers, bleach activators, and



sequestering agents.

5. 13. A composition as claimed in any one of Claims 1 to 12, which is ~~at least~~ substantially non-aqueous.
10. 14. A composition as claimed in any one of Claims 1 to 13, in which the detergent builder comprises an alkali metal polyphosphate, the alkylene glycol ether is diethylene glycol monobutyl ether, and the liquid non-ionic surfactant comprises a secondary C₁₃ fatty alcohol ethoxylated with about 8 moles ethylene oxide per mole of fatty alcohol.
15. 15. A composition as claimed in any one of Claims 1 to 14, which contains a polyether carboxylic acid which comprises a partial ester of a C₉ to C₁₁ fatty alcohol ethoxylated with ^{average} ~~about~~ 5 moles ethylene oxide with succinic acid or succinic acid anhydride, and an acidic organic phosphoric acid compound which comprises
20. a partial ester of phosphoric acid and a C₁₆ to C₁₈ alkanol.
25. 16. A non-aqueous liquid laundry composition which is pourable at temperatures below about 5°C and which does not gel when added to water at temperatures below about 20°C, the said composition comprising a liquid non-ionic surfactant and a ~~mono or poly(C₂ to C₃) alkylene glycol mono(C₁ C₅) alkyl ether~~ and being substantially free of water, the ^{weight} ~~ratio~~ of non-ionic surfactant to glycol ether being in the range from 50:1
30. to 3.4:1, the liquid non-ionic surfactant being a C₁₀ to C₁₈ primary alcohol ethoxylated with from ~~about~~ 3 to 12 ethylene oxide groups and the glycol ether is



diethylene glycol monobutyl ether.

17. In a method for filling a container with a non-aqueous liquid laundry detergent composition in which the detergent is composed at least predominantly of a liquid non-ionic surface active agent and for dispensing the composition from the said container into a water bath in which the said laundry is to be washed, in which the said dispensing is effected by directing a stream of unheated tap water onto the said composition in the said container whereby the said composition is carried by the said stream of water into the said water bath, the improvement comprising including in the said non-aqueous composition an amount of a mono- or poly(C_2 to C_3) alkylene glycol mono(C_1 - C_5) alkyl ether such that the composition can be easily poured into the said container even when the said composition is at temperatures below room temperature and whereby the composition does not undergo gelation when contacted by the said stream of water and readily disperses upon entry into the said water bath.

18. A method as claimed in Claim 17, in which the said glycol ether is diethylene glycol monobutyl ether.

19. A method as claimed in Claim 17 or 18, in which the said detergent composition further comprises at least one detergent builder stably suspended in the said liquid non-ionic surface active agent.

20. A method as claimed in Claim 19, in which the said detergent builder comprises an alkali metal polyphosphate.



21. A liquid heavy duty laundry composition as claimed in Claim 1 substantially as specifically described herein with reference to Example 1.

5. _____

10.