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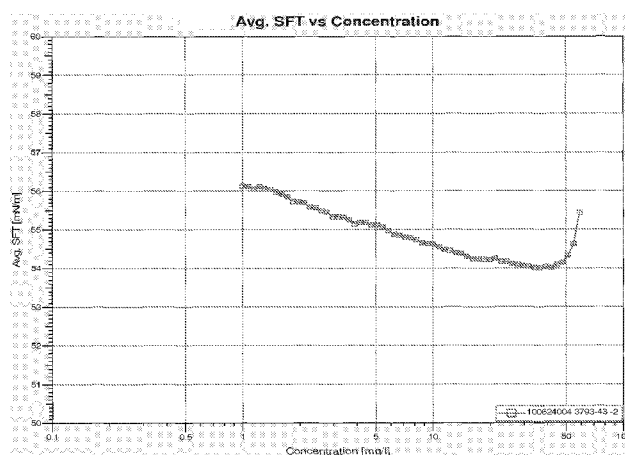
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(54) Title: MULTI-ARM HYDROPHILIC URETHANE POLYMERS, METHODS OF MAKING THEM, AND COMPOSITIONS AND PROCESSES EMPLOYING THEM

FIGURE 1



(57) **Abstract:** Hydrophilic, multi-arm urethane polymers are described that are dispersible and/or soluble in water, and provide wetting, foaming and cleaning benefits for aqueous cleaning products, including hard surface cleaners, machine dishwash, and liquid hand dishwash compositions. At least one composition manufactured via the reaction of at least one C1-6 polyol with at least one diisocyanate, followed by reaction with at least one low molecular weight polyethylene glycol. At least some of the arms of the star polymer are crosslinked via bonds formed between the diisocyanate groups at the free-end of each arm and at least one hydrophilic molecule that possesses at least two hydrophilic groups per molecule. The star polymer has from 1 to 6 arms. The hydrophilizing molecule is polyethylene glycol that reacts across the diisocyanates attached to different core groups lightly crosslinking the star polymers to provide the water-soluble and/or water-dispersible polymers.