

2088932

- 1 -

ORGANOPHILIC ORGANIC-CLAY COMPLEXES

5 This invention relates to organophilic organic-clay complexes which are dispersible in organic liquids to form a gel therein. More particularly such gels are useful in oil base muds and oil base packer fluids.

 It is well known that organic compounds
10 containing a cation will react with clays which contain a negative layer-lattice and exchangeable cations to form organophilic organic-clay products. The reaction of an organic cation containing at least one alkyl group of at least 10 carbon atoms with clay generally results in organo-
15 clays swellable in certain organic liquids.

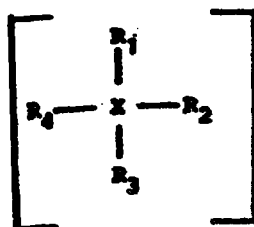
 Prior publications include U.S. Pat. No. 2,531,427, and U.S. Pat. No. 2,966,506, both incorporated herein by reference, and the book "Clay Mineralogy", 2nd Edition, 1968 by Ralph E. Grim (McGraw Hill Book Co., Inc.), particularly
20 Chapter 10, Clay-Mineral-Organic Reactions; pp. 356-368 - Ionic Reactions, Smectite; and pp. 392-401 - Organophilic Clay-Mineral Complexes.

 Maximum gelling (thickening) efficiency from these organoclays is achieved by adding a low molecular weight
25 polar organic dispersing material to the composition. Such materials are disclosed in U.S. Patents: O'Halloran 2,677,661; McCarthy et al. 2,704,276; Stratton 2,833,720; Stratton 2,879,229; and Stansfield et al. 3,294,683. The use of such dispersion aids was found unnecessary when using
30 particular organophilic clays derived from substituted

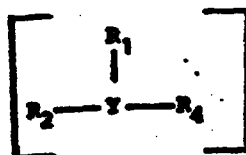
quaternary ammonium compounds as disclosed in Finlayson et al 4,105,578 and Finlayson 4,208,218.

Prior organophilic clays have exhibited limited broad range gelling utility due to fluctuating dispersion and viscosity properties. While the materials disclosed in U.S. Patent 4,105,578 have not shown such deficiencies, such materials are difficult and costly to produce.

An organophilic clay gellant comprising the reaction product of an organic cationic compound, an organic anion and a smectite-type clay having a cation exchange capacity of at least 75 milliequivalents per 100 grams of said clay such that an organic cation-organic anion complex is intercalated with the smectite-type clay and the cation exchange sites of the smectite-type clay are substituted with the organic cation, wherein the organic cation is selected from



and



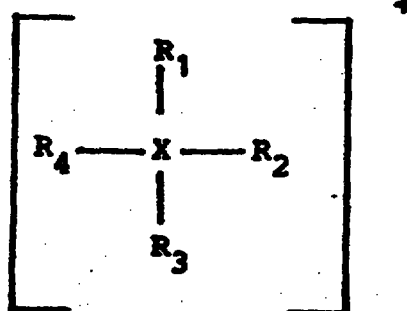
wherein X is nitrogen or phosphorus, Y is sulfur; R_1 is an alkyl group containin 8 to 60 carbon atoms; and R_2 , R_3 and R_4 are selected independently from hydrogen, a hydroxylalkyl group having 2 to 6 carbon atoms, alkyl groups containing 1 to 22 carbon atoms, aryl groups, aralkyl groups containing 1 to 22 carbon atoms on the alkyl chain, and mixtures thereof.

The organophilic clays of this invention can be prepared by admixing the clay, organic cation, organic anion and water together, preferably at a temperature within the range from 20°C. to 100°C., more preferably 35°C. to 77°C. for a period of time sufficient for the organic cation and organic anion complex to intercalate with the clay particles. The mixing step is followed by filtering, washing, drying and grinding. The addition of the organic cation and organic anion may be done either separately or as a complex. In using the organophilic clays in emulsions, the drying and grinding steps may be eliminated. When admixing the clay, organic cation, organic anion and water together in such concentrations that a slurry is not formed, filtration and washing steps can be eliminated.

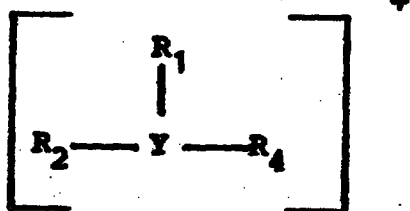
The organophilic clays of the invention may also be prepared by admixing the organic anion with an aqueous clay slurry preferably at a temperature between 20°C. and 100°C. for a sufficient time to prepare a homogenous mixture followed by the addition of the organic cation in sufficient amounts to satisfy the cation exchange capacity of the clay and the cationic capacity of the organic anion.

The mixture is reacted with agitation at a temperature between 20°C. and 100°C. for a sufficient time to allow the formation of an organic cation-organic anion complex which is intercalated with the clay and the cation exchange sites of the clay are substituted with the organic cation. Reaction temperatures below 20°C or above 100°C, are not preferred due to the need for additional processing equipment.

The organic cationic compounds used in the invention are selected from the groups consisting of the formulae:



and



wherein X is nitrogen or phosphorus, Y is sulfur, R_1 is an alkyl group having 8 to 60 carbon atoms; and R_2, R_3 and R_4 are individually selected from the group consisting of hydrogen; hydroxyalkyl groups having 2 to 6 carbon atoms; alkyl groups containing 1 to 22 carbon atoms; aryl groups; aralkyl groups containing 1 to 22 carbon atoms on the alkyl chain; and mixtures thereof. Preferably, X is nitrogen.

R_1

The long chain alkyl radical may be branched or unbranched, saturated or unsaturated, substituted or unsubstituted and should have from 8 to 60 carbon atoms in the straight chain portion of the radical. Preferably, R_1 is an alkyl group having 12 to 60 carbon atoms. More preferably, R_1 is an alkyl group having 12 to 22 carbon atoms.

The long chain alkyl radicals may be derived from naturally occurring oils including various vegetable oils, such as corn oil, coconut oil, soybean oil, cottonseed oil, and castor oil and various animal oils and fats such as tallow oil.

The alkyl radicals may be derived synthetically from sources such as alpha olefins.

Representative examples of useful branched, saturated alkyl radicals include 12-methylstearyl; and 5 12-ethylstearyl. Representative examples of useful branched, unsaturated radicals include 12-methyloleyl and 12-ethyloleyl. Representative examples of unbranched saturated radicals include lauryl; stearyl; tridecyl; myristal (tetradecyl); pentadecyl; hexadecyl; 10 hydrogenated tallow and docosonyl. Representative examples of unbranched, unsaturated and unsubstituted long chain alkyl radicals include oleyl, linoleyl; linolenyl, soya and tallow.

15 R_2, R_3, R_4

R_2 , R_3 , and R_4 are individually selected from the group consisting of hydrogen; a hydroxyalkyl group having 2 to 6 carbon atoms; an alkyl group containing 1 to 22 carbon atoms; an aryl group; an aralkyl group 20 containing 1 to 22 carbon atoms in the alkyl chain of the aralkyl group, and mixtures thereof.

Preferably, R_2 is selected from a group consisting of a β, γ -unsaturated alkyl group having less than 7 aliphatic carbon atoms, a hydroxyalkyl 25 group having 2 to 6 carbon atoms, and a aralkyl group containing 1 to 22 carbon atoms in the alkyl chain of the aralkyl group and mixtures thereof. Preferably R_3 and R_4 are individually selected from a group consisting of a β, γ -unsaturated alkyl group, a 30 hydroxyalkyl group having 2 to 6 carbon atoms, an alkyl group having 1 to 22 carbon atoms, an aralkyl group which includes benzyl and substituted benzyl moieties including fused ring moieties having linear or branched

chains of 1 to 22 carbon atoms in the alkyl portion of the aralkyl group and mixtures thereof.

The hydroxyalkyl group may be selected from a hydroxyl substituted cyclic or acyclic aliphatic radical having from 2 to 6 aliphatic carbons wherein the hydroxyl substitution is on C₂ to C₆, i.e. not on the carbon adjacent to the positive charged atom. The alkyl group may be substituted with an aromatic ring. Representative examples include 2-hydroxyethyl; 3-hydroxypropyl; 4-hydroxypentyl; 6-hydroxyhexyl; 2-hydroxypropyl; 2-hydroxybutyl; 2-hydroxypentyl; 2-hydroxyhexyl; 2-hydroxycyclohexyl; 3-hydroxycyclohexyl; 4-hydroxycyclohexyl; 2-hydroxycyclopentyl; 3-hydroxycyclopentyl; 2-methyl-2-hydroxypropyl; 3-methyl-2-hydroxybutyl; and 5-hydroxy-2-pentenyl.

The alkyl group containing 1 to 22 carbon atoms may be linear or branched, cyclic or acyclic, substituted or unsubstituted. Representative examples of useful alkyl groups include methyl; ethyl; propyl; 2-propyl; iso-butyl; cyclopentyl; and cyclohexyl.

The alkyl radicals may be derived from sources similar to the long chain alkyl radical, R₁, above.

The preferred β, γ -unsaturated alkyl group may be cyclic or acyclic, unsubstituted or substituted. β, γ -unsaturated alkyl radicals preferably contain less than 7 aliphatic carbon atoms. Aliphatic radicals substituted on the β, γ -unsaturated group preferably contain less than 4 carbon atoms. The β, γ -unsaturated alkyl radical may be substituted with an aromatic ring that is conjugated with the unsaturation of the β, γ moiety. The β, γ -radical may also be substituted both with aliphatic radicals and aromatic rings.

Representative examples of cyclic β, γ -unsaturated alkyl groups include 2-cyclohexenyl and 2-cyclopentenyl. Representative examples of acyclic β, γ -unsaturated alkyl groups containing 6 or less carbon atoms include

propargyl; 2-propenyl; 2-butenyl; 2-pentenyl; 2-hexenyl; 3-methyl-2-butenyl; 3-methyl-2-pentenyl; 2,3-dimethyl-2-butenyl; 1,1-dimethyl-2-propenyl; 1,2-dimethyl-2-propenyl; 2,4-pentadienyl; and 2,4-hexadienyl.

- 5 Representative examples of acyclic-aromatic substituted compounds include 3-phenyl-2-propenyl; 2-phenyl-2-propenyl; and 3-(4-methoxy phenyl)-2-propenyl. Representative examples of aromatic and aliphatic sub-

stituted materials include 3-phenyl-2-cyclohexenyl;
3-phenyl-2-cyclopentenyl; alkyl group may be substituted
5 with an aromatic ring.

Examples of aryl groups would include phenyl
such as in N-alkyl and N,N-dialkyl anilines, wherein the
alkyl groups contain between 1 to 22 carbon atoms; ortho-,
meta- and para-nitrophenyl, ortho-, meta- and para-alkyl phenyl,
10 wherein the alkyl group contains between 1 and 22 carbon
atoms, 2-, 3-, and 4- halophenyl wherein the halo group is
defined as chloro, bromo, or iodo, and 2-, 3-, and 4-
carboxyphenyl and esters thereof, where the alcohol of the
ester is derived from an alkyl alcohol, wherein the alkyl
15 group contains between 1 and 22 carbon atoms, aryl such as a
phenol, or aralkyl such as benzyl alcohols; fused ring aryl
moieties such as naphthalene, anthracene, and phenanthrene.

Representative examples of an aralkyl group,
include benzyl and those materials derived from compounds
20 such as benzyl halides, benzhydryl halides, trityl halides,
1-halo-1-phenylalkanes wherein the alkyl chain has from
1 to 22 carbon atoms such as 1-halo-1-phenylethane; 1-halo-1-
phenylpropane; and 1-halo-1-phenyloctadecane; substituted
benzyl moieties such as would be derived from ortho-, meta-
25 and para-chlorobenzyl halides, para-methoxybenzyl halides;
ortho-, meta- and para-nitrilobenzyl halides, and ortho-,
meta- and para-alkylbenzyl halides wherein the alkyl chain
contains from 1 to 22 carbon atoms; and fused ring benzyl-
type moieties such as would be derived from 2-halomethyl-
30 naphthalene, 9-halomethylanthracene and 9-halomethyl-
phenanthrene, wherein the halo group would be defined as
chloro-, bromo-, iodo-, or any other such group which serves
as a leaving group in the nucleophilic attack of the benzyl
type moiety such that the nucleophile replaces the leaving
35 group on the benzyl type moiety.

A compound is formed of the above described
organic cation and an anionic radical which is selected from
the group consisting of chloride, bromide, iodide, nitrite,
hydroxide, acetate, methyl sulfate and mixture thereof.
40 Preferably the anion is selected from the group consisting

of chloride and bromide, and mixtures thereof, and is more preferably chloride, although other anions such as iodide, acetate, hydroxide, nitrite, etc., may be present in the organic cationic compound to neutralize the cation.

Organic cationic salts may be prepared by methods as disclosed in U.S. 2,355,356, 2,775,617 and 3,136,819.

The organic anions useful in this invention should be capable of reacting with an organic cation and form intercalations with a smectite-type clay as an organic cation-organic anion complex. The molecular weight (gram molecular weight) of the organic anion is preferably 3,000 or less, and most preferably 1,000 or less and contains at least one acidic moiety per molecule as disclosed herein. The organic anion is preferably derived from an organic acid having a pK_A less than about 11.0. As indicated, the source acid must contain at least one ionizable hydrogen having the preferred pK_A in order to allow the formation of the organic cation-organic anion complex and subsequent intercalation reaction to occur.

Also useable is any compound which will provide the desired organic anion or hydrolysis. Representative compounds include:

- 1) acid anhydrides including acetic anhydride, maleic anhydride, succinic anhydride and phthalic anhydride;
- 2) acid halides including acetyl chloride octanoyl chloride, lauroyl chloride, lauroyl bromide and benzoyl bromide;
- 3) 1,1,1-trihalides including 1,1,1-trichloroethane and 1,1,1-tribromooctane; and
- 4) orthoesters including ethyl orthoformate, and ethyl orthostearate.

The organic anions may be in the acid or salt form. Salts may be selected from alkali metal salts, alkaline earth salts, ammonia, and organic amines. Representative salts include: hydrogen, lithium, sodium, potassium, magnesium, calcium, barium, ammonium and organic amines such as ethanolamine, diethanolamine, triethanolamine, methyl diethanolamine, butyl diethanolamine, diethyl amine,

dimethyl amine, triethyl amine, dibutyl amine, and mixtures thereof. The preferred alkali metal salt is sodium.

5 Suitable acidic functional organic compounds include:

1) Carboxylic acids including:

(a) benzenecarboxylic acids such as benzoic acid, ortho-, meta- and para-phthalic acid, 1,2,3-benzene
10 tricarboxylic acid; 1,2,4-benzenetricarboxylic acid; 1,3,5-benzenetricarboxylic acid; 1,2,4,5-benzene tetra-carboxylic acid; 1,2,3,4,5,6-benzenehexacarboxylic acid (mellitic acid);

(b) alkyl carboxylic acids having the
15 formula $H-(CH_2)_n - COOH$, wherein n is a number from 0 to 20, such compounds include acetic acid; propionic acid; butanoic acid; pentanoic acid; hexanoic acid; heptanoic acid; octanoic acid; nonanoic acid; decanoic acid; undecanoic acid; lauric acid; tridecanoic acid;
20 tetradecanoic acid; pentadecanoic acid; hexadecanoic acid; heptadecanoic acid; octadecanoic acid (stearic acid); nonadecanoic acid; and eicosonic acid.

(c) alkyl dicarboxylic acids having the
formula $HOOC-(CH_2)_n-COOH$, wherein n ranges from 0 to 8,
25 such as oxalic acid; malonic acid; succinic acid; glutaric acid; adipic acid; pimelic acid; suberic acid; azelaic acid; and sebacic acid;

(d) hydroxyalkyl carboxylic acids such
as citric acid; tartaric acids; malic acid; mandelic acid;
30 and 12-hydroxystearic acid;

(e) unsaturated alkyl carboxylic acids
such as maleic acid; fumaric acid; and cinnamic acid;

(f) fused ring aromatic carboxylic acids
such as naphthalenic acid; and anthracene carboxylic acid;

35 (g) cycloaliphatic acids such as cyclohexane carboxylic acid; cyclopentane carboxylic acid; furan corboxylic acids.

2) Organic sulfur acids including:

(a) sulfonic acids including:

40 (1) benzenesulfonic acids such as

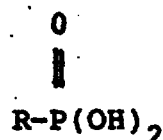
benzenesulfonic acid; phenolsulfonic acid; dodecylbenzene-sulfonic acid; benzenedisulfonic acid, benzenetrissulfonic acids; para-toluenesulfonic acid; and

(2) alkyl sulfonic acids such as methane sulfonic acid; ethane sulfonic acid; butane sulfonic acid; butane disulfonic acid; sulfosuccinate alkyl esters such as dioctyl succinyl sulfonic acid; and alkyl polyethoxy-succinyl sulfonic acid; and

(b) alkyl sulfates such as the lauryl half ester of sulfuric acid and the octadecyl half ester of sulfuric acid.

3) Organophosphorus acids including;

(a) phosphonic acids having the formula:



wherein R is an aryl group or alkyl having 1 to 22 carbon atoms;

(b) phosphinic acids having the formula:



wherein R is an aryl group or alkyl group having 1 to 22 carbon atoms, such as dicyclohexyl phosphinic acid; dibutyl phosphinic acid; and dilauryl phosphinic acid;

(c) thiophosphinic acids having the formula:



wherein R is an aryl group or alkyl group having 1 to 22 carbon atoms such as di-iso-butyl dithiophosphinic acid; dibutyl dithiophosphinic acid; dioctadecyl dithiophosphinic acid;

(d) phosphites, that is diesters of phosphorous acid having the formula: HO-P(OR)_2 ; wherein R is an alkyl group having 1 to 22 carbon atoms such as dioctadecylphosphite;

(e) phosphates, that is diesters of phosphoric

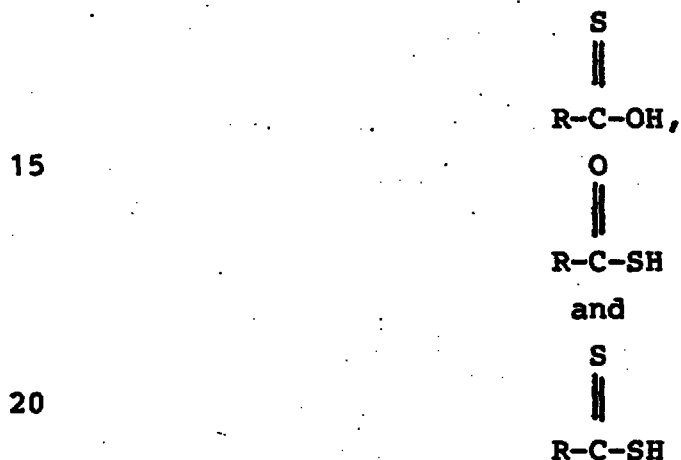
acid having the formula:



wherein R is an alkyl group having 1 to 22 carbon atoms, such as dioctadecyl phosphate.

4) Phenols such as phenol; hydroquinone; t-butylcatechol; p-methoxyphenol; and naphthols.

5) Thioacids having the formulae:



wherein R is an aryl group or alkyl group having 1 to 22 carbon atoms, such as thiosalicylic acid; thiobenzoic acid; thioacetic acid; thiolauroic acid; and thiostearic acid.

6) Amino acids such as the naturally occurring amino acids and derivatives thereof such as 6-aminohexanoic acid; 12-aminododecanoic acid; N-phenylglycine; and 3-aminocrotonic acid.

7) Polymeric acids prepared from acidic monomers wherein the acidic function remains in the polymer chain such as low molecular weight acrylic acid polymers and copolymers; styrene maleic anhydride copolymers.

8) Miscellaneous acids and acid salts such as ferrocyanide; ferricyanide; sodium tetraphenylborate; phosphotungstic acid; phosphosilicic acid, or any other such anion which will form a tight ion pair with an organic cation, i.e., any such anion which forms a water insoluble precipitate with an organic cation.

For convenience of handling it is preferred that the total organic content of the organophilic clay reaction

products of this invention should be less than about 50% by weight of the organoclay. While higher amounts are usable the reaction product is difficult to filter, dry and grind.

- 5 A sufficient amount of organic cation is employed to satisfy the cation exchange capacity of the clay and the cationic activity of the organic anion. Additional amounts of cation above the sum of the exchange capacity of the clay and anion are
- 10 optional. For example, smectite-type clays require at least 90 milliequivalents of organic cation to satisfy at least a portion of the total organic cation requirement. Use of amounts from 80 to 200 M.E., and preferably 100 to 160 M.E. are acceptable.
- 15 At lower milliequivalents ratios, an incomplete reaction will occur resulting in an ineffective gellant. More preferably, the amount of organic cation is from 100 to 130 milliequivalents per 100 g of smectite-type clay, 100% active clay basis.
- 20 The amount of organic anion added to the clay should be sufficient to impart to the organophilic clay the enhanced dispersion characteristic desired. This amount is defined as the milliequivalent ratio which is the number of milliequivalents (M.E.) of the
- 25 organic anion in the organoclay per 100 grams of clay, 100% active clay basis. The anion milliequivalent ratio should preferably range from 5 to 100 and more preferably 10 to 50.

The organic anion is preferably added to the

30 reactants in the desired milliequivalent ratio as a solid or solution in water under agitation to effect a macroscopically homogenous mixture.

Smectite-type clays occur naturally or are prepared synthetically. Suitable clays include

35 montmorillonite, bentonite, beidellite, hectorite, saponite, and stevensite. In particular smectite-

type clays should have a cation exchange capacity of at least 75 milliequivalents per 100 grams of clay. Particularly desirable types of clay are the naturally-occurring Wyoming varieties of bentonite and 5 hectorite, a swelling magnesium-lithium silicate clay. Suitable synthetic clays may be synthesized by conventional means including pneumatolitic and hydrothermal methods.

The clays, especially the bentonite type clays, 10 are preferably converted to the sodium form if they are not already in this form. This can conveniently be done by preparing an aqueous clay slurry and passing the slurry through a bed of cation exchange resin in the sodium form. Alternatively, the clay can be 15 mixed with water and a soluble sodium compound such as sodium carbonate and sodium hydroxide followed by shearing the mixture with a pugmill or extruder.

The cation exchange capacity of the smectite-type clays can be determined by the ammonium acetate 20 method.

The clay is preferably dispersed in water at a concentration from 1 to 80% and preferably from 2% to 20%, and more preferably from 2% to 7%. The slurry is agitated prior to reaction.

25 The organic cation compounds of the invention were prepared by standard prior art methods starting with an amine having the desired number of long chain alkyl groups bonded to the nitrogen atom. This long chain alkyl amine was then reacted by reductive 30 alkylation with an aldehyde and/or by nucleophilic displacement of an alkyl halide to form the desired quaternary ammonium compound.

The organophilic clay gellants of the invention are useful as gellants for oil base fluids, such as drilling fluids or packer fluids. Such oil-base fluids are disclosed and claimed in our copending patent application No. 8502403 published under the serial No. 2,152,109 .

The smectite-type clays used in the Examples were hectorite and Wyoming bentonite. The clay was slurried in water and centrifuged to remove essentially all of the non-clay impurities which may amount to 10% to about 50% of the starting clay composition. The Wyoming bentonite clay slurry was passed through a bed of cation exchange resin to convert it to the sodium form.

Examples 1 to 4 demonstrate the preparation of various organic cationic compounds which compounds may be used as reactants with an organoclay to form the organophilic clay reaction products of this invention.

The organic cationic compounds exemplified are representative of the cations of the invention and are not intended to be inclusive of only operative compounds.

The following examples are given to illustrate the invention, but are not deemed to be limiting thereof. All percentage given are based upon weight unless otherwise indicated. Plastic viscosity, yield point, and ten second gels were measured by the procedure described in API RP13B, American Petroleum Institutes Standard Procedure for Testing Fluids, 6th Ed., April 1976. Barrels (bbl) and gallons are U.S. measures.

Example 1

Allyl methyl di(hydrogenated-tallow)ammonium chloride (AM2HT).

824.7 g methyl di(hydrogenated-tallow)amine, 350 ml isopropyl alcohol, 250 g NaHCO_3 , 191.3 gm. allyl

chloride, and 10 gm. allyl bromide (as a catalyst) were mixed in a 4-liter reaction vessel equipped with a condenser. 5 The mixture was heated and allowed to reflux. A sample was removed, filtered, and titrated with HCl and NaOH. The reaction was considered complete as there was 0.0% amine HCl and 1.8% amine. The final analysis of the AM2HT showed an effective gram molecular weight of 831.17.

10

Example 2

A 3% clay slurry (sodium form of Wyoming bentonite) was heated to 60°C with stirring. 4.8637g (M.E. Ratio - 22.5) of an organic anionic compound, sodium benzoate (M.W. 144.11) was dissolved in water. The organic anion solution 15 was added to the clay slurry and reacted for 10 minutes at 60°C. 136.89 g (M.E. ratio - 122.5) ethanol methyl di (hydrogenated-tallow) ammonium chloride [EM2HT] (M.W. 745) (Armak Co., Division of Akzona Corp.) is dissolved in a 50% 2-propanol aqueous solution. The cation solution was 20 added and stirred for 45 minutes at 60°C. The organoclay (EM2HT/benzoate/bentonite) was collected on a vacuum filter. The filter cake was washed with hot water and dried at 60°C. The dried organoclay was ground using a hammer mill to reduce the particle size and then sieved through a U.S. 25 Standard 200 mesh screen.

Example 3

A 3% clay slurry (sodium form of Wyoming bentonite) was heated to 60°C. with stirring. 7.83g (M.E. Ratio - 22.5) of an organic anionic compound, p-Phenolsulfonic acid 30 sodium salt (M.W. 232.19) was dissolved in water. The organic anion solution was added to the clay slurry and reacted for 10 minutes at 60°C. 134.42g (M.E. ratio - 122.5) benzyl methyl di(hydrogenated-tallow) ammonium chloride BM2HT was dissolved in a 50% 2-propanol aqueous 35 solution. The cation solution was added and stirred for 45 minutes at 60°C. The organoclay (BM2HT/p-phenolsulfonate/bentonite) was collected on a vacuum filter. The filter cake was washed with hot water and dried at 60°C. The dried organo- 40 clay is ground using a hammer mill to reduce the particle size and then sieved through a U.S. Standard 200 mesh screen.

Example 4

A 3% clay slurry (sodium form of Wyoming bentonite) was heated to 60°C. with stirring. 5.40g (M.E. Ratio - 22.5) of an organic anionic compound, sodium salt of salicylic acid (M.W. 160.11) was dissolved in water. The organic anion solution was added to the clay slurry and reacted for 10 minutes at 60°C. 134.72g (M.E. ratio - 122.5) of AM2HT prepared in Example 1 is dissolved in a 50% 2-propanol aqueous solution. The cation solution was added and stirred for 45 minutes at 60°C. The organoclay (AM2HT/salicylate/bentonite) was collected on a vacuum filter. The filter cake was washed with hot water and dried at 60°C. The dried organoclay was ground using a hammer mill to reduce the particle size and then sieved through a U.S. Standard 200 mesh screen.

Examples 5-9

0.63 bbl (100 dm³) of diesel oil, 8 pounds (3.6 kg) emulsifier (Invermul, NL Industries, Inc.), 8 pounds (3.6 kg) filtration control, amine lignite (Duraton HT, NL Industries, Inc.), 4 pounds (1.8 kg) lime, and 0.11 bbl. (17.5 dm³) of water was stirred for 20 minutes.

22 pounds (10 kg) of calcium chloride, 325 pounds (147.5 kg) of barite (Baroid/NL Industries, Inc.) and 5 pounds (2.3 kg) of the three bentonite clay thickeners prepared in Examples 2-4 in addition to commercial products dimethyl di(hydrogenated-tallow) ammonium chloride (2M2HT)/bentonite and benzyl methyl di(hydrogenated-tallow) ammonium chloride (BM2HT)/bentonite.

The mixed fluid was tested at 95°F. (35°C) for standard rheology data and the results are shown in Table 2. None of the Examples settled following stirring:

Table 2

Example NO.	Gellant Compound	Yield Point #/	10 sec. Gel #/	10 min. Gel #/
		100ft ² (9.3m ²)	100ft ² (9.3m ²)	100ft ² (9.3m ²)
5	EM2HT/benzoate/ bentonite	16	8	12
6	BM2HT/p-phenolsulfonate/ bentonite	24	14	16
7	AM2HT/salicylate/ bentonite	18	10	14
8	2M2HT/bentonite	30	16	19
9	BM2HT/bentonite	24	14	18

The unstirred batches of Examples 5-9 were rolled at 150°F(66°C) for 16 hours and no settling was noted in any Example. The fluid was stirred for 25 minutes and tested at 88°F(31°C) for standard rheology data as in Example 5. The results are shown in Table 3 below. None of the Example settled following stirring.

Table 3

Example No.	Yield Point #/	10 sec. Gel #/	10 min. Gel #/
	$100\text{ft}^2(9.3\text{m}^2)$	$100\text{ft}^2(9.3\text{m}^2)$	$100\text{ft}^2(9.3\text{m}^2)$
5	14	7	10
6	22	14	17
7	16	11	13
8	20	13	18
9	21	14	19

10

Examples 10 to 14

350 ml. batches of fluid consisting of 0.60 bbl (95.4 dm^3) diesel oil, 8 pounds (3.6 kg) emulsifier (Invermul, NL Industries, Inc.), 8 pounds (3.6 kg) amine lignite filtration control (Duratone, NL Industries, Inc.), 5 pounds (1.8 kg) lime, 0.20 bbl (31.8 dm^3) of 11.0 ppg calcium chloride, and 320 pounds (145.3 kg) of barite (Baroid, NL Industries, Inc.) were admixed, stirred for 15 minutes in a Hamilton Beach mixer and cooled to 28°F (-2°C) in an ice bath. A 6lb/bbl (17.1 g/dm^3) concentration of gellants EM2HT/benzoate/bentonite, BM2HT/p-phenolsulfonate/bentonite and AM2HT/salicylate/bentonite produced in Example 2-4 in over a 5 minute period at low shear with a Lightning mixer. The cold examples in a viscometer cup, were placed on a Fann 35 viscometer and stirred at 600 rpm while the temperature rose to 70°F (21°C). The batches were then placed in a preheated cup jackets set at 125°F (52°C) and allowed to heat to 110°F (43°C). The plastic viscosity, yield point and 10-sec gel were measured at every 5°F (2.8°C) increment from 30 to 70°F (-1° to 21°C) and at every 10°F (5.6°C) increment from 70 to 110°F (21° - 43°C). The results of the measurements are presented in Figure 1.

Examples 10 to 14 at 115°F (46°C) were stirred for 15 minutes in a Hamilton Beach mixer and cooled to 80°F (27°C) and tested as with Example 5. The results are presented in Table

4 below.

Table 4

5	Example No.	Gellant Compound	Yield	10 sec.	10 min.
			Point #/	Gel #/	Gel #/
			100ft ² (9.3m ²)	100ft ² (9.3m ²)	100ft ² (9.3m ²)
	10	EM2HT/benzoate/ bentonite	40	17	20
	11	BM2HT/p-phenolsulfonate/51 bentonite		27	29
10	12	AM2HT/salicylate/ bentonite	54	23	30
	13	2M2HT/bentonite	50	21	26
	14	BM2HT/bentonite	50	23	28

15

Examples 15 to 19

Batches of fluids consisting of 0.41 bbl (65.2 dm³) of diesel oil and 12 pounds (5.4 kg) of gellant clays prepared in Examples 2, 3, 4 and 5 in addition to 2M2HT/bentonite and BM2HT/Bentonite which were prepared without anionic reactants were admixed and stirred for five minutes in a Hamilton Beach mixer at low speed. 0.41 bbl(65.2 dm³) of diesel oil, 18 pounds (8.2 kg) asphalt (Baroid Asphalt, NL Industries, Inc.) and 0.275 pounds (125 g) of barite, (Baroid, NL Industries, Inc.) were admixed with the prepared batches above and stirred for 15 minutes in a Hamilton Beach mixer.

350 ml samples of Examples 15 to 24 were tested for rheological properties as in Example 5 at 93°F(34°C).

The results are presented in Table 5 below.

Table 5

5	Example No.	Gellant Compound	Yield Point	10 sec. Gel	10 min. Gel
			#/ 100ft ² (9.3m ²)	#/ 100ft ² (9.3m ²)	#/ 100ft ² (9.3m ²)
	15	EM2HT/benzoate/ bentonite	15	7	27
	16	BM2HT/p-phenolsulf-			
10		onate/bentonite	17	7	31
	17	AM2HT/salicylate/ bentonite	15	4	11
	18	2M2HT/bentonite	54	34	74
	19	BM2HT/bentonite	25	11	40

15 350 ml samples of Example 15 through 19 were hot rolled at 150°F (66°C) for 16 hours. After cooling the batches to 80°F (27°C), settling of solids were checked prior to measurement of rheological properties as in Example 5 at 93°F (34°C). The results are shown in Table 6 below.

Table 6

20	Example No.	Gellant Compound	Yield Point	10 sec. Gel	10 min. Gel
			#/ 100ft ² (9.3m ²)	#/ 100ft ² (9.3m ²)	#/ 100ft ² (9.3m ²)
25	15	EM2HT/sodium/ benzoate/bentonite	37	10	40
	16	BM2HT/p-phenolsulfon/ ate/bentonite	37	13	55
	17	AM2HT/salicylate/ bentonite	52	17	78
30	18	2M2HT/bentonite	91	55	100
	19	BM2HT/bentonite	69	39	108

Mud cake and filtrates were stirred back into the respective samples and the batches were aged for 16 hours at 350°F (177°C).

- 5 Each batch was cooled to 80°F (27°C) and checked for solids settling. The batches were stirred for 5 minutes and tested as with Example 5. The results are shown in Table 7 below.

Table 7

10	Example No.	Gellant Compound	Yield Point	10 sec. Gel	10 min. Gel
			#/ 100ft ² (9.3m ²)	#/ 100ft ² (9.3m ²)	#/ 100ft ² (9.3m ²)
	15	EM2HT/benzoate/bentonite	68	10	34
15	16	BM2HT/p-phenolsulfonate/bentonite	70	14	51
	17	AM2HT/salicylate/bentonite	62	15	30
	18	2M2HT/bentonite	120	45	82
20	19	BM2HT/bentonite	99	41	78

Examples 20 to 24

- 350 ml. batches of fluids consisting of 0.69 bbl (109.7 dm³) of diesel oil, 6 pounds (2.7 kg) emulsifier (EZ mul, NL Industries, Inc.), 0.12 bbl (19 dm³) of water, 225 pounds (102.2 kg) of barite (Baroid, NL Industries, Inc.), 24 pounds of (10.9 kg) of calcium chloride and 6 pounds (2.7 kg) of gellant clays EM2HT/benzoate/bentonite, BM2HT/p-phenolsulfonate/bentonite and AM2HT/salicylate/bentonite prepared in Examples 2-4 respectively in addition to 2M2HT/bentonite and BM2HT/bentonite described in Example 5 were admixed and stirred for 20 minutes in a Hamilton Beach mixer.

350 ml. batches of Examples 20 through 24 were tested at 88°F (31°C) for rheological properties as in Example 5. The results are presented in Table 8 below.

TABLE 8

Example No.	Gellant Compound	Yield Point #/	10 sec. Gel #/	10 min. Gel #/
		$100\text{ft}^2(9.3\text{m}^2)$	$100\text{ft}^2(9.3\text{m}^2)$	$100\text{ft}^2(9.3\text{m}^2)$
5	20 EM2HT/benzoate/ bentonite	9	4	6
	21 BM2HT/p-phenolsulfon/ ate/bentonite	8	4	6
	22 AM2HT/salicylate/ bentonite	9	4	5
	23 2M2HT/bentonite	9	5	6
	24 BM2HT/bentonite	8	4	5

350 ml sample of Example 20 through 24 were hot rolled at 150°F (66°C) for 16 hours. After cooling the batches to 80°F, (27°C) settling of solids was checked prior to measurement of rheological properties as in Example 5 at 84°F (29°C). The results are shown in Table 9 below.

Example No.	Yield Point #/	Table 9	
		10 sec. Gel #/	10 min. Gel #/
	$100\text{ft}^2(9.3\text{m}^2)$	$100\text{ft}^2(9.3\text{m}^2)$	$100\text{ft}^2(9.3\text{m}^2)$
20	9	5	5
21	9	5	7
25	22 10	5	8
	23 15	8	14
	24 9	4	5

Mud cake and filtrate were stirred back into the respective samples and the batches were aged for 16 hours at 350°F (177°C).

Each batch was cooled to 80°F (27°C) and checked for solids settling. The batches were stirred for 5 minutes and tested as with Example 5. HT-HP filtrates were conducted on each batch at 350°F (177°C). The results are shown in Table 10 below.

Table 10

Example No.	Yield Point / 100ft ² (9.3m ²)	10 sec. Gel / 100ft ² (9.3m ²)	10 min. Gel / 100ft ² (9.3m ²)
5	20	10	5
	21	6	5
	22	9	5
	23	12	6
	24	8	5

10

Example 25-29

350 ml. batches of a fluid consisting of 0.63 bbl (100.2 dm³) of diesel oil, 8 pounds (3.6 kg) emulsifier (Invermul, NL Industries, Inc.), 0.11 bbl (17.5 dm³) of water, 325 pounds (147.5 kg) of barite (Baroid, NL Industries, Inc.), 8 pounds (3.6 kg) filtration aid (Duratone - NL Industries, Inc.), 22 pounds (10 kg) of calcium chloride, 4 pounds (1.8 kg) lime and 9 pounds (4 kg) of gellant clays, EM2HT/benzoate/bentonite, BM2HT/p-phenolsulfonate/bentonite, and AM2HT/salicylate/bentonite prepared in Examples 2-4 respectively, commercial clays 2M2HT/bentonite, BM2HT/bentonite described in Example 5 above and an additional commercial clay.

350 ml samples of Examples 25 through 29 were tested at 92°F (33°C) for rheological properties as in Example 5. The results are presented in Table 11.

Table 11

Example No.	Gellant Composition	Yield Point	10 sec. Gel	10 min. Gel
		# / 100ft ² (9.3m ²)	# / 100ft ² (9.3m ²)	# / 100ft ² (9.3m ²)
5	25 EM2HT/sodium benzoate bentonite	40	14	18
	26 BM2HT/p-phenol sulfonic bentonite	55	28	33
	27 AM2HT/salicylic acid bentonite	43	18	20
	28 2M2HT/bentonite	60	22	33
	29 BM2HT/bentonite	51	24	28

The batches were aged for 16 hours at 300°F (149°C) cooled to 80°F (27°C), checked for solids settling. The batches were stirred for 10 minutes and tested as with Example 5 at 90°F (32°C). The results are shown in Table 12 below.

Table 12

Example No.	Yield Point	10 sec. Gel	10 min. Gel
	# / 100ft ² (9.3m ²)	# / 100ft ² (9.3m ²)	# / 100ft ² (9.3m ²)
25	32	18	23
26	29	23	28
25 27	27	20	26
28	34	18	26
29	26	24	29

It will be obvious to one skilled in the art that the invention may be varied in many ways. Such variations are not to be regarded as a departure from the scope of the invention and all such modifications are intended to be included within the

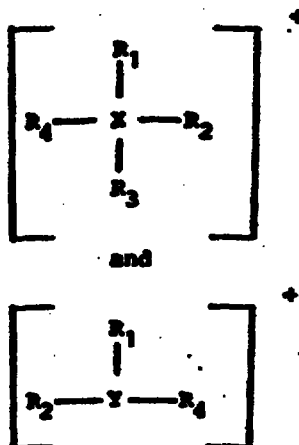
5 scope of the following claims.



- 27 -

CLAIMS

1. An organophilic clay gellant comprising the reaction product of an organic cationic compound, an organic anion and a smectite-type clay having a cation exchange capacity of at least 75 milliequivalents per 100 grams of said clay such that an organic cation-organic anion complex is intercalated with the smectite-type clay and the cation exchange sites of the smectite-type clay are substituted with the organic cation, wherein the organic cation is selected from



wherein X is nitrogen or phosphorus, Y is sulfur; R_1 is an alkyl group containing 8 to 60 carbon atoms; and R_2 , R_3 and R_4 are selected independently from hydrogen, a hydroxyalkyl group having 2 to 6 carbon atoms, alkyl groups containing 1 to 22 carbon atoms, aryl groups, aralkyl groups containing 1 to 22 carbon atoms on the alkyl chain, and mixtures thereof.

2. A gellant according to claim 1, wherein R_1 is a long chain alkyl group having 12 to 60 carbon atoms.
3. A gellant according to claim 2, wherein R_1 has from 12 to 22 carbon atoms.
4. A gellant according to claim 3, wherein R_1 is a fatty acid group.



(JW)

-28-

5. A gellant according to any one of claims 1 to 4, wherein R_2 is selected from a β, γ -unsaturated alkyl group having less than 7 aliphatic carbon atoms, a hydroxyalkyl group having 2 to 6 carbon atoms, an aralkyl group containing 1 to 22 carbon atoms in the alkyl chain and mixtures thereof.
6. A gellant according to any one of claims 1 to 4, wherein R_2 is selected from a β, γ -unsaturated cyclic alkyl group, a β, γ -unsaturated acyclic alkyl group having less than 7 carbon atoms, an acyclic β, γ -unsaturated alkyl group substituted with aromatic groups, an aromatic β, γ -unsaturated group substituted with aliphatic groups and mixtures thereof.
7. A gellant according to any one of claims 1 to 4, wherein R_2 is a hydroxyalkyl group selected from cyclic groups, acyclic groups and mixtures thereof, and the hydroxyl substitution is on C_2 to C_6 .
8. A gellant according to any one of claims 1 to 7, wherein R_3 and R_4 are individually selected from a β, γ -unsaturated alkyl group having less than 7 aliphatic carbon atoms, a hydroxyalkyl group having 2 to 6 carbon atoms, an aralkyl group, containing 1-22 carbon atoms in the alkyl chain thereof, an alkyl group having from 1 to 22 carbon atoms and mixtures thereof.
9. A gellant according to any one of claims 1 to 8, wherein the amount of said organic anion is from 5 to 100 milliequivalents per 100 g of said clay, 100% active clay basis.
10. A gellant according to any one of claims 1 to 9, wherein the amount of said organic cation is sufficient to satisfy the cation exchange capacity of the smectite-type clay and the cationic exchange capacity of the organic anion.

(4)



-29-

11. A gellant according to claim 10, wherein the amount of said organic cation is from 100 to 130 milliequivalents per 100 grams of said clay, 100% active clay basis.
 12. A gellant according to any one of claims 1 to 11, wherein the smectite-type clay is selected from hectorite, bentonite and mixtures thereof.
-