

POLYAMIDE-BASED MICROCAPSULES

Technical Field

5 The present invention relates to a new process for the preparation of polyamide-based microcapsules. Polyamide-based microcapsules are also an object of the invention. Perfuming compositions and consumer products comprising said microcapsules, in particular perfumed consumer products in the form of home care or personal care products, are also part of the invention.

10 Background of the Invention

One of the problems faced by the perfumery industry lies in the relatively rapid loss of olfactive benefit provided by odoriferous compounds due to their volatility, particularly that of “top-notes”. In order to tailor the release rates of volatiles, delivery systems such as microcapsules containing a perfume are needed to protect and later release the core payload when triggered. A key requirement from the industry regarding these systems is to survive suspension in challenging bases without physically dissociating or degrading. This is referred to as *stability* for the delivery system. For instance, fragranced personal and household cleansers containing high levels of aggressive surfactant detergents are very challenging for the stability of microcapsules.

15 Polyurea and polyurethane-based microcapsule slurry are widely used for example in perfumery industry for instance as they provide a long lasting pleasant olfactory effect after their applications on different substrates. Those microcapsules have been widely disclosed in the prior art.

In addition to the performance in terms of stability and olfactive performance, the consumer demand for eco-friendly delivery systems is more and more important and is driving the development of new delivery systems.

25 There is therefore still a need to provide new microcapsules using more eco-friendly materials, while not compromising on the performance of the microcapsules, in particular in terms of stability in a challenging medium such as a consumer product base, as well as in delivering a good performance in terms of active ingredient delivery, e.g. olfactive performance in the case of perfuming ingredients.

The present invention is proposing a solution to the above-mentioned problem by providing new polyamide-based microcapsules and a process for preparing said microcapsules.

Summary of the Invention

- 5 It has now been surprisingly found that performing core-shell microcapsules encapsulating hydrophobic material could be obtained by reacting an acyl chloride with at least one amino-compound, optionally in the presence of a carbohydrate. The process of the invention therefore provides a solution to the above-mentioned problems as it allows preparing microcapsules with the desired stability in challenging bases.
- 10 In a first aspect, the present invention relates to a process for preparing a polyamide-based core-shell microcapsule slurry comprising the following steps:
- a) Dissolving at least one acyl chloride in a hydrophobic material, preferably a perfume to form an oil phase;
 - b) Dispersing the oil phase obtained in step a) into a dispersing phase to form a two-phases
15 dispersion;
 - c) Performing a curing step to form polyamide-based microcapsules in the form of a slurry; wherein at least one amino-compound A chosen in the group consisting of ethylene amine having a functionality greater than 3, an aminosilane, a polyethylenimine, an amino-acid and mixtures thereof, is added in the dispersing phase before the formation of the two-phases
20 dispersion and/or in the two-phases dispersion obtained after step b).

In a second aspect, the present invention relates to a polyamide-based core-shell microcapsule slurry obtainable by the process as defined above.

- A third object of the invention is a polyamide-based core-shell microcapsule or a polyamide-
25 based core-shell microcapsule slurry comprising at least one microcapsule, the microcapsule comprising:
- a core, preferably an oil-based core, comprising a hydrophobic material, preferably a perfume, and
 - a polyamide-based shell comprising the reaction product of:
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 - an acyl chloride,

- an amino compound A chosen in the group consisting of ethylene amine having a functionality greater than 3, an aminosilane, a polyethylenimine, an amino-acid and mixtures,
- optionally a carbohydrate,
- 5 • optionally an amino compound B, and
- optionally a polymer, preferably a protein.

A perfuming composition comprising:

- (i) microcapsule or microcapsule slurry as defined above, wherein the hydrophobic material
10 comprises a perfume,
 - (ii) at least one ingredient selected from the group consisting of a perfumery carrier and a perfumery base
 - (iii) optionally at least one perfumery adjuvant
- is another object of the invention.

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Another object of the invention is a consumer product comprising:

- a personal care active base, and
- microcapsules or microcapsule slurry as defined above or the perfuming composition as defined above,
- 20 wherein the consumer product is in the form of a personal care composition.

Another object of the invention is a consumer product comprising:

- a home care or a fabric care active base, and
 - microcapsules or microcapsule slurry as defined above or the perfuming composition as
25 defined above,
- wherein the consumer product is in the form of a home care or a fabric care composition.

Detailed description of the invention

Unless stated otherwise, percentages (%) are meant to designate a percentage by weight of
30 a composition.

By “**active ingredient**”, it is meant a single compound or a combination of ingredients.

By “**perfume or flavour oil**”, it is meant a single perfuming or flavouring compound or a mixture of several perfuming or flavouring compounds.

By “**consumer product**” or “**end-product**” it is meant a manufactured product ready to be distributed, sold and used by a consumer.

5 For the sake of clarity, by the expression “**dispersion**” in the present invention it is meant a system in which particles are dispersed in a continuous phase of a different composition and it specifically includes a suspension or an emulsion.

A “**microcapsule**”, or the similar, in the present invention it is meant that core-shell microcapsules have a particle size distribution in the micron range (e.g. a mean diameter ($d(v, 0.5)$)
10 comprised between about 1 and 3000 microns, preferably between 1 and 500 microns) and comprise an external solid polyamide-based shell and an internal continuous oil phase enclosed by the external shell.

By “**microcapsule slurry**”, it is meant microcapsule(s) that is (are) dispersed in a liquid. According to an embodiment, the slurry is an aqueous slurry, i.e the microcapsule(s) is (are)
15 dispersed in an aqueous phase.

By “**amino-compound**” it should be understood a compound having at least one reactive amine groups.

By “**polyamide-based microcapsules**”, it means that the microcapsule’s shell comprises a polyamide material. The wording “polyamide-based microcapsules” can also encompass a shell
20 made of a composite comprising a polyamide material and another material, for example a polymer (like a protein). The wording “polyamide-based microcapsules” can also encompass a shell made of a composite comprising a polyamide material coming from the reaction between the acyl chloride and the amino-compound and a polyester material coming from the reaction between a carbohydrate (OH functions of the carbohydrate), when present, and the acyl chloride.
25 “Polyamide-based microcapsules” and “polyamide microcapsules” are used indifferently in the present invention.

It has been found that core-shell polyamide-based microcapsules with overall good performance in challenging bases could be obtained when an acyl chloride reacts with at least one amino-compound with optionally the presence of a carbohydrate during the process.

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PROCESS FOR PREPARING A POLYAMIDE-BASED MICROCAPSULE SLURRY

In a first aspect, the present invention relates to a process for preparing a polyamide-based core-shell microcapsule slurry comprising the following steps:

- 5 a) Dissolving at least one acyl chloride in a hydrophobic material, preferably a perfume to form an oil phase;
- b) Dispersing the oil phase obtained in step a) into a dispersing phase to form a two-phases dispersion;
- c) Performing a curing step to form polyamide-based microcapsules in the form of a slurry; wherein at least one amino-compound A chosen in the group consisting of ethylene amine
10 having a functionality greater than 3, an aminosilane, a polyethylenimine, an amino-acid and mixtures thereof, is added in the dispersing phase before the formation of the two-phases dispersion and/or in the two-phases dispersion obtained after step b).

According to a particular embodiment, a carbohydrate is added in the oil phase and/or in the
15 dispersing phase.

According to an embodiment, the dispersing phase comprises, preferably consists of water.

According to an embodiment, the dispersing phase is a water phase.

According to an embodiment, the two-phases dispersion is an oil-in-water emulsion.

According to an embodiment, the dispersing phase comprises water and an alcohol such as
20 glycerol, 1,4-butanediol, ethylene glycol, and mixtures thereof.

In one step of the process, an oil phase is formed by admixing at least one hydrophobic material with at least one acyl chloride.

25 **Hydrophobic material**

The hydrophobic material according to the invention can be “inert” material like solvents or active ingredients. The core is preferably an oil-based core.

By “hydrophobic material”, it is meant any hydrophobic material which forms a two-phase dispersion when mixed with water. The hydrophobic material is typically liquid at about 20°C.

30 According to an embodiment, the hydrophobic material is a hydrophobic active ingredient.

According to a particular embodiment, the hydrophobic material comprises a phase change material (PCM).

When hydrophobic materials are active ingredients, they are preferably chosen from the group consisting of flavors, flavor ingredients, perfumes, perfume ingredients, nutraceuticals, cosmetics, pest control agents, biocide actives and mixtures thereof.

According to a particular embodiment, the hydrophobic material comprises a mixture of a perfume with another ingredient selected from the group consisting of nutraceuticals, cosmetics, pest control agents and biocide actives.

According to a particular embodiment, the hydrophobic material comprises a mixture of biocide actives with another ingredient selected from the group consisting of perfumes, nutraceuticals, cosmetics, pest control agents.

According to a particular embodiment, the hydrophobic material comprises a mixture of pest control agents with another ingredient selected from the group consisting of perfumes, nutraceuticals, cosmetics, biocide actives.

According to a particular embodiment, the hydrophobic material comprises a perfume.

According to a particular embodiment, the hydrophobic material consists of a perfume.

According to a particular embodiment, the hydrophobic material consists of biocide actives.

According to a particular embodiment, the hydrophobic material consists of pest control agents.

By “perfume” (or also “perfume oil”) what is meant here is an ingredient or a composition that is a liquid at about 20°C. According to any one of the above embodiments said perfume oil can be a perfuming ingredient alone or a mixture of ingredients in the form of a perfuming composition. As a “perfuming ingredient” it is meant here a compound, which is used for the primary purpose of conferring or modulating an odor. In other words such an ingredient, to be considered as being a perfuming one, must be recognized by a person skilled in the art as being able to at least impart or modify in a positive or pleasant way the odor of a composition, and not just as having an odor. For the purpose of the present invention, perfume oil also includes a combination of perfuming ingredients with substances which together improve, enhance or modify the delivery of the perfuming ingredients, such as perfume precursors, emulsions or dispersions, as well as combinations which impart an additional benefit beyond that of modifying or imparting

an odor, such as long-lastingness, blooming, malodor counteraction, antimicrobial effect, microbial stability, pest control.

The nature and type of the perfuming ingredients present in the oil phase do not warrant a more detailed description here, which in any case would not be exhaustive, the skilled person being able to select them on the basis of its general knowledge and according to intended use or application and the desired organoleptic effect. In general terms, these perfuming ingredients belong to chemical classes as varied as alcohols, aldehydes, ketones, esters, ethers, acetates, nitriles, terpenoids, nitrogenous or sulfurous heterocyclic compounds and essential oils, and said perfuming co-ingredients can be of natural or synthetic origin. Many of these co-ingredients are in any case listed in reference texts such as the book by S. Arctander, *Perfume and Flavor Chemicals*, 1969, Montclair, New Jersey, USA, or its more recent versions, or in other works of a similar nature, as well as in the abundant patent literature in the field of perfumery.

In particular one may cite perfuming ingredients which are commonly used in perfume formulations, such as:

Aldehydic ingredients: decanal, dodecanal, 2-methyl-undecanal, 10-undecenal, octanal, nonanal and/or nonenal;

Aromatic-herbal ingredients: eucalyptus oil, camphor, eucalyptol, 5-methyltricyclo[6.2.1.0~2,7~]undecan-4-one, 1-methoxy-3-hexanethiol, 2-ethyl-4,4-dimethyl-1,3-oxathiane, 2,2,7/8,9/10-Tetramethylspiro[5.5]undec-8-en-1-one, menthol and/or alpha-pinene;

Balsamic ingredients: coumarin, ethylvanillin and/or vanillin;

Citrus ingredients: dihydromyrcenol, citral, orange oil, linalyl acetate, citronellyl nitrile, orange terpenes, limonene, 1-p-menthen-8-yl acetate and/or 1,4(8)-p-menthadiene;

Floral ingredients: methyl dihydrojasmonate, linalool, citronellol, phenylethanol, 3-(4-tert-butylphenyl)-2-methylpropanal, hexylcinnamic aldehyde, benzyl acetate, benzyl salicylate, tetrahydro-2-isobutyl-4-methyl-4(2H)-pyranol, beta ionone, methyl 2-(methylamino)benzoate, (E)-3-methyl-4-(2,6,6-trimethyl-2-cyclohexen-1-yl)-3-buten-2-one, (1E)-1-(2,6,6-trimethyl-2-cyclohexen-1-yl)-1-penten-3-one, 1-(2,6,6-trimethyl-1,3-cyclohexadien-1-yl)-2-buten-1-one, (2E)-1-(2,6,6-trimethyl-2-cyclohexen-1-yl)-2-buten-1-one, (2E)-1-[2,6,6-trimethyl-3-cyclohexen-1-yl]-2-buten-1-one, (2E)-1-(2,6,6-trimethyl-1-cyclohexen-1-yl)-2-buten-1-one, 2,5-dimethyl-2-indanmethanol, 2,6,6-trimethyl-3-cyclohexene-1-carboxylate, 3-(4,4-dimethyl-1-cyclohexen-1-yl)propanal, hexyl salicylate, 3,7-dimethyl-1,6-nonadien-3-ol, 3-(4-

isopropylphenyl)-2-methylpropanal, verdyl acetate, geraniol, p-menth-1-en-8-ol, 4-(1,1-dimethylethyl)-1-cyclohexyle acetate, 1,1-dimethyl-2-phenylethyl acetate, 4-cyclohexyl-2-methyl-2-butanol, amyl salicylate, high cis methyl dihydrojasmonate, 3-methyl-5-phenyl-1-pentanol, verdyl propionate, geranyl acetate, tetrahydro linalool, cis-7-p-menthanol, propyl (S)-
 5 2-(1,1-dimethylpropoxy)propanoate, 2-methoxynaphthalene, 2,2,2-trichloro-1-phenylethyl acetate, 4/3-(4-hydroxy-4-methylpentyl)-3-cyclohexene-1-carbaldehyde, amylcinnamic aldehyde, 8-decen-5-olide, 4-phenyl-2-butanone, isononyl acetate, 4-(1,1-dimethylethyl)-1-cyclohexyl acetate, verdyl isobutyrate and/or mixture of methylionones isomers;

Fruity ingredients: gamma-undecalactone, 2,2,5-trimethyl-5-pentylcyclopentanone, 2-
 10 methyl-4-propyl-1,3-oxathiane, 4-decanolide, ethyl 2-methyl-pentanoate, hexyl acetate, ethyl 2-methylbutanoate, gamma-nonolactone, allyl heptanoate, 2-phenoxyethyl isobutyrate, ethyl 2-methyl-1,3-dioxolane-2-acetate, 3-(3,3/1,1-dimethyl-5-indanyl)propanal, diethyl 1,4-cyclohexanedicarboxylate, 3-methyl-2-hexen-1-yl acetate, 1-[3,3-dimethylcyclohexyl]ethyl [3-ethyl-2-oxiranyl]acetate and/or diethyl 1,4-cyclohexane dicarboxylate;

Green ingredients: 2-methyl-3-hexanone (E)-oxime, 2,4-dimethyl-3-cyclohexene-1-carbaldehyde, 2-tert-butyl-1-cyclohexyl acetate, styrallyl acetate, allyl (2-methylbutoxy)acetate, 4-methyl-3-decen-5-ol, diphenyl ether, (Z)-3-hexen-1-ol and/or 1-(5,5-dimethyl-1-cyclohexen-1-yl)-4-penten-1-one;

Musk ingredients: 1,4-dioxo-5,17-cycloheptadecanedione, (Z)-4-cyclopentadecen-1-one,
 20 3-methylcyclopentadecanone, 1-oxa-12-cyclohexadecen-2-one, 1-oxa-13-cyclohexadecen-2-one, (9Z)-9-cycloheptadecen-1-one, 2-{1S}-1-[(1R)-3,3-dimethylcyclohexyl]ethoxy}-2-oxoethyl propionate 3-methyl-5-cyclopentadecen-1-one, 1,3,4,6,7,8-hexahydro-4,6,6,7,8,8-hexamethylcyclopenta-g-2-benzopyrane, (1S,1'R)-2-[1-(3',3'-dimethyl-1'-cyclohexyl)ethoxy]-2-methylpropyl propanoate, oxacyclohexadecan-2-one and/or (1S,1'R)-[1-(3',3'-dimethyl-1'-
 25 cyclohexyl)ethoxycarbonyl]methyl propanoate, ;

Woody ingredients: 1-[(1R,6SR)-2,2,6-trimethylcyclohexyl]-3-hexanol, 3,3-dimethyl-5-[(1R)-2,2,3-trimethyl-3-cyclopenten-1-yl]-4-penten-2-ol, 3,4'-dimethylspiro[oxirane-2,9'-tricyclo[6.2.1.0^{2,7}]undec[4]ene, (1-ethoxyethoxy)cyclododecane, 2,2,9,11-tetramethylspiro[5.5]undec-8-en-1-yl acetate, 1-(octahydro-2,3,8,8-tetramethyl-2-naphthalenyl)-1-
 30 ethanone, patchouli oil, terpenes fractions of patchouli oil, clearwood®, (1'R,E)-2-ethyl-4-(2',2',3'-trimethyl-3'-cyclopenten-1'-yl)-2-buten-1-ol, 2-ethyl-4-(2,2,3-trimethyl-3-cyclopenten-1-

yl)-2-buten-1-ol, methyl cedryl ketone, 5-(2,2,3-trimethyl-3-cyclopentenyl)-3-methylpentan-2-ol, 1-(2,3,8,8-tetramethyl-1,2,3,4,6,7,8,8a-octahydronaphthalen-2-yl)ethan-1-one and/or isobornyl acetate;

Other ingredients (e.g. amber, powdery spicy or watery): dodecahydro-3a,6,6,9a-tetramethyl-naphtho[2,1-b]furan and any of its stereoisomers, heliotropin, anisic aldehyde, eugenol, cinnamic aldehyde, clove oil, 3-(1,3-benzodioxol-5-yl)-2-methylpropanal, 7-methyl-2H-1,5-benzodioxepin-3(4H)-one, 2,5,5-trimethyl-1,2,3,4,4a,5,6,7-octahydro-2-naphthalenol, 1-phenylvinyl acetate, 6-methyl-7-oxa-1-thia-4-azaspiro[4.4]nonan and/or 3-(3-isopropyl-1-phenyl)butanal.

It is also understood that said ingredients may also be compounds known to release in a controlled manner various types of perfuming compounds also known as properfume or profragrance. Non-limiting examples of suitable properfumes may include 4-(dodecylthio)-4-(2,6,6-trimethyl-2-cyclohexen-1-yl)-2-butanone, 4-(dodecylthio)-4-(2,6,6-trimethyl-1-cyclohexen-1-yl)-2-butanone, 3-(dodecylthio)-1-(2,6,6-trimethyl-3-cyclohexen-1-yl)-1-butanone, 2-(dodecylthio)octan-4-one, 2-phenylethyl oxo(phenyl)acetate, 3,7-dimethylocta-2,6-dien-1-yl oxo(phenyl)acetate, (Z)-hex-3-en-1-yl oxo(phenyl)acetate, 3,7-dimethyl-2,6-octadien-1-yl hexadecanoate, bis(3,7-dimethylocta-2,6-dien-1-yl) succinate, (2-((2-methylundec-1-en-1-yl)oxy)ethyl)benzene, 1-methoxy-4-(3-methyl-4-phenethoxybut-3-en-1-yl)benzene, (3-methyl-4-phenethoxybut-3-en-1-yl)benzene, 1-(((Z)-hex-3-en-1-yl)oxy)-2-methylundec-1-ene, (2-((2-methylundec-1-en-1-yl)oxy)ethoxy)benzene, 2-methyl-1-(octan-3-yloxy)undec-1-ene, 1-methoxy-4-(1-phenethoxyprop-1-en-2-yl)benzene, 1-methyl-4-(1-phenethoxyprop-1-en-2-yl)benzene, 2-(1-phenethoxyprop-1-en-2-yl)naphthalene, (2-phenethoxyvinyl)benzene, 2-(1-((3,7-dimethyloct-6-en-1-yl)oxy)prop-1-en-2-yl)naphthalene, (2-((2-pentylcyclopentylidene)methoxy)ethyl)benzene, 4-allyl-2-methoxy-1-((2-methoxy-2-phenylvinyl)oxy)benzene, (2-((2-heptylcyclopentylidene)methoxy)ethyl)benzene, 1-isopropyl-4-methyl-2-((2-pentylcyclopentylidene)methoxy)benzene, 2-methoxy-1-((2-pentylcyclopentylidene)methoxy)-4-propylbenzene, 3-methoxy-4-((2-methoxy-2-phenylvinyl)oxy)benzaldehyde, 4-((2-(hexyloxy)-2-phenylvinyl)oxy)-3-methoxybenzaldehyde or a mixture thereof.

The perfuming ingredients may be dissolved in a solvent of current use in the perfume industry. The solvent is preferably not an alcohol. Examples of such solvents are diethyl phthalate,

isopropyl myristate, Abalyn® (rosin resins, available from Eastman), benzyl benzoate, ethyl citrate, limonene or other terpenes, or isoparaffins. Preferably, the solvent is very hydrophobic and highly sterically hindered, like for example Abalyn® or benzyl benzoate. Preferably the perfume comprises less than 30% of solvent. More preferably the perfume comprises less than 20% and even more preferably less than 10% of solvent, all these percentages being defined by weight relative to the total weight of the perfume. Most preferably, the perfume is essentially free of solvent.

According to a particular embodiment, the perfume comprises a fragrance modulator (that can be used in addition to the hydrophobic solvent when present or as substitution of the hydrophobic solvent when there is no hydrophobic solvent).

Preferably, the fragrance modulator is defined as a fragrance material with

- a vapor pressure of less than 0.0008 Torr at 22°C;
- a clogP of 3.5 and higher, preferably 4.0 and higher and more preferably 4.5
- at least two Hansen solubility parameters selected from a first group consisting of: an atomic dispersion force from 12 to 20, a dipole moment from 1 to 7, and a hydrogen bonding from 2.5 to 11,
- at least two Hansen solubility parameters selected from a second group consisting of: an atomic dispersion force from 14 to 20, a dipole moment from 1 to 8, and a hydrogen bonding from 4 to 11, when in solution with a compound having a vapor pressure range of 0.0008 to 0.08 Torr at 22°C.

Preferably as examples the following ingredients can be listed as fragrance modulators but the list is not limited to the following materials: alcohol C12, oxacyclohexadec-12/13-en-2-one, 3-[(2',2',3'-trimethyl-3'-cyclopenten-1'-yl)methoxy]-2-butanol, cyclohexadecanone, (Z)-4-cyclopentadecen-1-one, cyclopentadecanone, (8Z)-oxacycloheptadec-8-en-2-one, 2-[5-(tetrahydro-5-methyl-5-vinyl-2-furyl)-tetrahydro-5-methyl-2-furyl]-2-propanol, muguet aldehyde, 1,5,8-trimethyl-13-oxabicyclo[10.1.0]trideca-4,8-diene, (+)-4,6,6,7,8,8-hexamethyl-1,3,4,6,7,8-hexahydrocyclopenta[g]isochromene, (+)-(1S,2S,3S,5R)-2,6,6-trimethylspiro[bicyclo[3.1.1]heptane-3,1'-cyclohexane]-2'-en-4'-one, oxacyclohexadecan-2-one, 2-{(1S)-1-[(1R)-3,3-dimethylcyclohexyl]ethoxy}-2-oxoethyl propionate, (+)-(4R,4aS,6R)-4,4a-dimethyl-6-(1-propen-2-yl)-4,4a,5,6,7,8-hexahydro-2(3H)-naphthalenone, amylcinnamic

aldehyde, hexylcinnamic aldehyde, hexyl salicylate, (1E)-1-(2,6,6-trimethyl-1-cyclohexen-1-yl)-1,6-heptadien-3-one, (9Z)-9-cycloheptadecen-1-one.

According to a particular embodiment, the perfume comprises at least 35% of perfuming ingredients having a log P above 3.

5 LogP is the common logarithm of estimated octanol-water partition coefficient, which is known as a measure of lipophilicity.

The LogP values of many perfuming compound have been reported, for example, in the Pomona92 database, available from Daylight Chemical Information Systems, Inc. (Daylight CIS), Irvine, Calif., which also contains citations to the original literature. LogP values are most
10 conveniently calculated by the "CLOGP" program, also available from Daylight CIS. This program also lists experimental logP values when they are available in the Pomona92 database. The "calculated logP" (cLogP) is determined by the fragment approach of Hansch and Leo (cf., A. Leo, in Comprehensive Medicinal Chemistry, Vol. 4, C. Hansch, P. G. Sammens, J. B. Taylor and C. A. Ramsden, Eds., p. 295, Pergamon Press, 1990). The fragment approach is based on the
15 chemical structure of each perfume oil ingredient, and takes into account the numbers and types of atoms, the atom connectivity, and chemical bonding. The cLogP values, which are the most reliable and widely used estimates for this physicochemical property, are preferably used instead of the experimental LogP values in the selection of perfuming compounds which are useful in the present invention.

20 In a particular embodiment, the perfume oil comprises at least 40 wt.%, preferably at least 50 wt.%, more preferably at least 60 wt.% of ingredients having a logP above 3, preferably above 3.5 and even more preferably above 3.75.

Preferably, the perfume oil contains less than 10 wt.% of its own weight of primary alcohols, less than 15 wt.% of its own weight of secondary alcohols and less than 20% of its own
25 weight of tertiary alcohols. Advantageously, the perfume used in the invention does not contain any primary alcohols and contains less than 15 wt.% of secondary and tertiary alcohols.

According to a particular embodiment, the perfume comprises at least 20 wt.%, preferably at least 25 wt.%, more preferably at least 40 wt.% of Bulky materials of groups 1 to 6, preferably 3 to 6.

The term Bulky materials is herein understood as perfuming ingredients having a high steric hindrance, i.e. having a substitution pattern which provides high steric hindrance and thus the Bulky materials are in particular those from one of the following groups:

- Group 1: perfuming ingredients comprising a cyclohexane, cyclohexene, cyclohexanone or cyclohexenone ring substituted with at least one 1 to 4 nodes comprising substituent, preferably at least one linear or branched C1 to C4 alkyl or alkenyl substituent;
- Group 2: perfuming ingredients comprising a cyclopentane, cyclopentene, cyclopentanone or cyclopentenone ring substituted with at least one 4 or more nodes comprising substituent, preferably at least one linear or branched C4 or longer, preferably C4 to C8 alkyl or alkenyl substituent;
- Group 3: perfuming ingredients comprising a phenyl ring or perfuming ingredients comprising a cyclohexane, cyclohexene, cyclohexanone or cyclohexenone ring substituted with at least one 5 or more nodes comprising substituent, preferably at least one linear or branched C5 or longer, preferably C5 to C8, alkyl or alkenyl substituent, or with at least one phenyl substituent and optionally one or more 1 to 3 nodes comprising substituents, preferably one or more linear or branched C1 to C3 alkyl or alkenyl substituents;
- Group 4: perfuming ingredients comprising at least two fused or linked 5 membered or 6 membered rings, preferably at least two fused or linked C5 and/or C6 rings;
- Group 5: perfuming ingredients comprising a camphor-like ring structure, i.e. two 5 or 6 membered rings that are fused in a bridge-type fashion;
- Group 6: perfuming ingredients comprising at least one 7 to 20 membered ring, preferably at least one C7 or C20 ring structure.

The term nodes as understood in this context means any atom which is able to provide at least two, preferably at least 3, more preferably 4, bonds to further atoms. Particular examples of nodes as herein understood are carbon atoms (up to 4 bonds to further atoms), nitrogen atoms (up to 3 bonds to further atoms), oxygen atoms (up to 2 bonds to further atoms) and sulfur (up to 2 bonds to further atoms). Particular examples of further atoms as understood in this context could be carbon atoms, nitrogen atoms, sulfur atoms, oxygen atoms and hydrogen atoms.

Examples of ingredients from each of these groups are:

- Group 1: 2,4-dimethyl-3-cyclohexene-1-carbaldehyde (origin: Firmenich SA, Geneva, Switzerland), isocyclocitral, menthone, isomenthone, methyl 2,2-dimethyl-6-methylene-

- 1-cyclohexanecarboxylate (origin: Firmenich SA, Geneva, Switzerland), nerone, terpineol, dihydroterpineol, terpenyl acetate, dihydroterpenyl acetate, dipentene, eucalyptol, hexylate, rose oxide, (S)-1,8-p-menthadiene-7-ol (origin: Firmenich SA, Geneva, Switzerland), 1-p-menthene-4-ol, (1R,3R,4SR)-3-p-mentanyl acetate, (1R,2S,4R)-4,6,6-trimethyl-bicyclo[3,1,1]heptan-2-ol, 5 tetrahydro-4-methyl-2-phenyl-2H-pyran (origin: Firmenich SA, Geneva, Switzerland), cyclohexyl acetate, cyclanol acetate, 1,4-cyclohexane diethyldicarboxylate (origin: Firmenich SA, Geneva, Switzerland), (3ARS,6SR,7ASR)-perhydro-3,6-dimethyl-benzo[B]furan-2-one (origin: Firmenich SA, Geneva, Switzerland), ((6R)-perhydro-3,6-dimethyl-benzo[B]furan-2-one (origin: Firmenich SA, Geneva, Switzerland), 2,4,6-trimethyl-4-phenyl-1,3-dioxane, 2,4,6-trimethyl-3-cyclohexene- 10 1-carbaldehyde;
- Group 2: (E)-3-methyl-5-(2,2,3-trimethyl-3-cyclopenten-1-yl)-4-penten-2-ol (origin: Givaudan SA, Vernier, Switzerland), (1'R,E)-2-ethyl-4-(2',2',3'-trimethyl-3'-cyclopenten-1'-yl)-2-buten-1-ol (origin: Firmenich SA, Geneva, Switzerland), (1'R,E)-3,3-dimethyl-5-(2',2',3'-trimethyl-3'-cyclopenten-1'-yl)-4-penten-2-ol (origin: Firmenich SA, Geneva, Switzerland), 2- 15 heptylcyclopentanone, methyl-cis-3-oxo-2-pentyl-1-cyclopentane acetate (origin: Firmenich SA, Geneva, Switzerland), 2,2,5-Trimethyl-5-pentyl-1-cyclopentanone (origin: Firmenich SA, Geneva, Switzerland), 3,3-dimethyl-5-(2,2,3-trimethyl-3-cyclopenten-1-yl)-4-penten-2-ol (origin: Firmenich SA, Geneva, Switzerland), 3-methyl-5-(2,2,3-trimethyl-3-cyclopenten-1-yl)-2-pentanol (origin: Givaudan SA, Vernier, Switzerland);
- Group 3: damascones, 1-(5,5-dimethyl-1-cyclohexen-1-yl)-4-penten-1-one (origin: Firmenich SA, Geneva, Switzerland), nectalactone ((1'R)-2-[2-(4'-methyl-3'-cyclohexen-1'-yl)propyl]cyclopentanone), alpha-ionone, beta-ionone, damascenone, mixture of 1-(5,5-dimethyl-1-cyclohexen-1-yl)-4-penten-1-one and 1-(3,3-dimethyl-1-cyclohexen-1-yl)-4-penten-1-one (origin: Firmenich SA, Geneva, Switzerland), 1-(2,6,6-trimethyl-1-cyclohexen-1-yl)-2-buten-1- 25 one (origin: Firmenich SA, Geneva, Switzerland), (1S,1'R)-[1-(3',3'-Dimethyl-1'-cyclohexyl)ethoxycarbonyl]methyl propanoate (origin: Firmenich SA, Geneva, Switzerland), 2-tert-butyl-1-cyclohexyl acetate (origin: International Flavors and Fragrances, USA), 1-(2,2,3,6-tetramethyl-cyclohexyl)-3-hexanol (origin: Firmenich SA, Geneva, Switzerland), trans-1-(2,2,6-trimethyl-1-cyclohexyl)-3-hexanol (origin: Firmenich SA, Geneva, Switzerland), (E)-3-methyl-4- 30 (2,6,6-trimethyl-2-cyclohexen-1-yl)-3-buten-2-one, terpenyl isobutyrate, 4-(1,1-dimethylethyl)-1-cyclohexyl acetate (origin: Firmenich SA, Geneva, Switzerland), 8-methoxy-1-p-menthene,

(1S,1'R)-2-[1-(3',3'-dimethyl-1'-cyclohexyl) ethoxy]-2-methylpropyl propanoate (origin: Firmenich SA, Geneva, Switzerland), para tert-butylcyclohexanone, menthenethiol, 1-methyl-4-(4-methyl-3-pentenyl)-3-cyclohexene-1-carbaldehyde, allyl cyclohexylpropionate, cyclohexyl salicylate, 2-methoxy-4-methylphenyl methyl carbonate, ethyl 2-methoxy-4-methylphenyl carbonate, 4-ethyl-2-methoxyphenyl methyl carbonate;

- Group 4: Methyl cedryl ketone (origin: International Flavors and Fragrances, USA), a mixture of (1RS,2SR,6RS,7RS,8SR)-tricyclo[5.2.1.0~2,6~]dec-3-en-8-yl 2-methylpropanoate and (1RS,2SR,6RS,7RS,8SR)-tricyclo[5.2.1.0~2,6~]dec-4-en-8-yl 2-methylpropanoate, vetyverol, vetyverone, 1-(octahydro-2,3,8,8-tetramethyl-2-naphthalenyl)-1-ethanone (origin: International Flavors and Fragrances, USA), (5RS,9RS,10SR)-2,6,9,10-tetramethyl-1-oxaspiro[4.5]deca-3,6-diene and the (5RS,9SR,10RS) isomer, 6-ethyl-2,10,10-trimethyl-1-oxaspiro[4.5]deca-3,6-diene, 1,2,3,5,6,7-hexahydro-1,1,2,3,3-pentamethyl-4-indenone (origin: International Flavors and Fragrances, USA), a mixture of 3-(3,3-dimethyl-5-indanyl)propanal and 3-(1,1-dimethyl-5-indanyl)propanal (origin: Firmenich SA, Geneva, Switzerland), 3',4-dimethyl-tricyclo[6.2.1.0(2,7)]undec-4-ene-9-spiro-2'-oxirane (origin: Firmenich SA, Geneva, Switzerland), 9/10-ethyldiene-3-oxatricyclo[6.2.1.0(2,7)]undecane, (perhydro-5,5,8A-trimethyl-2-naphthalenyl acetate (origin: Firmenich SA, Geneva, Switzerland), octalynol, (dodecahydro-3a,6,6,9a-tetramethyl-naphtho[2,1-b]furan, origin: Firmenich SA, Geneva, Switzerland), tricyclo[5.2.1.0(2,6)]dec-3-en-8-yl acetate and tricyclo[5.2.1.0(2,6)]dec-4-en-8-yl acetate as well as tricyclo[5.2.1.0(2,6)]dec-3-en-8-yl propanoate and tricyclo[5.2.1.0(2,6)]dec-4-en-8-yl propanoate, (+)-(1S,2S,3S)-2,6,6-trimethylbicyclo[3.1.1]heptane-3-spiro-2'-cyclohexen-4'-one;

- Group 5: camphor, borneol, isobornyl acetate, 8-isopropyl-6-methylbicyclo[2.2.2]oct-5-ene-2-carbaldehyde, pinene, camphene, 8-methoxycedrane, (8-methoxy-2,6,6,8-tetramethyl-tricyclo[5.3.1.0(1,5)]undecane (origin: Firmenich SA, Geneva, Switzerland), cedrene, cedrenol, cedrol, mixture of 9-ethylidene-3-oxatricyclo[6.2.1.0(2,7)]undecan-4-one and 10-ethylidene-3-oxatricyclo[6.2.1.0(2,7)]undecan-4-one (origin: Firmenich SA, Geneva, Switzerland), 3-methoxy-7,7-dimethyl-10-methylene-bicyclo[4.3.1]decane (origin: Firmenich SA, Geneva, Switzerland);

- Group 6: (trimethyl-13-oxabicyclo-[10.1.0]-trideca-4,8-diene (origin: Firmenich SA, Geneva, Switzerland), Ambrettolide LG ((E)-9-hexadecen-16-olide, origin: Firmenich SA,

Geneva, Switzerland), pentadecenolide (origin: Firmenich SA, Geneva, Switzerland), muscenone (3-methyl-(4/5)-cyclopentadecenone, origin: Firmenich SA, Geneva, Switzerland), 3-methylcyclopentadecanone (origin: Firmenich SA, Geneva, Switzerland), pentadecanolide (origin: Firmenich SA, Geneva, Switzerland), cyclopentadecanone (origin: Firmenich SA, Geneva, Switzerland), 1-ethoxyethoxycyclododecane (origin: Firmenich SA, Geneva, Switzerland), 1,4-dioxacycloheptadecane-5,17-dione, 4,8-cyclododecadien-1-one;

- Group 7: (+-)-2-methyl-3-[4-(2-methyl-2-propanyl)phenyl]propanal (origin: Givaudan SA, Vernier, Switzerland), 2,2,2-trichloro-1-phenylethyl acetate.

Preferably, the perfume comprises at least 30%, preferably at least 50%, more preferably at least 60% of ingredients selected from Groups 1 to 7, as defined above. More preferably said perfume comprises at least 30%, preferably at least 50% of ingredients from Groups 3 to 7, as defined above. Most preferably said perfume comprises at least 30%, preferably at least 50% of ingredients from Groups 3, 4, 6 or 7, as defined above.

According to another preferred embodiment, the perfume comprises at least 30%, preferably at least 50%, more preferably at least 60% of ingredients having a logP above 3, preferably above 3.5 and even more preferably above 3.75.

Preferably, the perfume used in the invention contains less than 10% of its own weight of primary alcohols, less than 15% of its own weight of secondary alcohols and less than 20% of its own weight of tertiary alcohols. Advantageously, the perfume used in the invention does not contain any primary alcohols and contains less than 15% of secondary and tertiary alcohols.

According to an embodiment, the oil phase (or the oil-based core) comprises:

- 25-100wt% of a perfume oil comprising at least 15wt% of high impact perfume raw materials having a Log T<-4, and
- 0-75wt% of a density balancing material having a density greater than 1.07 g/cm³.

According to a particular embodiment, the oil phase (or the oil-based core) comprises:

- 25-98wt% of a perfume oil comprising at least 15wt% of high impact perfume raw materials having a Log T<-4, and
- 2-75wt% of a density balancing material having a density greater than 1.07 g/cm³.

“High impact perfume raw materials” should be understood as perfume raw materials having a LogT<-4. The odor threshold concentration of a chemical compound is determined in part by its shape, polarity, partial charges and molecular mass. For convenience, the threshold

concentration is presented as the common logarithm of the threshold concentration, i.e., Log [Threshold] ("LogT").

5 A "density balancing material" should be understood as a material having a density preferably greater than 1.07 g/cm³ and having preferably low or no odor. According to an embodiment, the density balancing material is chosen in the group consisting of benzyl salicylate, benzyl benzoate, cyclohexyl salicylate, benzyl phenylacetate, phenylethyl phenoxyacetate, triacetin, methyl and ethyl salicylate, benzyl cinnamate, and mixtures thereof.

The density of a component is defined as the ratio between its mass and its volume (g/cm³).

Several methods are available to determine the density of a component.

10 One may refer for example to the ISO 298:1998 method to measure d₂₀ densities of essential oils.

The odor threshold concentration of a perfuming compound is determined by using a gas chromatograph ("GC"). Specifically, the gas chromatograph is calibrated to determine the exact volume of the perfume oil ingredient injected by the syringe, the precise split ratio, and the hydrocarbon response using a hydrocarbon standard of known concentration and chain-length distribution. The air flow rate is accurately measured and, assuming the duration of a human inhalation to last 12 seconds, the sampled volume is calculated. Since the precise concentration at the detector at any point in time is known, the mass per volume inhaled is known and hence the concentration of the perfuming compound. To determine the threshold concentration, solutions are delivered to the sniff port at the back-calculated concentration. A panelist sniffs the GC effluent and identifies the retention time when odor is noticed. The average across all panelists determines the odor threshold concentration of the perfuming compound. The determination of odor threshold is described in more detail in C. Vuilleumier et al., Multidimensional Visualization of Physical and Perceptual Data Leading to a Creative Approach in Fragrance Development, Perfume & Flavorist, Vol. 33, September, 2008, pages 54-61.

25 According to an embodiment, the high impact perfume raw materials having a Log T < -4 are selected from the group consisting of (+)-1-methoxy-3-hexanethiol, 4-(4-hydroxy-1-phenyl)-2-butanone, 2-methoxy-4-(1-propenyl)-1-phenyl acetate, pyrazobutyle, 3-propylphenol, 1-(3-methyl-1-benzofuran-2-yl)ethanone, 2-(3-phenylpropyl)pyridine, 1-(3,3,5,5-dimethyl-1-cyclohexen-1-yl)-4-penten-1-one, 1-(5,5-dimethyl-1-cyclohexen-1-yl)-4-penten-1-one, a mixture comprising (3RS,3aRS,6SR,7ASR)-perhydro-3,6-dimethyl-benzo[b]furan-2-one and

(3SR,3aRS,6SR,7ASR)-perhydro-3,6-dimethyl-benzo[b]furan-2-one, (+-)-1-(5-ethyl-5-methyl-1-cyclohexen-1-yl)-4-penten-1-one, (1'S,3'R)-1-methyl-2-[(1',2',2'-trimethylbicyclo[3.1.0]hex-3'-yl)methyl]cyclopropyl}methanol, (+-)-3-mercaptohexyl acetate, (2E)-1-(2,6,6-trimethyl-1,3-cyclohexadien-1-yl)-2-buten-1-one, H-methyl-2h-1,5-benzodioxepin-3(4H)-one, (2E,6Z)-2,6-nonadien-1-ol, (4Z)-4-dodecenal, (+-)-4-hydroxy-2,5-dimethyl-3(2H)-furanone, methyl 2,4-dihydroxy-3,6-dimethylbenzoate, 3-methylindole, (+-)-perhydro-4alpha,8abeta-dimethyl-4a-naphthalenol, patchoulol, 2-methoxy-4-(1-propenyl)phenol, mixture comprising (+-)-5,6-dihydro-4-methyl-2-phenyl-2H-pyran and tetrahydro-4-methylene-2-phenyl-2H-pyran, mixture comprising 4-methylene-2-phenyltetrahydro-2H-pyran and (+-)-4-methyl-2-phenyl-3,6-dihydro-2H-pyran, 4-hydroxy-3-methoxybenzaldehyde, nonylenic aldehyde, 2-methoxy-4-propylphenol, 3-methyl-5-phenyl-2-pentenitrile, 1-(spiro[4.5]dec-6/7-en-7-yl)-4-penten-1-one, 2-methoxynaphthalene, (-)-(3aR,5AS,9AS,9BR)-3a,6,6,9a-tetramethyldodecahydronaphtho[2,1-b]furan, 5-nonanolide, (3aR,5AS,9AS,9BR)-3a,6,6,9a-tetramethyldodecahydronaphtho[2,1-b]furan, 7-isopropyl-2H,4H-1,5-benzodioxepin-3-one, coumarin, 4-methylphenyl isobutyrate, (2E)-1-(2,6,6-trimethyl-1,3-cyclohexadien-1-yl)-2-buten-1-one, beta,2,2,3-tetramethyl-delta-methylene-3-cyclopentene-1-butanol, delta damascone ((2E)-1-[(1RS,2SR)-2,6,6-trimethyl-3-cyclohexen-1-yl]-2-buten-1-one), (+-)-3,6-dihydro-4,6-dimethyl-2-phenyl-2h-pyran, anisaldehyde, paracresol, 3-ethoxy-4-hydroxybenzaldehyde, methyl 2-aminobenzoate, ethyl methylphenylglycidate, octalactone gamma, ethyl 3-phenyl-2-propenoate, (-)-(2E)-2-ethyl-4-[(1R)-2,2,3-trimethyl-3-cyclopenten-1-yl]-2-buten-1-ol, paracresyl acetate, dodecalactone, tricyclone, (+)-(3R,5Z)-3-methyl-5-cyclopentadecen-1-one, undecalactone, (1R,4R)-8-mercapto-3-p-menthanone, (3S,3AS,6R,7AR)-3,6-dimethylhexahydro-1-benzofuran-2(3H)-one, beta ionone, (+-)-6-pentyltetrahydro-2H-pyran-2-one, (3E,5Z)-1,3,5-undecatriene, 10-undecenal, (9E)-9-undecenal (9Z)-9-undecenal, (Z)-4-decenal, (+-)-ethyl 2-methylpentanoate, 1,2-diallyldisulfane, 2-tridecenitrile, 3-tridecenitrile, , (+-)-2-ethyl-4,4-dimethyl-1,3-oxathiane, (+)-(3R,5Z)-3-methyl-5-cyclopentadecen-1-one, 3-(4-tert-butylphenyl)propanal, allyl (cyclohexyloxy)acetate, methylnaphthylketone, (+-)-(4E)-3-methyl-4-cyclopentadecen-1-one, (+-)-5E3-methyl-5-cyclopentadecen-1-one, cyclopropylmethyl 3-hexenoate, (4E)-4-methyl-5-(4-methylphenyl)-4-pentenal, (+-)-1-(5-propyl-1,3-benzodioxol-2-yl)ethanone, 4-methyl-2-pentylpyridine, (+-)-(E)-3-methyl-4-(2,6,6-trimethyl-2-cyclohexen-1-yl)-3-buten-2-one, (3aRS,5aSR,9aSR,9bRS)-3a,6,6,9a-tetramethyldodecahydronaphtho[2,1-b]furan, (2S,5R)-5-

methyl-2-(2-propenyl)cyclohexanone oxime, 6-hexyltetrahydro-2H-pyran-2-one, (+)-3-(3-isopropyl-1-phenyl)butanal, methyl 2-(3-oxo-2-pentylcyclopentyl)acetate, 1-(2,6,6-trimethyl-1-cyclohex-2-enyl)pent-1-en-3-one, indol, 7-propyl-2H,4H-1,5-benzodioxepin-3-one, ethyl praline, (4-methylphenoxy)acetaldehyde, ethyl tricyclo[5.2.1.0.2,6]decane-2-carboxylate, (+)-(1'S,2S,E)-
 5 3,3-dimethyl-5-(2',2',3'-trimethyl-3'-cyclopenten-1'-yl)-4-penten-2-ol, (4E)-3,3-dimethyl-5-[(1R)-2,2,3-trimethyl-3-cyclopenten-1-yl]-4-penten-2-ol, 8-isopropyl-6-methyl-bicyclo[2.2.2]oct-5-ene-2-carbaldehyde, methyl-nonyl-acetaldehyde, 4-formyl-2-methoxyphenyl 2-methylpropanoate, (E)-4-decenal, (+)-2-ethyl-4-(2,2,3-trimethyl-3-cyclopenten-1-yl)-2-buten-1-ol, (1R,5R)-4,7,7-trimethyl-6-thiabicyclo[3.2.1]oct-3-ene, (1R,4R,5R)-4,7,7-trimethyl-6-thiabicyclo[3.2.1]octane,
 10 (-)-(3R)-3,7-dimethyl-1,6-octadien-3-ol, (E)-3-phenyl-2-propenenitrile, 4-methoxybenzyl acetate, (E)-3-methyl-5-(2,2,3-trimethyl-3-cyclopenten-1-yl)-4-penten-2-ol, allyl (2/3-methylbutoxy)acetate, (+)-(2E)-1-(2,6,6-trimethyl-2-cyclohexen-1-yl)-2-buten-1-one, (1E)-1-(2,6,6-trimethyl-1-cyclohexen-1-yl)-1-penten-3-one, and mixtures thereof.

According to an embodiment, perfume raw materials having a Log T<-4 are chosen in the
 15 group consisting of aldehydes, ketones, alcohols, phenols, esters lactones, ethers, epoxydes, nitriles and mixtures thereof.

According to an embodiment, perfume raw materials having a Log T<-4 comprise at least one compound chosen in the group consisting of alcohols, phenols, esters lactones, ethers, epoxydes, nitriles and mixtures thereof, preferably in amount comprised between 20 and 70 wt.%
 20 based on the total weight of the perfume raw materials having a Log T<-4.

According to an embodiment, perfume raw materials having a Log T<-4 comprise between 20 and 70 wt.% by weight of aldehydes, ketones, and mixtures thereof based on the total weight of the perfume raw materials having a Log T<-4.

The remaining perfume raw materials contained in the oil-based core may have therefore a
 25 Log T>-4.

According to an embodiment, the perfume raw materials having a Log T>-4 are chosen in the group consisting of ethyl 2-methylbutyrate, (E)-3-phenyl-2-propenyl acetate, (+)-6/8-sec-butylquinoline, (+)-3-(1,3-benzodioxol-5-yl)-2-methylpropanal, verdyl propionate, 1-(octahydro-2,3,8,8-tetramethyl-2-naphthalenyl)-1-ethanone, methyl 2-((1RS,2RS)-3-oxo-2-pentylcyclopentyl)acetate, (+)-(E)-4-methyl-3-decen-5-ol, 2,4-dimethyl-3-cyclohexene-1-carbaldehyde, 1,3,3-trimethyl-2-oxabicyclo[2.2.2]octane, tetrahydro-4-methyl-2-(2-methyl-1-

propenyl)-2H-pyran, dodecanal, 1-oxa-12/13-cyclohexadecen-2-one, (+-)-3-(4-isopropylphenyl)-2-methylpropanal, aldehyde C11, (+-)-2,6-dimethyl-7-octen-2-ol, allyl 3-cyclohexylpropanoate, (Z)-3-hexenyl acetate, 5-methyl-2-(2-propanyl)cyclohexanone, allyl heptanoate, 2-(2-methyl-2-propanyl)cyclohexyl acetate, 1,1-dimethyl-2-phenylethyl butyrate, geranyl acetate, neryl acetate, 5 (+-)-1-phenylethyl acetate, 1,1-dimethyl-2-phenylethyl acetate, 3-methyl-2-butenyl acetate, ethyl 3-oxobutanoate, (2Z)-ethyl 3-hydroxy-2-butenate, 8-p-menthanol, 8-p-menthanyl acetate, 1-p-menthanyl acetate, (+-)-2-(4-methyl-3-cyclohexen-1-yl)-2-propanyl acetate, (+-)-2-methylbutyl butanoate, 2-{(1S)-1-[(1R)-3,3-dimethylcyclohexyl]ethoxy}-2-oxoethyl propionate, 3,5,6-trimethyl-3-cyclohexene-1-carbaldehyde, 2,4,6-trimethyl-3-cyclohexene-1-carbaldehyde, 2-cyclohexylethyl acetate, octanal, ethyl butanoate, (+-)-(3E)-4-(2,6,6-trimethyl-1/2-cyclohexen-1-yl)-3-buten-2-one, 1-[(1R,6SR)-2,2,6-trimethylcyclohexyl]-3-hexanol, 1,3,3-trimethyl-2-oxabicyclo[2.2.2]octane, 1,3,3-trimethyl-2-oxabicyclo[2.2.2]octane, ethyl hexanoate, undecanal, decanal, 2-phenylethyl acetate, (1S,2S,4S)-1,7,7-trimethylbicyclo[2.2.1]heptan-2-ol, (1S,2R,4S)-1,7,7-trimethylbicyclo[2.2.1]heptan-2-ol), (+-)-3,7-dimethyl-3-octanol, 1-methyl-4-(2-propanylidene)cyclohexene, (+)-(R)-4-(2-methoxypropan-2-yl)-1-methylcyclohex-1-ene, verdyl acetate, (3R)-1-[(1R,6S)-2,2,6-trimethylcyclohexyl]-3-hexanol, (3S)-1-[(1R,6S)-2,2,6-trimethylcyclohexyl]-3-hexanol, (3R)-1-[(1S,6S)-2,2,6-trimethylcyclohexyl]-3-hexanol, (+)-(1S,1'R)-2-[1-(3',3'-dimethyl-1'-cyclohexyl)ethoxy]-2-methylpropyl propanoate, and mixtures thereof.

20 The nature of high impact perfume raw materials having a Log T<-4 and density balancing material having a density greater than 1.07 g/cm³ are described in WO2018115250, the content of which are included by reference.

According to an embodiment, the core comprises:

- 25 - 0 to 60 wt.% of a hydrophobic solvent (based on the total weight of the perfume formulation),
- 40 to 100 wt.% of a perfume oil (based on the total weight of the perfume formulation), wherein the perfume oil has at least two, preferably all of the following characteristics:

at least 35%, preferably at least 40%, preferably at least 50%, more preferably at least 60%
 30 of perfuming ingredients having a log P above 3, preferably above 3.5,

at least 20%, preferably at least 25%, preferably at least 30%, more preferably at least 40% of Bulky materials of groups 1 to 6, preferably 3 to 6 as previously defined and

at least 15%, preferably at least 20%, more preferably at least 25%, even more preferably at least 30% of high impact perfume materials having a Log T < -4 as previously defined,

5 optionally, further hydrophobic active ingredients.

According to a particular embodiment, the perfume comprises 0 to 60 wt.% of a hydrophobic solvent.

According to a particular embodiment, the hydrophobic solvent is a density balancing material preferably chosen in the group consisting of benzyl salicylate, benzyl benzoate, 10 cyclohexyl salicylate, benzyl phenylacetate, phenylethyl phenylacetate, triacetin, ethyl citrate, methyl and ethyl salicylate, benzyl cinnamate, and mixtures thereof.

In a particular embodiment, the hydrophobic solvent has Hansen Solubility Parameters compatible with entrapped perfume oil.

The term "Hansen solubility parameter" is understood refers to a solubility parameter 15 approach proposed by Charles Hansen used to predict polymer solubility and was developed around the basis that the total energy of vaporization of a liquid consists of several individual parts. To calculate the "weighted Hansen solubility parameter" one must combine the effects of (atomic) dispersion forces, (molecular) permanent dipole-permanent dipole forces, and (molecular) hydrogen bonding (electron exchange). The weighted Hansen solubility parameter" is calculated 20 as $(\delta D^2 + \delta P^2 + \delta H^2)^{0.5}$, wherein δD is the Hansen dispersion value (also referred to in the following as the atomic dispersion fore), δP is the Hansen polarizability value (also referred to in the following as the dipole moment), and δH is the Hansen Hydrogen-bonding ("h-bonding") value (also referred to in the following as hydrogen bonding). For a more detailed description of the parameters and values, see Charles Hansen, The Three Dimensional Solubility Parameter and 25 Solvent Diffusion Coefficient, Danish Technical Press (Copenhagen, 1967).

Euclidean difference in solubility parameter between a fragrance and a solvent is calculated as $(4 * (\delta D_{\text{solvent}} - \delta D_{\text{fragrance}})^2 + (\delta P_{\text{solvent}} - \delta P_{\text{fragrance}})^2 + (\delta H_{\text{solvent}} - \delta H_{\text{fragrance}})^2)^{0.5}$, in 30 which $\delta D_{\text{solvent}}$, $\delta P_{\text{solvent}}$, and $\delta H_{\text{solvent}}$, are the Hansen dispersion value, Hansen polarizability value, and Hansen h-bonding values of the solvent, respectively; and $\delta D_{\text{fragrance}}$, $\delta P_{\text{fragrance}}$, and $\delta H_{\text{fragrance}}$ are the Hansen dispersion value, Hansen polarizability value, and Hansen h-bonding values of the fragrance, respectively.

In a particular embodiment, the perfume oil and the hydrophobic solvent have at least two Hansen solubility parameters selected from a first group consisting of: an atomic dispersion force (δD) from 12 to 20, a dipole moment (δP) from 1 to 8, and a hydrogen bonding (δH) from 2.5 to 11.

5 In a particular embodiment, the perfume oil and the hydrophobic solvent have at least two Hansen solubility parameters selected from a second group consisting of: an atomic dispersion force (δD) from 12 to 20, preferably from 14 to 20, a dipole moment (δP) from 1 to 8, preferably from 1 to 7, and a hydrogen bonding (δH) from 2.5 to 11, preferably from 4 to 11.

According to a particular embodiment, the hydrophobic material is free of any active
10 ingredient (such as perfume). According to this particular embodiment, it comprises, preferably consists of hydrophobic solvents, preferably chosen in the group consisting of isopropyl myristate, tryglycerides (e.g. Neobee® MCT oil, vegetable oils), D-limonene, silicone oil, mineral oil, and mixtures thereof with optionally hydrophilic solvents preferably chosen in the group consisting of 1,4-butanediol, benzyl alcohol, triethyl citrate, triacetin, benzyl acetate, ethyl
15 acetate, propylene glycol (1,2-propanediol), 1,3-propanediol, dipropylene glycol, glycerol, glycol ethers and mixtures thereof.

According to a particular embodiment, the hydrophobic material comprises an active ingredient (preferably a perfume) and a hydrophobic solvent such as isopropyl myristate, tryglycerides (e.g. Neobee® MCT oil, vegetable oils such as sunflower oil), D-limonene, silicone
20 oil, mineral oil, benzyl salicylate, benzyl benzoate, cyclohexyl salicylate, benzyl phenylacetate, phenylethyl phenylacetate, triacetin, ethyl citrate, methyl and ethyl salicylate, benzyl cinnamate and mixtures thereof.

The term "biocide" refers to a chemical substance capable of killing living organisms (e.g. microorganisms) or reducing or preventing their growth and/or accumulation. Biocides are
25 commonly used in medicine, agriculture, forestry, and in industry where they prevent the fouling of, for example, water, agricultural products including seed, and oil pipelines. A biocide can be a pesticide, including a fungicide, herbicide, insecticide, algicide, molluscicide, miticide and rodenticide; and/or an antimicrobial such as a germicide, antibiotic, antibacterial, antiviral, antifungal, antiprotozoal and/or antiparasite.

30 As used herein, a "pest control agent" indicates a substance that serves to repel or attract pests, to decrease, inhibit or promote their growth, development or their activity. Pests refer to any

living organism, whether animal, plant or fungus, which is invasive or troublesome to plants or animals, pests include insects notably arthropods, mites, spiders, fungi, weeds, bacteria and other microorganisms.

By "flavor oil", it is meant here a flavoring ingredient or a mixture of flavoring ingredients, solvents or adjuvants of current use for the preparation of a flavoring formulation, i.e. a particular mixture of ingredients which is intended to be added to an edible composition or chewable product to impart, improve or modify its organoleptic properties, in particular its flavor and/or taste. Flavoring ingredients are well known to a person skilled in the art and their nature does not warrant a detailed description here, which in any case would not be exhaustive, the skilled flavorist being able to select them on the basis of his general knowledge and according to the intended use or application and the organoleptic effect it is desired to achieve. Many of these flavoring ingredients are listed in reference texts such as in the book by S. Arctander, *Perfume and Flavor Chemicals*, 1969, Montclair, N.J., USA, or its more recent versions, or in other works of similar nature such as *Fenaroli's Handbook of Flavor Ingredients*, 1975, CRC Press or *Synthetic Food Adjuncts*, 1947, by M. B. Jacobs, van Nostrand Co., Inc. Solvents and adjuvants of current use for the preparation of a flavoring formulation are also well known in the art.

In a particular embodiment, the flavor is a mint flavor. In a more particular embodiment, the mint is selected from the group consisting of peppermint and spearmint.

In a further embodiment, the flavor is a cooling agent or mixtures thereof.

In another embodiment, the flavor is a menthol flavor.

Flavors that are derived from or based on fruits where citric acid is the predominant, naturally-occurring acid include but are not limited to, for example, citrus fruits (e.g. lemon, lime), limonene, strawberry, orange, and pineapple. In one embodiment, the flavors food is lemon, lime or orange juice extracted directly from the fruit. Further embodiments of the flavor comprise the juice or liquid extracted from oranges, lemons, grapefruits, key limes, citrons, clementines, mandarins, tangerines, and any other citrus fruit, or variation or hybrid thereof. In a particular embodiment, the flavor comprises a liquid extracted or distilled from oranges, lemons, grapefruits, key limes, citrons, clementines, mandarins, tangerines, any other citrus fruit or variation or hybrid thereof, pomegranates, kiwifruits, watermelons, apples, bananas, blueberries, melons, ginger, bell peppers, cucumbers, passion fruits, mangos, pears, tomatoes, and strawberries.

In a particular embodiment, the flavor comprises a composition that comprises limonene, in a particular embodiment, the composition is a citrus that further comprises limonene.

In another particular embodiment, the flavor comprises a flavor selected from the group comprising strawberry, orange, lime, tropical, berry mix, and pineapple.

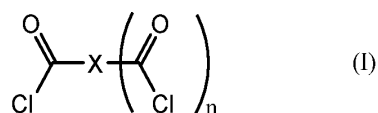
5 The phrase flavor includes not only flavors that impart or modify the smell of foods but include taste imparting or modifying ingredients. The latter do not necessarily have a taste or smell themselves but are capable of modifying the taste that other ingredients provide, for instance, salt enhancing ingredients, sweetness enhancing ingredients, umami enhancing ingredients, bitterness blocking ingredients and so on.

10 In a further embodiment, suitable sweetening components may be included in the particles described herein. In a particular embodiment, a sweetening component is selected from the group consisting of sugar (e.g., but not limited to sucrose), a stevia component (such as but not limited to stevioside or rebaudioside A), sodium cyclamate, aspartame, sucralose, sodium saccharine, and Acesulfam K or mixtures thereof.

15 According to an embodiment, the hydrophobic material represents between about 10% and 95% by weight, relative to the total weight of the oil phase. According to another embodiment, the hydrophobic material represents between about 10% and 80% by weight, relative to the total weight of the oil phase. According to another embodiment, the hydrophobic material represents between about 10% and 60% by weight, relative to the total weight of the oil phase. According to
20 another embodiment, the hydrophobic material represents between about 15% and 45% by weight, relative to the total weight of the oil phase.

Acyl chloride

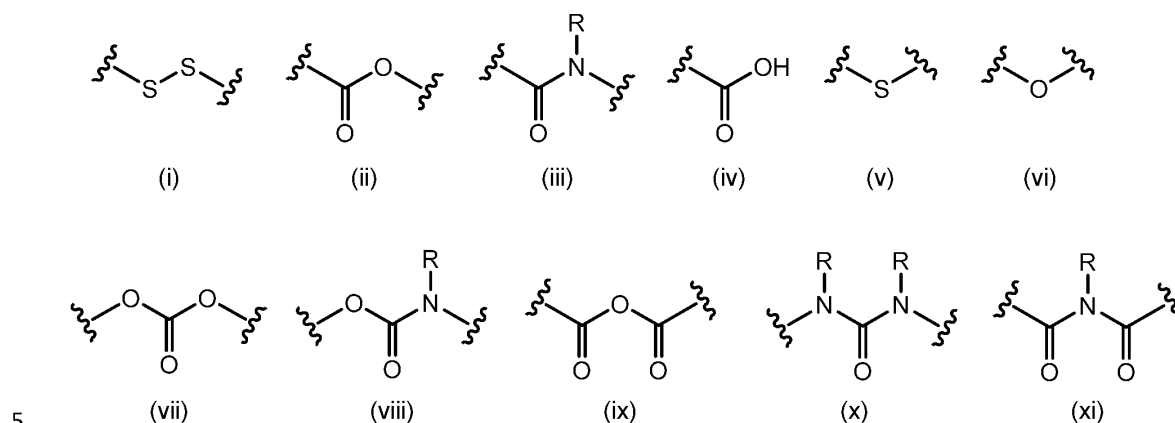
25 According to a particular embodiment, the acyl chloride has the following formula (I)



wherein n is an integer varying between 1 and 8, preferably between 1 and 6, more preferably

between 1 and 4, and

wherein X is an (n+1)-valent C₂ to C₄₅ hydrocarbon group optionally comprising at least one group selected from (i) to (xi), particularly from (i) to (vi)



wherein R is a hydrogen atom or an alkyl group such as a methyl or an ethyl group, preferably a hydrogen atom.

It is understood that by "... **hydrocarbon group** ..." it is meant that said group consists of hydrogen and carbon atoms and can be in the form of an aliphatic hydrocarbon, i.e. linear or branched saturated hydrocarbon (e.g. alkyl group), a linear or branched unsaturated hydrocarbon (e.g. alkenyl or alkynyl group), a saturated cyclic hydrocarbon (e.g. cycloalkyl) or an unsaturated cyclic hydrocarbon (e.g. cycloalkenyl or cycloalkynyl), or can be in the form of an aromatic hydrocarbon, i.e. aryl group, or can also be in the form of a mixture of said type of groups, e.g. a specific group may comprise a linear alkyl, a branched alkenyl (e.g. having one or more carbon-carbon double bonds), a (poly)cycloalkyl and an aryl moiety, unless a specific limitation to only one type is mentioned. Similarly, in all the embodiments of the invention, when a group is mentioned as being in the form of more than one type of topology (e.g. linear, cyclic or branched) and/or being saturated or unsaturated (e.g. alkyl, aromatic or alkenyl), it is also meant a group which may comprise moieties having any one of said topologies or being saturated or unsaturated, as explained above. Similarly, in all the embodiments of the invention, when a group is mentioned as being in the form of one type of saturation or unsaturation, (e.g. alkyl), it is meant that said group can be in any type of topology (e.g. linear, cyclic or branched) or having several moieties

with various topologies.

It is understood that with the term "... **a hydrocarbon group, optionally comprising ...**" it is meant that said hydrocarbon group optionally comprises heteroatoms to form ether, thioether, amine, nitrile or carboxylic acid groups and derivatives (including for example esters, acids, amide). These groups can either substitute a hydrogen atom of the hydrocarbon group and thus be laterally attached to said hydrocarbon, or substitute a carbon atom (if chemically possible) of the hydrocarbon group and thus be inserted into the hydrocarbon chain or ring.

According to a particular embodiment, the acyl chloride is chosen from the group consisting of benzene-1,3,5-tricarbonyl trichloride (trimesoyl trichloride), benzene-1,2,4-tricarbonyl trichloride, benzene-1,2,4,5-tetracarboxyl tetrachloride, cyclohexane-1,3,5-tricarbonyl trichloride, isophthaloyl dichloride, diglycolyl dichloride, terephthaloyl chloride, fumaryl dichloride, adipoyl chloride, succinic dichloride, propane-1,2,3-tricarbonyl trichloride, cyclohexane-1,2,4,5-tetracarboxyl tetrachloride, 2,2'-disulfanediylsuccinyl dichloride, 2-(2-chloro-2-oxo-ethyl)sulfanylbutanedioyl dichloride, (4-chloro-4-oxobutanoyl)-L-glutamoyl dichloride, (S)-4-((1,5-dichloro-1,5-dioxopentan-2-yl)amino)-4-oxobutanoic acid, 2,2-bis[(4-chloro-4-oxo-butanoyl)oxymethyl]butyl 4-chloro-4-oxo-butanoate, [2-[2,2-bis[(4-chloro-4-oxo-butanoyl)oxymethyl]butoxymethyl]-2-[(4-chloro-4-oxo-butanoyl)oxymethyl]butyl] 4-chloro-4-oxo-butanoate, 2,2-bis[(2-chlorocarbonylbenzoyl)oxymethyl]butyl 2-chlorocarbonyl-benzoate, [2-[2,2-bis[(2-chlorocarbonylbenzoyl)oxymethyl]butoxymethyl]-2-[(2-chlorocarbonylbenzoyl)oxymethyl]butyl] 2-chlorocarbonylbenzoate, 4-(2,4,5-trichlorocarbonylbenzoyl)oxybutyl 2,4,5-trichlorocarbonyl-benzoate, propane-1,2,3-triyl tris(4-chloro-4-oxobutanoate), propane-1,2-diyl bis(4-chloro-4-oxobutanoate) and mixtures thereof.

According to a particular embodiment, the acyl chloride is chosen from the group consisting of benzene-1,2,4-tricarbonyl trichloride, benzene-1,2,4,5-tetracarboxyl tetrachloride, cyclohexane-1,3,5-tricarbonyl trichloride, isophthaloyl dichloride, diglycolyl dichloride, terephthaloyl chloride, fumaryl dichloride, adipoyl dichloride, succinic dichloride, propane-1,2,3-tricarbonyl trichloride, cyclohexane-1,2,4,5-tetracarboxyl tetrachloride, 2,2'-disulfanediylsuccinyl dichloride, 2-(2-chloro-2-oxo-ethyl)sulfanylbutanedioyl dichloride, (4-chloro-4-oxobutanoyl)-L-glutamoyl dichloride, (S)-4-((1,5-dichloro-1,5-dioxopentan-2-yl)amino)-4-oxobutanoic acid, 2,2-bis[(4-chloro-4-oxo-butanoyl)oxymethyl]butyl 4-chloro-4-oxo-butanoate, [2-[2,2-bis[(4-chloro-4-oxo-butanoyl)oxymethyl]butoxymethyl]-2-[(4-chloro-4-

oxo-butanoyl)oxymethyl]butyl] 4-chloro-4-oxo-butanoate, 2,2-bis[(2-chlorocarbonylbenzoyl)oxymethyl]butyl 2-chlorocarbonyl-benzoate, [2-[2,2-bis[(2-chlorocarbonylbenzoyl)oxymethyl]butoxymethyl]-2-[(2-chlorocarbonylbenzoyl)oxymethyl]butyl] 2-chlorocarbonylbenzoate, 4-(2,4,5-trichlorocarbonylbenzoyl)oxybutyl 2,4,5-trichlorocarbonyl-benzoate, propane-1,2,3-triyl tris(4-chloro-4-oxobutanoate), propane-1,2-diyl bis(4-chloro-4-oxobutanoate), and mixtures thereof.

According to another particular embodiment, the acyl chloride is chosen from the group consisting of fumaryl dichloride, adipoyl dichloride, succinic dichloride, propane-1,2,3-triyl tris(4-chloro-4-oxobutanoate), propane-1,2-diyl bis(4-chloro-4-oxobutanoate), and mixtures thereof.

According to an embodiment, the acyl chloride is a mixture of acyl chlorides.

The weight ratio between acyl chloride and the hydrophobic material is preferably comprised between 0.01 and 0.09, more preferably between 0.02 and 0.07.

According to a particular embodiment, the acyl chloride is used in an amount comprised between 1.7 and 7%, preferably between 2.5 and 5 % by weight based on the total weight of the hydrophobic material.

The acyl chloride can be dissolved (or dispersed) directly in the perfume oil or can be pre-dispersed (or pre-dissolved) in an inert solvent or any inert perfumery solvent/ingredient such as benzyl benzoate, triethyl citrate, ethyl acetate, vegetable oil (such as sunflower oil), hexyl salicylate, Neobee (caprylic/capric triglyceride), isopropyl myristate, triglycerides, D-limonene, silicone oil, mineral oil, benzyl salicylate, benzyl benzoate, cyclohexyl salicylate, benzyl phenylacetate, phenylethyl phenylacetate, triacetin, ethyl citrate, methyl and ethyl salicylate, benzyl cinnamate and mixtures thereof, before mixing with the perfume oil.

According to an embodiment, a polyfunctional monomer is added in the oil phase.

By “**polyfunctional monomer**”, it is meant a molecule that, as unit, reacts or binds chemically to form a polymer or supramolecular polymer. The polyfunctional polymer of the invention has at least two functions capable of forming a microcapsule shell.

It should be understood that, when added, the polyfunctional monomer is added in addition to the acyl chloride.

The polyfunctional monomer is preferably chosen in the group consisting of at least one isocyanate, maleic anhydride, acyl chloride, epoxide, acrylate monomers, alkoxysilane and mixtures thereof.

According to an embodiment, the polyfunctional monomer used in the process of the invention is present in amounts representing from 0.1 to 15%, preferably from 0.5 to 10% and more preferably from 0.8 to 6%, and even more preferably between 1 and 3% by weight based on the total amount of the oil phase.

5 According to a particular embodiment, a polyisocyanate having at least two isocyanate functional groups is further added in the oil phase in addition to the acyl chloride.

Suitable polyisocyanates used according to the invention can include aromatic polyisocyanate, aliphatic polyisocyanate and mixtures thereof. Said polyisocyanate comprises at least 2, preferably at least 3 but may comprise up to 6, or even only 4, isocyanate functional groups.

10 According to a particular embodiment, a triisocyanate (3 isocyanate functional group) is used.

According to one embodiment, said polyisocyanate is an aromatic polyisocyanate.

The term “aromatic polyisocyanate” is meant here as encompassing any polyisocyanate comprising an aromatic moiety. Preferably, it comprises a phenyl, a toluyl, a xylyl, a naphthyl or a diphenyl moiety, more preferably a toluyl or a xylyl moiety. Preferred aromatic polyisocyanates are biurets, polyisocyanurates and trimethylol propane adducts of diisocyanates, more preferably comprising one of the above-cited specific aromatic moieties. More preferably, the aromatic polyisocyanate is a polyisocyanurate of toluene diisocyanate (commercially available from Bayer under the tradename Desmodur[®] RC), a trimethylol propane-adduct of toluene diisocyanate (commercially available from Bayer under the tradename Desmodur[®] L75), a trimethylol propane-adduct of xylylene diisocyanate (commercially available from Mitsui Chemicals under the tradename Takenate[®] D-110N). In a most preferred embodiment, the aromatic polyisocyanate is a trimethylol propane-adduct of xylylene diisocyanate.

According to another embodiment, said polyisocyanate is an aliphatic polyisocyanate. The term “aliphatic polyisocyanate” is defined as a polyisocyanate which does not comprise any aromatic moiety. Preferred aliphatic polyisocyanates are a trimer of hexamethylene diisocyanate, a trimer of isophorone diisocyanate, a trimethylol propane-adduct of hexamethylene diisocyanate (available from Mitsui Chemicals) or a biuret of hexamethylene diisocyanate (commercially available from Bayer under the tradename Desmodur[®] N 100), among which a biuret of hexamethylene diisocyanate is even more preferred.

30 According to another embodiment, the at least one polyisocyanate is in the form of a mixture of at least one aliphatic polyisocyanate and of at least one aromatic polyisocyanate, both

comprising at least two or three isocyanate functional groups, such as a mixture of a biuret of hexamethylene diisocyanate with a trimethylol propane-adduct of xylylene diisocyanate, a mixture of a biuret of hexamethylene diisocyanate with a polyisocyanurate of toluene diisocyanate and a mixture of a biuret of hexamethylene diisocyanate with a trimethylol propane-adduct of toluene diisocyanate. Most preferably, it is a mixture of a biuret of hexamethylene diisocyanate with a trimethylol propane-adduct of xylylene diisocyanate. Preferably, when used as a mixture the molar ratio between the aliphatic polyisocyanate and the aromatic polyisocyanate is ranging from 80:20 to 10:90.

According to an embodiment, the at least one polyisocyanate is present in amounts representing from 0.1 to 15%, preferably from 0.5 to 10% and more preferably from 0.8 to 6%, and even more preferably between 1 and 3% by weight based on the total amount of the oil phase.

In another step of the process according to the invention, the oil phase of step a) is dispersed into a dispersing phase, preferably a water phase to form a two-phases dispersion.

The mean droplet size of the two-phases dispersion is preferably comprised between 1 and 1000 microns, more preferably between 1 and 500 microns, and even more preferably between 5 and 50 microns.

The two-phases dispersion can be prepared by using high speed mechanical disperser or ultrasonic dispersers, well-known from the person skilled in the art.

Carbohydrate

According to an embodiment, a carbohydrate is added in the dispersing phase, preferably a water phase, and/or in the oil phase.

According to an embodiment, by "carbohydrate" it should be understood a polymer or an oligomer having a number of units greater than 2.

According to an embodiment, the carbohydrate is not gum Arabic.

According to an embodiment, the carbohydrate is not lactose.

According to an embodiment, the carbohydrate does not bear amino-groups.

According to an embodiment, the carbohydrate is not chitosan.

According to another embodiment, the carbohydrate, the amino-compound A and the amino compound B are different components.

According to the invention, at least one carbohydrate is added in the oil phase and/or in the dispersing phase.

According to an embodiment, the carbohydrate is not a polyphenol.

According to an embodiment, the carbohydrate is not a functionalized carbohydrate.

5 According to an embodiment, the carbohydrate is a polysaccharide.

According to an embodiment, the polysaccharide is an anionic polysaccharide.

According to a particular embodiment, the polysaccharide is added in the dispersing phase.

The polysaccharide is preferably chosen in the group consisting of anionic salt of alginic acid, preferably alginic acid sodium salt, pectin, lignin, anionic modified starch,
10 carboxymethylcellulose, carrageenan and mixtures thereof.

According to a particular embodiment, the carbohydrate is an anionic salt of alginic acid, preferably alginic acid sodium salt.

“Alginic acid sodium salt” and “sodium alginate” are used indifferently in the present invention.

15 According to a particular embodiment, the carbohydrate is used in an amount comprised between 0.1 and 5%, preferably between 0.5 and 1.1% by weight based on the total weight of the dispersing phase.

Amino-compound A

20 According to the invention, at least one amino-compound A chosen in the group consisting of ethylene amine having a functionality greater than 3, an aminosilane, a polyethylenimine, an amino-acid and mixtures thereof, is added in the dispersing phase before the formation of the two-phases dispersion and/or in the two-phases dispersion obtained after step b).

By “ethylene amine having a functionality greater than 3”, it should be understood that a
25 functionality of 3 is excluded. The functionality encompasses the different amines functional groups such as primary amine and/or secondary amine and/or tertiary amine.

According to an embodiment, the ethylene amine having a functionality greater than 3 is chosen in the group consisting of triethylenetetramine, tetraethylenepentamine, and mixture thereof.

30 The polyethylenimine can be a branched polyethylenimine and/or a linear polyethylenimine.
According to an embodiment, the amino-compound A is polyethylenimine branched.

The aminosilane can be Bis[3-(triethoxysilyl)propyl]amine, 3-(2-Aminoethylamino)propyltriethoxysilane, 3-aminopropyltriethoxysilane or mixtures thereof.

According to an embodiment, the aminosilane is Bis[3-(triethoxysilyl)propyl]amine and/or 3-(2-Aminoethylamino)propyltriethoxysilane.

5 According to an embodiment, the aminosilane is not 3-aminopropyltriethoxysilane.

According to an embodiment, the amino-compound A is an amino-acid, preferably chosen in the group consisting of lysine, arginine, leucine, histidine, tryptophane, serin, glutamine, threonine, alanine, asparagine, aspartic acid, cysteine, glutamic acid, glycine, isoleucine, methionine, phenylalanine, proline, tyrosine, valine, and mixtures thereof.

10 According to an embodiment, the amino-compound A is an amino-acid, preferably chosen in the group consisting of L-Lysine, L-Arginine, L-leucine, L-Histidine, L-Tryptophane, L-Serin, L-Glutamine, L-Threonine and/or its derived oligomers and polymers, and mixtures thereof, preferably L-Lysine, L-Arginine, L-Histidine, L-Tryptophane and mixtures thereof, more preferably L-Lysine, L-Arginine, L-Histidine and mixtures thereof.

15 According to an embodiment, the amino-compound A is not L-Arginine.

According to a particular embodiment, at least one amino-compound A is added in the dispersing phase before the formation of the two-phases dispersion.

According to a particular embodiment, at least one amino-compound A is added in the two-phases dispersion obtained after step b).

20 According to a particular embodiment, at least one amino-compound A is added in the dispersing phase before the formation of the two-phases dispersion and in the two-phases dispersion obtained after step b).

The amino-compound A can be used in combination with another amino-compound(s) for example chosen in the group consisting of a xylylene diamine, 1,2-diaminocyclohexane, 1,4-diaminocyclohexane, L-lysine, L-Lysine ethyl ester, polyetheramines (Jeffamine®), ethylene diamine, diethylene triamine, spermine, spermidine, polyamidoamine (PAMAM), guanidine carbonate, chitosan, tris-(2-aminoethyl)amine, 3-aminopropyltriethoxysilane, L-arginine, 1,4-diaminobutane, 2,2 Dimethyl-1,3-propanediamine, 1,3-diaminopentane (Dytek EP diamine), 1,2-diaminopropane, an amine having a disulfide bond such as cystamine, cystamine hydrochloride, 30 cystine, cystine hydrochloride, cystine dialkyl ester, cystine dialkyl ester hydrochloride; 1,3-diaminopropane; urea; ethylene urea; aminoguanidine bicarbonate; 1-(2-

aminoethyl)imidazolidin-2-one; N-(3-aminopropyl)-N-dodecylpropane-1,3-diamine; N1-(2-Aminoethyl)-N1-dodecyl-1,2-ethanediamine; aminoethylethanolamine; N1-(3-aminopropyl)propane-1,3-diamine and mixtures thereof.

According to a particular embodiment, no ethylene diamine is added during the process.

5 According to an embodiment, the molar ratio between the functional groups NH_2 and/or NH of the amino compound A and the functional groups COCl of the acyl chloride is comprised between 0.1 and 3, preferably from 0.2 and 2, more preferably between 0.35 and 1.

According to an embodiment, the molar ratio between the functional groups NH_2 and/or NH of the amino compound A and the functional groups COCl of the acyl chloride is comprised
10 between 0.5 and 2.

According to an embodiment, the molar ratio between the functional groups NH_2 and/or NH of the amino compound A and the functional groups COCl of the acyl chloride is comprised between 0.2 and 1

15 **Base**

According to an embodiment, the dispersing phase comprises a base preferably chosen in the group consisting of sodium carbonate, sodium bicarbonate, sodium hydroxide, guanidine carbonate, triethanolamine, and mixtures thereof.

According to a particular embodiment, the base is not an amino compound.

20 According to an embodiment, the dispersing phase comprises a base preferably chosen in the group consisting of sodium carbonate, sodium bicarbonate, sodium hydroxide, and mixtures thereof.

The base can be added in an amount comprised between 0.01 and 1.5%, preferably between 0.01 and 0.7% by weight based on the total weight of the dispersing phase.

25

Polymer/stabilizer

According to a particular embodiment, a polymer is added in the oil phase and/or in the dispersing phase. According to a particular embodiment, the polymer is added in the oil phase.

The polymer is preferably used in an amount comprised between 0.1 and 10%, preferably
30 between 0.5 and 7% by weight based on the total weight of the oil phase or the dispersing phase.

According to an embodiment, the polymer is chosen in the group consisting of protein, chitosan, cationic guar and mixtures thereof.

According to an embodiment, the polymer is a cationic polymer.

According to an embodiment, the polymer is a protein.

5 According to an embodiment, the polymer is cationic and is chosen in the group consisting of protein, chitosan, cationic guar and mixtures thereof.

According to an embodiment, when the cationic polymer is a protein, the protein is cationic at a pH below its isoelectric point (IEP).

10 According to an embodiment, when the cationic polymer is chitosan, the chitosan is cationic below the pKa of the amine groups.

According to an embodiment, the protein is a plant-based protein.

According to an embodiment, the protein is chosen in the group consisting of canola protein, sunflower seed protein, potato protein, chickpea protein, pea protein, algae protein, faba bean protein, barley protein, oat protein, wheat gluten protein, lupin protein, soy protein, rice
15 protein, whey protein, white egg albumin, casein, sodium caseinate, gelatin (preferably fish gelatin), bovine serum albumin, hydrolyzed soy protein, hydrolyzed sericin, pseudocollagen, silk protein, sericin powder, gelatin and mixtures thereof.

According to an embodiment, the protein is fungal protein.

Fungal protein and mycoprotein can be used indifferently in the present invention.

20 According to an embodiment, the polymer acts as a stabilizer.

According to an embodiment, a stabilizer is added in the dispersing phase and/or the oil phase to form the dispersion. According to an embodiment, the stabilizer is a colloidal stabilizer.

By “stabilizer”, it is meant a compound capable to stabilize oil/water interface as an emulsion typically by lowering the interfacial tension between the oil phase and the dispersing
25 phase.

“Stabilizer” or “emulsifier” can be used indifferently in the present invention.

According to an embodiment, the stabilizer is a colloidal stabilizer.

The colloidal stabilizer can be a polymeric emulsifier (standard emulsion), a surfactant, or solid particles (Pickering emulsion).

30 “Molecular emulsifier” and “polymeric emulsifier” are used indifferently in the present invention.

By “polymeric emulsifier”, it meant an emulsifier having both a polar group with an affinity for water (hydrophilic) and a nonpolar group with an affinity for oil (hydrophobic). The hydrophilic part will dissolve in the dispersing phase and the hydrophobic part will dissolve in the oil phase providing a film around droplets.

5 By “surfactant”, it meant a non-polymeric substance with a polar and a non-polar group.

According to an embodiment, the stabilizer is chosen in the group consisting of inorganic particles, polymeric emulsifier such as polysaccharides, proteins, glycoproteins, and mixtures thereof.

10 When the stabilizer is solid particles, it can be chosen in the group consisting of calcium phosphate, silica, silicates, titanium dioxide, aluminium oxide, zinc oxide, iron oxide, mica, kaolin, montmorillonite, laponite, bentonite, perlite, dolomite, diatomite, vermiculite, hectorite, gibbsite, illite, kaolinite, aluminosilicates, gypsum, bauxite, magnesite, talc, magnesium carbonate, calcium carbonate, diatomaceous earth and mixtures thereof.

According to a particular embodiment, the stabilizer is a biopolymer.

15 According to a particular embodiment, the stabilizer is the polymer as defined above.

By “biopolymers” it is meant biomacromolecules produced by living organisms. Biopolymers are characterized by molecular weight distributions ranging from 1,000 (1 thousand) to 1,000,000,000 (1 billion) Daltons. These macromolecules may be carbohydrates (sugar based) or proteins (amino-acid based) or a combination of both (gums) and can be linear or branched.

20 According to an embodiment, the colloid stabilizer is chosen in the group consisting of gum Arabic, modified starch, polyvinyl alcohol, polyvinylpyrrolidone (PVP), carboxymethylcellulose (CMC), anionic polysaccharides, acrylamide copolymer, inorganic particles, protein such as soy protein, rice protein, whey protein, white egg albumin, sodium caseinate, gelatin, bovine serum albumin, hydrolyzed soy protein, hydrolyzed sericin, pseudocollagen, silk protein, sericin powder, and mixtures thereof.

25 According to another embodiment, the stabilizer is chosen in the group consisting of canola protein, sunflower seed protein, potato protein, chickpea protein, pea protein, algae protein, faba bean protein, barley protein, oat protein, wheat gluten protein, lupin protein, soy protein, rice protein, whey protein, white egg albumin, casein, sodium caseinate, gelatin, bovine serum albumin, hydrolyzed soy protein, hydrolyzed sericin, pseudocollagen, silk protein, sericin powder, gelatin and mixtures thereof.

Potato proteins are typically extracted from potato tuber (*Solanum tuberosum*). According to an embodiment, the potato protein is a native potato protein and preferably comprises or consisting of patatin.

According to an embodiment, the solubility of the potato protein is greater than 10%.
5 According to an embodiment, the solubility of the potato protein is greater than 20%. According to an embodiment, the solubility of the potato protein is greater than 30%. According to an embodiment, the solubility of the potato protein is greater than 40%. According to an embodiment, the solubility of the potato protein is greater than 50%. According to an embodiment, the solubility of the potato protein is greater than 60%. According to an embodiment, the solubility of the potato
10 protein is greater than 70%. According to an embodiment, the solubility of the potato protein is greater than 80%. According to an embodiment, the solubility of the potato protein is greater than 90%. The above solubilities are given in water at room temperature (typically 20°C) and preferably at native pH.

The protein used in this invention may be native, partially or completely denaturated by
15 any suitable method. Denaturation is a process which modify the conformational structure of a protein by unfolding, i.e., it involves the disruption and possible destruction of both the secondary and tertiary structures of the protein. Indeed, denaturation implicates the breaking of many of the weak linkages, or bonds (e.g., hydrogen bonds), within a protein molecule that are responsible for the highly ordered structure of the protein in its native state. Denaturation is reversible (the proteins
20 can regain their native state when the denaturing influence is removed) or irreversible.

Denaturation can be brought about in various ways. Proteins can be denatured by exposure to temperature, radiation or mechanical stress including shear, changes in pH (treatment with a base or an acid), treatment with oxidizing or reducing agents, inorganic salt, certain organic solvents, chaotropic agents (i.e, compounds having a positive chaotropic value - kJ Kg^{-1} mole on
25 the Hallsworth Scale - such as guanidine salts - e.g., guanidine carbonate, guanidine hydrochloride -, urea, calcium chloride, n-butanol, ethanol, lithium perchlorate, lithium acetate, magnesium chloride, phenol, 2-propanol, sodium dodecyl sulfate, thiourea).

The protein used in this invention can also be derivatized or modified (e.g., derivatized or chemically modified). For example, the protein can be modified by covalently attaching sugars,
30 lipids, peptides or chemical groups such as phosphates or methyl.

According to an embodiment, before use, the protein can be treated by a heat treatment (typically around 90°C) with or without the presence of a salt (for example CaCl₂ or NaCl).

When added in the oil phase, the stabilizer can be pre-dispersed (or pre-dissolved) in an inert solvent or any inert perfumery solvent/ingredient such as benzyl benzoate, triethyl citrate, ethyl acetate, vegetable oil (such as sunflower oil), hexyl salicylate, Neobee (caprylic/capric triglyceride), isopropyl myristate, triglycerides, D-limonene, silicone oil, mineral oil, benzyl salicylate, benzyl benzoate, cyclohexyl salicylate, benzyl phenylacetate, phenylethyl phenylacetate, triacetin, ethyl citrate, methyl and ethyl salicylate, benzyl cinnamate and mixtures thereof, or can be mixed to the active ingredient, preferably comprising a perfume oil.

The stabilizer and acyl chloride can be premixed and can be heated at a temperature between for example 10 and 80°C before mixing with the hydrophobic material, preferably comprising a perfume oil.

When the colloidal stabilizer is added in the dispersing phase, it is preferably chosen in the group consisting of gum Arabic, modified starch, polyvinyl alcohol, polyvinylpyrrolidone (PVP), carboxymethylcellulose (CMC), anionic polysaccharides, acrylamide copolymer, inorganic particles, protein such as soy protein, rice protein, whey protein, white egg albumin, sodium caseinate, gelatin, bovine serum albumin, hydrolyzed soy protein, hydrolyzed sericin, Pseudocollagen, Silk protein, sericin powder and mixtures thereof.

According to an embodiment, the polymer can be a stabilizer as defined above.

According to any one of the above embodiments of the present invention, the dispersion (two-phases dispersion) comprises between about 0.01% and 3.0% of at least a stabilizer, preferably colloid stabilizer, percentage being expressed on a w/w basis relative to the total weight of the two-phases dispersion as obtained after step b). In still another aspect of the invention, the dispersion (two-phases dispersion) comprises between about 0.05% and 2.0%, preferably between 0.05 and 1% of at least a stabilizer, preferably colloid stabilizer. In still another aspect of the invention, the dispersion (two-phases dispersion) comprises between about 0.1% and 1.6%, preferably between 0.1% and 0.8% by weight of at least a stabilizer, preferably colloid stabilizer.

Amino-compound B

According to an embodiment, at least one amino-compound B is added in the dispersing phase before the formation of the two-phases dispersion and/or in the two-phases dispersion obtained after step b).

5 According to a particular embodiment, at least one amino-compound B is added in the dispersing phase before the formation of the two-phases dispersion.

According to a particular embodiment, at least one amino-compound B is added in the two-phases dispersion obtained after step b).

10 According to a particular embodiment, at least one amino-compound B is added in the dispersing phase before the formation of the two-phases dispersion and in the two-phases dispersion obtained after step b).

According to an embodiment, the amino-compound B is an amino-acid, preferably chosen in the group consisting of lysine, arginine, leucine, histidine, tryptophane, serin, glutamine, threonine, alanine, asparagine, aspartic acid, cysteine, glutamic acid, glycine, isoleucine, methionine, 15 phenylalanine, proline, tyrosine, valine, and mixtures thereof.

According to a particular embodiment, the amino-compound B is an amino-acid, preferably chosen in the group consisting of L-Lysine, L-Arginine, L-leucine, L-Histidine, L-Tryptophane, L-Serin, L-Glutamine, L-Threonine and/or its derived oligomers and polymers, and mixtures thereof, preferably L-Lysine, L-Arginine, L-Histidine, L-Tryptophane and mixtures thereof, more 20 preferably L-Lysine, L-Arginine, L-Histidine and mixtures thereof.

The amino-acid has preferably two nucleophilic groups.

According to a particular embodiment, the amino-compound B may be chosen in the group consisting of L-Lysine, L-Lysine ethyl ester, guanidine carbonate, chitosan, 3-aminopropyltriethoxysilane, and mixtures thereof. According to a particular embodiment, the 25 amino compound B is L-Lysine.

According to an embodiment, the amino-compound B is L-Lysine and is added in the dispersing phase before the formation of the two-phases dispersion and/or in the two-phases dispersion obtained after step b).

According to an embodiment, the weight percent of amino-compound B in the dispersing 30 phase is comprised between 0 and 5, preferably between 0.1 and 1.5, more preferably between 0.3 and 0.8.

According to a particular embodiment, the amino-compound A is triethylenetetramine and the amino-compound B is an amino-acid, preferably L-Lysine.

According to a particular embodiment, the amino-compound A is tetraethylenepentamine and the amino-compound B is an amino-acid, preferably L-Lysine.

5 According to a particular embodiment, the amino-compound A is polyethylenimine and the amino-compound B is an amino-acid, preferably L-Lysine.

According to a particular embodiment, the amino-compound A is an amino-acid, preferably L-Arginine and the amino-compound B is an amino-acid, preferably L-Lysine.

10 According to a particular embodiment, a multivalent salt (such as calcium chloride, magnesium chloride, zinc chloride, iron trichloride) is added after step b), before or during step c).

This is followed by a curing step c) which allows ending up with microcapsules in the form of a slurry. According to a preferred embodiment, to enhance the kinetics, said step is performed at a temperature comprised between 5 and 90°C, possibly under pressure, for 1 to 8 hours. More
15 preferably it is performed at between 10 and 80°C for between 30 minutes and 5 hours.

Optional outer coating

According to a particular embodiment of the invention, at the end of step c) or during step c), one may also add to the invention's slurry a polymer selected from the group consisting of a non-ionic
20 polysaccharide, a cationic polymer, a polysuccinimide derivative (as described for instance in WO2021185724) and mixtures thereof to form an outer coating to the microcapsule.

Non-ionic polysaccharide polymers are well known to a person skilled in the art and are described for instance in WO2012/007438 page 29, lines 1 to 25 and in WO2013/026657 page 2, lines 12 to 19 and page 4, lines 3 to 12. Preferred non-ionic polysaccharides are selected from the
25 group consisting of locust bean gum, xyloglucan, guar gum, hydroxypropyl guar, hydroxypropyl cellulose and hydroxypropyl methyl cellulose.

Cationic polymers are well known to a person skilled in the art. Preferred cationic polymers have cationic charge densities of at least 0.5 meq/g, more preferably at least about 1.5 meq/g, but also preferably less than about 7 meq/g, more preferably less than about 6.2 meq/g. The cationic
30 charge density of the cationic polymers may be determined by the Kjeldahl method as described in the US Pharmacopoeia under chemical tests for Nitrogen determination. The preferred cationic

polymers are chosen from those that contain units comprising primary, secondary, tertiary and/or quaternary amine groups that can either form part of the main polymer chain or can be borne by a side substituent directly connected thereto. The weight average (Mw) molecular weight of the cationic polymer is preferably between 10,000 and 3.5M Dalton, more preferably between 50,000 and 1.5M Dalton. According to a particular embodiment, one will use cationic polymers based on acrylamide, methacrylamide, N-vinylpyrrolidone, quaternized N,N-dimethylaminomethacrylate, diallyldimethylammonium chloride, quaternized vinylimidazole (3-methyl-1-vinyl-1H-imidazol-3-ium chloride), vinylpyrrolidone, acrylamidopropyltrimonium chloride, cassia hydroxypropyltrimonium chloride, guar hydroxypropyltrimonium chloride or polygalactomannan 2-hydroxypropyltrimethylammonium chloride ether, starch hydroxypropyltrimonium chloride and cellulose hydroxypropyltrimonium chloride. Preferably copolymers shall be selected from the group consisting of polyquaternium-5, polyquaternium-6, polyquaternium-7, polyquaternium-10, polyquaternium-11, polyquaternium-16, polyquaternium-22, polyquaternium-28, polyquaternium-43, polyquaternium-44, polyquaternium-46, cassia hydroxypropyltrimonium chloride, guar hydroxypropyltrimonium chloride or polygalactomannan 2-hydroxypropyltrimethylammonium chloride ether, starch hydroxypropyltrimonium chloride and cellulose hydroxypropyltrimonium chloride. As specific examples of commercially available products, one may cite Salcare® SC60 (cationic copolymer of acrylamidopropyltrimonium chloride and acrylamide, origin: BASF) or Luviquat®, such as the PQ 11N, FC 550 or Style (polyquaternium-11 to 68 or quaternized copolymers of vinylpyrrolidone origin: BASF), or also the Jaguar® (C13S or C17, origin Rhodia).

According to any one of the above embodiments of the invention, there is added an amount of polymer described above comprised between about 0% and 5% w/w, or even between about 0.1% and 2% w/w, percentage being expressed on a w/w basis relative to the total weight of the slurry as obtained after step c) or d). It is clearly understood by a person skilled in the art that only part of said added polymers will be incorporated into/deposited on the microcapsule shell.

Another object of the invention is a process for preparing a microcapsule powder comprising the steps as defined above and an additional step d) or e) consisting of submitting the slurry obtained in step c) or d) to a drying, like spray-drying, to provide the microcapsules as such, i.e. in a powdery form. It is understood that any standard method known by a person skilled in the art to perform such drying is also applicable. In particular the slurry may be spray-dried preferably

in the presence of a polymeric carrier material such as polyvinyl acetate, polyvinyl alcohol, dextrans, natural or modified starch, vegetable gums, pectins, xanthans, alginates, carragenans or cellulose derivatives to provide microcapsules in a powder form.

According to a particular embodiment, the carrier material contains free perfume oil which
5 can be the same or different from the perfume from the core of the microcapsules.

However, one may cite also other drying method such as the extrusion, plating, spray granulation, the fluidized bed, or even a drying at room temperature using materials (carrier, desiccant) that meet specific criteria as disclosed in WO2017/134179.

10 CORE-SHELL MICROCAPSULE

Another object of the invention is a microcapsule or a microcapsule slurry obtainable by the process as described above.

Another object of the invention is a polyamide-based core-shell microcapsule or a polyamide-based core-shell microcapsule slurry comprising at least one microcapsule, the microcapsule
15 comprising:

- a core, preferably an oil-based core, comprising a hydrophobic material, preferably a perfume, and
- a polyamide-based shell comprising a reaction product of:
 - an acyl chloride,
 - 20 • an amino compound A chosen in the group consisting of ethylene amine having a functionality greater than 3, an aminosilane, a polyethylenimine, an amino-acid and mixtures thereof,
 - optionally a carbohydrate,
 - optionally an amino compound B, and
 - 25 • optionally a polymer, preferably a protein.

According to an embodiment, the polyamide-based core-shell microcapsule or a polyamide-based core-shell microcapsule slurry comprising at least one microcapsule, has a shell comprising:

- 30 - between 5 and 40%, preferably between 5 and 35% by weight of acyl chlorides moieties, preferably reacted acyl chlorides moieties,

- optionally, between 5 and 60%, preferably between 10 and 50% by weight of a carbohydrate, preferably reacted carbohydrate
 - optionally between 30 and 80%, preferably between 40 and 65%, more preferably between 40 and 60% by weight of a polymer, preferably reacted polymer,
 - 5 - between 1 and 40%, preferably between 3 and 30%, more preferably between 6 and 30% by weight of amino compound(s).
- based on the total weight of the shell.

Amino-compound(s) can encompass at least one amino-compound A with optionally at least
10 one amino-compound B.

By “reacted acyl chloride moieties”, it is meant that the chemical structure of the acyl chloride is altered by the reaction with amino compound A and/or the carbohydrate and/or the amino-compound B and/or the polymer.

By “reacted polymer”, it is meant that the chemical structure of the polymer is altered by the
15 reaction with amino compound A and/or the acyl chloride and/or the amino compound B and/or the carbohydrate, preferably with the acyl chloride.

By “reacted carbohydrate”, it is meant that the chemical structure of the carbohydrate is altered by the reaction with amino compound A and/or the acyl chloride and/or the amino-compound B, and/or the polymer, preferably with the acyl chloride.

20 The embodiments described above for the process according to the invention also apply to the microcapsule or the microcapsule slurry according to the invention. This particularly applies to the hydrophobic material, the carbohydrate, the polymer, the acyl chloride, the amino compound(s), the stabilizer.

The composition of the shell can be quantified for example by elemental analysis and
25 identified by solid-state NMR which are two well-known techniques for the person skilled in the art.

According to an embodiment, amino-compound A and amino-compound B are different.

According to a particular embodiment, the polyamide microcapsule comprises an inner shell of polyurea.

30 In a particular embodiment, the shell material is a biodegradable material.

In a particular embodiment, the shell has a biodegradability of at least 60%, preferably at least 65%, 70%, 75%, 80%, 85%, 90%, 95% or 98%, within 60 days according to OECD301F.

In a particular embodiment, the core-shell microcapsule has a biodegradability of at least 40 %, preferably at least 60 %, preferably at least 65%, 70%, 75%, 80%, 85%, 90%, 95% or 98% within 60 days according to OECD301F.

Thereby it is understood that the core-shell microcapsule including all components, such as the core, shell and optionally coating may have a biodegradability of at least 40 %, preferably at least 60 %, preferably at least 65%, 70%, 75%, 80%, 85%, 90%, 95% or 98% within 60 days according to OECD301F.

In a particular embodiment, the oil core, preferably perfume oil, has a biodegradability of at least 40 %, preferably at least 60 %, preferably at least 65%, 70%, 75%, 80%, 85%, 90%, 95% or 98% within 60 days according to OECD301F.

OECD301F is a standard test method on the biodegradability from the Organization of Economic Co-operation and Development.

A typical method for extracting the shell for measuring the biodegradability is disclosed in *Gasparini and all in Molecules 2020, 25,718*.

According to a particular embodiment, the microcapsule of the present invention comprises a mineral layer. The mineral layer preferably comprises a material chosen in the group consisting of iron oxides, iron oxyhydroxide, titanium oxides, zinc oxides, calcium carbonates, calcium phosphates, barium salt, strontium salt, magnesium salt, and mixtures thereof and mixtures thereof.

Another object of the invention is a solid particle comprising:

- a carrier material, preferably a polymeric carrier material chosen in the group consisting of polyvinyl acetate, polyvinyl alcohol, dextrans, natural or modified starch, vegetable gums, pectins, xanthans, alginates, carragenans, cellulose derivatives and mixtures thereof, and
- microcapsules as defined above entrapped in said carrier material, and
- optionally free perfume entrapped in said carrier material.

Solid particle as defined above and microcapsule powder can be used indifferently in the present invention.

Optional components

When microcapsules are in the form of a slurry, the microcapsule slurry can comprise auxiliary ingredients selected from the group of thickening agents/rheology modifiers, antimicrobial agents, opacity-building agents, mica particles, salt, pH stabilizers/buffering ingredients, preferably in an amount comprised between 0 and 15% by weight based on the total weight of the slurry.

According to another embodiment, the microcapsule slurry of the invention comprises additional free (i.e non-encapsulated) perfume, preferably in an amount comprised between 5 and 50% by weight based on the total weight of the slurry.

10

MULTIPLE MICROCAPSULES SYSTEM

According to an embodiment, the microcapsules of the invention (first type of microcapsule) can be used in combination with a second type of microcapsules.

Another object of the invention is a microcapsule delivery system comprising:

- 15
- the microcapsules of the present invention as a first type of microcapsule, and
 - a second type of microcapsules, wherein the first type of microcapsule and the second type of microcapsules differ in their hydrophobic material and/or their wall material and/or in their coating material.

20 According to a particular embodiment, the microcapsule delivery system is in the form of a slurry.

The wall of the second type of microcapsules can vary. As non-limiting examples, the polymer shell of the second type of microcapsules comprises a material selected from the group consisting of polyurea, polyurethane, polyamide, polyhydroxyalkanoates, polyacrylate, polyesters, polyaminoesters, polyepoxides, polysiloxane, polycarbonate, polysulfonamide, urea formaldehyde, melamine formaldehyde resin, melamine formaldehyde resin cross-linked with polyisocyanate or aromatic polyols, melamine urea resin, melamine glyoxal resin, gelatin/ gum arabic shell wall, and mixtures thereof.

30 The second type of microcapsule can comprise an oil-based core comprising a hydrophobic active, preferably perfume, and a composite shell comprising a first material and a second material, wherein the first material and the second material are different, the first material is a coacervate,

the second material is a polymeric material. In a particular embodiment, the weight ratio between the first material and the second material is comprised between 50:50 and 99.9:0.1. In a particular embodiment, the coacervate comprises a first polyelectrolyte, preferably selected among proteins (such as gelatin), polypeptides or polysaccharides (such as chitosan), most preferably Gelatin and
5 a second polyelectrolyte, preferably alginate salts, cellulose derivatives guar gum, pectinate salts, carrageenan, polyacrylic and methacrylic acid or xanthan gum, or yet plant gums such as acacia gum (Gum Arabic), most preferably Gum Arabic. The coacervate first material can be hardened chemically using a suitable cross-linker such as glutaraldehyde, glyoxal, formaldehyde, tannic acid or genipin or can be hardened enzymatically using an enzyme such as transglutaminase. The second
10 polymeric material can be selected from the group consisting of polyurea, polyurethane, polyamide, polyester, polyacrylate, polysiloxane, polycarbonate, polysulfonamide, polymers of urea and formaldehyde, melamine and formaldehyde, melamine and urea, or melamine and glyoxal and mixtures thereof, preferably polyurea and/or polyurethane. The second material is preferably present in an amount less than 3 wt.%, preferably less than 1 wt.% based on the total weight of the
15 second type of microcapsule slurry.

As non-limiting examples, the shell of the second type of microcapsules can be aminoplast-based, polyurea-based or polyurethane-based. The shell of the second type of microcapsules can also be hybrid, namely organic-inorganic such as a hybrid shell composed of at least two types of inorganic particles that are cross-linked, or yet a shell resulting from the hydrolysis and
20 condensation reaction of a polyalkoxysilane macro-monomeric composition.

According to an aspect, the shell of the second type of microcapsules comprises an aminoplast copolymer, such as melamine-formaldehyde or urea-formaldehyde or cross-linked melamine formaldehyde or melamine glyoxal.

According to another aspect the shell of the second type of microcapsules is polyurea-based
25 made from, for example but not limited to isocyanate-based monomers and amine-containing crosslinkers such as guanidine carbonate and/or guanazole. Certain polyurea microcapsules comprise a polyurea wall which is the reaction product of the polymerisation between at least one polyisocyanate comprising at least two isocyanate functional groups and at least one reactant selected from the group consisting of an amine (for example a water-soluble guanidine salt and
30 guanidine); a colloidal stabilizer or emulsifier; and an encapsulated perfume. However, the use of an amine can be omitted. According to a particular aspect, the colloidal stabilizer includes an

aqueous solution of between 0.1% and 0.4% of polyvinyl alcohol, between 0.6% and 1% of a cationic copolymer of vinylpyrrolidone and of a quaternized vinylimidazol (all percentages being defined by weight relative to the total weight of the colloidal stabilizer). According to another aspect, the emulsifier is an anionic or amphiphilic biopolymer, which may be, in one aspect, chosen from the group consisting of gum Arabic, soy protein, gelatin, sodium caseinate and mixtures thereof.

According to another embodiment, the microcapsule wall material of the second type of microcapsules may comprise any suitable resin and especially including melamine, glyoxal, polyurea, polyurethane, polyamide, polyester, etc. Suitable resins include the reaction product of an aldehyde and an amine, suitable aldehydes include, formaldehyde and glyoxal. Suitable amines include melamine, urea, benzoguanamine, glycoluril, and mixtures thereof. Suitable melamines include, methylol melamine, methylated methylol melamine, imino melamine and mixtures thereof. Suitable ureas include, dimethylol urea, methylated dimethylol urea, urea-resorcinol, and mixtures thereof. Suitable materials for making may be obtained from one or more of the following companies Solutia Inc. (St Louis, Missouri U.S.A.), Cytec Industries (West Paterson, New Jersey U.S.A.), Sigma-Aldrich (St. Louis, Missouri U.S.A.).

According to another embodiment, the second type of microcapsules is a one-shell aminoplast core-shell microcapsule obtainable by a process comprising the steps of:

- 1) admixing a perfume oil with at least a polyisocyanate having at least two isocyanate functional groups to form an oil phase;
- 2) dispersing or dissolving into water an aminoplast resin and optionally a stabilizer to form a water phase;
- 3) preparing an oil-in-water dispersion, wherein the mean droplet size is comprised between 1 and 100 microns, by admixing the oil phase and the water phase;
- 4) performing a curing step to form the wall of said microcapsule; and
- 5) optionally drying the final dispersion to obtain the dried core-shell microcapsule.

According to an embodiment, the second type of microcapsules is a formaldehyde-free capsule. A typical process for the preparation of aminoplast formaldehyde-free microcapsules slurry comprises the steps of

- 1) preparing an oligomeric composition comprising the reaction product of, or obtainable by reacting together:

- a. a polyamine component in the form of melamine or of a mixture of melamine and at least one C₁-C₄ compound comprising two NH₂ functional groups;
 - b. an aldehyde component in the form of a mixture of glyoxal, a C₄₋₆ 2,2-dialkoxy-ethanal and optionally a glyoxalate, said mixture having a molar ratio glyoxal/C₄₋₆ 2,2-dialkoxy-ethanal comprised between 1/1 and 10/1; and
 - c. a protic acid catalyst;
- 2) preparing an oil-in-water dispersion, wherein the droplet size is comprised between 1 and 600 microns, and comprising:
- a. an oil;
 - b. a water medium;
 - c. at least an oligomeric composition as obtained in step 1;
 - d. at least a cross-linker selected amongst:
 - i. C₄-C₁₂ aromatic or aliphatic di- or tri-isocyanates and their biurets, triurets, trimmers, trimethylol propane-adduct and mixtures thereof; and/or
 - ii. a di- or tri-oxiran compounds of formula:

$$A-(\text{oxiran-2-ylmethyl})_n$$

wherein n stands for 2 or 3 and 1 represents a C₂-C₆ group optionally comprising from 2 to 6 nitrogen and/or oxygen atoms;
 - e. optionally a C₁-C₄ compounds comprising two NH₂ functional groups;
- 3) Heating the dispersion; and
- 4) Cooling the dispersion.

In another particular embodiment, the second type of microcapsule comprises

- an oil-based core comprising a hydrophobic active, preferably perfume,
- optionally an inner shell made of a polymerized polyfunctional monomer;
- a biopolymer shell comprising a protein, wherein at least one protein is cross-linked.

According to a particular embodiment, the protein is chosen in the group consisting of milk proteins, caseinate salts such as sodium caseinate or calcium caseinate, casein, whey protein, hydrolyzed proteins, gelatins, gluten, pea protein, soy protein, silk protein and mixtures thereof, preferably sodium caseinate, most preferably sodium caseinate

According to a particular embodiment, the protein comprises sodium caseinate and a globular protein, preferably chosen in the group consisting of whey protein, beta-lactoglobulin, ovalbumine, bovine serum albumin, vegetable proteins, and mixtures thereof.

The protein is preferably a mixture of sodium caseinate and whey protein.

5 According to a particular embodiment, the biopolymer shell comprises a crosslinked protein chosen in the group consisting of sodium caseinate and/or whey protein.

According to a particular embodiment, the second type of microcapsules slurry comprises at least one microcapsule made of:

- an oil-based core comprising the hydrophobic active, preferably perfume;
- 10 - an inner shell made of a polymerized polyfunctional monomer; preferably a polyisocyanate having at least two isocyanate functional groups
- a biopolymer shell comprising a protein, wherein at least one protein is cross-linked; wherein the protein contains preferably a mixture comprising sodium caseinate and a globular protein, preferably whey protein.
- 15 - optionally at least an outer mineral layer.

According to an embodiment, sodium caseinate and/or whey protein is (are) cross-linked protein(s).

The weight ratio between sodium caseinate and whey protein is preferably comprised between 0.01 and 100, preferably between 0.1 and 10, more preferably between 0.2 and 5.

20

In another particular embodiment, the second type of microcapsules is a polyamide core-shell polyamide microcapsule comprising:

- an oil-based core comprising comprising a hydrophobic active, preferably perfume, and
- 25 - a polyamide shell comprising or being obtainable from:
 - an acyl chloride,
 - a first amino compound, and
 - a second amino compound.

30 According to a particular embodiment, the second type of microcapsules comprises: an oil-based core comprising a hydrophobic active, preferably perfume, and

a polyamide shell comprising or being obtainable from:

- an acyl chloride, preferably in an amount comprised between 5 and 98%, preferably between 20 and 98%, more preferably between 30 and 85% w/w
- a first amino compound, preferably in an amount comprised between 1% and 50% w/w, preferably between 7 and 40% w/w;
- a second amino compound, preferably in an amount comprised between 1% and 50% w/w, preferably between 2 and 25% w/w
- a stabilizer, preferably a biopolymer, preferably in an amount comprised between 0 and 90%, preferably between 0.1 and 75%, more preferably between 1 and 70%.

According to a particular embodiment, the second type of microcapsules comprises:

- an oil-based core comprising a hydrophobic active, preferably perfume, and
- a polyamide shell comprising or being obtainable from:
 - an acyl chloride,
 - a first amino-compound being an amino-acid, preferably chosen in the group consisting of L-Lysine, L-Arginine, L-Histidine, L-Tryptophane and/or mixture thereof.
 - a second amino compound chosen in the group consisting of ethylene diamine, diethylene triamine, cystamine and/or mixture thereof, and
 - a biopolymer chosen in the group consisting of casein, sodium caseinate, bovin serum albumin, whey protein, and/or mixture thereof.

According to another aspect, the shell of the second type of microcapsules is polyurea- or polyurethane-based. Examples of processes for the preparation of polyurea and polyurethane-based microcapsule slurry are for instance described in International Patent Application Publication No. WO2007/004166, European Patent Application Publication No. EP 2300146, and European Patent Application Publication No. EP25799. Typically a process for the preparation of polyurea or polyurethane-based microcapsule slurry include the following steps:

- a) Dissolving at least one polyisocyanate having at least two isocyanate groups in an oil to form an oil phase;

- b) Preparing an aqueous solution of an emulsifier or colloidal stabilizer to form a water phase;
- c) Adding the oil phase to the water phase to form an oil-in-water dispersion, wherein the mean droplet size is comprised between 1 and 500 μm , preferably between 5 and 50 μm ; and
- 5 d) Applying conditions sufficient to induce interfacial polymerisation and form microcapsules in form of a slurry.

PERFUMING COMPOSITION AND CONSUMER PRODUCTS

The microcapsules of the invention can be used in combination with active ingredients. An
10 object of the invention is therefore a composition comprising:

- (i) microcapsules or a microcapsule slurry as defined above;
- (ii) an active ingredient, preferably chosen in the group consisting of a cosmetic ingredient, skin caring ingredient, perfume ingredient, flavor ingredient, malodour counteracting ingredient, bactericide ingredient, fungicide ingredient, pharmaceutical or agrochemical ingredient, a
15 sanitizing ingredient, an insect repellent or attractant, and mixtures thereof.

The capsules of the invention show a good performance in terms of stability in challenging medium.

Another object of the present invention is a perfuming composition comprising:

- 20 (i) microcapsules or a microcapsule slurry as defined above, wherein the oil comprises a perfume;
- (ii) at least one ingredient selected from the group consisting of a perfumery carrier, a perfumery co-ingredient and mixtures thereof;
- (iii) optionally at least one perfumery adjuvant.

25 As liquid perfumery carriers one may cite, as non-limiting examples, an emulsifying system, i.e. a solvent and a surfactant system, or a solvent commonly used in perfumery. A detailed description of the nature and type of solvents commonly used in perfumery cannot be exhaustive. However, one can cite as non-limiting examples solvents such as dipropyleneglycol, diethyl phthalate, isopropyl myristate, benzyl benzoate, 2-(2-ethoxyethoxy)-1-ethanol or ethyl citrate,
30 which are the most commonly used. For the compositions which comprise both a perfumery carrier and a perfumery co-ingredient, other suitable perfumery carriers than those previously specified,

can be also ethanol, water/ethanol mixtures, limonene or other terpenes, isoparaffins such as those known under the trademark Isopar® (origin: Exxon Chemical) or glycol ethers and glycol ether esters such as those known under the trademark Dowanol® (origin: Dow Chemical Company). By “perfumery co-ingredient” it is meant here a compound, which is used in a perfuming preparation or a composition to impart a hedonic effect and which is not a microcapsule as defined above. In other words such a co-ingredient, to be considered as being a perfuming one, must be recognized by a person skilled in the art as being able to at least impart or modify in a positive or pleasant way the odor of a composition, and not just as having an odor.

The nature and type of the perfuming co-ingredients present in the perfuming composition do not warrant a more detailed description here, which in any case would not be exhaustive, the skilled person being able to select them on the basis of his general knowledge and according to the intended use or application and the desired organoleptic effect. In general terms, these perfuming co-ingredients belong to chemical classes as varied as alcohols, lactones, aldehydes, ketones, esters, ethers, acetates, nitriles, terpenoids, nitrogenous or sulfurous heterocyclic compounds and essential oils, and said perfuming co-ingredients can be of natural or synthetic origin. Many of these co-ingredients are in any case listed in reference texts such as the book by S. Arctander, *Perfume and Flavor Chemicals*, 1969, Montclair, New Jersey, USA, or its more recent versions, or in other works of a similar nature, as well as in the abundant patent literature in the field of perfumery. It is also understood that said co-ingredients may also be compounds known to release in a controlled manner various types of perfuming compounds. Co-ingredients may be chosen in the group consisting of 4-(dodecylthio)-4-(2,6,6-trimethyl-2-cyclohexen-1-yl)-2-butanone, 4-(dodecylthio)-4-(2,6,6-trimethyl-1-cyclohexen-1-yl)-2-butanone, trans-3-(dodecylthio)-1-(2,6,6-trimethyl-3-cyclohexen-1-yl)-1-butanone, 2-(dodecylthio)octan-4-one, 2-phenylethyl oxo(phenyl)acetate, 3,7-dimethylocta-2,6-dien-1-yl oxo(phenyl)acetate, (Z)-hex-3-en-1-yl oxo(phenyl)acetate, 3,7-dimethyl-2,6-octadien-1-yl hexadecanoate, bis(3,7-dimethylocta-2,6-dien-1-yl) succinate, (2-((2-methylundec-1-en-1-yl)oxy)ethyl)benzene, 1-methoxy-4-(3-methyl-4-phenethoxybut-3-en-1-yl)benzene, (3-methyl-4-phenethoxybut-3-en-1-yl)benzene, 1-(((Z)-hex-3-en-1-yl)oxy)-2-methylundec-1-ene, (2-((2-methylundec-1-en-1-yl)oxy)ethoxy)benzene, 2-methyl-1-(octan-3-yloxy)undec-1-ene, 1-methoxy-4-(1-phenethoxyprop-1-en-2-yl)benzene, 1-methyl-4-(1-phenethoxyprop-1-en-2-yl)benzene, 2-(1-phenethoxyprop-1-en-2-yl)naphthalene, (2-phenethoxyvinyl)benzene, 2-(1-((3,7-dimethyloct-6-en-1-yl)oxy)prop-1-en-2-yl)naphthalene,

(2-((2-pentylcyclopentylidene)methoxy)ethyl)benzene, 4-allyl-2-methoxy-1-((2-methoxy-2-phenylvinyl)oxy)benzene, (2-((2-heptylcyclopentylidene)methoxy)ethyl)benzene, 1-isopropyl-4-methyl-2-((2-pentylcyclopentylidene)methoxy)benzene, 2-methoxy-1-((2-pentylcyclopentylidene)methoxy)-4-propylbenzene, 3-methoxy-4-((2-methoxy-2-phenylvinyl)oxy)benzaldehyde, 4-((2-(hexyloxy)-2-phenylvinyl)oxy)-3-methoxybenzaldehyde or a mixture thereof.

By “perfumery adjuvant” we mean here an ingredient capable of imparting additional added benefit such as a color, a particular light resistance, chemical stability, etc. A detailed description of the nature and type of adjuvant commonly used in perfuming bases cannot be exhaustive, but it has to be mentioned that said ingredients are well known to a person skilled in the art.

Preferably, the perfuming composition according to the invention comprises between 0.01 and 30 % by weight of microcapsules or a microcapsule slurry as defined above.

The invention’s microcapsules can advantageously be used in many application fields and used in consumer products. Microcapsules can be used in liquid form applicable to liquid consumer products as well as in powder form, applicable to powder consumer products.

According to a particular embodiment, the consumer product as defined above is liquid and comprises:

- a) from 2 to 65% by weight, relative to the total weight of the consumer product, of at least one surfactant;
- b) water or a water-miscible hydrophilic organic solvent; and
- c) a microcapsule slurry or microcapsules as defined above,
- d) optionally non-encapsulated perfume.

According to a particular embodiment, the consumer product as defined above is in a powder form and comprises:

- a) from 2 to 65% by weight, relative to the total weight of the consumer product, of at least one surfactant;
- b) a microcapsule powder as defined above.
- c) optionally perfume powder that is different from the microcapsules defined above.

In the case of microcapsules including a perfume oil-based core, the products of the invention, can in particular be of used in perfumed consumer products such as product belonging

to fine fragrance or “functional” perfumery. Functional perfumery includes in particular personal-care products including hair-care, body cleansing, skin care, hygiene-care as well as home-care products including laundry care, surface care and air care. Consequently, another object of the present invention consists of a perfumed consumer product comprising as a perfuming ingredient, 5 the microcapsules defined above or a perfuming composition as defined above. The perfume element of said consumer product can be a combination of perfume microcapsules as defined above and free or non-encapsulated perfume, as well as other types of perfume microcapsules than those here-disclosed.

In particular a liquid consumer product comprising:

- 10 a) from 2 to 65% by weight, relative to the total weight of the consumer product, of at least one surfactant;
- b) water or a water-miscible hydrophilic organic solvent; and
- c) a perfuming composition as defined above is another object of the invention.

Also a powder consumer product comprising

- 15 (a) from 2 to 65% by weight, relative to the total weight of the consumer product, of at least one surfactant; and
- (b) a perfuming composition as defined above is part of the invention.

The invention’s microcapsules can therefore be added as such or as part of an invention’s perfuming composition in a perfumed consumer product.

20 For the sake of clarity, it has to be mentioned that, by “perfumed consumer product” it is meant a consumer product which is expected to deliver among different benefits a perfuming effect to the surface to which it is applied (e.g. skin, hair, textile, paper, or home surface) or in the air (air-freshener, deodorizer etc.). In other words, a perfumed consumer product according to the invention is a manufactured product which comprises a functional formulation also referred to as 25 “base”, together with benefit agents, among which an effective amount of microcapsules according to the invention.

The nature and type of the other constituents of the perfumed consumer product do not warrant a more detailed description here, which in any case would not be exhaustive, the skilled person being able to select them on the basis of his general knowledge and according to the nature 30 and the desired effect of said product. Base formulations of consumer products in which the microcapsules of the invention can be incorporated can be found in the abundant literature relative

to such products. These formulations do not warrant a detailed description here which would in any case not be exhaustive. The person skilled in the art of formulating such consumer products is perfectly able to select the suitable components on the basis of his general knowledge and of the available literature.

5 Non-limiting examples of suitable perfumed consumer products can be a perfume, such as a fine perfume, a cologne, an after-shave lotion, a body-splash; a fabric care product, such as a liquid or solid detergent, tablets and unit dose (single or multi chambers), a fabric softener, a dryer sheet, a fabric refresher, an ironing water, or a bleach; a personal-care product, such as a hair-care product (e.g. a shampoo, hair conditioner, a coloring preparation or a hair spray), a cosmetic
10 preparation (e.g. a vanishing cream, body lotion or a deodorant or antiperspirant), or a skin-care product (e.g. a perfumed soap, shower or bath mousse, body wash, oil or gel, bath salts, or a hygiene product); an air care product, such as an air freshener or a “ready to use” powdered air freshener; or a home care product, such all-purpose cleaners, liquid or power or tablet dishwashing products, toilet cleaners or products for cleaning various surfaces, for example sprays & wipes
15 intended for the treatment / refreshment of textiles or hard surfaces (floors, tiles, stone-floors etc.); a hygiene product such as sanitary napkins, diapers, toilet paper.

Another object of the invention is a consumer product comprising:

- a personal care active base, and
 - microcapsules, preferably perfume microcapsules, or a microcapsule slurry as defined above or
20 the perfuming composition as defined above,
- wherein the consumer product is in the form of a personal care composition.

Personal care active bases in which the microcapsules of the invention can be incorporated can be found in the abundant literature relative to such products. These formulations do not warrant a detailed description here which would in any case not be exhaustive. The person skilled in the
25 art of formulating such consumer products is perfectly able to select the suitable components on the basis of his general knowledge and of the available literature.

The personal care composition is preferably chosen in the group consisting of a hair-care product (e.g. a shampoo, hair conditioner, a coloring preparation or a hair spray), a cosmetic preparation (e.g. a vanishing cream, body lotion or a deodorant or antiperspirant), or a skin-care product (e.g.
30 a perfumed soap, shower or bath mousse, body wash, oil or gel, bath salts, or a hygiene product);

Another object of the invention is a consumer product comprising:

- a home care or a fabric care active base, and
 - microcapsules, preferably perfume microcapsules, or a microcapsule slurry as defined above or the perfuming composition as defined above,
- wherein the consumer product is in the form of a home care or a fabric care composition.

5 Home care or fabric care active bases in which the microcapsules of the invention can be incorporated can be found in the abundant literature relative to such products. These formulations do not warrant a detailed description here which would in any case not be exhaustive. The person skilled in the art of formulating such consumer products is perfectly able to select the suitable components on the basis of his general knowledge and of the available literature.

10 Preferably, the consumer product comprises from 0.1 to 15 wt%, more preferably between 0.2 and 5 wt% of the microcapsules or microcapsule slurry of the present invention, these percentages being defined by weight relative to the total weight of the consumer product. Of course, the above concentrations may be adapted according to the benefit effect desired in each product.

15 For liquid consumer product mentioned below, by “active base”, it should be understood that the active base includes active materials (typically including surfactants) and water.

 For solid consumer product mention below, by “active base”, it should be understood that the active base includes active materials (typically including surfactants) and auxiliary agents (such as bleaching agents, buffering agent; builders; soil release or soil suspension polymers;

20 granulated enzyme particles, corrosion inhibitors, antifoaming, sud suppressing agents; dyes, fillers, and mixtures thereof).

Fabric softener

 An object of the invention is a consumer product in the form of a fabric softener composition

25 comprising:

- a fabric softener active base; preferably comprising at least one active material chosen in the group consisting of dialkyl quaternary ammonium salts, dialkyl ester quaternary ammonium salts (esterquats), Hamburg esterquat (HEQ), TEAQ (triethanolamine quat), silicones and mixtures thereof, the active base being used preferably in an amount
- 30 comprised between 85 and 99.95% by weight based on the total weight of the composition,

- a microcapsule slurry or microcapsules as defined above, preferably in an amount comprised between 0.05 to 15 wt%, more preferably between 0.1 and 5 wt% by weight based on the total weight of the composition,
- optionally free perfume oil.

5

Liquid detergent

An object of the invention is a consumer product in the form of a liquid detergent composition comprising:

- a liquid detergent active base; preferably comprising at least one active material chosen in the group consisting of anionic surfactant such as alkylbenzenesulfonate (ABS), secondary alkyl sulfonate (SAS), primary alcohol sulfate (PAS), lauryl ether sulfate (LES), methyl ester sulfonate (MES) and nonionic surfactant such as alkyl amines, alkanolamide, fatty alcohol poly(ethylene glycol) ether, fatty alcohol ethoxylate (FAE), ethylene oxide (EO) and propylene oxide (PO) copolymers, amine oxydes, alkyl polyglucosides, alkyl polyglucosamides, the active base being used preferably in an amount comprised between 85 and 99.95% by weight based on the total weight of the composition,
- a microcapsule slurry or microcapsules as defined above, preferably in an amount comprised between 0.05 to 15 wt%, more preferably between 0.1 and 5 wt% by weight based on the total weight of the composition,
- optionally free perfume oil.

20

Solid detergent

An object of the invention is a consumer product in the form of a solid detergent composition comprising:

- a solid detergent active base; preferably comprising at least one active material chosen in the group consisting of anionic surfactant such as alkylbenzenesulfonate (ABS), secondary alkyl sulfonate (SAS), primary alcohol sulfate (PAS), lauryl ether sulfate (LES), methyl ester sulfonate (MES) and nonionic surfactant such as alkyl amines, alkanolamide, fatty alcohol poly(ethylene glycol) ether, fatty alcohol ethoxylate (FAE), ethylene oxide (EO) and propylene oxide (PO) copolymers, amine oxydes, alkyl polyglucosides, alkyl

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polyglucosamides, the active base being used preferably in an amount comprised between 85 and 99.95% by weight based on the total weight of the composition,

- a microcapsule powder or microcapsule slurry as defined above, preferably in an amount comprised between 0.05 to 15 wt%, more preferably between 0.1 and 5 wt% by weight based on the total weight of the composition,
- optionally free perfume oil.

Shampoo/shower gel

An object of the invention is a consumer product in the form of a shampoo or a shower gel composition comprising:

- a shampoo or a shower gel active base; preferably comprising at least one active material chosen in the group consisting of sodium alkylether sulfate, ammonium alkylether sulfates, alkylamphoacetate, cocamidopropyl betaine, cocamide MEA, alkylglucosides and aminoacid based surfactants and mixtures thereof, the active base being used preferably in an amount comprised between 85 and 99.95% by weight based on the total weight of the composition,
- a microcapsule slurry or microcapsules as defined above, preferably in an amount comprised between 0.05 to 15 wt%, more preferably between 0.1 and 5 wt% by weight based on the total weight of the composition,
- optionally free perfume oil.

Rinse-Off Conditioner

An object of the invention is a consumer product in the form of a rinse-off conditioner composition comprising:

- a rinse-off conditioner active base; preferably comprising at least one active material chosen in the group consisting of cetyltrimonium chloride, stearyl trimonium chloride, benzalkonium chloride, behentrimonium chloride and mixture thereof, the active base being used preferably in an amount comprised between 85 and 99.95% by weight based on the total weight of the composition,

- a microcapsule slurry or microcapsules as defined above, preferably in an amount comprised between 0.05 to 15 wt%, more preferably between 0.1 and 5 wt% by weight based on the total weight of the composition,
- optionally free perfume oil.

5

Solid scent booster

An object of the invention is a consumer product in the form of a solid scent booster composition comprising:

- a solid carrier, preferably chosen in the group consisting of urea, sodium chloride, sodium sulphate, sodium acetate, zeolite, sodium carbonate, sodium bicarbonate, clay, talc, calcium carbonate, magnesium sulfate, gypsum, calcium sulfate, magnesium oxide, zinc oxide, titanium dioxide, calcium chloride, potassium chloride, magnesium chloride, zinc chloride, saccharides such as sucrose, mono-, di-, and polysaccharides and derivatives such as starch, cellulose, methyl cellulose, ethyl cellulose, propyl cellulose, polyols/sugar alcohols such as sorbitol, maltitol, xylitol, erythritol, and isomalt, PEG, PVP, citric acid or any water soluble solid acid, fatty alcohols or fatty acids and mixtures thereof,
- a microcapsule slurry or microcapsules as defined above, in a powdered form, preferably in an amount comprised between 0.05 to 15 wt%, more preferably between 0.1 and 5 wt% by weight based on the total weight of the composition,
- optionally free perfume oil.

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20**Liquid scent booster**

An object of the invention is a consumer product in the form of a liquid scent booster composition comprising:

- an aqueous phase,
- a surfactant system essentially consisting of one or more than one non-ionic surfactant, wherein the surfactant system has a mean HLB between 10 and 14, preferably chosen in the group consisting of ethoxylated aliphatic alcohols, POE/PPG (polyoxyethylene and polyoxypropylene) ethers, mono and polyglyceryl esters, sucrose ester compounds, polyoxyethylene hydroxylesters, alkyl polyglucosides, amine oxides and combinations thereof;

25
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- a linker chosen in the group consisting of alcohols, salts and esters of carboxylic acids, salts and esters of hydroxyl carboxylic acids, fatty acids, fatty acid salts, glycerol fatty acids, surfactant having an HLB less than 10 and mixtures thereof, and
- 5 - a microcapsule slurry or microcapsules as defined above, in the form of a slurry, preferably in an amount comprised between 0.05 to 15 wt%, more preferably between 0.1 and 5 wt% by weight based on the total weight of the composition,
- optionally free perfume oil.

10 **Hair coloration**

An object of the invention is a consumer product in the form of an oxidative hair coloring composition comprising:

- an oxidizing phase comprising an oxidizing agent and an alkaline phase comprising an alkakine agent, a dye precursor and a coupling compound; wherein said dye precursor and
- 15 said coupling compound form an oxidative hair dye in the presence of the oxidizing agent, preferably in an amount comprised between 85 and 99.95% by weight based on the total weight of the composition,
- microcapsules or microcapsule slurry as defined above, preferably in an amount comprised between 0.05 to 15 wt%, more preferably between 0.1 and 5 wt% by weight based on the
- 20 total weight of the composition,
- optionally free perfume oil

Perfuming composition

According to a particular embodiment, the consumer product is in the form of a perfuming

25 composition comprising:

- 0.1 to 30%, preferably 0.1 to 20% of microcapsules or microcapsule slurry as defined previously,
- 0 to 40%, preferably 3-40% of perfume, and
- 20-90%, preferably 40-90% of ethanol, by weight based on the total weight of the
- 30 perfuming composition.

The invention will now be further described by way of examples. It will be appreciated that the invention as claimed is not intended to be limited in any way by these examples.

EXAMPLES

5 General protocol:

Oil phase preparation:

A protein was optionally added in an inert solvent (**IS**) (for example Benzyle Benzoate (**BB**) or Sunflower oil (**SF**)) at 60°C for 30 min and then introduced into the perfume (see Table 1). The acyl chloride monomer (for example 1,3,5-benzene tricarbonyl chloride - **TMCI**) was introduced
10 in the previous mixture just before the emulsification process.

Water phase:

This phase was composed by the dissolution (or dispersion) of an anionic polysaccharide (**PS**) (for example Alginic acid sodium salt) in water (94g of water).

An amino-compound A (**AC A** in tables below) is added to the water solution before the
15 emulsification step.

An amino-compound B (**AC B** in tables below) (for example L-Lysine), a base (for example NaOH) or both, can be added in the water phase before the emulsification process.

Oil phase was mixed with the water phase and dispersed with an Ultra Turrax at 24,000 rpm for 30 s to afford an emulsion. The reaction mixture was stirred at 60°C for 4 h to afford a white
20 dispersion.

Ingredients

- 1,3,5-benzene tricarbonyl chloride (TMCI); origin: Aldrich, Switzerland
- 25 - L-arginine, origin: Aldrich, Switzerland
- Sodium caseinate (SC): origin: Aldrich, Switzerland
- Alginic acid sodium salt from brown algae low viscosity (Sodium alginate – SA): origin: Aldrich, Switzerland
- L-Lysine (LL), origin: Aldrich, Switzerland
- 30 - Sodium hydroxyde: origin: Aldrich, Switzerland
- Potato protein (Solanic® 200), Origin: Avebe, Netherlands

- Canola protein (CanolaPro®, Origin: DSM)
- Sodium caseinate (Origin: Aldrich)

Perfume:

5 Table 1 - Formulation of the perfume oil

Ingredients	% in oil
Ethyl 2-methyl-pentanoate	3.20%
Eucalyptol	7.80%
2,4-Dimethyl-3-cyclohexene-1-carbaldehyde	0.75%
Aldehyde C ₁₀	0.75%
Citronellyl Nitrile	4.30%
Isobornyl acetate	3.00%
2-tert-butyl-1-cyclohexyl acetate	9.80%
Citronellyl Acetate	1.30%
2-Methylundecanal	3.00%
Diphenyloxide	0.80%
Aldehyde C ₁₂	1.30%
Dicyclopentadiene acetate	9.85%
Ionone beta	3.30%
Undecalactone gamma	18.75%
Hexyl Salicylate	15.90%
Benzyl Salicylate	16.20%

Example 1

Microcapsule preparation according to the invention

10

Microcapsules A: Preparation of capsules with 1,3,5-benzene tricarbonyl chloride (**TMCI**), triethylenetetramine (**TET**), potato protein (**PP**) or canola protein (**CP**) or sodium caseinate (**SC**),

Alginic acid sodium salt (sodium alginate - **SA**), L-Lysine (**LL**), NaOH and perfume (see Table 1)

Table 2: Microcapsules A composition

A	Acyl chloride (g)	AC A (g)	IS (g)	Perfume (g)	Stabilizer (g)	PS (g)	AC B (g)	Base (g)	[NH ₂ and/or NH]/[COCl] (mol/mol)
A1	0.88 TMC1	0.26 TET	10 BB	25	1 PP	0.5 SA	0.7 LL	0.11 NaOH	0.7
A2	0.88 TMC1	0.13 TET	10 BB	25	1 PP	0.5 SA	0.7 LL	0.11 NaOH	0.35
A3	0.88 TMC1	0.09 TET	10 BB	25	1 PP	0.5 SA	0.7 LL	0.11 NaOH	0.25
A4	0.88 TMC1	0.13 TET	10 SF	25	1.16 PP	0.5 SA	0.7 LL	0.11 NaOH	0.35
A5	0.44 TMC1	0.18 TET	10 SF	25	1.16 PP	0.5 SA	0.2 LL	0.11 NaOH	1
A6	0.88 TMC1	0.09 TET	10 BB	25	1 CP	0.5 SA	0.7 LL	0.11 NaOH	0.25
A7	0.44 TMC1	0.18 TET	10 SF	25	1.16 CP	0.5 SA	0.2 LL	0.11 NaOH	1
A8	0.88 TMC1	0.09 TET	10 BB	25	1 SC	0.5 SA	0.7 LL	0.11 NaOH	0.25
A9	0.44 TMC1	0.18 TET	10 SF	25	1.16 SC	0.5 SA	0.2 LL	0.11 NaOH	1

Microcapsules B: Preparation of capsules with 1,3,5-benzene tricarbonyl chloride (**TMC1**), tetraethylenepentamine (**TEP**), potato protein (**PP**) or canola protein (**CP**) or sodium caseinate (**SC**), Alginic acid sodium salt (sodium alginate - **SA**), L-Lysine (**LL**), NaOH and perfume (see Table 1)

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Table 3: Microcapsules B composition

B	Acyl chloride (g)	AC A (g)	IS (g)	Perfume (g)	Stabilizer (g)	PS (g)	AC B (g)	Base (g)	[NH ₂ and/or NH]/[COCl] (mol/mol)
B1	0.88 TMC1	0.13 TEP	10 SF	25	1 PP	0.5 SA	0.7 LL	0.11 NaOH	0.35
B2	0.88 TMC1	0.13 TEP	10 SF	25	1 CP	0.5 SA	0.7 LL	0.11 NaOH	0.35
B3	0.88 TMC1	0.13 TEP	10 SF	25	1 CS	0.5 SA	0.7 LL	0.11 NaOH	0.35

Microcapsules C: Preparation of capsules with 1,3,5-benzene tricarbonyl chloride (**TMC1**), polyethylenimine branched (**PEB**), potato protein (**PP**) or canola protein (**CP**) or sodium caseinate (**SC**), Alginic acid sodium salt (sodium alginate - **SA**), L-Lysine (**LL**), NaOH and perfume (see Table 1)

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Table 4: Microcapsules C composition

C	Acyl chloride (g)	AC A (g)	IS (g)	Perfume (g)	Stabilizer (g)	PS (g)	AC B (g)	Base (g)	[NH ₂ and/or NH]/ [COCl] (mol/mol)
C1	0.88 TMCI	0.3 PEB	10 BB	25	1 PP	0.5 SA	0.7 LL	0.11 NaOH	0.35
C2	0.88 TMCI	0.3 PEB	10 SF	25	1.16 PP	0.5 SA	0.7 LL	0.11 NaOH	0.35
C3	0.88 TMCI	0.15 PEB	10 SF	25	1.16 PP	0.5 SA	0.7 LL	0.11 NaOH	0.17
C4	0.88 TMCI	0.5 PEB	10 SF	25	1.16 PP	0.5 SA	0.7 LL	0.11 NaOH	0.5
C5	0.88 TMCI	0.09 TET	10 BB	25	1 CP	0.5 SA	0.7 LL	0.11 NaOH	0.25
C6	0.44 TMCI	0.18 TET	10 SF	25	1.16 CP	0.5 SA	0.2 LL	0.11 NaOH	1
C7	0.88 TMCI	0.09 TET	10 BB	25	1 SC	0.5 SA	0.7 LL	0.11 NaOH	0.25
C8	0.44 TMCI	0.18 TET	10 SF	25	1.16 SC	0.5 SA	0.2 LL	0.11 NaOH	1

Microcapsules D: Preparation of capsules with 1,3,5-benzene tricarbonyl chloride (**TMCI**), L-arginine (**LA**), potato protein (**PP**) or canola protein (**CP**) or sodium caseinate (**SC**), Alginic acid sodium salt (sodium alginate - **SA**), L-Lysine (**LL**), NaOH and perfume (see Table 1)

Table 5: Microcapsules D composition

D	Acyl chloride (g)	AC A (g)	IS (g)	Perfume (g)	Stabilizer (g)	PS (g)	AC B (g)	Base (g)	[NH ₂ and/or NH]/ [COCl] (mol/mol)
D1	0.88 TMC1	0.3 LA	10 BB	25	1 PP	0.5 SA	0.7 LL	0.11 NaOH	0.5
D2	0.88 TMC1	0.3 LA	10 BB	25	1 CP	0.5 SA	0.7 LL	0.11 NaOH	0.5
D3	0.88 TMC1	0.3 LA	10 BB	25	1 SC	0.5 SA	0.7 LL	0.11 NaOH	0.5

Example 2

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Stability performance of microcapsules according to the invention

Microcapsules of the present invention are dispersed in a fabric softener composition described in Table 6 to obtain a concentration of encapsulated perfume oil at 0.116%.

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Table 6: Fabric Conditioner composition

Product	Wt %
Stepantex VL 90A	8.88
Calcium Chloride Sol. 10%	0.36

Proxel GXL	0.04
Perfume	1.00
Water	89.72
TOTAL	100

Protocol:

Weigh 2g of sample (base with capsules) in a 20mL vial. Add to the vial 10 mL of the extraction solvent isooctane containing the internal standard 1,4-dibromobenzene at a precisely known concentration around 90 ng/uL. Shake for 45 min at 40RPM to extract the free perfume. Remove the solvent phase.

To measure the leakage in the base the Agilent GCFID7890A is used, the injector is set at 250°C, helium is used as the carrier gas at a flow rate of 1 mL/min, the oven temperature is programmed from 120°C, held 5 minutes, increased to 170°C at 10°C/min, increased to 220°C at 25°C/min and then increased to 260 at 25°C/min. To finish a post run is apply at 260°C to finish the measure.

Calibration solutions are prepared at 100, 300 and 600 ng/uL of fragrance oil in the isooctane. It is important that the fragrance oil used to prepare the calibration curve comes from the same batch used to produce the microcapsules.

Table 7: Leakage 3days/30 days (37°C)

Microcapsule	3days	30 days
A1	18%	29%
A2	15%	31%
A3	22%	35%
A4	17%	27%
A5	34%	n.m.
B1	21%	o.g.
C1	22%	34%
C2	18%	36%
C3	32%	n.m.
D1	33%	n.m.

n.m.: not measured

One can conclude that the microcapsules of the present invention show good stability in challenging bases.

Example 3

5 Biodegradability of microcapsules according to the invention

Shell extraction (following method disclosed in *Gasparini and all in Molecules 2020, 25,718*)

The microcapsule slurry was lyophilized. The recovered solid was grinded using a crusher IKA tube-mill control for 30 sec. The resulting paste (fragrance oil + polymeric shells) was suspended
10 in 300mL of Ethyl acetate and the mixture was stirred for 1h at room temperature. The solid was collected by filtration under vacuum over a gooch filter crucible (porosity 4). This extraction step was repeated 5 times to remove the maximum of fragrance oil from the shells. The powder was dried under vacuum (10 mBar) at 50°C until the weight of the polymer, monitored by gravimetry, was constant. The resulting powder was grinded using a crusher IKA tube-mill control for 1min
15 30sec, suspended in Di water (0.5%w/w) and stirred at 300 RPM for 24H at RT. The water was removed by filtration under vacuum over a gooch filter crucible (porosity 4) and the powder was dried at RT for 2.5 days and then under vacuum (10 mBar) at 50°C overnight. Finally, the obtained powder was grinded using a crusher IKA tube-mill control for 1min and 30 seconds, and extracted an additional five times with ethyl acetate as described before. The final powder was dried under
20 vacuum (10 mBar) at 50°C overnight. To ensure that the totality of the perfume was removed, the sample was analyzed by GC-pyrolysis and send to biodegradation measurement following the OECD301F method.

The biodegradability of the shell for the exemplified samples was greater than 40% after 60 days of test.

25

Example 4

Spray-dried microcapsules preparation

Emulsions A-E having the following ingredients are prepared.

30

Table 8: Composition of Emulsions A-E and composition of granulated powder A-E after spray-drying

Ingredients	Emulsion A	Emulsion B	Emulsion C	Emulsion D	Emulsion E
Modified starch ¹⁾	2.6%	2.6%	2.6%	12.5%	2%
Maltodextrin ²⁾	26.8%	22.8%	19.3%	0%	19.1%
Maltose ³⁾	0%	0%	0%	7.9%	0%
Citric Acid	0%	0%	0%	1%	0%
Tripotassium Citrate	0%	0%	0%	1.9%	0%
Exemplified Microcapsules	12.0%	24%	37.0%	8.9%	56.2%
Silica ⁴⁾	1.1%	1.1%	1.1%	0%	0%
Free Perfume B ⁵⁾	0%	0%	0%	11%	0%
Water	57.6%	49.6%	40.1%	56.9%	22.7%
	Granule A	Granule B	Granule C	Granule D	Granule E
Modified starch ¹⁾	7.5%	7.4%	7.2%	31.6%	4.9%
Maltodextrin ²⁾	77.4%	65.5%	53.8%	0%	44.7%
Maltose	0%	0%	0%	20.9%	
Citric Acid	0%	0%	0%	2.6%	0%
Tripotassium citrate	0%	0%	0%	4.9%	0%
Encapsulated perfume B	0%	0%	0%	28.1%	0%

Microcapsules I-L	12.0%	24.1%	36.1%	9.8%	48.4%
Silica	3.0	3.0%	2.9%	2.0%	2%
Fragrance loading in powder after spray-drying	10.1%	20.1%	30%	35.8%	40.2%

- 1) Capsul™, Ingredion
- 2) Maltodextrin 10DE origin: Roquette
- 3) Maltose, Lehmann & Voss
- 5 4) Silica, Evonik
- 5) see table 9

Table 9: Composition of Perfume B

Component	%
ACÉTATE DE 4-(1,1-DIMÉTHYLÉTHYL)-1-CYCLOHEXYLE 1)	14.50
LINALOL BJ	10.50
LILIAL® ²⁾	10.00
ISO E SUPER ³⁾	10.00
CITRONELLYL NITRILE	9.00
DIPHENYLOXYDE	6.50
ISOBORNYL ACETATE	6.00
BETA IONONE	6.00
TRICYCLO[5.2.1.0~2,6~]DEC-3-EN-8-YL ACETATE (A) + TRICYCLO[5.2.1.0~2,6~]DEC-4-EN-8-YL ACETATE (B) 4)	5.50
ETHER MT	4.00
HEDIONE® ⁵⁾	4.00

GERANIOL 60	3.00
CITRAL	2.50
ALDEHYDE C 10	2.50
ALLYL HEPTANOATE	2.50
ETHYL METHYL-2-BUTYRATE	1.50
GERANYL ACETATE	1.00
2,4-DIMETHYL-3-CYCLOHEXENE-1-CARBALDEHYDE ⁶⁾	1.00

1) Firmenich SA, Switzerland

2) 3-(4-tert-butylphenyl)-2-methylpropanal, Givaudan SA, Vernier, Switzerland

3) 1-(octahydro-2,3,8,8-tetramethyl-2-naphthalenyl)-1-ethanone, International Flavors & Fragrances,
5 USA

4) Firmenich SA, Switzerland

5) Methyl dihydrojasmonate, Firmenich SA, Switzerland

6) Firmenich SA, Switzerland

10 Components for the polymeric matrix (Maltodextrin and capsulTM, or capsulTM, citric acid and tripotassium citrate) are added in water at 45-50°C until complete dissolution.

For emulsion D, free perfume C is added to the aqueous phase.

Microcapsules slurry is added to the obtained mixture. Then, the resulting mixture is then mixed gently at 25°C (room temperature).

15 Granulated powder A-E are prepared by spray-drying Emulsion A-E using a Sodeva Spray Dryer (Origin France), with an air inlet temperature set to 215°C and a throughput set to 500 ml per hour. The air outlet temperature is of 105°C. The emulsion before atomization is at ambient temperature.

Example 5

20 Liquid scent booster composition

A sufficient amount of exemplified microcapsules is weighed and mixed in a liquid scent booster (Table 22) to add the equivalent of 0.2% perfume.

Table 10: Liquid scent booster composition

Ingredients	Amount (% wt)					
	1	2	3	4	5	6
Water	71.20%	89.5%	78.8%	79.4%	70%	70%
Propylene glycol	20.30%	-	-	-	20%	20%
Polyethylene glycol ethers of decyl alcohol ¹⁾	4.00%	6%				
Polyethylene glycol ether of Lauryl Alcohol ²⁾					4.00%	4.00%
alkyl polyglucoside C8-C10 ³⁾			8.30%	7.7%		
Deceth-3 ¹⁾	1.50%					
Lauryl lactate				1%		
Lauric acid		1.5%	1.60%			
Glyceryl Caprylate					3.00%	3.00%
Fragrance	3.00%	3.0%	3.00%	3.00%	3.00%	0%

1) Deceth-8; trademark and origin : KKK Oleo

2) Laureth-9

5 3) Plantacare 2000UP; trademark and origin : BASF

Different ringing gel compositions are prepared (compositions 1-6) according to the following protocol.

10 In a first step, the aqueous phase (water), the solvent (propylene glycol) if present and surfactants are mixed together at room temperature under agitation with magnetic stirrer at 300 rpm for 5 min.

In a second step, the linker is dissolved in the hydrophobic active ingredient (fragrance) at room temperature under agitation with magnetic stirrer at 300 rpm. The resulting mixture is mixed for 5 min.

Then, the aqueous phase and the oil phase are mixed together at room temperature for 5 min leading to the formation of a transparent or opalescent ringing gel.

Example 6

5

Liquid detergent composition

A sufficient amount of exemplified microcapsules is weighed and mixed in a liquid detergent to add the equivalent of 0.2% perfume.

10 Table 11: Liquid detergent composition

Ingredients	Concentration [wt%]
Sodium C ₁₄₋₁₇ Alkyl Sec Sulfonate ¹⁾	7
Fatty acids, C ₁₂₋₁₈ and C ₁₈ -unsaturated ²⁾	7.5
C _{12/14} fatty alcohol polyglycol ether with 7 mol EO ³⁾	17
Triethanolamine	7.5
Propylene Glycol	11
Citric acid	6.5
Potassium Hydroxyde	9.5
Properase L ⁴⁾	0.2
Puradax EG L ⁴⁾	0.2
Purastar ST L ⁴⁾	0.2
Acrylates/Steareth-20 Methacrylate structuring Crosspolymer ⁵⁾	6
Deionized Water	27.4

- 1) Hostapur SAS 60; Origin: Clariant
- 2) Edenor K 12-18; Origin: Cognis
- 3) Genapol LA 070; Origin: Clariant
- 4) Origin: Genencor International
- 5) Aculyn 88; Origin: Dow Chemical

Example 7

Unit dose formulation

- 10 A sufficient amount of exemplified microcapsules is weighed and mixed in a unit dose formulation to add the equivalent of 0.2% perfume.

The unit dose formulation can be contained in a PVOH (polyvinyl alcohol) film.

Table 12: Unit dose composition

Ingredients	Concentration [wt%]
C12 - C14 alkyl poly ethoxylate	15
C12 - C14 alkyl poly ethoxylate sulfate Mono Ethanol Amine salt	9.5
Linear Alkylbenzene sulfonic acid	17
Citric Acid	0.5
C12 - C18 Fatty Acid	17
Enzymes	1.2
Fluorescent brightener	0.3
1,2 propanediol	12
Glycerol	9
Sodium Hydroxide	1
Mono Ethanol Amine	6
PDMS	2.5
Potassium sulphite	0.2
water	8.8

Total	100
-------	-----

Example 8

Powder detergent composition

5

A sufficient amount of exemplified microcapsules is weighed and mixed in a powder detergent composition (Table 13) to add the equivalent of 0.2% perfume.

Table 13: Powder detergent composition

10

Ingredients	Part
Anionic (Linear Alkyl Benzene Sulphonates)	20%
Nonionics (Alcohol Ethoxylates (5-9 ethylene oxide)	6%
Builders (zeolites, sodium carbonate)	25%
Silicates	6%
Sodium Sulphate	35%
Others (Enzymes, Polymers, Bleach)	7.5%
Spray-dried granule powder A-E	0.5%

Example 9

Concentrated All Purpose Cleaner composition

15

A sufficient amount of exemplified microcapsules is weighed and mixed in a concentrated all-purpose cleaner composition (Table 14) to add the equivalent of 0.2% perfume.

Table 14: concentrated all-purpose cleaner composition

Ingredients	Amount (%) wt)	Function
Ethoxylated Alcohol (C9-C11, 8EO) ⁽¹⁾	20	Non-ionic surfactant
Sodium Dodecyl Benzene Sulfonate ⁽²⁾	16	Anionic surfactant
Sodium Cumene Sulfonate ⁽³⁾	8	Hydrotrope
Methyl chloro isothiazolinone Methyl isothiazolinone 3.3:1 ⁽⁴⁾	0.8%	preservative
Water	55.9	solvent

1) Neodol 91-8 ®; trademark and origin : Shell Chemical

2) Biosoft D-40®; trademark and origin : Stepan Company

5 3) Stepanate SCS®; trademark and origin : Stepan Company

4) Kathon CG®; trademark and origin : Dow Chemical Company

All ingredients are mixed together and then the mixture was diluted with water to 100%.

Example 10

10 Solid scent booster composition

The following compositions are prepared.

Table 15: Salt-based solid scent booster compositions

15

Ingredients	Part
Sodium chloride	95
Spray-dried granule powder A-E	5

Table 16: Urea-based solid scent booster compositions

Ingredients	Part
-------------	------

Urea (beads)	94
Spray-dried granule powder A-E	8
Bentonite	3
Perfume	3

Example 11Shampoo composition

- 5 A sufficient amount of exemplified microcapsules is weighed and mixed in a shampoo composition to add the equivalent of 0.2% perfume.

Table 17: Shampoo composition

	Ingredients	Concentration [wt%]
A	Water deionized	44.4
	Polyquaternium-10 ¹⁾	0.3
	Glycerin 85% ²⁾	1
	DMDM Hydantoin ³⁾	0.2
B	Sodium Laureth Sulfate ⁴⁾	28
	Cocamidopropyl Betaine ⁵⁾	3.2
	Disodium Cocoamphodiacetate ⁶⁾	4
	Ethoxy (20) Stearyl Alcohol ⁶⁾	1
C	Sodium Laureth Sulfate ⁴⁾	3
	Glyceryl Laureate ⁷⁾	0.2
D	Water deionized	1
	Sodium Methylparaben ⁸⁾	0.1
E	Sodium Chloride 10% aqueous sol.	15
	Citric acid 10% aqueous sol. till pH 5.5-6	q.s.
	Perfume	0.5

	T O T A L:	100
--	-------------------	------------

- 1) Ucare Polymer JR-400, Noveon
- 2) Schweizerhall
- 3) Glydant, Lonza
- 4) Texapon NSO IS, Cognis
- 5) Tego Betain F 50, Evonik
- 6) Amphotensid GB 2009, Zschimmer & Schwarz
- 7) Monomuls 90 L-12, Gruenau
- 8) Nipagin Monosodium, NIPA

Polyquaternium-10 is dispersed in water. The remaining ingredients of phase A are mixed separately by addition of one after the other while mixing well after each adjunction. Then this pre-mix is added to the Polyquaternium-10 dispersion and was mixed for 5 min. Then Phase B and the premixed Phase C (heat to melt Monomuls 90L-12 in Texapon NSO IS) are added. The mixture is mixed well. Then, Phase D and Phase E are added while agitating. The pH was adjusted with citric acid solution till pH: 5.5 – 6.0.

Example 12

Shampoo composition

A sufficient amount of exemplified microcapsules is weighed and mixed in a shampoo composition to add the equivalent of 0.2% perfume.

Table 18: Shampoo composition

	Ingredients	Concentration [wt%]
A	Water deionized	45.97
	Tetrasodium EDTA ¹⁾	0.05
	Guar Hydroxypropyltrimonium Chloride ²⁾	0.05
	Polyquaternium-10 ³⁾	0.075
B	NaOH 10% aqueous sol.	0.3

C	Ammonium Lauryl Sulfate ⁴⁾	34
	Ammonium Laureth Sulfate ⁵⁾	9.25
	Cocamidopropyl Betaine ⁶⁾	2
	Dimethicone (&) C12-13 Pareth-4 (&) C12-13 Pareth-23 (&) Salicylic Acid ⁷⁾	2.5
D	Cetyl Alcohol ⁸⁾	1.2
	Cocamide MEA ⁹⁾	1.5
	Glycol Distearate ¹⁰⁾	2
E	Methylchloroisothiazolinone & Methylisothiazolinone ¹¹⁾	0.1
	D-Panthenol 75% ¹²⁾	0.1
	Water deionized	0.3
F	Sodium Chloride 25% aqueous sol.	0.6
	T O T A L:	100

1) EDETA B Powder, BASF

2) Jaguar C14 S, Rhodia

3) Ucare Polymer JR-400, Noveon

4) Sulfetal LA B-E, Zschimmer & Schwarz

5) Zetesol LA, Zschimmer & Schwarz

6) Tego Betain F 50, Evonik

7) Xiameter MEM-1691, Dow Corning

8) Lanette 16, BASF

9) Comperlan 100, Cognis

10) Cutina AGS, Cognis

11) Kathon CG, Rohm & Haas

12) D-Panthenol, Roche

A premix comprising Guar Hydroxypropyltrimonium Chloride and Polyquaternium-10 are added to water and Tetrasodium EDTA while mixing. When the mixture is homogeneous, NaOH is added. Then, Phase C ingredients are added and the mixture was heat to 75 °C. Phase D ingredients are added and mixed till homogeneous. The heating is stopped and temperature of the mixture is

decreased to RT. At 45 °C, ingredients of Phase E while mixing final viscosity is adjusted with 25% NaCl solution and pH of 5.5-6 is adjusted with 10% NaOH solution.

Example 13

5

Rinse-off hair composition

A sufficient amount of exemplified microcapsules is weighed and mixed in a rinse-off composition (Table 19) to add the equivalent of 0.2% perfume.

10 Table 19: rinse-off composition

	Ingredients	Concentration [wt %]
A	Water deionized	81.8
	Behentrimonium Chloride ¹⁾	2.5
	Hydroxyethylcellulose ²⁾	1.5
B	Cetearyl Alcohol ³⁾	4
	Glyceryl Stearate (and) PEG-100 Stearate ⁴⁾	2
	Behentrimonium Methosulfate (and) Cetyl alcohol (and) Butylene Glycol ⁵⁾	4
	Ethoxy (20) Stearyl Alcohol ⁶⁾	1
C	Amodimethicone (and) Trideceth-12 (and) Cetrimonium Chloride ⁷⁾	3
	Chlorhexidine Digluconate ⁸⁾ 20% aqueous solution	0.2
D	Citric acid 10% aqueous sol. till pH 3.5-4	q.s.
	T O T A L:	100

1) Genamin KDMP, Clariant

2) Tylose H10 Y G4, Shin Etsu

3) Lanette O, BASF

4) Arlacel 165, Croda

15 5) Incroquat Behenyl TMS-50-PA- (MH), Croda

6) Brij S20, Croda

7) Xiameter MEM-949, Dow Corning

8) Alfa Aesar

Ingredients of Phase A are mixed until an uniform mixture was obtained. Tylose is allowed to completely dissolve. Then the mixture is heated up to 70-75°C. Ingredients of Phase B are combined and melted at 70-75°C. Then ingredients of Phase B are added to Phase A with good agitation and the mixing is continued until cooled down to 60°C. Then, ingredients of Phase C are added while agitating and keeping mixing until the mixture cooled down to 40°C. The pH is adjusted with citric acid solution till pH: 3.5 – 4.0.

Example 14

Antiperspirant spray anhydrous composition

A sufficient amount of exemplified microcapsules is weighed and mixed in an antiperspirant spray anhydrous composition to add the equivalent of 0.2% perfume.

Table 20: antiperspirant spray anhydrous composition

Ingredient	Amount (wt %)
Cyclomethicone ¹⁾	53.51
Isopropyl miristate	9.04
Silica ²⁾	1.03
Quaternium-18-Hectorite ³⁾	3.36
Aluminium Chlorohydrate ⁴⁾	33.06

1) Dow Corning® 345 Fluid; trademark and origin: Dow Corning

2) Aerosil® 200 ; trademark and origin : Evonik

3) Bentone® 38; trademark and origin : Elementis Specialities

4) Micro Dry Ultrafine; origin : Reheis

Using a high speed stirrer, Silica and Quaternium-18-Hectorite are added to the Isopropyl miristate and Cyclomethicone mixture. Once completely swollen, Aluminium Chlorohydrate is added

portion wise under stirring until the mixture was homogeneous and without lumps. The aerosol cans are filled with 25 % Suspension of the suspension and 75 % of Propane/Butane (2,5 bar).

Example 15

Antiperspirant spray emulsion composition

5

A sufficient amount of exemplified microcapsules is weighed and mixed in antiperspirant spray emulsion composition to add the equivalent of 0.2% perfume.

Table 21: antiperspirant spray emulsion composition

Ingredient	Amount (wt %)
Polysorbate 65 ¹⁾ (Part A)	0.95
Polyglyceryl-2 dipolyhydroxystearate ²⁾ (Part A)	1.05
Cetyl PEG/PPG-10/1 Dimethicone ³⁾ (Part A)	2.75
Cyclomethicone ⁴⁾ (Part A)	16.4
Isopropylisostearate ⁵⁾ (Part A)	4.5
Phenoxyethanol ⁶⁾ (Part A)	0.5
Ethylhexylglycerin ⁷⁾ (Part A)	0.2
C12-15 Alkyl Benzoate ⁸⁾ (Part A)	5.65
Silica Silylate ⁹⁾ (Part A)	0.1
Sodium Methylparaben ¹⁰⁾ (Part B)	0.1
Aluminium Chlorohydrate ¹¹⁾ (Part B)	20
Water (Part B)	44.47
Fragrance (Part C)	3.33

10

- 1) Tween 65; trademark and origin : CRODA
- 2) Dehymuls PGPH; trademark and origin : BASF
- 3) Abil EM-90; trademark and origin : BASF
- 4) Dow Corning 345 fluid; trademark and origin : Dow Corning
- 5) Crodamol ipis; trademark and origin : CRODA

- 6) Phenoxyethanol; trademark and origin : LANXESS
7) Sensiva sc 50; trademark and origin : KRAFT
8) Tegosoft TN; trademark and origin : Evonik
9) Aerosil R 812; trademark and origin : Evonik
5 10) Nipagin mna; trademark and origin : CLARIANT
11) Locron L; trademark and origin : CLARIANT

The ingredients of Part A and Part B are weighted separately. Ingredients of Part A are heated up to 60°C and ingredients of Part B are heated to 55 °C. Ingredients of Part B are poured small parts
10 while continuous stirring into A. Mixture were stirred well until the room temperature was reached. Then, ingredients of part C are added. The emulsion is mixed and is introduced into the aerosol cans. The propellant is crimped and added.

Aerosol filling: 30% Emulsion: 70% Propane / Butane 2,5 bar
15

Example 16

Deodorant spray composition

A sufficient amount of exemplified microcapsules is weighed and mixed in antiperspirant
20 deodorant spray composition to add the equivalent of 0.2% perfume.

Table 22: deodorant spray composition

Ingredient	Amount (wt %)
Ethanol 95 %	90.65
Triclosan ¹⁾	0.26
Isopropyl miristate	9.09

1) Irgasan[®] DP 300; trademark and origin : BASF

25

All the ingredients according to the sequence of the Table 24 are mixed and dissolved. Then the aerosol cans are filled, crimp and the propellant is added (Aerosol filling: 40% active solution 60% Propane / Butane 2.5 bar).

5

Example 17

Antiperspirant roll-on emulsion composition

A sufficient amount of exemplified microcapsules is weighed and mixed in antiperspirant roll-on emulsion composition to add the equivalent of 0.2% perfume.

10

Table 23: antiperspirant roll-on emulsion composition

Ingredient	Amount (wt %)
Steareth-2 ¹⁾ (Part A)	3.25
Steareth-21 ²⁾ (Part A)	0.75
PPG-15 Stearyl Ether ³⁾ (Part A)	4
WATER deionised (Part B)	51
Aluminum Chlorohydrate 50% aqueous solution ⁴⁾ (Part C)	40
Fragrance (Part D)	1

- 1) BRIJ 72; origin : ICI
- 2) BRIJ 721; origin : ICI
- 3) ARLAMOL E; origin : UNIQEMA-CRODA
- 4) LOCRON L; origin : CLARIAN

15

Part A and B are heated separately to 75°C; Part A is added to part B under stirring and the mixture is homogenized for 10 minutes. Then, the mixture is cooled down under stirring; and part C is slowly added when the mixture reached 45°C and part D when the mixture reached at 35 °C while stirring. Then the mixture is cooled down to RT.

20

Example 18

Antiperspirant roll-on composition

A sufficient amount of exemplified microcapsules is weighed and mixed in antiperspirant roll-on composition to add the equivalent of 0.2% perfume.

Table 24: antiperspirant roll-on composition

Ingredient	QUANTITY
Water (Part A)	45
Aluminum Chlorohydrate 50% aqueous solution ¹⁾ (Part B)	20
Alcohol Denat. (Ethanol 96%) (Part B)	30
Ceteareth-12 ²⁾ (Part C)	2
Ceteareth-30 ³⁾ (Part C)	2
Fragrance (Part D)	1

1) LOCRON L; origin: CLARIANT

2) EUMULGIN B-1; origin : BASF

3) EUMULGIN B-3; origin : BASF

The ingredients of part B are mixed in the vessel then ingredient of part A is added. Then dissolved part C in part A and B. With perfume, 1 part of Cremophor RH40 for 1 part of perfume is added while mixing well

Example 19

Antiperspirant roll-on composition

A sufficient amount of exemplified microcapsules is weighed and mixed in antiperspirant roll-on emulsion composition to add the equivalent of 0.2% perfume.

Table 25: antiperspirant roll-on emulsion composition

Ingredient	Amount (wt %)
------------	---------------

Water (Part A)	50.51
Hydroxyethylcellulose ¹⁾ (Part A)	0.71
Ethanol 95 % (Part B)	40.40
1,2-Propylene Glycol (Part B)	5.05
Triclosan ²⁾ (Part B)	0.30
PEG-40 Hydrogenated castor oil ³⁾ (Part C)	3.03

- 1) Natrosol® 250 H; trademark and origin: Ashland
- 2) Irgasan® DP 300; trademark and origin : BASF
- 3) Cremophor® RH 40; trademark and origin : BASF

5 Part A is prepared by sprinkling little by little the Hydroxyethylcellulose in the water whilst rapidly stirring with the turbine. Stirring is continued until the Hydroxyethylcellulose is entirely swollen and giving a limpid gel. Then, Part B is poured little by little in Part A whilst continuing stirring until the whole is homogeneous. Part C is added.

10

Example 20

Deodorant pump without alcohol formulation

A sufficient amount of exemplified microcapsules is weighed and mixed in the following composition to add the equivalent of 0.2% perfume.

15

Table 26: deodorant composition

Ingredients	Amount (wt %)
C12-15 Alkyl Lactate ¹⁾	5
Dimethicone ²⁾	91.6
Cetyl Lactate ³⁾	1
Octyldodecanol ⁴⁾	0.8
Triclosan ⁵⁾	0.1
PERFUME	1.5

- 1) Ceraphyl 41; trademark and origin ASHLAND

- 2) DOW CORNING 200 FLUID 0.65cs; trademark and origin DOW CORNING CORPORATION
- 3) Ceraphyl 28; trademark and origin ASHLAND
- 4) Eutanol G; trademark and origin BASF
- 5) Irgasan[®] DP 300; trademark and origin : BASF

All the ingredients are mixed according to the sequence of the table and the mixture is heated slightly to dissolve the Cetyl Lactate.

10

Example 21

Deodorant pump with alcohol formulation

A sufficient amount of exemplified microcapsules is weighed and mixed in the following composition to add the equivalent of 0.2% perfume.

15

Table 27: deodorant composition

Ingredients	Amount (wt %)
Ethyl Alcohol (Part A)	60
PEG-6 Caprylic/Capric Glycerides ¹⁾ (Part A)	2
Water (Part A)	35.6
PEG-40 Hydrogenated Castor Oil ²⁾ (Part B)	0.4
PERFUME (Part B)	2

- 1) Softigen 767; trademark and origin CRODA
- 2) Cremophor[®] RH 40; trademark and origin : BASF

- 20 Ingredients from Part B are mixed together. Ingredients of Part A are dissolved according to the sequence of the Table and are poured into part B.

Example 22Talc formulation

A sufficient amount of granules A-E is weighed and mixed in introduced in a standard talc base:

- 5 100% talc, very slight characteristic odor, white powder, origin: LUZENAC to add the equivalent of 0.2% perfume.

Example 23Shower-gel Reference

- 10 A sufficient amount of exemplified microcapsules is weighed and mixed in the following composition to add the equivalent of 0.2% perfume.

Table 28: shower gel composition

Ingredients	Amount (% wt)	Function
WATER deionised	49.350	Solvent
Tetrasodium EDTA ¹⁾	0.050	Chelating agent
Acrylates Copolymer ²⁾	6.000	Thickener
Sodium C12-C15 Pareth Sulfate ³⁾	35.000	Surfactant
Sodium Hydroxide 20% aqueous solution	1.000	pH adjuster
Cocamidopropyl Betaine ⁴⁾	8.000	Surfactant
Methylchloroisothiazolinone and Methylisothiazolinone ⁵⁾	0.100	Preservative
Citric Acid (40%)	0.500	pH adjuster

1) EDETA B POWDER; trademark and origin: BASF

- 15 2) CARBOPOL AQUA SF-1 POLYMER; trademark and origin: NOVEON

3) ZETESOL AO 328 U; trademark and origin: ZSCHIMMER & SCHWARZ

4) TEGO-BETAIN F 50; trademark and origin: GOLDSCHMIDT

5) KATHON CG; trademark and origin: ROHM & HASS

- 20 Ingredients are mixed, pH is adjusted to 6-6.3 (Viscosity: 4500cPo +/-1500cPo (Brookfield RV / Spindle#4 / 20RPM)).

Example 24

Shower-gel composition

5 A sufficient amount of exemplified microcapsules is weighed and mixed in the following composition to add the equivalent of 0.2% perfume.

Table 29: shower gel composition

Ingredients	Amount (% wt)	Function
WATER deionized	52.40	Solvent
Tetrasodium EDTA ¹⁾	0.10	Chelating agent
Sodium Benzoate	0.50	Preservative
Propylene Glycol	2.00	Solvent
Sodium C12-C15 Pareth Sulfate ²⁾	35.00	Surfactant
Cocamidopropyl Betaine ³⁾	8.00	Surfactant
Polyquaternium-7 ⁴⁾	0.20	Conditioning agent
Citric Acid (40%)	1.00	pH adjuster
Sodium Chloride	0.80	Viscosity adjuster

- 1) EDETA B POWDER; trademark and origin: BASF
- 10 2) ZETESOL AO 328 U; trademark and origin: ZSCHIMMER & SCHWARZ
- 3) TEGO-BETAIN F 50; trademark and origin: GOLDSCHMIDT
- 4) MERQUAT 550; trademark and origin: LUBRIZOL

Ingredients are mixed, pH is adjusted to 4.5 (Viscosity: 3000cPo +/-1500cPo (Brookfield RV /
15 Spindle#4 / 20RPM)).

Example 25Shower-gel composition

A sufficient amount of exemplified microcapsules is weighed and mixed in the following
 5 composition to add the equivalent of 0.2% perfume.

Table 30: shower gel composition

Ingredients	Amount (% wt)	Function
WATER deionized	50.950	Solvent
Tetrasodium EDTA ¹⁾	0.050	Chelating agent
Sodium Benzoate	0.500	Preservative
Glycerin 86%	3.500	Solvent
Sodium Laureth Sulfate ²⁾	27.000	Surfactant
Polyquaternium-7 ³⁾	1.000	Conditioning Agent
Coco-Betaine ⁴⁾	6.000	Surfactant
PEG-120 Methyl Glucose trioleate ⁵⁾	1.000	Thickener
Citric Acid (40%)	1.000	pH adjuster
Glycol Distearate & Laureth-4 & Cocamidopropyl Betaine ⁶⁾	3.000	Pearlizing agent
Sodium Chloride 20%	5.000	Viscosity adjuster
PEG-40 Hydrogenated Castor Oil ⁷⁾	1.000	Viscosity adjuster

1) EDETA B POWDER; trademark and origin: BASF

2) Texapon NSO IS; trademark and origin: COGNIS

10 3) MERQUAT 550; trademark and origin: LUBRIZOL

4) DEHYTON AB-30; trademark and origin: COGNIS

5) GLUCAMATE LT; trademark and origin: LUBRIZOL

6) EUPERLAN PK 3000 AM; trademark and origin: COGNIS

7) CREMOPHOR RH 40; trademark and origin: BASF

15

Ingredients are mixed, pH is adjusted to 4.5 (Viscosity: 4000cPo +/-1500cPo (Brookfield RV /
 Spindle#4 / 20RPM))

Example 26Hand Dishwash

- 5 A sufficient amount of exemplified microcapsules is weighed and mixed in the following composition to add the equivalent of 0.2% perfume.

Table 31: Hand dishwash composition

Ingredients	Amount (% wt)	Function
Linear alkylbenzene sulfonic acid ⁽¹⁾	20	Anionic surfactant
Diethanolamide ⁽²⁾	3.5	Foam booster
Sodium Hydroxide (50%) ⁽³⁾	3.4	pH Adjuster/neutralizer
Secondary alcohol ethoxolate ⁽⁴⁾	2.5	Non-ionic surfactant
Sodium xylene sulfonate	6.3	Hydrotrope
Water	64.3	Solvent

- 1) Biosoft S-118®; trademark and origin : Stepan Company
- 10 2) Ninol 40-CO®; trademark and origin : Stepan Company
- 3) Stepanate SXS®; trademark and origin : Stepan Company
- 4) Tergitol 15-S-9®; trademark and origin : Dow Chemical Company

- Water with sodium hydroxide and diethanolamide are mixed. LAS is added. After the LAS is
- 15 neutralized, the remaining ingredients are added. The pH was Checked (=7-8) and adjusted if necessary.

Example 27Soap bar formulation

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A soap bar composition including exemplified microcapsules is prepared at a concentration of 7.5% w/w.

Table 32: composition of soap formulation

Ingredients	Soap Formulation (%)
Surfactants	
Sodium Linear Alkyl Benzene Sulfonate	
Soap	10 to 25
Alpha Olefin Sulfonate (AOS)	
sodium lauryl sulfate	
Builders	
Sodium Carbonate	5 to 15
Sodium Tri Polyphosphate	
Zeolite	
Fillers	
Sodium Sulphate	5 to 30
Talc	5 to 30
Dolomite	5 to 50
China Clay	5 to 50
Calcite - Calcium Carbonate	
Sodium Chloride	5 to 20
Structuring Ingredients	
Aluminium Sulphate	0.5 to 5
Alkaline Silicate	1 to 5
Others	
Colour	0.1 to 1
Perfume	0.1 to 1

Moisture	5 to 15
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Example 28

Toothpaste formulation

5 A sufficient amount of a microcapsule slurry M (prepared according to the protocol disclosed in example 1 except that a menthol flavor is encapsulated) is weighed and mixed in the following composition to add the equivalent of 0.2% flavor.

Table 33: Toothpaste formulation

Ingredients	Amount (% wt)
Polyethylene glycol 400	2.0%
Xanthan Gum	0.6%
Sorbitol 70% Solution	50%
Sodium Fluoride	0.220%
Sodium Benzoate	0.2%
Water	15.230%
Hydrated Silica ¹⁾	22.0%
Hydrated Silica ²⁾	7.0%
Titanium Dioxide CI77891	0.5%
Sodium Lauryl Sulfate	1.250%
Flavor	1.2%
TOTAL	100%

- 10 1) Tixosil 73
- 2) Tixosil 43

15

Example 29Dicalcium Phosphate based toothpaste formulation

5 A sufficient amount of a microcapsule slurry M (prepared according to the protocol disclosed in example 1 except that a menthol flavor is encapsulated) is weighed and mixed in the following composition to add the equivalent of 0.2% flavor.

Table 34: Toothpaste formulation

Ingredients	Amount (% wt)
Sodium carboxymethyl cellulose	1.2%
Flavor	1.2%
DI/Purified Water	Q.S to Final Wt.
Sodium Lauryl Sulfate	1.3%
Glycerine	20.0%
Sodium Saccharin	0.2%
Dicalcium phosphate dihydrate	36.0%
Methylparaben	0.2%
Silica ¹⁾	3.0%
TOTAL	100%

10 1) Aerosil®200

Example 30Mouthwash alcohol free formulation

15 A sufficient amount of a microcapsule slurry M (prepared according to the protocol disclosed in example 1 except that a menthol flavor is encapsulated) is weighed and mixed in the following composition to add the equivalent of 0.2% flavor.

Table 35: Mouthwash formulation

Ingredients	Amount (% wt)
Propylene Glycol	10%
Flavor	0.240%
DI/Purified Water	Q.S to Final Wt.
Poloxamer 407 NF	0.240%
Sodium Lauryl Sulfate	0.040%
Sorbitol 70% Solution	10.0%
Sodium Saccharin	0.030%
Glycerine	3.0%
Sodium Benzoate	0.100%
Sucralose	0.020%
Benzoic Acid	0.050%
TOTAL	100%

5

Example 31Mouthwash formulation

A sufficient amount of a microcapsule slurry M (prepared according to the protocol disclosed in example 1 except that a menthol flavor is encapsulated) is weighed and mixed in the following composition to add the equivalent of 0.2% flavor.

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Table 36: Mouthwash formulation

Ingredients	Amount (% wt)
Ethyl Alcohol 190 Proof	15.0%
Flavor	0.240%
DI/Purified Water	Q.S to Final Wt.

Poloxamer 407 NF	0.240%
Sodium Lauryl Sulfate	0.040%
Sorbitol 70% Solution	10.0%
Sodium Saccharin	0.030%
Glycerine	3.0%
Sodium Benzoate	0.100%
Sucralose	0.020%
Benzoic Acid	0.050%
TOTAL	100%

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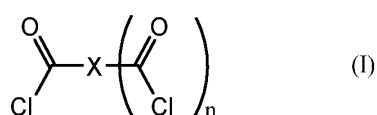
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CLAIMS

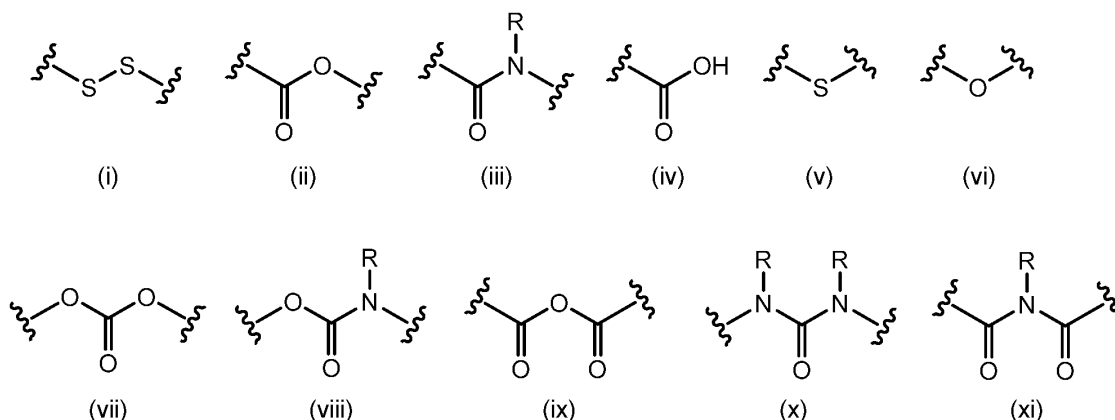
- 1- A process for preparing a polyamide-based core-shell microcapsule slurry comprising the following steps:
- 5 a) Dissolving at least one acyl chloride in a hydrophobic material, preferably a perfume to form an oil phase;
- b) Dispersing the oil phase obtained in step a) into a dispersing phase to form a two-phases dispersion;
- c) Performing a curing step to form polyamide-based microcapsules in the form of a slurry;
- 10 wherein at least one amino-compound A chosen in the group consisting of ethylene amine having a functionality greater than 3, an aminosilane, a polyethylenimine, an amino-acid and mixtures thereof, is added in the dispersing phase before the formation of the two-phases dispersion and/or in the two-phases dispersion obtained after step b).
- 2- The process according to claim 1, wherein the amino-compound A is chosen in the
- 15 group consisting of triethylenetetramine, tetraethylenepentamine and mixture thereof.
- 3- The process according to claim 1 or 2, wherein a carbohydrate is added in the oil phase and/or in the dispersing phase, preferably in the dispersing phase.
- 20 4- The process according to claim 3, wherein the carbohydrate is a polysaccharide chosen from the group consisting of anionic salt of alginic acid, pectin, lignin, anionic modified starch, carboxymethylcellulose, carrageenan and mixtures thereof.
- 5- The process according to anyone of the preceding claims, wherein a polymer, is added in
- 25 the oil phase.
- 6- The process according to claim 5, wherein the polymer is a protein, preferably selected from the group consisting of canola protein, sunflower seed protein, potato protein, chickpea protein, pea protein, algae protein, faba bean protein, barley protein, oat
- 30 protein, wheat gluten protein, lupin protein, soy protein, rice protein, whey protein, white

egg albumin, casein, sodium caseinate, gelatin, bovine serum albumin, hydrolyzed soy protein, hydrolyzed sericin, pseudocollagen, silk protein, sericin powder, and mixtures thereof.

- 5 **7-** The process according to anyone of the preceding claims, wherein at least one amino-compound B is added in the dispersing phase before the formation of the two-phases dispersion and/or in the two-phases dispersion obtained after step b).
- 10 **8-** The process according to claim 7, wherein the amino compound B is an amino-acid, preferably chosen in the group consisting of lysine, arginine, leucine, histidine, tryptophane, serin, glutamine, threonine, alanine, asparagine, aspartic acid, cysteine, glutamic acid, glycine, isoleucine, methionine, phenylalanine, proline, tyrosine, valine.
- 15 **9-** The process according to anyone of the preceding claims, wherein the dispersing phase comprises a base, preferably chosen in the group consisting of sodium carbonate, sodium bicarbonate, sodium hydroxide, guanidine carbonate, triethanolamine, and mixtures thereof.
- 20 **10-** The process according to anyone of the preceding claims, wherein the acyl chloride is a compound of formula (I)



- 25 wherein n is an integer varying between 1 and 8, preferably between 1 and 6, more preferably between 1 and 4, and
- wherein X is an (n+1)-valent C₂ to C₄₅ hydrocarbon group optionally comprising at least one group selected from (i) to (xi)



wherein R is a hydrogen atom or an alkyl group such as a methyl or an ethyl group, preferably a hydrogen atom.

11- A polyamide-based core-shell microcapsule comprising:

- a core, preferably an oil-based core, comprising a hydrophobic material, preferably a perfume, and
- a polyamide-based shell comprising a reaction product of:
 - an acyl chloride,
 - an amino compound A chosen in the group consisting of ethylene amine having a functionality greater than 3, an aminosilane, a polyethylenimine, amino-acid, and mixtures thereof,
 - optionally a carbohydrate,
 - optionally an amino compound B, and
 - optionally a polymer, preferably a protein.

12- The polyamide-based core-shell microcapsule according to claim 11, wherein the shell comprises:

- between 5 and 40%, preferably between 5 and 35% by weight of acyl chlorides moieties, preferably reacted acyl chlorides moieties,

- optionally between 5 and 60%, preferably between 10 and 50% by weight of a carbohydrate, preferably reacted carbohydrate,
 - optionally between 30 and 80%, preferably between 40 and 65%, more preferably between 40 and 60% by weight of a polymer, preferably reacted polymer,
 - 5 - between 1 and 40%, preferably between 3 and 30%, more preferably between 6 and 30% by weight of amino compound(s).
- based on the total weight of the shell.

13- A perfuming composition comprising

- 10 (i) microcapsule as defined in claims 11 or 12, wherein the hydrophobic active ingredient comprises a perfume,
- (ii) At least one ingredient selected from the group consisting of a perfumery carrier and a perfumery base
- (iii) Optionally at least one perfumery adjuvant.

15

14- A consumer product comprising:

- a personal care active base, and
- microcapsule as defined in claims 11 or 12 or the perfuming composition as defined in claim 13,

20 wherein the consumer product is in the form of a personal care composition.

15- A consumer product comprising:

- a home care or a fabric care active base, and
- microcapsule as defined in claims 11 or 12 or the perfuming composition as defined in claim 13,

25

wherein the consumer product is in the form of a home care or a fabric care composition.

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