

COMMONWEALTH OF AUSTRALIA

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LODGED AT SUB OFFICE

- 7 AUG 1986

Sydney

Patents Act 1952

CONVENTION APPLICATION FOR A STANDARD PATENT

XXXWE, COLGATE-PALMOLIVE COMPANY, a corporation organized and existing under the laws of Delaware of 300 Park Avenue, New York, N.Y. 10022, United States of America

hereby apply for the grant of a Standard Patent for an invention entitled

BUILT DETERGENT COMPOSITIONS CONTAINING STABILIZING AGENTS

which is described in the accompanying complete specification.

This application is made under the provision of Part XVI of the Patents Act 1952 and is based on an application for a patent or similar protection made

in United States of America on 20 August 1985  
No. (767,568)

in United States of America on 20 August 1985  
No. (767,569)

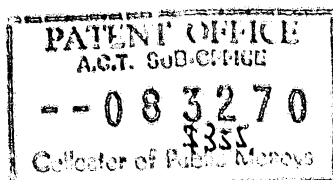
Our address for service is: F.B. RICE & CO.,  
28A Montague St,  
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Dated this 7th day of August 1986.

COLGATE-PALMOLIVE COMPANY

APPLICATION ACCEPTED AND AMENDMENTS

ALLOWED 13.11.89.



By:

Registered Patent Attorney

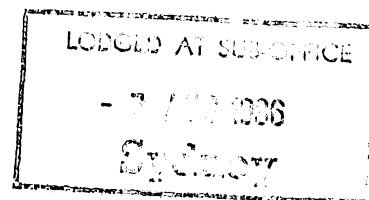
TO: The Commissioner of Patents,  
COMMONWEALTH OF AUSTRALIA

A DECLARATION IN SUPPORT  
OF :

~~AN APPLICATION~~  
**A CONVENTION APPLICATION FOR A  
PATENT ~~OR PATENT OF ADDITION~~**

In support of the ~~Application~~  
Convention Application made by

COLGATE-PALMOLIVE COMPANY  
300 Park Avenue  
New York, New York 10022



for a ~~patent of addition~~ <sup>patent</sup> for an invention entitled

BUILT DETERGENT COMPOSITIONS CONTAINING STABILIZING AGENTS

I/~~We~~, Herbert S. Sylvester, Assistant General Counsel Industrial  
Property

do solemnly and sincerely declare as follows:

(1) I am/~~We are the applicant~~ <sup>-patent-</sup> for the ~~patent of addition~~

(1) I am authorised by COLGATE-PALMOLIVE COMPANY

the applicant for the <sup>patent</sup> ~~patent of addition~~ to make this declaration

on its behalf.

(2) The basic application as defined by Section ~~142~~ <sup>142</sup> of the Act ~~was~~ <sup>were</sup>  
made in United States on 20 August 1985  
of America  
in United States on 20 August 1985  
of America

by

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are the actual inventor/s of the invention and the facts upon  
which COLGATE-PALMOLIVE COMPANY  
is/~~are~~ entitled to make the application are as follows: The applicant is the assignee of  
the invention from the inventors identified above.

The basic applications referred to in paragraph 2 of this Declaration  
is/~~are~~ the first application/s made in a Convention country in respect of  
the invention the subject of the application.

New York, New York

Declared at JUN 17 1986 this 17th day of June 1986.

COLGATE-PALMOLIVE COMPANY

By Herbert S. Sylvester  
H.S. Sylvester \*  
Assistant General Counsel  
Industrial Property

To: The Commissioner of Patents  
Commonwealth of Australia

F. B. RICE & CO.,  
Patent Attorneys,  
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(12) PATENT ABRIDGMENT (11) Document No. AU-B-60964/86  
(19) AUSTRALIAN PATENT OFFICE (10) Acceptance No. 592812

- (54) Title  
BUILT DETERGENT COMPOSITIONS CONTAINING STABILIZING AGENTS
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- (56) Prior Art Documents  
AU 554642 91766/82 C11D  
AU 529807 37596/78 C11D  
AU 55034/73 C11D

(57) This invention relates to nonaqueous liquid fabric treating compositions. More particularly, this invention relates to nonaqueous liquid laundry detergent compositions which are stable against phase separation and gelation and are easily pourable and to the use of these compositions for cleaning soiled fabrics.

#### CLAIM

1. A non-aqueous fabric treating detergent composition which comprises a suspension of insoluble inorganic builder salt particles in 10 to 70 percent of a non-ionic liquid surfactant detergent, and 0.1 to 5% of an anti-settling agent chosen from a urea compound or a cationic quaternary amine salt surface active agent, to increase the stability of the suspension, the urea compound having the formula



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(10) 592812

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wherein at least one of the  $R_1$  to  $R_4$  is hydrogen and the remainder are selected from the group consisting of alkyl, aryl, hydroxyl and chlorine, and X is O or NH, the cationic quaternary amine salt surface active agent being selected from the group consisting of (I) mono-higher alkyl tri-lower alkyl quaternary ammonium salt, (II) di-higher alkyl di-lower alkyl quaternary ammonium salt, (III) mono-higher alkyl mono-lower alkyl diethoxylated quaternary ammonium salt and (IV) di-higher alkyl diethoxylated quaternary ammonium salt. .

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COMMONWEALTH OF AUSTRALIA

Patents Act 1952

C O M P L E T E   S P E C I F I C A T I O N  
(ORIGINAL)

Class

Int. Class

Application Number: 60964/86.

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Accepted :  
Published :

Priorities : 20 August 1985 and 20 August 1985

Related Art :

Name of Applicant : COLGATE-PALMOLIVE COMPANY

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BALMAIN 2041

Complete Specification for the invention entitled:

**BUILT DETERGENT COMPOSITIONS CONTAINING STABILIZING AGENTS**

The following statement is a full description of this invention  
including the best method of performing it known to us :-

# BUILT DETERGENT COMPOSITIONS CONTAINING STABILIZING AGENTS

## BACKGROUND OF THE INVENTION

### (1) Field of Invention

This invention relates to nonaqueous liquid fabric treating compositions. More particularly, this invention relates to nonaqueous liquid laundry detergent compositions which are stable against phase separation and gelation and are easily pourable and to the use of these compositions for cleaning soiled fabrics.

### (2) Discussion of Prior Art

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

The related pending applications assigned to the common assignee are  
SN 687,815, filed December 31, 1984;  
SN 597,793, filed April 6, 1984;  
SN 597,948, filed April 9, 1984;  
SN 725,455, filed April 22, 1985; and  
20 SN 687,816, filed December 31, 1984.

These applications are directed to liquid nonaqueous nonionic laundry detergent compositions.

Liquid detergents are often considered to be more convenient to employ than dry powdered or particulate products and, therefore, have found substantial favor with consumers. They are readily measurable, speedily dissolved in the wash water, capable of being easily applied in concentrated solutions or dispersions to soiled areas on garments to be laundered and are non-dusting, and they usually occupy less storage space. Additionally, the liquid detergents may have incorporated in their formulations materials which

could not stand drying operations without deterioration, which materials are often desirably employed in the manufacture of particulate detergent products. Although they are possessed of many advantages over unitary or particulate solid products, liquid detergents often have certain inherent disadvantages too, which have to be overcome to produce acceptable commercial detergent products. Thus, some such products separate out on storage and others separate out on cooling and are not readily redispersed. In some cases the product viscosity changes and it becomes either too thick to pour or so thin as to appear watery. Some clear products become cloudy and others gel on standing.

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The present inventors have been involved in studying the behavior of nonionic liquid surfactant systems with particulate matter suspended therein. Of particular interest has been nonaqueous built laundry liquid detergent compositions and the problem of settling of the suspended builder and other laundry additives as well as the problem of gelling associated with nonionic surfactants. These considerations have an impact on, for example, product stability, pourability and dispersibility.

It is known that one of the major problems with built liquid laundry detergents is their physical stability. This problem stems from the fact that the density of the solid particles dispersed in the nonionic liquid surfactant is higher than the density of the liquid surfactant.

Therefore, the dispersed particles tend to settle out. Two basic solutions exist to solve the settling out problem: increase nonionic liquid viscosity and reduce the dispersed solid particle size.

It is known that suspensions can be stabilized against settling by adding inorganic or organic thickening agents or dispersants, such as, for example, very high surface area inorganic materials, e.g. finely divided silica, clays, etc., organic thickeners, such as the cellulose ethers, acrylic and acrylamide polymers, polyelectrolytes, etc. However, such increases in suspension viscosity are naturally limited by the requirement that the liquid

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suspension be readily pourable and flowable, even at low temperature. Furthermore, these additives do not contribute to the cleaning performance of the formulation.

Grinding to reduce the particle size provides the following advantages:

1. Specific surface area of the dispersed particles is increased, and, therefore, particle wetting by the nonaqueous vehicle (liquid nonionic) is proportionately improved.

2. The average distance between dispersed particles is reduced with a proportionate increase in particle-to-particle interaction. Each of these effects contributes to increase the rest-gel strength and the suspension yield stress while at the same time, grinding significantly reduces plastic viscosity.

The yield stress is defined as the minimum stress necessary to induce a plastic deformation (flow) of the suspension. Thus, visualizing the suspension as a loose network of dispersed particles, if the applied stress is lower than the yield stress, the suspension behaves like an elastic gel and no plastic flow will occur. Once the yield stress is overcome, the network breaks at some points and the sample begins to flow, but with a very high apparent viscosity. If the shear stress is much higher than the yield stress, the pigments are partially shear-deflocculated and the apparent viscosity decreases. Finally, if the shear stress is much higher than the yield stress value, the dispersed particles are completely shear-deflocculated and the apparent viscosity is very low, as if no particle interaction were present.

Therefore, the higher the yield stress of the suspension, the higher the apparent viscosity at low shear rate and the better is the physical stability against settling of the product.

In addition to the problem of settling or phase separation, the nonaqueous liquid laundry detergents based on liquid nonionic surfactants suffer from the drawback that the nonionics tend to gel when added to cold



water. This is a particularly important problem in the ordinary use of European household automatic washing machines where the user places the laundry detergent composition in a dispensing unit (e.g. a dispensing drawer) of the machine. During the operation of the machine the detergent in the dispenser is subjected to a stream of cold water to transfer it to the main body of wash solution. Especially during the winter months when the detergent composition and water fed to the dispenser are particularly cold, the detergent viscosity increases markedly and a gel forms. As a result some of the composition is not flushed completely off the dispenser during operation of the machine, and a deposit of the composition builds up with repeated wash cycles, eventually requiring the user to flush the dispenser with hot water.

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

The tendency of concentrated detergent compositions to gel during storage is aggravated by storing the compositions in unheated storage areas, or by shipping the compositions during winter months in unheated transportation vehicles.

Partial solutions to the gelling problem have been proposed, for example, by diluting the liquid nonionic with certain viscosity controlling solvents and gel-inhibiting agents, such as lower alkanols, e.g. ethyl alcohol (see U.S.P. 3,953,380), alkali metal formates and adipates (see U.S.P. 4,368,147), hexylene glycol, polyethylene glycol, etc. and nonionic structure modification and optimization. As an example of nonionic surfactant modification one particularly successful result has been achieved by acidifying the hydroxyl moiety end group of the nonionic molecule. The advantages of introducing a carboxylic acid at the end of the nonionic include gel inhibition upon dilution; decreasing the nonionic pour point; and

formation of an anionic surfactant when neutralized in the washing liquor. Nonionic structure optimization has centered on the chain length of the hydrophobic-lipophilic moiety and the number and make-up of alkylene oxide (e.g. ethylene oxide) units of the hydrophilic moiety. For example, it has been found that a C<sub>13</sub> fatty alcohol ethoxylated with 8 moles of ethylene oxide presents only a limited tendency to gel formation.

Nevertheless, improvements are desired in both the stability and gel inhibition of nonaqueous liquid fabric treating compositions.

#### BRIEF DESCRIPTION OF THE INVENTION

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In accordance with the present invention a highly concentrated stable nonaqueous liquid laundry detergent composition is prepared by adding to the composition small effective amounts of a urea anti-settling stabilizing additive or small effective amounts of a quaternary ammonium surface active agent anti-settling stabilizing additive.

The compositions of the present invention contain as an essential ingredient a urea anti-settling stabilizing additive or a quaternary ammonium surface active agent anti-settling stabilizing additive.

The urea anti-settling stabilizing additive is believed to function in the detergent composition as a surface active agent to make the phosphate detergent builder more compatible with the nonionic surfactant detergent.

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The urea is believed to interact with the anionic phosphate detergent builder salts to make the builder salts more compatible with the nonionic surfactant and improve the contact between the builder salts and nonionic surfactant. The improvement in the contact between the phosphate and nonionic surfactant increases the stability of the phosphate suspension in the nonionic surface active agent.

The urea compound even when added to the composition in small amounts improves the dispersibility of the suspension of builder salt by acting to inhibit gel formation of the suspension of builder salt.

The urea improves dispersibility by inhibiting gel formation of the suspension of detergent builder salt particles when water is added to the composition, for example, in the dispensing drawer of a dishwashing machine and/or when the composition is added to water.

The urea compound that is used in the compositions of the present invention has the formula  $\text{H}_2\text{NCONH}_2$ . The urea forms a tautomer which has the formula  $\text{H}_2\text{NCNHOH}$  and is called carbamide.

10 The quaternary ammonium anti-settling stabilizing additives are cationic surfactants. The quaternary ammonium cationic surfactants that are useful in the present invention are those surface active compounds which contain a long chain hydrocarbon hydrophobic group in their molecular structure and a hydrophile group, i.e. water soluble salt forming anion group. The quaternary ammonium cationic surface active anti-settling stabilizing agents of the present invention are well known and are commercially available. The quaternary ammonium compounds have been used as fabric softeners and have been used as surface active detergents.

20 The preferred quaternary ammonium compounds used in accordance with the present invention are the mono and di higher alkyl lower alkyl quaternary ammonium salts and the mono and di higher alkyl di ethoxylated quaternary ammonium salts.

The quaternary ammonium salts are believed to interact with anionic phosphate detergent builder salts to coat the anionic phosphate with a lipophylic skin. The lipophylic coating makes the anionic phosphate detergent builder salts more compatible with the nonionic surfactant and improves the contact between the phosphate and nonionic surfactant. The improvement in the contact between the phosphate and nonionic surfactant increases the stability of the phosphate suspension in the nonionic surfactant.

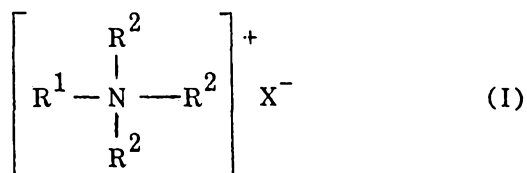
The preferred cationic quaternary ammonium surface active anti-settling stabilizing agents of the present invention are members of the group consisting of:

- I Mono-higher alkyl tri-lower alkyl quaternary ammonium salts.
- II Di-higher alkyl di-lower alkyl quaternary ammonium salts.
- III Mono-higher alkyl mono-lower alkyl diethoxylated quaternary ammonium salts; and
- IV Di-higher alkyl diethoxylated quaternary ammonium salts.

The cationic quaternary ammonium compound anti-settling stabilizing agents of the present invention are briefly described as follows:

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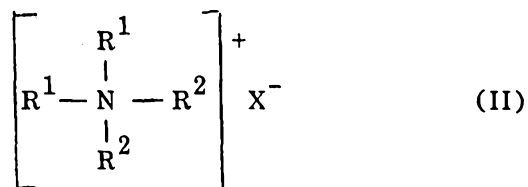
The formula I compounds are mono-higher alkyl tri-lower alkyl quaternary ammonium salts represented by the formula



wherein  $R^1$  is a long chain aliphatic radical having from 10 to 22 carbon atoms, the  $R^2$ 's are, independently, lower alkyl or hydroxy alkyl having from 1 to 4 carbon atoms, and X is a water soluble salt forming anion.

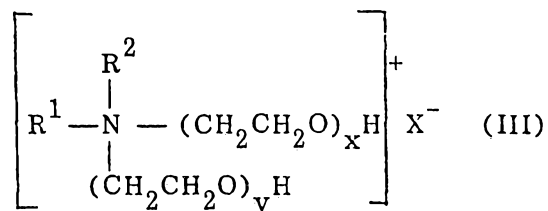
The formula II compounds are di-higher alkyl di-lower alkyl quaternary ammonium salts represented by the formula

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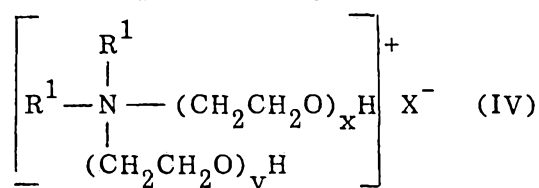
wherein  $R^1$ 's are, independently, long chain aliphatic radicals having from 10 to 22 carbon atoms, the  $R^2$ 's are, independently, lower alkyl or hydroxy alkyl having from 1 to 4 carbon atoms, and X is a water soluble salt forming anion.

The formula III compounds are mono-higher alkyl mono-lower alkyl diethoxy quaternary ammonium compounds represented by the formula



wherein  $R^1$  is a long chain aliphatic radical having from 10 to 22 carbon atoms,  $R^2$  is a lower alkyl or hydroxy alkyl having from 1 to 4 carbon atoms, x and y are each positive numbers of at least 1 and the sum of  $x + y$  is from 2 to 15, and X is a water soluble salt forming anion.

The formula IV compounds are di higher alkyl diethoxylated quaternary ammonium salts represented by the formula



wherein  $R^1$ 's are independently, long chain aliphatic radicals having from 10 to 22 carbon atoms, x and y are each positive numbers of at least 1 and the sum of  $x + y$  is from 2 to 15, and X is a water soluble salt forming anion.

In order to improve the viscosity characteristics of the composition an acid terminated nonionic surfactant can be added. To further improve the viscosity characteristics of the composition and the storage properties of the composition there can be added to the composition viscosity improving and anti gel agents such as alkylene glycols, poly alkylene glycols and alkylene glycol mono alkyl ethers and additional anti settling agents such as phosphoric acid ester and/or aluminum stearate. In an embodiment of the invention the detergent composition contains an acid terminated nonionic surfactant, an alkylene glycol mono alkyl ether and a urea anti-settling stabilizing agent or a quaternary ammonium anti settling stabilizing agent.

Sanitizing or bleaching agents and activators therefor can be added to improve the bleaching and cleansing characteristics of the composition.

In an embodiment of the invention the builder components of the composition are ground to a particle size of less than 100 microns and to preferably less than 10 microns to further improve the stability of the

suspension of the builder components in the liquid nonionic surfactant detergent.

In addition other ingredients can be added to the composition such as anti-incrustation agents, anti-foam agents, optical brighteners, enzymes, anti-redeposition agents, perfume and dyes.

The presently manufactured washing machines for home use normally operate at washing temperatures of up to 95°C. About 18.5 gallons (20 liters) of water are used during the wash and rinse cycles.

About 200-250 gms of powder detergent per wash is normally used.

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In accordance with the present invention where the highly concentrated liquid detergent is used normally only 100 gms (78 cc) of the liquid detergent composition is required to wash a full load of dirty laundry.

Accordingly, in one aspect the present invention provides a liquid heavy duty laundry composition composed of a suspension of a detergent builder salt or of an anionic detergent builder salt, e.g. a phosphate builder salt, in a liquid nonionic surfactant wherein the composition includes an effective amount of a urea compound to increase the stability of the suspension against settling and the dispersibility of the suspension in water or a quaternary ammonium surface active agent to to increase the stability of the suspension against settling.

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According to another aspect, the invention provides a concentrated liquid heavy duty laundry detergent composition which is stable, non-settling in storage and non-gelling in storage and in use. The liquid compositions of the present invention are easily pourable, easily measured and easily put into the washing machine.

According to another aspect, the invention provides a method for dispensing a liquid nonionic laundry detergent composition into and/or with cold water without undergoing gelation. In particular, a method is provided for filling a container with a nonaqueous liquid laundry detergent composition in which the detergent is composed, at least predominantly, of a liquid

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nonionic surface active agent and for dispensing the composition from the container into an aqueous wash bath, wherein the dispensing is effected by directing a stream of unheated water onto the composition such that the composition is carried by the stream of water into the wash bath.

#### ADVANTAGES OVER THE PRIOR ART

10 The addition of the urea compound to the detergent compositions reduce the problem of dispersed particle settling and phase separation and improves the dispersibility of the suspended detergent particles in water. The addition of the quaternary ammonium surface active agents to the detergent compositions reduce the problem of dispersed particle settling and phase separation.

The concentrated nonaqueous liquid nonionic surfactant laundry detergent compositions of the present invention have the advantages of being stable, non-settling in storage, and non-gelling in storage. The liquid compositions are easily pourable, easily measured and easily put into the laundry washing machines.

#### OBJECTS OF THE INVENTION

20 It is an object of the present invention to provide a stable liquid heavy duty nonaqueous nonionic detergent composition containing at least one urea compound anti-settling stabilizing agent and optionally an anionic phosphate detergent builder salt suspended in a nonionic surfactant.

It is another object of the present invention to provide a stable liquid heavy duty nonaqueous nonionic detergent composition containing at least one quaternary ammonium anti-settling stabilizing agent and at least one anionic phosphate detergent builder salt suspended in a nonionic surfactant.

It is an other object of the invention to provide liquid fabric treating compositions which are suspensions of insoluble inorganic particles in a nonaqueous liquid and which are storage stable, easily pourable and dispersible in cold, warm or hot water.

Another object of this invention is to formulate highly built heavy duty nonaqueous liquid nonionic surfactant laundry detergent compositions which can be poured at all temperatures and which can be repeatedly dispersed from the dispensing unit of European style automatic laundry washing machines without fouling or plugging of the dispenser even during the winter months.

10 A specific object of this invention is to provide non-gelling, stable suspensions of heavy duty built nonaqueous liquid nonionic laundry detergent composition which include an effective amount of a urea compound or a quaternary ammonium surface active agent sufficient to increase the yield stress of the composition to thereby increase its stability, i.e. prevent settling of builder particles, etc., preferably while reducing or at least without increasing, the plastic viscosity (viscosity under shear conditions) of the composition.

These and other objects of the invention which will become more apparent from the following detailed description of preferred embodiments are generally provided for by preparing a detergent composition by adding to the nonaqueous liquid nonionic surfactant an effective amount of a urea compound anti-settling stabilizing agent or of a quaternary ammonium surface active anti-settling stabilizing agent sufficient to inhibit settling of the suspended particles, wherein said composition includes inorganic or organic fabric treating additives, e.g. viscosity improving agents and one or more anti-gel agents, anti-incrustation agents, pH control agents, bleaching agents, bleach activators, anti-foam agents, optical brighteners, enzymes, anti-redeposition agents, perfume and dyes.

#### DETAILED DESCRIPTION OF THE INVENTION

30 In accordance with the present invention the physical stability of the suspension of the anionic phosphate detergent builder compound or the anionic detergent builder compound or compounds and any other suspended additive, such as bleaching agent, etc. in the liquid nonionic surfactant



vehicle is substantially improved by the addition of an anti-settling stabilizing agent which is urea or a quaternary ammonium surface active agent.

The addition of very small amounts of the urea anti-settling stabilizing agent or the quaternary ammonium surface active anti-settling stabilizing agents is sufficient to substantially improve the physical stability of the detergent compositions. The urea anti-settling agent also substantially improves the dispersibility of the compositions in water.

In an embodiment of the present invention the compositions contain as an essential ingredient urea anti-settling stabilizing agent additive. The anti-settling stabilizing additive can comprise one or more urea compounds.

The urea compounds that are used in the compositions of the present invention have the formula 
$$R_1R_2\overset{\overset{||}{X}}{N}NR_3R_4$$

wherein at least one of the  $R_1$  to  $R_4$  is hydrogen and the remainder are alkyl, preferably  $C_1$  to  $C_4$  alkyl, aryl, preferably phenyl, hydroxyl or chlorine, and X is O or NH. The urea forms a tautomer which has the formula  $H_2NCNHOH$  and is called carbamido. Urea and carbamide compounds and derivative compounds such as methyl urea, dimethyl urea, ethyl urea, propyl urea, butyl urea, hydroxyl urea and phenyl urea, salts of the foregoing are suitable for use in the present invention.

In addition to the action as a physical stabilizing agent, the urea compounds have the advantages over other physical stabilizing agents that they are compatible with the nonionic surfactant component and that they substantially improve the dispersibility of the detergent composition in cold water.

Although applicants do not wish to be bound by any particular theory of the manner by which the urea or carbamide compounds function to prevent settling of the suspended anionic phosphate builder detergent particles, it is believed that the urea or carbamide compounds interact with

the anionic phosphate detergent builder salts to make the phosphate more compatible with the nonionic surfactant, improve the contact between the phosphate and nonionic surfactant and increase the wettability of the dispersed phosphate solid particles surfaces by the nonionic surfactant. The improvement in the contact between the phosphate and nonionic surfactant and the improved wettability of the dispersed phosphate particles by the nonionic surfactant increases the stability of the phosphate suspension in the nonionic surface active agent and allows the suspended phosphate to more easily remain in suspension.

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The increased physical stability is manifested by an increase in the yield stress of the composition as compared to the same composition without the stabilizing agent. As described above, the higher is the yield stress, the higher is the apparent viscosity at low shear rate and the better is the physical stability.

The urea compound even when added to the composition in small amounts improves the dispersibility of the suspension of builder salt by acting to inhibit gel formation of the suspension of builder when contacted with water.

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The urea improves dispersibility by inhibiting gel formation of the suspension of detergent builder salt particles when water is added to the composition, for example, in the dispensing drawer of a dishwashing machine and/or when the composition is added to the wash water.

Only very small amounts of urea compound are required to obtain the significant improvements in physical stability of the detergent composition, and the dispersibility of the composition in cold water. For example, based on the total weight of the nonionic liquid surfactant composition, suitable amounts of urea are in the range of from about 0.1% to about 5%, preferably from about 0.2% to about 2.0% and more preferably about 0.5 to 1.5%.

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In another embodiment of the present invention the compositions contain as an essential ingredient a quaternary ammonium surface active anti-settling

stabilizing agent additive. The anti-settling stabilizing additive can comprise one or more of the quaternary ammonium surface active agents.

The anionic surface active agents that are useful in the present invention are those cationic surface active compounds which contain a long chain hydrocarbon hydrophobic group in their molecular structure and a hydrophile group, i.e. water soluble salt forming anion group.

The preferred cationic quaternary ammonium surface active anti-settling stabilizing agents of the present invention are members of the group consisting of:

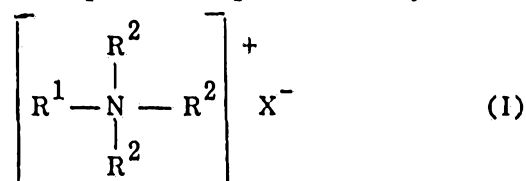
I Mono-higher alkyl tri-lower alkyl quaternary ammonium salts.

II Di-higher alkyl di-lower alkyl quaternary ammonium salts.

III Mono-higher alkyl mono-lower alkyl diethoxylated quaternary ammonium salts; and

IV Di-higher alkyl diethoxylated quaternary ammonium salts.

The formula I cationic anti-settling stabilizing agents used in the present invention are the mono-higher alkyl tri-lower alkyl quaternary ammonium compounds represented by the following formula:



wherein  $R^1$  is a long chain aliphatic radical having from 10 to 22 carbon atoms, and the  $R^2$ 's are, independently, lower alkyl or hydroxy alkyl radicals and X is a water soluble salt forming anion such as halide, i.e. chloride, bromide, iodide; sulfate, nitrate, citrate, acetate, hydroxide, methosulfate, ethosulfate, phosphate, or similar inorganic or organic solubilizing radical. The  $R^1$  carbon chain of the aliphatic radical containing 10 to 22 carbon atoms, especially 12 to 20, preferably 12 to 18, and especially preferably 16 to 18 carbon atoms, may be straight or branched, and saturated or unsaturated. The  $R^2$  lower alkyl radicals have from 1 to 4 carbon atoms, e.g. methyl, ethyl, propyl and butyl, preferably 1 or 2

carbon atoms, especially preferably methyl, and may contain a hydroxyl radical.

The preferred ammonium salt is a mono-higher alkyl trimethyl ammonium chloride wherein the alkyl group is derived from tallow, hydrogenated tallow or stearic acid. Specific examples of quaternary ammonium anti-settling stabilizing agents of the formula I suitable for use in the composition of the present invention include the following:

tallow trimethyl ammonium chloride

hydrogenated tallow trimethyl ammonium chloride

stearyl trimethyl ammonium chloride

stearyl triethyl ammonium chloride

cetyl trimethyl ammonium chloride

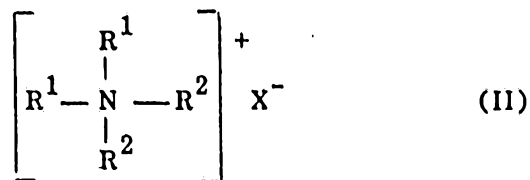
soya trimethyl ammonium chloride

stearyl dimethylethyl ammonium chloride

tallow-diisopropylmethyl ammonium chloride

The corresponding sulfate, methosulfate, ethosulfate, bromide and hydroxide salts thereof, can also be used.

The formula II cationic anti-settling stabilizing agents used in the present invention are the di-higher alkyl di-lower alkyl quaternary ammonium compounds represented by the following formula:



wherein  $R^1$ 's are, independently, long chain aliphatic radicals having from 10 to 22 carbon atoms, and the  $R^2$ 's are, independently, lower alkyl or hydroxy alkyl radicals and X is a water soluble salt forming anion such as halide, i.e. chloride, bromide, iodide; sulfate, nitrate, citrate, acetate, hydroxide, methosulfate, ethosulfate, phosphate, or similar inorganic or organic solubilizing radical. The  $R^1$  carbon chains of the aliphatic radicals containing 10 to 22 carbon atoms, especially 12 to 20, preferably 12 to 18,

and especially preferably 16 to 18 carbon atoms, may be straight or branched, and saturated or unsaturated. The  $R^2$  lower alkyl radicals have from 1 to 4 carbon atoms, e.g. methyl, ethyl, propyl and butyl, preferably 1 or 2 carbon atoms, especially preferably methyl, and may contain a hydroxyl radical.

Typical cationics of formula II include the following:

distearyl dimethyl ammonium chloride

ditallow dimethyl ammonium chloride

dihexadecyl dimethyl ammonium chloride

distearyl dimethyl ammonium bromide

di(hydrogenated tallow) dimethyl ammonium bromide

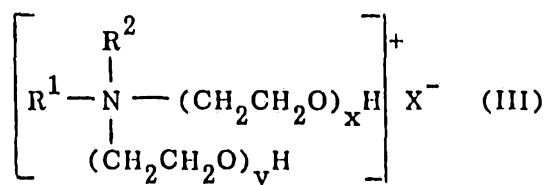
ditallow isopropyl methyl ammonium chloride

distearyl di(isopropyl) ammonium chloride

distearyl dimethyl ammonium methosulfate.

A preferred class of cationics is of formula II wherein two of the  $R^1$  groups are  $C_{14}$  to  $C_{18}$ , one  $R^2$  is methyl, or ethyl and one  $R^2$  is methyl, ethyl, isopropyl, n-propyl, hydroxy ethyl or hydroxy propyl.

The formula III cationic anti-settling stabilizing agents used in the present invention are the mono-higher alkyl mono-lower alkyl diethoxylated quaternary ammonium compounds represented by the following formula:



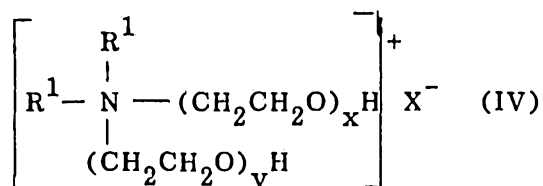
wherein  $R^1$  is a long chain aliphatic radical having from 10 to 22 carbon atoms, and the  $R^2$  is lower alkyl or hydroxy alkyl radicals, x and y are each positive numbers of at least 1 and the sum of  $x + y$  is from 2 to 15, and X is a water soluble salt forming anion such as halide, i.e. chloride, bromide, iodide; sulfate, nitrate, citrate, acetate, hydroxide, methosulfate, ethosulfate, phosphate, or similar inorganic or organic solubilizing radical.

atoms, especially 12 to 20, preferably 12 to 18, and especially preferably 16 to 18 carbon atoms, may be straight or branched, and saturated or unsaturated. The  $R^2$  lower alkyl radicals have from 1 to 4 carbon atoms, e.g. methyl, ethyl, propyl and butyl, preferably 1 or 2 carbon atoms, especially preferably methyl, and may contain a hydroxyl radical.

Typical examples of cationic quaternary ammonium anti-settling stabilizing agents of the formula III suitable for use in the composition of the present invention include the following:

coco methyl diethoxylated ( $x+y=2$ ) ammonium chloride  
 coco methyl diethoxylated ( $x+y=15$ ) ammonium chloride  
 oleic methyl diethoxylated ( $x+y=2$ ) ammonium chloride  
 oleic methyl diethoxylated ( $x+y=15$ ) ammonium chloride  
 stearyl methyl diethoxylated ( $x+y=2$ ) ammonium chloride  
 stearyl methyl diethoxylated ( $x+y=15$ ) ammonium chloride  
 tallow methyl diethoxylated ( $x+y=10$ ) ammonium chloride

The formula IV cationic anti-settling stabilizing agents used in the present invention are the di-higher alkyl diethoxylated quaternary ammonium compounds represented by the following formula:



wherein  $R^1$ 's are, independently, long chain aliphatic radical having from 10 to 22 carbon atoms, x and y are each positive numbers of at least 1 and the sum of  $x+y$  is from 2 to 15, and X is a water soluble salt forming anion such as halide, i.e. chloride, bromide, iodide; sulfate, nitrate, citrate, acetate, hydroxide, methosulfate, ethosulfate, phosphate, or similar inorganic or organic solubilizing radical. The  $R^1$  carbon chains of the aliphatic radicals containing 10 to 22 carbon atoms, especially 12 to 20, preferably 12 to 18, and especially preferably 16 to 18 carbon atoms, may be straight or branched, and saturated or unsaturated.

A specific example of a cationic quaternary ammonium anti-settling stabilizing agent of the formula IV suitable for use in the composition of the present invention is di-tallow diethoxylated ( $x+y=4$ ) ammonium chloride (Ethoquat 2T/14).

The mono and di-higher alkyl diethoxylated compounds are stable in both acid and alkaline solutions and possess greater water solubility and compatibility than other related compounds.

10 In the formula I to IV compounds, the long carbon chains are obtained from long chain fatty acids, such as those derived from tallow and soybean oil. The terms "soya," and "tallow," etc., as used herein refer to the source from which the long chain fatty alkyl chains are derived. Mixtures of the quaternary ammonium compound anti-settling stabilizing agents can be used.

The linear higher alkyl quaternary ammonium salts are readily biodegradable and are preferred.

Although applicants do not wish to be bound by any particular theory of the manner by which the quaternary ammonium surfactants function to prevent settling of the suspended anionic phosphate detergent builder particles, it is believed that the quaternary ammonium salts interact with the anionic phosphate detergent builder salts to coat the anionic phosphate with a cationic lipophylic skin to make the phosphate more compatible with the nonionic surfactant, improves the contact between the phosphate and nonionic surfactant and increase the wettability of the dispersed phosphate solid particles surfaces by the nonionic surfactant. The improvement in the contact between the phosphate and nonionic surfactant and the improved wettability of the dispersed phosphate particles by the nonionic surfactant increases the stability of the phosphate suspension and allows the suspended phosphate to more easily remain in suspension.

20  
30 The increased physical stability is manifested by an increase in the yield stress of the composition of, for example, from 65 dynes/cm<sup>2</sup> to 260

dynes/cm<sup>2</sup> and increase in the apparent viscosity of, for example, from 2350 to 3250 (LVT, sp.4, 60 rpm), as compared to the same composition without the quaternary ammonium salt stabilizing agent. As described above, the higher the yield stress, the higher the apparent viscosity at low shear rate and the better the physical stability.

In addition to its action as a physical stabilizing agent, the higher alkyl quaternary ammonium salts have the additional advantages over other physical stabilizing agents that they are cationic in character and are compatible with the nonionic surfactant component.

10 Only very small amounts of the quaternary ammonium salt stabilizing agent is required to obtain the significant improvements in physical stability. For example, based on the total weight of the nonionic liquid surfactant composition, suitable amounts of the quaternary ammonium salt are in the range of from about 0.1% to about 5%, preferably from about 0.3% to about 2.0% and more preferably about 0.5 to 1.5%.

While the urea compounds and the quaternary ammonium salts are effective in their physical stabilizing action, there can be added to the formulation other known physical stabilizers, such as, for example, an acidic organic phosphorus compound having an acidic - POH group, such as a partial ester of phosphorous acid and an alkanol and/or an aluminum salt of a fatty acid.

20

#### Nonionic Surfactant Detergent

The nonionic synthetic organic detergents employed in the practice of the invention may be any of a wide variety of known compounds.

As is well known, the nonionic synthetic organic detergents are characterized by the presence of an organic hydrophobic group and an organic hydrophilic group and are typically produced by the condensation of an organic aliphatic or alkyl aromatic hydrophobic compound with ethylene oxide (hydrophilic in nature). Practically any hydrophobic compound having a carboxy, hydroxy, amido or amino group with a free hydrogen attached to

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the nitrogen can be condensed with ethylene oxide or with the polyhydration product thereof, polyethylene glycol, to form a nonionic detergent. The length of the hydrophilic or polyoxy ethylene chain can be readily adjusted to achieve the desired balance between the hydrophobic and hydrophilic groups. Typical suitable nonionic surfactants are those disclosed in U.S. patents 4,316,812 and 3,630,929.

10 Usually, the nonionic detergents are poly-lower alkoxyated lipophiles wherein the desired hydrophile-lipophile balance is obtained from addition of a hydrophilic poly-lower alkoxy group to a lipophilic moiety. A preferred class of the nonionic detergent employed is the poly-lower alkoxyated higher alkanol wherein the alkanol is of 9 to 18 carbon atoms and wherein the number of mols of lower alkylene oxide (of 2 or 3 carbon atoms) is from 3 to 12. Of such materials it is preferred to employ those wherein the higher alkanol is a higher fatty alcohol of 9 to 11 or 12 to 15 carbon atoms and which contain from 5 to 8 or 5 to 9 lower alkoxy groups per mol. Preferably, the lower alkoxy is ethoxy but in some instances, it may be desirably mixed with propoxy, the latter, if present, often being a minor (less than 50%) proportion.

20 Exemplary of such compounds are those wherein the alkanol is of 12 to 15 carbon atoms and which contain about 7 ethylene oxide groups per mol, e.g. Neodol 25-7 and Neodol 23-6.5, which products are made by Shell Chemical Company, Inc. The former is a condensation product of a mixture of higher fatty alcohols averaging about 12 to 15 carbon atoms, with about 7 mols of ethylene oxide and the latter is a corresponding mixture wherein the carbon atom content of the higher fatty alcohol is 12 to 13 and the number of ethylene oxide groups present averages about 6.5. The higher alcohols are primary alkanols.

30 Other examples of such detergents include Tergitol 15-S-7 and Tergitol 15-S-9, both of which are linear secondary alcohol ethoxylates made by Union Carbide Corp. The former is mixed ethoxylation product of 11 to 15

carbon atoms linear secondary alkanol with seven mols of ethylene oxide and the latter is a similar product but with nine mols of ethylene oxide being reacted.

Also useful in the present composition as a component of the nonionic detergent are higher molecular weight nonionics, such as Neodol 45-11, which are similar ethylene oxide condensation products of higher fatty alcohols, with the higher fatty alcohol being of 14 to 15 carbon atoms and the number of ethylene oxide groups per mol being about 11. Such products are also made by Shell Chemical Company.

10

Other useful nonionics are represented by the commercially well known class of nonionics sold under the trademark Plurafac. The Plurafacs are the reaction product of a higher linear alcohol and a mixture of ethylene and propylene oxides, containing a mixed chain of ethylene oxide and propylene oxide, terminated by a hydroxyl group. Examples include products which are (A)  $C_{13}-C_{15}$  fatty alcohol condensed with 6 moles ethylene oxide and 3 moles propylene oxide, (B)  $C_{13}-C_{15}$  fatty alcohol condensed with 7 moles propylene oxide and 4 moles ethylene oxide, (C)  $C_{13}-C_{15}$  fatty alcohol condensed with 5 moles propylene oxide and 10 moles ethylene oxide, and (D) a product which is a 1:1 mixture of products (B) and (C).

20

Another group of liquid nonionics are commercially available from Shell Chemical Company, Inc. under the Dobanol trademark: Dobanol 91-5 is an ethoxylated  $C_9-C_{11}$  fatty alcohol with an average of 5 moles ethylene oxide and Dobanol 25-7 is an ethoxylated  $C_{12}-C_{15}$  fatty alcohol with an average of 7 moles ethylene oxide per mole of fatty alcohol.

30

In the preferred poly-lower alkoxyated higher alkanols, to obtain the best balance of hydrophilic and lipophilic moieties the number of lower alkoxyes will usually be from 40% to 100% of the number of carbon atoms in the higher alcohol, preferably 40 to 60% thereof and the nonionic detergent will preferably contain at least 50% of such preferred poly-lower alkoxy higher alkanol. Higher molecular weight alkanols and various other normally

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

20 When greater proportions of non-terminally alkoxyated alkanols, propylene oxide-containing poly-lower alkoxyated alkanols and less hydrophile-lipophile balanced nonionic detergent than mentioned above are employed and when other nonionic detergents are used instead of the preferred nonionics recited herein, the product resulting may not have as good detergency, stability, viscosity and non-gelling properties as the preferred compositions but use of the viscosity and gel controlling compounds of the invention can also improve the properties of the detergents based on such nonionics. In some cases, as when a higher molecular weight polylower alkoxyated higher alkanol is employed, often for its detergency, 30 the proportion thereof will be regulated or limited in accordance with the

results of routine experiments, to obtain the desired detergency and still have the product non-gelling and of desired viscosity. Also, it has been found that it is only rarely necessary to utilize the higher molecular weight nonionics for their detergent properties since the preferred nonionics described herein are excellent detergents and additionally, permit the attainment of the desired viscosity in the liquid detergent without gelation at low temperatures.

10 Another useful group of nonionic surfactants are the "Surfactant T" series of nonionics available from British Petroleum. The Surfactant T nonionics are obtained by the ethoxylation of secondary  $C_{13}$  fatty alcohols having a narrow ethylene oxide distribution. The Surfactant T5 has an average of 5 moles of ethylene oxide; Surfactant T7 an average of 7 moles of ethylene oxide; Surfactant T9 an average of 9 moles of ethylene oxide and Surfactant T12 an average of 12 moles of ethylene oxide per mole of secondary  $C_{13}$  fatty alcohol.

In the compositions of this invention, preferred nonionic surfactants include the  $C_{12}$ - $C_{15}$  secondary fatty alcohols with relatively narrow contents of ethylene oxide in the range of from about 7 to 9 moles, and the  $C_9$  to  $C_{11}$  fatty alcohols ethoxylated with about 5-6 moles ethylene oxide.

20 Mixtures of two or more of the liquid nonionic surfactants can be used and in some cases advantages can be obtained by the use of such mixtures.

#### Acid Terminated Nonionic Surfactant

The viscosity and gel properties of the liquid detergent compositions can be improved by including in the composition an effective amount an acid terminated liquid nonionic surfactant. The acid terminated nonionic surfactants consist of a nonionic surfactant which has been modified to convert a free hydroxyl group thereof to a moiety having a free carboxyl group, such as an ester or a partial ester of a nonionic surfactant and a polycarboxylic acid or anhydride.

As disclosed in the commonly assigned copending application Serial No. 597,948 filed April 9, 1984, the disclosure of which is incorporated herein by reference, the free carboxyl group modified nonionic surfactants, which may be broadly characterized as polyether carboxylic acids, function to lower the temperature at which the liquid nonionic forms a gel with water.

10 The addition of the acid terminated nonionic surfactants to the liquid nonionic surfactant aids in the dispensibility of the composition, i.e. pourability, and lowers the temperature at which the liquid nonionic surfactants form a gel in water without a decrease in their stability against settling. The acid terminated nonionic surfactant reacts in the washing machine water with the alkalinity of the dispersed builder salt phase of the detergent composition and acts as an effective anionic surfactant.

Specific examples include the half-esters of product (A) with succinic anhydride, the ester or half ester of Dobanol 25-7 with succinic anhydride, and the ester or half ester of Dobanol 91-5 with succinic anhydride. Instead of succinic anhydride, other polycarboxylic acids or anhydrides can be used, e.g. maleic acid, maleic acid anhydride, glutaric acid, malonic acid, phthalic acid, phthalic anhydride, citric acid and the like.

The acid terminated nonionic surfactants can be prepared as follows:

20 Acid Terminated product (A). 400g of product (A) nonionic surfactant which is a  $C_{13}$  to  $C_{15}$  alkanol which has been alkoxyated to introduce 6 ethylene oxide and 3 propylene oxide units per alkanol unit is mixed with 32g of succinic anhydride and heated for 7 hours at  $100^{\circ}\text{C}$ . The mixture is cooled and filtered to remove unreacted succinic material. Infrared analysis indicated that about one half of the nonionic surfactant has been converted to the acidic half-ester thereof.

30 Acid Terminated Dobanol 25-7. 522g of Dobanol 25-7 nonionic surfactant which is the product of ethoxylation of a  $C_{12}$  to  $C_{15}$  alkanol and has about 7 ethylene oxide units per molecule of alkanol is mixed with 100g of succinic anhydride and 0.1g of pyridine (which acts as an esterification

catalyst) and heated at 260°C for 2 hours, cooled and filtered to remove unreacted succinic material. Infrared analysis indicates that substantially all the free hydroxyls of the surfactant have reacted.

Acid Terminate Dobanol 91-5. 1000g of Dobanol 91-5 nonionic surfactant which is the product of ethoxylation of a C<sub>9</sub> to C<sub>11</sub> alkanol and has about 5 ethylene oxide units per molecule of alkanol is mixed with 265g of succinic anhydride and 0.1g of pyridine catalyst and heated at 260°C for 2 hours, cooled and filtered to remove unreacted succinic material. Infrared analysis indicates that substantially all the free hydroxyls of the surfactant have reacted.

Other esterification catalysts, such as an alkali metal alkoxide (e.g. sodium methoxide) may be used in place of, or in admixture with, the pyridine.

The acidic polyether compound, i.e. the acid terminated nonionic surfactant is preferably added dissolved in the nonionic surfactant.

#### BUILDER SALTS

The liquid nonaqueous nonionic surfactant used in the compositions of the present invention has dispersed and suspended therein fine particles of inorganic and/or inorganic detergent builder salts.

The invention detergent compositions include water soluble and/or water insoluble detergent builder salts. Water soluble inorganic alkaline builder salts which can be used alone with the detergent compound or in admixture with other builders are alkali metal carbonates, bicarbonates, borates, phosphates, polyphosphates, and silicates. (Ammonium or substituted ammonium salts can also be used.) Specific examples of such salts are sodium tripolyphosphate, sodium carbonate, sodium tetraborate, sodium pyrophosphate, potassium pyrophosphate, sodium bicarbonate, potassium tripolyphosphate, sodium hexametaphosphate, sodium sesquicarbonate, sodium mono and diorthophosphate, and potassium bicarbonate. Sodium tripolyphosphate (TPP) is especially preferred.

Since the compositions of this invention are generally highly concentrated, and, therefore, may be used at relatively low dosages, it is desirable to supplement any phosphate builder (such as sodium tripolyphosphate) with an auxiliary builder such as a poly lower carboxylic acid or a polymeric carboxylic acid having high calcium binding capacity to inhibit incrustation which could otherwise be caused by formation of an insoluble calcium phosphate.

A suitable lower poly carboxylic acid comprises alkali metal salts of lower polycarboxylic acids, preferably the sodium and potassium salts. Suitable lower polycarboxylic acids have two to four carboxylic acid groups. The preferred sodium and potassium lower polycarboxylic acids salts are the citric and tartaric acid salts.

The sodium citric acid salts are the most preferred, especially the trisodium citrate. The monosodium and disodium citrates can also be used. The monosodium and disodium tartaric acid salts can also be used. The alkali metal lower polycarboxylic acid salts are particularly good builder salts; because of their high calcium and magnesium binding capacity they inhibit incrustation which could otherwise be caused by formation of insoluble calcium and magnesium salts.

Other organic builders are polymers and copolymers of polyacrylic acid and polymaleic anhydride and the alkali metal salts thereof. More specifically such builder salts can consist of a copolymer which is the reaction product of about equal moles of methacrylic acid and maleic anhydride which has been completely neutralized to form the sodium salt thereof. The builder is commercially available under the tradename of Sokalan CP5. This builder serves when used even in small amounts to inhibit incrustation.

Examples of organic alkaline sequestrant builder salts which can be used with the detergent builder salts or in admixture with other organic and inorganic builders are alkali metal, ammonium or substituted ammonium, aminopolycarboxylates, e.g. sodium and potassium ethylene

diaminetetraacetate (EDTA), sodium and potassium nitrilotriacetates (NTA), and triethanolammonium N-(2-hydroxyethyl)nitrilodiacetates. Mixed salts of these aminopolycarboxylates are also suitable.

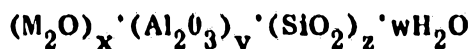
Other suitable builders of the organic type include carboxymethylsuccinates, tartronates and glycollates. Of special value are the polyacetal carboxylates. The polyacetal carboxylates and their use in detergent compositions are described in application Serial No. (IR 220/221), filed \_\_\_\_\_ assigned to applicants' assignee and in a U.S.P. Nos. 4,144,226, 4,315,092 and 4,146,495.

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The alkali metal silicates are useful builder salts which also function to adjust or control the pH and to make the composition anticorrosive to washing machine parts. Sodium silicates of  $\text{Na}_2\text{O}/\text{SiO}_2$  ratios of from 1.6/1 to 1/3.2, especially about 1/2 to 1/2.8 are preferred. Potassium silicates of the same ratios can also be used.

Other typical suitable builders include, for example, those disclosed in U.S. Patents 4,316,812, 4,264,466 and 3,630,929. The inorganic builder salts can be used with the nonionic surfactant detergent compound or in admixture with other inorganic builder salts or with organic builder salts.

The water insoluble crystalline and amorphous aluminosilicate zeolites can be used. The zeolites generally have the formula



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

Various crystalline zeolites (i.e. aluminosilicates) that can be used are described in British Patent 1,504,168, U.S.P. 4,409,136 and Canadian Patents 1,072,835 and 1,087,477, all of which are hereby incorporated by

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reference for such descriptions. An example of amorphous zeolites useful herein can be found in Belgium Patent 835,351 and this patent too is incorporated herein by reference.

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

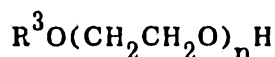
#### Viscosity Control and Anti Gel Agents

The inclusion in the detergent composition of an effective amount of viscosity control and gel-inhibiting agents for the nonionic surfactant improves the storage properties, of the composition. The viscosity control and gel-inhibiting agents act to lower the temperature at which the nonionic surfactant will form a gel when added to water. Such viscosity control and gel-inhibiting agents can be for example, lower alkanol, e.g. ethyl alcohol (see U.S.P. 3,953,380), hexylene glycol, polyethylene glycol, for example, polyethylene glycol having a molecular weight of about 400 (PEG 400) and low molecular weight alkylene oxide lower mono-alkyl ether amphiphilic compounds.

Preferred viscosity control and gel-inhibiting compounds are the low molecular weight amphiphilic compounds. The amphiphilic compounds function as viscosity control and gel inhibiting agents for the nonionic surfactant and

substantially improve the storage properties of the composition. The amphiphilic compounds can be considered to be analogous in chemical structure to the ethoxylated and/or propoxylated fatty alcohol liquid nonionic surfactants but have relatively short hydrocarbon chain lengths ( $C_2$  to  $C_8$ ) and a low content of ethylene oxide (about 2 to 6 ethylene oxide groups per molecule).

Suitable amphiphilic compounds are represented by the following general formula



where  $R^3$  is a  $C_2$ - $C_8$  alkyl group, and  $n$  is a number of from about 1 to 6, on average.

Specifically the compounds are lower ( $C_2$  to  $C_3$ ) alkylene glycol mono lower ( $C_2$  to  $C_5$ ) alkyl ethers.

More specifically the compounds are mono di- or tri lower ( $C_2$  to  $C_3$ ) alkylene glycol mono lower ( $C_1$  to  $C_5$ ) alkyl ethers.

Specific examples of suitable amphiphilic compounds include ethylene glycol monoethyl ether ( $C_2H_5-O-CH_2CH_2OH$ ), diethylene glycol monobutyl ether ( $C_4H_9-O-(CH_2CH_2O)_2H$ ), tetraethylene glycol monobutyl ether ( $C_4H_9-O-(CH_2CH_2O)_4H$ ) and dipropylene glycol monomethyl ether ( $CH_3-O-(CHCH_2O)_2H$ ).



Diethylene glycol monobutyl ether is especially preferred.

The inclusion in the composition of the low molecular weight lower alkylene glycol mono alkyl ether decreases the viscosity of the composition, such that it is more easily pourable, improves the stability against settling and improves the dispersibility of the composition on the addition to warm water or cold water.

The compositions of the present invention have improved viscosity and stability characteristics and remain stable and pourable at temperatures as low as about  $5^\circ C$  and lower.

The urea compounds in addition to acting as an anti-settling stabilizing agent acts to improve the dispersibility of the suspension of phosphate detergent builder particles by inhibiting gel formation of the suspended particles when cold water is added to the composition in the dispensing drawer and/or when the composition is added to water.

In an embodiment of this invention a supplemental stabilizing agent which is an alkanol ester of phosphoric acid or an aluminum salt of a higher fatty acid can be added to the formulation.

10 Improvements in stability of the composition may be achieved by incorporation of a small effective amount of an acidic organic phosphorus compound having an acidic - POH group, such as a partial ester of phosphorous acid and an alkanol.

As disclosed in the commonly assigned copending application Serial No. 597,948 filed April 9, 1984 the disclosure of which is incorporated herein by reference, the acidic organic phosphorous compound having an acidic - POH group can increase the stability of the suspension of builders in the nonaqueous liquid nonionic surfactant.

20 The acidic organic phosphorus compound may be, for instance, a partial ester of phosphoric acid and an alcohol such as an alkanol which has a lipophilic character, having, for instance, more than 5 carbon atoms, e.g. 8 to 20 carbon atoms.

A specific example is a partial ester of phosphoric acid and a C<sub>16</sub> to C<sub>18</sub> alkanol (Empiphos 5632 from Marchon); it is made up of about 35% monoester and 65% diester.

The inclusion of quite small amounts of the acidic organic phosphorus compound makes the suspension stable against settling on standing but remains pourable, while, for the low concentration of stabilizer, e.g. below about 1%, its plastic viscosity will generally decrease.

Improvements in the stability and anti-settling properties of the composition may also be achieved by the addition of a small effective amount of an aluminum salt of a higher fatty acid to the composition.

The aluminum salt stabilizing agents are the subject matter of the commonly assigned copending application Serial No. 725,455 filed April 22, 1985, the disclosure of which is incorporated herein by reference.

10 The preferred higher aliphatic fatty acids will have from about 8 to about 22 carbon atoms, more preferably from about 10 to 20 carbon atoms, and especially preferably from about 12 to 18 carbon atoms. The aliphatic radical may be saturated or unsaturated and may be straight or branched. As in the case of the nonionic surfactants, mixtures of fatty acids may also be used, such as those derived from natural sources, such as tallow fatty acid, coco fatty acid, etc.

20 Examples of the fatty acids from which the aluminum salt stabilizers can be formed include, decanoic acid, dodecanoic acid, palmitic acid, myristic acid, stearic acid, oleic acid, eicosanoic acid, tallow fatty acid, coco fatty acid, mixtures of these acids, etc. The aluminum salts of these acids are generally commercially available, and are preferably used in the triacid form, e.g. aluminum stearate as aluminum tristearate  $\text{Al}(\text{C}_{17}\text{H}_{35}\text{COO})_3$ . The monoacid salts, e.g. aluminum monostearate,  $\text{Al}(\text{OH})_2(\text{C}_{17}\text{H}_{35}\text{COO})$  and diacid salts, e.g. aluminum distearate,  $\text{Al}(\text{OH})(\text{C}_{17}\text{H}_{35}\text{COO})_2$ , and mixtures of two or three of the mono-, di- and triacid aluminum salts can also be used. It is most preferred, however, that the triacid aluminum salt comprises at least 30%, preferably at least 50%, especially preferably at least 80% of the total amount of aluminum fatty acid salt.

The aluminum salts, as mentioned above, are commercially available and can be easily produced by, for example, saponifying a fatty acid, e.g. animal fat, stearic acid, etc., followed by treatment of the resulting soap with alum, alumina, etc.

Only very small amounts of the aluminum salt stabilizing agent is required to obtain an improvement in physical stability.

### Bleaching Agents

10 The bleaching agents are classified broadly, for convenience, as chlorine bleaches and oxygen bleaches. Chlorine bleaches are typified by sodium hypochlorite ( $\text{NaOCl}$ ), potassium dichloroisocyanurate (59% available chlorine), and trichloroisocyanuric acid (95% available chlorine). Oxygen bleaches are preferred and are represented by percompounds which liberate hydrogen peroxide in solution. Preferred examples include sodium and potassium perborates, percarbonates, and perphosphates, and potassium monopersulfate. The perborates, particularly sodium perborate monohydrate, are especially preferred.

20 The peroxygen compound is preferably used in admixture with an activator therefor. Suitable activators which can lower the effective operating temperature of the peroxide bleaching agent are disclosed, for example, in U.S.P. 4,264,466 or in column 1 of U.S.P. 4,430,244, the relevant disclosures of which are incorporated herein by reference. Polyacetylated compounds are preferred activators; among these, compounds such as tetraacetyl ethylene diamine ("TAED") and pentaacetyl glucose are particularly preferred.

Other useful activators include, for example, acetylsalicylic acid derivatives, ethylidene benzoate acetate and its salts, ethylidene carboxylate acetate and its salts, alkyl and alkenyl succinic anhydride, tetraacetylglucouril ("TAGU"), and the derivatives of these. Other useful classes of activators are disclosed, for example, in U.S.P. 4,111,826, 4,422,950 and 3,661,789.

The bleach activator usually interacts with the peroxygen compound to form a peroxyacid bleaching agent in the wash water. It is preferred to include a sequestering agent of high complexing power to inhibit any

undesired reaction between such peroxyacid and hydrogen peroxide in the wash solution in the presence of metal ions.

Suitable sequestering agents for this purpose include the sodium salts of nitrilotriacetic acid (NTA), ethylene diamine tetraacetic acid (EDTA), diethylene triamine pentaacetic acid (DETPA), diethylene triamine pentamethylene phosphonic acid (DTPMP) sold under the tradename Dequest 2066; and ethylene diamine tetramethylene phosphonic acid (EDITEMPA). The sequestering agents can be used alone or in admixture.

10 In order to avoid loss of peroxide bleaching agent, e.g. sodium perborate, resulting from enzyme-induced decomposition, such as by catalase enzyme, the compositions may additionally include an enzyme inhibitor compound, i.e. a compound capable of inhibiting enzyme-induced decomposition of the peroxide bleaching agent. Suitable inhibitor compounds are disclosed in U.S.P. 3,606,990, the relevant disclosure of which is incorporated herein by reference.

Of special interest as the inhibitor compound, mention can be made of hydroxylamine sulfate and other water-soluble hydroxylamine salts. In the preferred nonaqueous compositions of this invention, suitable amounts of the hydroxylamine salt inhibitors can be as low as about 0.01 to 0.4%. Generally, however, suitable amounts of enzyme inhibitors are up to about 20 15%, for example, 0.1 to 10%, by weight of the composition.

In addition to the detergent builders, various other detergent additives or adjuvants may be present in the detergent product to give it additional desired properties, either of functional or aesthetic nature. Thus, there may be included in the formulation, minor amounts of soil suspending or anti-redeposition agents, e.g. polyvinyl alcohol, fatty amides, sodium carboxymethyl cellulose, and hydroxy-propyl methyl cellulose. A preferred anti-redeposition agent is sodium carboxymethyl cellulose having a 2:1 ratio of CM/MC which is sold under the tradename Relatin DM 4050.

There may also be included in the urea compound containing composition small amounts of an alkyl or alkylene succinic anhydride, such as octenyl succinic anhydride which functions as a viscosity control and anti-gel agent. The octenyl succinic anhydride can be added in amounts such as 0.5 to 10 percent, preferably 1 to 6 percent and more preferably 1 to 4 percent by weight of the composition.

10

There may also be included in the quaternary ammonium containing composition small amounts of Alcosperse D107 which is sodium polyacrylate and which functions as an anti scaling agent. The Alcosperse D107 can be included in amounts such as 0.5 to 8%, preferably 2 to 6% and more preferably 3 to 5% by weight of the composition.

Optical brighteners for cotton, polyamide and polyester fabrics can be used. Suitable optical brighteners include stilbene, triazole and benzidine sulfone compositions, especially sulfonated substituted triazinyl stilbene, sulfonated naphthotriazole stilbene, benzidine sulfone, etc., most preferred are stilbene and triazole combinations. A preferred brightener is Stilbene Brightener N4 which is a dianilindimorpholino stilbene polysulfonate.

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Enzymes, preferably proteolytic enzymes, such as subtilisin, bromelin, papain, trypsin and pepsin, as well as amylase type enzymes, lipase type enzymes, and mixtures thereof can be added. Preferred enzymes include protease slurry, esperase slurry and amylase. A preferred enzyme is Esperase SL8 which is a proteolytic enzyme. Anti-foam agents, e.g. silicon compounds, such as Silicane L 7604, which is a polysiloxane and can be added in small effective amounts.

Bactericides, e.g. tetrachlorosalicylanilide and hexachlorophene, fungicides, dyes, pigments (water dispersible), preservatives, ultraviolet absorbers, anti-yellowing agents, such as sodium carboxymethyl cellulose, pH modifiers and pH buffers, color safe bleaches, perfume, and dyes and bluing agents such as ultramarine blue can be used.

The composition may also contain small amounts of paint pigments to provide coloring such as  $\text{TiO}_2$ , white pigment. The  $\text{TiO}_2$  can be added in amounts such as 0.1 to 4 percent, preferably 0.1 to 2 percent and more preferably 0.1 to 1 percent.

The composition may also contain small amounts of Bentone 27 which is an organic derivative of hydrous magnesium aluminum silicate. The Bentone 27 can be used in amounts such as 0.2 to 3%, preferably 0.5 to 2%, and more preferably about 1% by weight.

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

20 In an embodiment of the invention the stability of the builder salts in the composition during storage and the dispersibility of the composition in water is improved by grinding and reducing the particle size of the solid builders to less than 100 microns, preferably less than 40 microns and more preferably to less than 10 microns. The solid builders, e.g. sodium tripolyphosphate (TPP), are generally supplied in particle sizes of about 100, 200 or 400 microns. The nonionic liquid surfactant phase can be mixed with the solid builders prior to or after carrying out the grinding operation.

30 In a preferred embodiment of the invention, the mixture of liquid nonionic surfactant and solid ingredients is subjected to an attrition type of mill in which the particle sizes of the solid ingredients are reduced to less than about 10 microns, e.g. to an average particle size of 2 to 10 microns or



even lower (e.g. 1 micron). Preferably less than about 10%, especially less than about 5% of all the suspended particles have particle sizes greater than 10 microns. Compositions whose dispersed particles are of such small size have improved stability against separation or settling on storage. Addition of the acid terminated nonionic surfactant compound can decrease the yield stress of such dispersions and aid in the dispersibility of the dispersions without a corresponding decrease in the dispersions stability against settling.

10

In the grinding operation, it is preferred that the proportion of solid ingredients be high enough (e.g. at least about 40% such as about 50%) that the solid particles are in contact with each other and are not substantially shielded from one another by the nonionic surfactant liquid. After the grinding step any remaining liquid nonionic surfactant can be added to the ground formulation. Mills which employ grinding balls (ball mills) or similar mobile grinding elements have given very good results. Thus, one may use a laboratory batch attritor having 8 mm diameter steatite grinding balls. For larger scale work a continuously operating mill in which there are 1 mm or 1.5 mm diameter grinding balls working in a very small gap between a stator and a rotor operating at a relatively high speed (e.g. a CoBall mill) may be employed; when using such a mill, it is desirable to pass the blend of nonionic surfactant and solids first through a mill which does not effect such fine grinding (e.g. a colloid mill) to reduce the particle size to less than 100 microns (e.g. to about 40 microns) prior to the step of grinding to an average particle diameter below about 10 microns in the continuous ball mill.

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In the preferred heavy duty liquid laundry detergent compositions of the invention, typical proportions (percent based on the total weight of composition, unless otherwise specified) of the ingredients are as follows:

Liquid nonionic surfactant detergent in the range of about 10 to 60 or 70, such as 20 to 50 or 60 percent, e.g. about 30 to 40 or 50 percent.

Acid terminated nonionic surfactant in an amount in the range of about 0 to 20, such as 1 or 3 to 15 percent, e.g. about 4 to 10.

Detergent builder, such as sodium tripolyphosphate (TPP), in the range of about 10 to 60, such as 15 to 50 percent, e.g. about 15 or 25 to 35.

Alkali metal silicate in the range of about 0 to 30, such as 5 to 25 percent, e.g. about 10 to 20.

Copolymer of polyacrylate and polymaleic anhydride alkali metal salt, e.g. Sokalan CP5, anti-incrustation agent in the range of about 0 to 10, such as 2 to 8 percent, e.g. about 3 to 5.

10

Alkylene glycol monoalkylether anti-gel agent can be used with the urea compound additive in an amount in the range of about 5 to 30, such as 5 to 20 percent, e.g. about 5 to 15 percent.

Alkylene glycol viscosity control and gel-inhibiting agent can be used with the quaternary ammonium additive in an amount in the range of about 5 to 30, such as 5 to 25 percent, e.g. about 15 to 25. The preferred viscosity control and gel-inhibiting agents are the alkylene glycol mono-alkylethers.

20

The urea or the quaternary ammonium salt anti-settling stabilizing agent in the range of 0.1 to 5, preferably 0.2 to 2.0 and more preferably about 0.5 to 1.5 percent. It is an essential feature of the invention that at least one of the urea compound or at least one of the quaternary ammonium salts be included in the composition.

Phosphoric acid alkanol ester stabilizing agent in the range of 0 to 2.0 or 0.1 to 2.0, such as 0.10 to 1.0 percent.

Aluminum salt of fatty acid stabilizing agent in the range of about 0 to 5.0, such as 0.5 to 2.0 percent, e.g. about 0.1 to 1.0 percent.

Bleaching agent in the range of about 0 to 30, such as 2 to 20, e.g. about 5 to 15 percent.

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Bleach activator in the range of about 0 to 15, such as 1 to 8 or 10, e.g. about 1 to 8 or 2 to 6 percent.

Sequestering agent for bleach, e.g. Dequest 2066, in the range of about 0 to 3.0, preferably 0.5 to 2.0 percent, e.g. about 0.75 to 1.25 percent.

Anti-redeposition agent, e.g. Relatin DM 4050, in the range of about 0 to 4.0 or 5.0, preferably 0.5 to 3.0 or 4.0 percent, e.g. 1.0 to 3.0 or 0.5 to 1.5 percent.

Optical brightener in the range of about 0 to 2.0, preferably 0.05 or 0.25 to 1.0 percent, e.g. 0.15 or 0.25 to 0.75 percent.

Enzymes in the range of about 0 to 3.0, preferably 0.5 to 2.0 percent, e.g. 0.75 to 1.25 percent.

Perfume in the range of about 0 to 3.0, preferably 0.10 or 0.25 to 1.25 percent, e.g. 0.25 or 0.75 to 1.0 percent.

Coloring pigment in the range of about 0.1 to 4.0, preferably 0.1 to 2.0 and more preferably 0.1 to 1.0 percent.

Dye in the range of about 0 to 0.10, preferably 0.0025 to 0.050, e.g. 0.0025 to 0.0100 percent.

Various of the previously mentioned additives can optionally be added to achieve the desired function of the added materials.

The urea anti-settling stabilizing agent is preferably used with at least one of the alkylene glycol mono-ether or the acid terminated nonionic surfactant viscosity control and anti-gel agents. In some cases advantages can be obtained by using both the alkylene glycol mono-ethers and the acid terminate nonionic surfactants.

Mixtures of the acid terminated nonionic surfactant and viscosity control and gel-inhibiting agents, e.g. the alkylene glycol alkyl ether anti-gel agents, can be used and in some cases advantages can be obtained by the use of such mixtures alone, or with the addition to the mixture of the anti-settling stabilizing agent.

In the selection of the additives, they will be chosen to be compatible with the main constituents of the detergent composition. In this application,

as mentioned above, all proportions and percentages are by weight of the entire formulation or composition unless otherwise indicated.

The concentrated nonaqueous nonionic liquid detergent composition of the present invention dispenses readily in the water in the washing machine.

The liquid nonionic detergent compositions of the present invention are preferably nonaqueous, e.g. they are substantially anhydrous. Though minor amounts of water can be tolerated, it is preferred that the compositions contain less than 3%, preferably less than 2% and more preferably less than 1% water.

10

The presently used home washing machines normally use 200-250 gms of powder detergent to wash a full load of laundry. In accordance with the present invention only 100 cc or 78 gms of the concentrated liquid nonionic detergent composition is needed.

In the urea compound additive embodiment of the invention the detergent composition of a typical formulation is formulated using the below named ingredients:

	<u>Weight %</u>
Nonionic surfactant detergent.	30-40
Acid terminated surfactant.	0-20
Phosphate detergent builder salt.	10-60
Anti-incrustation agent.	0-10
Alkylene glycol monoalkylether anti-gel agent.	5-15
Urea compound.	0.2-2.0
Anti-redeposition agent.	0-4.0
Alkali metal perborate bleaching agent.	5-15
Bleach activator (TAED).	1.0-8.0
Sequestering agent for bleach.	0-3.0
Optical brightener.	0.05-0.75
Enzymes.	0.75-1.25
Perfume.	0.1-1.0

30

In the quaternary ammonium compound additive embodiment of the invention the detergent composition of a typical formulation is formulated using the below named ingredients:

	<u>Weight %</u>
Nonionic surfactant detergent or mixture thereof.	30-50
Acid terminated surfactant.	0-20
Phosphate detergent builder salt.	15-35
Copolymer of polyacrylate and polymaleic anhydride alkali metal salt anti-encrustation agent (Sokalan CP-5).	0-10
Alkylene glycol viscosity control and gel-inhibiting agent.	10-25
Quaternary ammonium salt anti-gel stabilizing agent.	0.2-2.0
Anti-redeposition agent.	0-5.0
Alkali metal perborate bleaching agent.	3-15
Bleach activator (TAED).	1.0-6.0
Sequestering agent.	0-3.0
Optical brightener (Stilbene Brightener N4).	0-2.0
Enzymes (Protease-Espase SL8).	0-3.0
Perfume.	0-3.0

The present invention is further illustrated by the following examples.

#### Urea Compound Additive

##### EXAMPLE 1

A concentrated nonaqueous liquid nonionic surfactant detergent composition is formulated from the following ingredients in the amounts specified.

	<u>Weight %</u>
Nonionic surfactant.	37.7
Acid terminated Dobanol 91-5 reaction product with succinic anhydride.	5.0
Sodium tri polyphosphate (TPP).	30
Diethylene glycol monobutylether anti-gel agent.	10
Urea.	1.0

Sodium perborate monohydrate bleaching agent.	9.0
Tetraacetylene diamine (TAED) bleach activator.	4.5
Anti-redeposition agent (Relatin DM 4096) <sup>(1)</sup>	1.0
Optical brightener.	0.2
Perfume.	0.6
Enzyme (which is Esperase).	1.0

(1) CMC/MC 2:1 mixture of sodium carboxymethyl cellulose and hydroxymethylcellulose.

The addition of 1% of urea is found to increase the yield stress of the formulation.

The formulation is ground for about 1.0 hour to reduce the particle size of the suspended builder salts to less than 1.0 microns. The formulated detergent composition is found to be stable and non-gelling in storage and readily dispersible in water.

#### EXAMPLE 2

A concentrated nonaqueous liquid nonionic surfactant detergent composition is formulated from the following ingredients in the amounts specified.

	<u>Weight %</u>
Surfactant T7.	18
Surfactant T9.	18
Octenyl succinic anhydride <sup>(1)</sup> .	2
Sodium tri-polyphosphate (TPP).	29.5
Anti-incrustation agent (Sokalan CP5).	4.0
Diethylene glycol monobutylether anti-gel agent.	10
Urea anti-settling stabilizing agent.	1.0
Sodium perborate monohydrate bleaching agent.	9
Tetraacetylene diamine (TAED) bleaching agent.	4.5
Sequestering agent for bleach (Dequest 2066).	1.0
Anti-redeposition agent (Relatin DM 4096) <sup>(2)</sup> .	1.0

Optical brighteners (ATS-X).	0.2
Enzyme (which is a protease).	1.0
Perfume.	0.6
TiO <sub>2</sub> (pigment).	0.2

(1) Viscosity control and anti-gel agent.

(2) CMC/MC 2:1 mixture of sodium carboxymethyl cellulose and hydroxymethylcellulose.

The addition of 1 percent of urea is found to increase the yield stress of the formulation. The apparent viscosity of the formulation at 100 reciprocal seconds is found to be 1.1 Pa.

The formulation is ground for about 1 hour to reduce the particle size of the suspended builder salts to less than 10 microns. The formulated detergent composition is found to be stable and non-gelling in storage and readily dispersible in water.

The formulations of Examples 1 and 2 can be prepared without grinding the builder salts and suspended solid particles to a small particle size, but best results are obtained by grinding the formulation to reduce the particle size of the suspended solid particles.

The urea anti-settling stabilizing agent can also be used to improve the compatibility of the nonionic surfactant and polyphosphate detergent builder salt in powder detergent compositions.

#### Quaternary Ammonium Compound Additive

##### EXAMPLE 3

A concentrated nonaqueous liquid nonionic surfactant detergent composition is formulated from the following ingredients in the amounts specified.

	<u>Weight %</u>
Product D nonionic surfactant.	39
Acid terminated Dobanol 91-5 reaction product with succinic anhydride.	5.0

Sodium tri polyphosphate (TPP).	30
Diethylene glycol monobutylether anti-gel agent.	10
Quaternary ammonium salt <sup>(1)</sup> .	1.0
Sodium perborate monohydrate bleaching agent.	9.0
Tetraacetylene diamine (TAED) bleach activator.	4.5
Stilbene brightener.	0.5
Protease (Esperase).	1.0

(1) The quaternary amine salt anti-settling stabilizing agent used is Arosurf TA 100 (distearyl dimethyl ammonium chloride).

10

The addition of 1% of the quaternary ammonium salt is found to increase the yield stress of the formulation from about 2 Pa to about 6 Pa. The apparent viscosity of the formulation is found to increased from about 0.5 Pa.s. to 0.4 Pa.s.

The formulation is ground for about 1 hour to reduce the particle size of the suspended builder salts to less than 10 microns. The formulated detergent composition is found to be stable and non-gelling in storage and to have a high detergent capacity.

#### EXAMPLE 4

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A concentrated nonaqueous liquid nonionic surfactant detergent composition is formulated from the following ingredients in the amounts specified.

	<u>Weight %</u>
Surfactant T7	18.7
Surfactant T9	18.7
Acid terminated Dobanol 91-5 reaction product with succinic anhydride.	5.0
Sodium tri-polyphosphate (TPP).	30
Diethylene glycol monobutylether anti-gel agent.	10
Quaternary ammonium salt <sup>(1)</sup> .	1.0
Sodium perborate monohydrate bleaching agent.	9

30



Tetraacetylene diamine (TAED) bleaching agent.	4.5
Stilbene brightener.	0.5
Protease (Esperase).	1.0
Relatin DM 4096 (CMC/MC) <sup>(2)</sup>	1.0
Perfume.	0.6

(1) The quaternary amine salt anti-settling stabilizing agent used is Ethoquat 2T14 (di-tallow diethoxylated (x+y=4) ammonium chloride.

(2) A 2:1 mixture of sodium carboxymethyl cellulose and hydroxy methyl cellulose.

10

The addition of 1% of the quaternary amine salt is found to increase the yield stress of the formulation from about 3 Pa to 10 Pa. The apparent viscosity of the formulation is found to increase from about 0.5 Pa.s to 0.4 Pa.s.

The formulation is ground for about 1 hour to reduce the particle size of the suspended builder salts to less than 10 microns. The formulated detergent composition is found to be stable and non-gelling in storage and to have a high detergent capacity.

#### EXAMPLE 5

Concentrated nonaqueous liquid nonionic surfactant detergent compositions were formulated from the following ingredients in the amounts specified.

	<u>A</u>	<u>B</u>
Plurafac RA50	35	35
Plurafac B26	9.0	9.0
Sodium tri-polyphosphate (TPP)	18	18
Polyethylene glycol (Mol.Wt. 400) anti-gel agent	20	20
Quaternary Ammonium Salt <sup>(1)</sup>	1.0	---
Sodium perborate monohydrate bleaching agent	3.6	4.1
Tetra acetyl ethylene diamine (TEAD) Bleach Activator	4.5	5.0
Relatin DM4096 (CMC/MC) <sup>(2)</sup> anti-redeposition agent	3.0	3.0

30

EDTA Sequestering Agent (3)	0.9	0.9
Bentone 27 <sup>(4)</sup>	1.0	1.0
Alcosperse D107 <sup>(5)</sup>	<u>4.0</u>	<u>4.0</u>
	100.0	100.0

1. Ethoquat 2T 14 which is the di-tallow diethoxy (x+y=4) quaternary ammonium chloride.

2. A 2:1 mixture of sodium carboxymethyl cellulose and hydroxy methyl cellulose.

3. Ethylene diamine tetra acetic acid.

4. Organic derivative of hydrous magnesium aluminum silicate which functions as an anti-settling agent.

5. Alcosperse D107 which is sodium polyacrylate and which functions as antiscaling agent.

The formulation was ground for about fifteen minutes to reduce the particle size of the suspended builder salts to less than 10 microns. The formulated detergent composition A of the invention is found to be stable and non-gelling in storage and to have a high detergent capacity.

A comparison of the inventive composition A with anti-settling stabilizing the quaternary ammonium salt with composition B without the quaternary ammonium salt gave the following results.

	<u>A</u>	<u>B</u>
Apparent viscosity (LVT, Sp.4, 60rpm) (m Pa.s)	3250	2350
Stability after 48h: phase separation %:	1%	7%
Yield stress: (Pa)	26	6.5
Plastic viscosity (m Pa.s)	400	510

The data obtained show that the addition to the formulation of as little as 1% quaternary ammonium salt anti-settling stabilizing agent of the present

invention substantially increased the stability of the formulation, increased the apparent viscosity, increased the yield stress and decreased the plastic viscosity.

The formulations of Examples 3, 4 and 5 can be prepared without grinding the builder salts and suspended solid particles to a small particle size, but best results are obtained by grinding the formulation to reduce the particle size of the suspended solid particles.

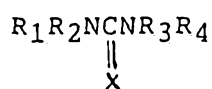
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In the examples 1 to 5 the builder salts can be used as provided or the builder salts and suspended solid particles can be ground or partially ground prior to mixing them with the nonionic surfactant. The grinding can be carried out in part prior to mixing and grinding completed after mixing or the entire grinding operation can be carried out after mixing with the liquid surfactant. The formulations containing suspended builder and solid particles less than 10 microns in size are preferred.

It is understood that the foregoing detailed description is given merely by way of illustration and that variations may be made therein without departing from the spirit of the invention.

THE CLAIMS DEFINING THE INVENTION ARE AS FOLLOWS:-

1. A non-aqueous fabric treating detergent composition which comprises a suspension of insoluble inorganic builder salt particles in 10 to 70 percent of a non-ionic liquid surfactant detergent, and 0.1 to 5% of an anti-settling agent chosen from a urea compound or a cationic quaternary amine salt surface active agent, to increase the stability of the suspension, the urea compound having the formula



wherein at least one of the  $R_1$  to  $R_4$  is hydrogen and the remainder are selected from the group consisting of alkyl, aryl, hydroxyl and chlorine, and X is O or NH, the cationic quaternary amine salt surface active agent being selected from the group consisting of (I) mono-higher alkyl tri-lower alkyl quaternary ammonium salt, (II) di-higher alkyl di-lower alkyl quaternary ammonium salt, (III) mono-higher alkyl mono-lower alkyl diethoxylated quaternary ammonium salt and (IV) di-higher alkyl diethoxylated quaternary ammonium salt.

2. The composition of claim 1 wherein the insoluble inorganic particles comprise 10 to 60 percent of phosphate detergent builder salt.

3. The composition of claim 2 wherein the phosphate detergent builder salt comprises alkali metal polyphosphate.

4. The composition of claim 1 wherein the inorganic particles comprise 15 to 50 percent of a polyphosphate detergent builder salt.

5. The detergent composition of claim 1 wherein the composition comprises at least one viscosity control and anti-gel agent selected from the group consisting 5 to 30



percent of a C<sub>2</sub> to C<sub>3</sub> alkylene glycol mono C<sub>1</sub> to C<sub>5</sub> alkyl ether and 3 to 15 percent of a polycarboxylic acid terminated nonionic surfactant.

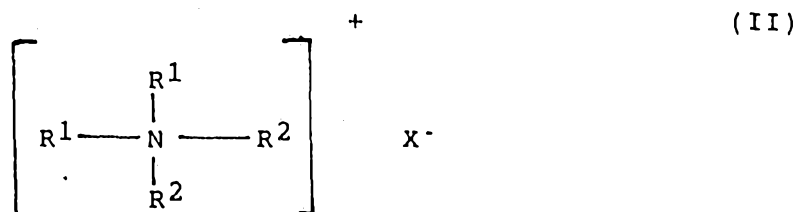
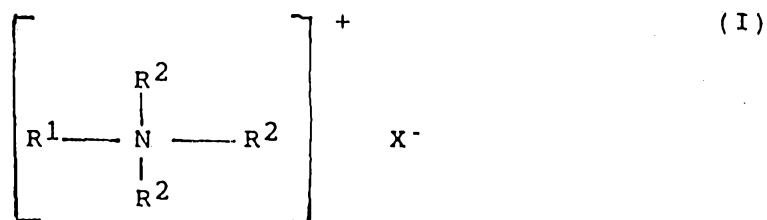
6. The detergent composition of claim 1 comprising one or more detergent adjuvants selected from the group consisting of anti-incrustation agent, bleaching agent, bleach activator, sequestering agent, anti-redeposition agent, optical brightener, enzymes, perfume and pigment coloring.

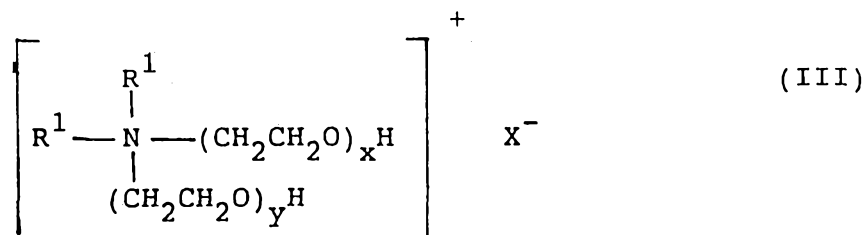
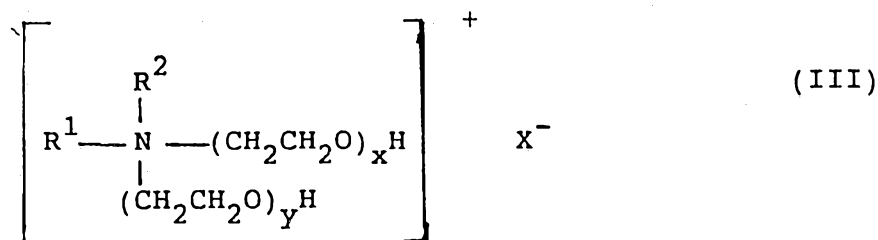
7. The detergent composition of claim 5 comprising 5 to 20 percent of C<sub>2</sub> to C<sub>3</sub> alkylene glycol mono C<sub>1</sub> to C<sub>5</sub> alkyl ether.

8. The composition of claim 1 wherein the inorganic particles have a particle size distribution such that no more than 10% by weight of said particles have a particle size of more than 10 microns.

9. The composition of claim 1 which contains from 0.2 to 2.0 percent by weight, based on the total composition, of said anti-settling agent.

10. The composition of claim 1 wherein the cationic quaternary amine salt surface active agent is selected from the group consisting of compounds represented by the formulae





wherein the  $\text{R}^1$ 's are independently, long chain aliphatic radicals having from 10 to 22 carbon atoms, the  $\text{R}^2$ 's are independently, lower alkyl or hydroxy alkyl radicals,  $x$  and  $y$  are each positive numbers of at least 1 and the sum of  $x$  and  $y$  is from 2 to 15, and  $\text{X}$  is a water soluble salt forming anion.

11. A nonaqueous heavy duty, built laundry detergent composition which is pourable at high and low temperatures and does not gel when mixed with cold water, and which comprises

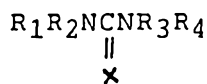
at least one liquid nonionic surfactant in an amount of from 10 to 60 percent by weight;

at least one inorganic alkali metal polyphosphate detergent builder salt suspended in the nonionic surfactant in an amount of from 10 to 60 percent by weight; a polycarboxylic acid terminated nonionic surfactant as a gel inhibiting additive, in an amount of 0 to 20 percent by weight;

a compound of the formula  $\text{RO}(\text{CH}_2\text{CH}_2\text{O})_n\text{H}$  where  $\text{R}$  is a  $\text{C}_2$  to a  $\text{C}_8$  alkyl group and  $n$  is a number having an average value in the range of from 1 to 6, as a gel inhibiting additive in an amount up to 5 to 30 percent by



weight, and  
urea anti-settling and stabilizing agent in an amount of  
0.2 to 2.0 percent by weight, the urea compound have the  
formula



wherein at least one of the  $R_1$  to  $R_4$  is hydrogen and  
the remainder are selected from the group consisting of  
alkyl, aryl, hydroxyl and chlorine, and  $X$  is O or NH.

12. The detergent composition of claim 11 which contains  
one or more detergent adjuvants selected from the group  
consisting of enzymes, corrosion inhibitors, anti-foam  
agents, suds suppressors soil suspending or anti  
redemption agents, anti-yellowing agents, colorants,  
perfumes, optical brighteners, blueing agents, pH  
modifiers, pH buffers, bleaching agents, bleach  
stabilizers, bleach activators, enzyme inhibitors and  
sequestering agents.

13. A nonaqueous liquid heavy duty built laundry  
detergent composition of claim 11 which comprises by weight

Nonionic surfactant in an amount of	20 - 50%
Sodium Tri polyphosphate (TPP) in an amount of	15 - 50%
Copolymer of methacrylic acid and maleic anhydride sodium salt in an amount of	2 - 8%
Diethylene glycol $C_1$ to $C_5$ mono alkyl ether in an amount of	5 - 20%
Urea in an amount of	0.2 - 2.0%
Sodium perborate monohydrate bleaching agent in an amount of	2 - 20%
Tetraacetylene diamine (TAED) in an amount of	1 - 10%.

14. A nonaqueous liquid heavy duty built laundry  
detergent composition of claim 11 which comprises by weight



Nonionic surfactant in an amount of	30 - 40%
Octenyl succinic anhydride in an amount of	1 - 6%
Sodium tripolyphosphate in an amount of	25 - 35%
Copolymer of methacrylic acid and maleic anhydride sodium salt in an amount of	3 - 5%
Diethylene glycol monobutylether in an amount of	5 - 15%
Urea in an amount of	0.5 - 1.5%
Sodium perborate monohydrate bleaching agent in an amount of	5 - 15%
Tetraacetylene diamine (TAED) bleach activator in an amount of	2 - 6.0%
Anti-redeposition agent in an amount of	0.5 - 1.5%

15. A non-aqueous, liquid, heavy-duty, built laundry detergent composition comprising:

10-70% by weight of at least one liquid nonionic surfactant, said liquid nonionic surfactant consisting of a polyloweralkoxylated higher alkanol, wherein said alkanol is of 9 to 18 carbon atoms and the number of moles of said lower alkylene oxide is from 3 to 12 per mole of said alkanol;

10-60% by weight of at least one particulate detergent builder salt suspended in said at least one nonionic surfactant;

0.1-5% by weight of a cationic quaternary ammonium salt surface active anti-settling agent selected from the group consisting of (I) mono-higher alkyl tri-lower alkyl quaternary ammonium salt, (II) di-higher alkyl di-lower alkyl quaternary ammonium salt, (III) mono-higher alkyl mono-lower alkyl diethoxylated quaternary ammonium salt and (IV) di-higher alkyl diethoxylated quaternary ammonium salt;

5-30% by weight of a viscosity control and gel-inhibiting agent selected from the group consisting of





alkylene glycols and alkylene glycol mono alkyl ethers;

0-2.0% by weight of a phosphoric acid alkanol ester stabilizing agent;

0-5.0% by weight of an aluminium salt of a fatty acid stabilizing agent;

0-30% by weight of a bleaching agent;

0-15% by weight of a bleach activator;

0-3.0% by weight of a sequestering agent for metal ions;

0-5.0% by weight of an anti-redeposition agent;

0-2.0% of an optical brightener;

0-3.0% of enzymes;

0-3.0% of perfume;

0-0.10% of dye.

16. The composition of claim 14, wherein said viscosity control and gel-inhibiting agent is polyethylene glycol.

17. The composition of claim 14, wherein said viscosity control and gel-inhibiting agent is diethylene glycol monobutylether.

18. A non-aqueous, liquid, heavy-duty, built laundry detergent composition comprising:

10-70% by weight of at least one liquid anionic surfactant, said liquid nonionic surfactant consisting of a polyloweralkoxylated higher alkanol, wherein said alkanol is of 9 to 18 carbon atoms and the number of moles of said lower alkylene oxide is from 3 to 12 per mole of said alkanol;

10-60% by weight of at least one particulate detergent builder salt suspended in said at least one liquid nonionic surfactant;

0.1-5% by weight of a cationic quaternary ammonium salt surface active anti-swelling agent selected from the group consisting of (I) mono-higher alkyl tri-lower alkyl quaternary ammonium salt, (II) di-higher alkyl di-lower alkyl quaternary ammonium salt, (III) mono-higher alkyl



mono-lower alkyl diethoxylated quaternary ammonium salt and (IV) di-higher alkyl diethoxylated quaternary ammonium salt;

0-2.0% by weight of a phosphoric acid alkanol ester stabilizing agent;

0-5.0% by weight of an aluminium salt of a fatty acid stabilizing agent;

0-30% by weight of a bleaching agent;

0-15% by weight of a bleach activator;

0-3.0% by weight of a sequestering agent for metal ions;

0-5.0% by weight of an anti-redeposition agent;

0-2.0% of an optical brightener;

0-3.0% of enzymes;

0-3.0% of perfume;

0-1.10% of dye;

balance, one or more detergent adjuvants selected from corrosion inhibitors, anti-foam agents, suds suppressors, anti-yellowing agents, bluing agents, pH modifiers, pH buffers, bleach stabilizers and enzyme inhibitors.

19. A non-aqueous, liquid, heavy-duty, built laundry detergent composition comprising:

10-70% by weight of at least one liquid nonionic surfactant, said liquid nonionic surfactant consisting of a polyloweralkoxylated higher alkanol, wherein said alkanol is of 9 to 18 carbon atoms and the number of moles of said lower alkylene oxide is from 3 to 12 per mole of said alkanol;

10-60% by weight of at least one particulate detergent builder salt suspended in said at least one nonionic surfactant;

0.1-5% by weight of a cationic quaternary ammonium salt surface active anti-settling agent selected from the group consisting of (I) mono-higher alkyl tri-lower alkyl



quaternary ammonium salt, (II) di-higher alkyl di-lower alkyl quaternary ammonium salt, (III) mono-higher alkyl mono-lower alkyl diethoxylated quaternary ammonium salt and (IV) di-higher alkyl di-ethoxylated quaternary ammonium salt;

5-30% by weight of a viscosity control and gel-inhibiting agent selected from alkylene glycols and alkylene glycol mono alkyl ethers;

0-2.0% by weight of a phosphoric acid alkanol ester stabilizing agent;

0-5.0% by weight of an aluminium salt of a fatty acid stabilizing agent;

0-30% by weight of a bleaching agent;

0-15% by weight of a bleach activator;

0-3.0% by weight of a sequestering agent for metal ions;

0-5.0% by weight of an anti-redeposition agent;

0-2.0% of an optical brightener;

0-3.0% of enzymes;

0-3.0% of perfume;

0-0.10% of dye;

balance, one or more detergent adjuvants selected from the group consisting of corrosion inhibitors, anti-foam agents, suds suppressors, anti-yellowing agents, bluing agents, pH modifiers, pH buffers, bleach stabilizers and enzyme inhibitors.

20. A method for cleaning soiled fabrics which comprises contacting the soiled fabrics with a sufficient cleaning amount of the laundry detergent composition of claim 1.

21. A method for cleaning soiled fabrics which comprises contacting the soiled fabrics with a sufficient cleaning amount of the laundry detergent composition of any one of claims 11 to 14.

22. A method for cleaning soiled fabrics which comprises contacting the soiled fabrics with a sufficient cleaning



amount of the laundry detergent composition of any one of claims 15 to 19.

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