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(71) Applicant (for all designated States except US): **HERCULES INCORPORATED** [US/US]; Hercules Plaza, 1313 North Market Street, Wilmington, DE 19894-0001 (US).

(72) Inventors; and

(75) Inventors/Applicants (for US only): **CHAN, Anita, N.** [US/US]; 709 Ashford Road, Wilmington, DE 19803 (US). **DZIUK, Louis, Patrick, Jr.** [US/US]; 2989 Highway 80, Karnes City, TX 78118 (US). **ERAZO-MAJEWICZ, Paquita** [US/US]; 126 Stoney Ridge Rd., Landenburg, PA 19350 (US). **MODI, Jashawant, J.** [US/US]; 57 Raphael Road, Hockessin, DE 19707 (US). **MICHELSON, M., Olaf** [US/US]; 5739 Cleathill Drive, Loveland, OH 45140 (US).

(74) Agents: **LUNN, Gregory, J.** et al.; WOOD, HERRON & EVANS, LLP, 2700 Carew Tower, 441 Vine Street, Cincinnati, OH 45202-2917 (US).

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(54) Title: POLYSACCHARIDE PRODUCTS WITH IMPROVED PERFORMANCE AND CLARITY IN SURFACTANT BASED AQUEOUS FORMULATIONS AND PROCESS FOR PREPARATION

(57) Abstract: A process for producing anionic, nonionic, amphoteric or cationic derivatized polysaccharide products which demonstrate high clarity in surfactant-based compositions. The polysaccharide polymer is reacted for a sufficient time and at a sufficient temperature in the presence of water, caustic, and at least one surfactant. The polysaccharide polymer may optionally be reacted with an oxidizing agent, hydrolytic or proteolytic enzymes, molecular weight reducing agents and a cationizing agent and nonionic agent. The formed derivatized polysaccharide has a lower clarity in water than in an aqueous surfactant system. The derivatized polysaccharide product can be used in personal care and or household care products.



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Polysaccharide Products with Improved Performance and Clarity in Surfactant-Based Aqueous Formulations and Process for Preparation

Field of the Invention

[0001] The present invention relates to polysaccharide compositions and more particularly cationic anionic, nonionic or amphoteric polysaccharide compositions which, when added to various personal care or household care compositions, yields a relatively transparent composition.

Background of the Invention

[0002] Personal care compositions containing cationic polymers have been found to deliver rheology, thickening, lather richness and conditioning benefits to hair and skin substrates. Cationic polymers also improve deposition of other active benefiting agents such as silicone and silicone derivatives, anti-dandruff agents, color, moisturizing agents, emollients. The cationic polymers can be based on polysaccharide backbones or on synthetic polymer backbones or mixture thereof.

[0003] Cationic polysaccharides and other polymers have been used widely in personal care, household, industrial, and institutional products to perform various benefiting agent functions in the final product, ranging from the use of the polymer as gellants, binders, thickeners, stabilizers, emulsifiers, spreading, lathering and deposition aids. Cationic polysaccharides and other polymers also function as carriers for enhancing the conditioning, anti-microbial activities, lubrication, rheology, efficacy, deposition, moisturizing, color, lather, emolliency, aesthetics as well as for the delivery of chemically and physiologically active

ingredients in personal care, household, institutional and industrial compositions. Depending on the application, substrates to which the personal care, household, industrial, and institutional product is applied can be skin, hair, or textile substrates.

[0004] Cationic polymers have been used in hair care products to provide conditioning, moisturizing, anti-static, deposition of color, other conditioning and non-conditioning agents, deposition of fragrance to the hair. In addition, in hair care products they provide for deposition of anti dandruff/antimicrobial agent to hair and scalp. In skin care products, these same polymers can provide conditioning effects to the skin. In addition, they provide moisturizing, lubrication, deposition of color, other conditioning and non-conditioning agents, deposition of fragrance, and deposition of anti dandruff/antimicrobial agent. When incorporated into detergent and/or fabric softening formulations, these same polymers can provide conditioning, softening, anti-abrasion and antistatic characteristics to fabrics.

[0005] Wet and dry compatibility measurements are typical test methods used to measure conditioning performance of polymers in shampoo and conditioner applications. These values are also frequently used to reflect conditioning benefits to skin since it is much easier make such measurements. Commercial cationic conditioning polymers in shampoo formulations have been reported to reduce the wet combing force experienced on combing wet hair by 5 %-99 % relative to the shampoo containing no polymer. The performance of different cationic polymers in these applications varies. However, typically it is desirable that shampoos contain cationic polymers to achieve a good balance of wet and dry combing force reduction, with good optical clarity in a formulation.

[0006] For example, cationic galactomannan polymers, such as cationic guar, and other polymers originating from seeds or other natural origins, contain insoluble components which can include protein components, which may interact with surfactants in the formulation, leading to unstable and opaque formulations. Since the conditioning performance of the polymer is strongly related to its solubility in and interactions with the surfactants in the formulation, it is desirable to improve the solubility of the conditioning polymer in the surfactant system which in effect improves the clarity of the surfactant-based formulation.

[0007] EP1501873 A1 addresses the need for a cationic galactomannan polymer with good optical clarity in personal care, household, and fabric cleansing formulations.

[0008] US 6210689 discloses an amphoteric guar composition for treating keratin substances.

[0009] US 5756720 describes a process for producing a polygalactomannan composition having nonionic and cationic groups attached to the backbone to achieve high optical clarity in cleansing surfactant formulations.

[0010] WO99/36054 describes hydroxypropyl modified cationic polygalactomannans, which have been found lacking in conditioning performance.

[0011] US 4381259 describes shampoo compositions containing cationic polymers and improvements in shampoo performance by addition of phosphoric acid ester surfactants to the shampoo composition. This patent does not discuss shampoo compositions with combined improved deposition of benefit agents and enhanced clarity in the formulation.

[0012] US 4298494 describes shampoo compositions containing cationic polygalactomannan gums and anionic additives to improve deposition onto hair

from the shampoo. This patent does not discuss surfactant compositions with improved clarity in the formulation.

[0013] US 5489674 describes a process for preparing polygalactomannan gums using an aqueous alcohol slurry process, the resulting product giving 85-100% transmittance at wavelengths between 500-600nm at 0.5 parts polymer in 100 parts of an aqueous solution. The use of this material in personal care applications is disclosed.

[0014] US 5536825 discusses a process for producing a derivatized guar gum composition that demonstrates greater than 75% light transmission at a wavelength from about 500-600 nanometers when dispersed in water in the amount of about 0.5 parts per 100 parts water and use of this composition in personal care compositions.

[0015] US 7067499 discloses a composition comprising at least one cationic polygalactomannan having a lower limit mean average MW of 5,000 and an upper limit MW of 200,000, having a light transmittance in aqueous solution at 10wt% polymer concentration of at least 80% at a wavelength of 600nm, and a protein content less than 1% based on polysaccharide content, and an aldehyde content of at least 0.01meq/g, where optical clarity is achieved through the use of a filtration process or other processes.

[0016] Cationic polysaccharides based on cellulosic backbones, such as UCare Polymer JR400 having a high cationic substitution, are known to give good clarity in a broad range of surfactant systems. However, these polymers have also been cited by the manufacturer as giving "buildup" problems on the hair after repeated use.

[0017] US 4129722 describes the use of surfactants in polysaccharide processing for producing water-soluble or water-swellaable polysaccharide derivatives having a high degree of substitution (DS), from 0.05-2.5 DS, comprising suspending the polysaccharide in an organic solvent, immiscible with the aqueous derivatizing reagent phase, in the presence of cationic, anionic, or nonionic surfactants. This patent does not discuss processing in aqueous processes or improved clarity of the resulting products in surfactant-based systems.

[0018] Consequently, there still exists a need in the marketplace for personal care and household care formulations with enhanced conditioning performance, including silky feel to the substrate, such as hair, skin, or textile fabric, enhanced deposition of active materials and conditioning agents, and improved clarity and improved aesthetics, such as shampoo clarity, and essentially no buildup of polymer or conditioning components after repeated use without the need for removal of insoluble material from the polysaccharide or the use of solvents to clarify the product. Also, the need exists for a process to produce these polysaccharides in an aqueous-based process rather than a solvent containing process.

Summary of the Invention

[0019] Applicants specifically incorporate by reference the entire contents of all cited documents in this disclosure. Further, when an amount, concentration, or other value or parameter is given as either a range, preferred range, or a list of upper preferable values and lower preferable values, this is to be understood as specifically disclosing all ranges formed from any pair of any upper range limit or

preferred value and any lower range limit or preferred value, regardless of whether ranges are separately disclosed. Where a range of numerical values is recited herein, unless otherwise stated, the range is intended to include the endpoints thereof, and all integers and fractions within the range. It is not intended that the scope of the invention be limited to the specific values recited when defining a range.

[0020] It has been found unexpectedly that cationic, anionic, nonionic or amphoteric polysaccharide polymers such as cationic galactomannan polymer compositions having high clarity in surfactant-based compositions can be produced by inclusion of materials such as surfactants during the preparation of the polymer compositions using an aqueous-based process. The present invention relates to a process for preparing a cationic, nonionic, amphoteric, or anionic polysaccharide polymer composition having high clarity in surfactant-based compositions and to the product produced through this process.

[0021] The process of the present invention comprises the steps of: reacting a polysaccharide polymer or derivatized polysaccharide polymer for a sufficient time and at a sufficient temperature in the presence of water, caustic and at least one surfactant. The reaction can be conducted with other processing steps. The process may additionally comprise reacting the polysaccharide polymer or derivatized polysaccharide polymer for a sufficient time and at a sufficient temperature with an oxidizing agent such as hydrogen peroxide or other reactant such as hydrolytic or proteolytic enzymes, acids, or other agents that reduce the molecular weight of the polysaccharide or galactomannan polymer or associated protein or other polysaccharide components.

[0022] The process may also comprise reacting the polysaccharide polymer or derivatized polysaccharide polymer for a sufficient time and at a sufficient temperature with a compound containing either hydrocarbon functionality, such as alkyl or hydroxyalkyl compounds, anionic functionality, such as a carboxylic acid compound, a sulfonic acid compound, a phosphoric acid compound, a phosphate compound, or cationic functionality, such as a primary, secondary, or tertiary amino compound or quaternary ammonium compound containing groups capable of reacting with reactive hydrogen ions present on the polysaccharide or derivatized polysaccharide to produce the nonionic, anionic, or cationic polysaccharide polymer composition. The polysaccharide polymer composition may also contain combinations of these groups.

[0023] The present process comprises using a surfactant, such as nonionic surfactants, such as polysorbate surfactants such as Tween 20 or Tween 60, or anionic surfactants such as fatty acids, phosphate ester surfactants, alkyl sulfate or alkyl ether sulfate surfactants, cationic surfactants such as tertiary amine or quaternary ammonium surfactants or mixtures during the production steps for the polysaccharide. An individual surfactant can be used alone or in combination with other surfactants, including other nonionic surfactants, carboxylate surfactants, sulfate or sulfonic acid surfactants, phosphate or phosphonic acid surfactants, amine or quaternary ammonium surfactants during the production steps for polysaccharide derivatives.

[0024] The present invention is directed to a composition of at least one polysaccharide, especially polysaccharides derived from natural sources, such as polygalactomannan or derivatized galactomannan polymers having a weight average molecular weight (Mw) in the range of from about 5,000 to about

10,000,000 and having a water-soluble and water-insoluble fraction, wherein the water-insoluble fraction constitutes greater than 0.4wt% % of the composition and the polymer having an aqueous clarity at 1wt% of less than 60% light transmittance at a wavelength between 500-600nm and clarity greater than 85-90% light transmittance at a wavelength of between 500-600 nm, in a surfactant system, when the nonionic, anionic, amphoteric or cationic polysaccharide polymer is present at a concentration of up to 0.2% by weight of the composition.

[0025] This invention is further directed to a process for preparing the composition mentioned above including the steps of reacting at least one polysaccharide, especially a galactomannan polymer or derivatized galactomannan polymer in the presence of at least one surfactant and an oxidizing agent, biochemical agents such as hydrolytic or proteolytic enzymes, acids, bases, or other agents that reduce the molecular weight of the polysaccharide or galactomannan polymer, associated protein, or other polysaccharide components, to produce the polysaccharide composition of the invention, or derivatized polysaccharide of the invention containing anionic, nonionic, or cationic, or amphoteric moieties, or combinations thereof.

[0026] This invention is further directed to a composition of a functional system of personal care products, household care products, and pet care products containing the above mentioned polysaccharide, or derivatized polysaccharide, especially an anionic or cationic polygalactomannan or derivatized anionic or cationic polygalactomannan composition and optionally at least one active personal care, household care, or pet care ingredient, respectively.

[0027] This invention is further directed to a composition of a functional system of personal care products, household care products, and pet care

products, especially surfactant compositions that contain the above mentioned polysaccharide, derivatized polysaccharide, galactomannan polymer, or derivatized galactomannan polymer, and optionally a synthetic polymer that increases deposition of the derivatized polysaccharide or polygalactomannan polymer and any disperse phase components in the composition.

[0028] The use of the polymer compositions of the invention is also contemplated in other formulated products where surfactant compositions are used such as oilfield, mining, coating, pharmaceutical, and constructions, fire retardant, under water explosive applications.

Detailed Description of the Invention

[0029] The process of the present invention comprises reacting a polysaccharide polymer with water, caustic and a surfactant. The reacted polysaccharides exhibit improved light transmittance in an aqueous surfactant solution when compared to the light transmittance of the polymer in an aqueous solution without the surfactant. The invention also includes the method of making the modified polysaccharide. The present invention provides a polysaccharide or derivatized polysaccharide polymer which includes anionic, cationic, nonionic or amphoteric moiety (or combinations thereof). Further, the present invention may be used to provide a polysaccharide polymer having a reduced molecular weight with improved light transmittance in an aqueous surfactant solution.

[0030] It has been found unexpectedly that polysaccharides such as galactomannan polymer compositions having anionic, nonionic, cationic, or amphoteric moieties (or mixtures thereof) with improved clarity in surfactant-based compositions can be produced by inclusion of anionic, nonionic, amphoteric,

betaine, or cationic surfactants such as 1) a combination of reagents such as polyoxyethylene sorbitol alkyl or alkenyl ester surfactants, or 2) alkylpolyethyleneoxide carboxylate surfactants, or 3) fatty acid surfactants and mixtures of fatty acids, in the processing of the polysaccharide or galactomannan polymer compositions. This list of surfactants is illustrative in nature, and not intended to be exhaustive.

[0031] In accordance with this invention, an oxidative reagent can be used in combination with the surfactant in addition to other reagents, including biochemical reagents, that reduce molecular weight. In order to achieve optimum results, it is preferable to include the surfactant and the oxidative step in the process. Oxidative agents include any reagent that can act to reduce the molecular weight of the polymer. Examples of these oxidizing agents are peroxides, peracids, persulfates, permanganates, perchlorates, hypochlorate, and oxygen. Optionally, biochemical reagents that reduce molecular weight, or acids or bases that reduce molecular weight of polysaccharides or associated protein components, may also be present.

[0032] In accordance with the invention, the polymers that can be used in the invention include polysaccharides, derivatized or nonderivatized, especially polygalactomannan, polyglucomannan, agar, dextran, starch, polyglucomannan polymers, xanthan polymers, and other polysaccharides.

[0033] The preferred polygalactomannans of this invention are guar, locust bean, cassia, fenugreek, locust, and flame tree with guar gum being the preferred source of the polygalactomannan. The preferred polygalactomannan starting material used in this invention is guar flour, guar powder, guar flakes, guar gum, or guar splits, including purified and highly purified sources of the galactomannan

polymer. The preferred polysaccharide backbone is polygalactomannan, such as guar, locust bean gum, cassia gum, tara gum, and other polysaccharides, such as galactomannan or glucomannan polymers, e.g., konjac gum or aloe gum.

[0034] In one embodiment, the polysaccharide polymer is reacted with functional groups such as anionic, cationic, or nonionic functional groups in the presence of caustic and the surfactant.

[0035] The amount of anionic, nonionic, or cationic functional group bonded to on the polysaccharide can be expressed in terms of moles of substituent. The term "degree of substitution" as used in this invention is equivalent to the molar substitution, the average number of moles of functional groups per anhydro sugar unit in the polysaccharide. The functionality can be present on these polymers at a DS level as low as 0.01, preferably about 0.1, and more preferably 0.2. The DS upper limit is normally about 3.0, preferably about 2.0, and more preferably 1.0 and most preferably below 0.7. In addition to molar substitution, the anionic or cationic charge on the polymers of this invention can be quantified as a charge density. The molar substitution can be converted to a charge density through a variety of methods. The preferred method for calculating charge density of cationic polymers uses a method that specifically quantifies the equivalents of quaternary ammonium groups on the polymer. A starting material having a cationic molar substitution level of 0.18 has been determined to have a charge density of 0.95 equivalents per gram (meq/g) according to the following equation:

$$\text{Cationic charge density of DS 0.18 cationic polysaccharide} = (1000 \times 0.18) / (162.14 + (151.64 \times 0.18)) = 0.95 \text{ meq/g.}$$

[0036] Charge density can be measured by any method that quantifies the net positive or negative charge present on a polymer. The charge density can be determined by measurement of the moles of quaternary ammonium groups bound

to the polymer backbone using standard NMR techniques of integration. This method was used for determining the charge density for polymers of this invention.

[0037] The cationic, anionic, nonionic or amphoteric functionality of the polysaccharide or derivatized polysaccharide can be added by several methods. For example, the starting polysaccharide material is contacted with caustic and water to swell the polymer, and the swollen mass can be reacted for a sufficient time and at a sufficient temperature, typically at between 40-70 degrees Celsius for 1-2 hours, with, for example, tertiary amino compound or quaternary ammonium compound containing groups capable of reacting with the reactive hydrogen ions present on the polysaccharide or derivatized polysaccharide in order to add the cationic functionality to the starting material. The reaction is conducted in the presence of a surfactant where the surfactant is present at a concentration ratio to the polysaccharide of 0.005 - 0.9, more preferably 0.01 -0.5, and most preferably 0.01 - 0.1. Crosslinking reagents, e.g., sodium borate, zirconates, titanates, or others known in the art, are then added and the product is washed, dried and ground. The sufficient time depends on the ingredients in the reaction mass and the temperature under which the reaction is taking place and the desired viscosity of the final product in aqueous solution.

[0038] The cationizing agent of the present invention is defined as a compound which, by substitution reaction with the hydroxy groups of the polygalactomannan, can make the polygalactomannan electrically positive, and there is no limitation to its types. Primary, secondary, or tertiary amino compounds or various quaternary ammonium compounds containing groups capable of reacting with reactive hydrogen present on the polygalactomannan,

can be used, such as 2-dialkylaminoethyl chloride and quaternary ammonium compounds such as 3-chloro-2-hydroxypropyltrimethylammonium chloride, and 2,3-epoxy-propyltrimethylammonium chloride. Preferred examples include glycidyltrialkylammonium salts and 3-halo-2-hydroxypropyltrialkylammonium salts such as glycidyltrimethylammonium chloride, glycidyltriethylammonium chloride, glycidyltripropylammonium chloride, glycidylethyldimethylammonium chloride, glycidyl-diethylmethylammonium chloride, and their corresponding bromides and iodides; 3-chloro-2-hydroxypropyltrimethylammonium chloride, 3-chloro-2-hydroxypropyltriethylammonium chloride, 3-chloro-2-hydroxypropyltripropylammonium chloride, 3-chloro-2-hydroxypropylethyldimethylammonium chloride, and their corresponding bromides and iodides; and quaternary ammonium compounds such as halides of imidazoline ring containing compounds.

[0039] The polysaccharides may also be reacted in the presence of surfactants with other substituent groups such as (1) nonionic substituents, i.e., hydroxyalkyl wherein the alkyl represents a straight or branched hydrocarbon moiety having 1 to 30 carbon atoms (e.g., hydroxyethyl, hydroxypropyl, hydroxybutyl) or, (2) anionic substituents, such as carboxymethyl groups, sulfonate groups, or phosphate or phosphonate groups. The nonionic substituents are linked to the polysaccharide polymer by the reaction with reagents such as (1) alkylene oxides (e.g., ethylene oxide, propylene oxide, butylene oxide) to obtain hydroxyethyl groups, hydroxypropyl groups, or hydroxybutyl groups, and the anionic substituents are linked to the polysaccharide by reaction with reagents such as (2) chloromethyl acetic acid to obtain a carboxymethyl group, or with sulfonyl chloride to obtain sulfonic acid groups on

the polysaccharide, or with phosphonyl chloride or other anion containing groups capable of reacting with the reactive hydrogen ions present on the polysaccharide or derivatized polysaccharide in order to add the anionic functionality to the starting material. The sufficient time depends on the ingredients in the reaction mass and the temperature under which the reaction is taking place. The process for preparing derivatized polygalactomannan is well known in the art.

[0040] The anionic or cationic polysaccharide of the invention can also contain alkyl or acyl substituents wherein the alkyl or acyl group represents a straight or branched alkyl group or alkylcarboxylic or alkylencarboxylic moiety, respectively, having 1 to 30 carbon atoms. These optional substituents can be reacted with the polysaccharide molecule in the presence of surfactant by the reaction of the polysaccharide molecule with reagents such as (1) alkyl halides to obtain alkyl functionality, (2) acyl chlorides, anhydrides, esters, or ketenedimer reagents to obtain ester or amide functionality, (3) alkylene oxides (e.g., ethylene oxide, propylene oxide, butylene oxide) to obtain hydroxyethyl groups, hydroxypropyl groups, or hydroxybutyl groups. If the polysaccharide is polygalactomannan, this derivatization reaction can take place when the polygalactomannan is in the "split", "flour", or any other physical form. The process for preparing derivatized polygalactomannan is well known in the art. These optional substituents can be introduced into the polysaccharide structure.

[0041] If the polysaccharide is polygalactomannan, this reaction can take place when the polygalactomannan is in the "split", "flour" or any other physical form. The process for preparing derivatized polygalactomannan is well known in the art.

[0042] In accordance with this invention, the formed derivatized polysaccharide or polygalactomannan composition of the invention contains a water-soluble and water-insoluble fraction, where-in the water-insoluble fraction comprises up to 3 wt% of the polymer composition, more preferable up to about 1-3wt% of the composition, and generally up to 0.4-2wt% of the composition of the invention. The water-insoluble fraction contains greater than 10wt% protein component, more preferably greater than 12wt% protein, and most preferably greater than 16wt% protein.

[0043] In accordance with this invention, the formed polysaccharide or polygalactomannan composition of the invention has a percent light transmittance in water at 1wt% polymer concentration of less than 60% at a wavelength of about 500- 600nm.

[0044] In accordance with this invention, the polysaccharide or polygalactomannan composition of the invention has a percent light transmittance in a surfactant system composed of 12% sodium lauryl ether sulfate surfactant/2% cocamidopropyl betaine surfactant, of greater than 85% transmittance, generally greater than 90% transmittance, at a wavelength of between 500-600nm when the polymer is present at a concentration of 0.2 wt%. The cationic polysaccharide, especially the cationic polygalactomannan of the invention, will have a percent light transmittance in a surfactant system consisting of 12 wt% sodium laureth sulfate/2 wt% cocamidopropyl betaine/1 wt% sodium chloride, greater than 85% transmittance, more preferably greater than 90%-95% transmittance at a wavelength of about 500- 600nm, when the polymer is present at a concentration of 0.2% by weight of the composition.

[0045] The polysaccharide polymer such as the guar can also be reacted under the same conditions without any functional group, only the caustic, water, oxidizing agent, and surfactant. This will provide a polymer with the same light transmittance qualities.

[0046] Further, the polysaccharide polymer may be reacted under these same conditions, time, and temperature, with caustic, surfactant and an oxidative reagent. In order to achieve optimum results, it is necessary to include the surfactant and the oxidative step in the process. Oxidative agents include any reagent that can act to reduce the molecular weight of the polymer. Examples of these oxidizing agents are peroxides, peracids, persulfates, permanganates, perchlorates, hypochlorite, and oxygen.

[0047] The derivatized polysaccharide of the invention, especially polysaccharides such as galactomannan polymers, will have a weight average molecular weight (Mw) having a lower limit of 5,000, preferably 25,000, more preferably 100,000, and most preferably 200,000. The upper limit of the Mw of these polymers is less than 10,000,000, preferably 5,000,000, and more preferably 2,000,000.

[0048] In accordance with this invention, the polysaccharide or polygalactomannan composition of the invention has a percent light transmittance in a surfactant system, of greater than 85% transmittance, generally greater than 90% to 95% transmittance, at a wavelength of between 500-600nm. The modified polysaccharide that was modified with a cationic moiety will have a percent light transmittance in a surfactant system consisting of 12 wt% sodium laureth sulfate/2wt% cocamidopropyl betaine/1wt% sodium chloride, greater than 85% transmittance, more preferably greater than 90-95% at a wavelength of between

500-600nm, when the polymer is present at a concentration of 0.2% by weight of the composition.

[0049] In accordance with this invention, if the product of the invention is a cationic polysaccharide, the cationic polygalactomannan or cationic derivatized polygalactomannan composition has a trimethylamine content in a 0.5 % aqueous solution of less than 100 ppm, preferably less than 75 ppm, and most preferably less than 25 ppm when measured by any method known to those skilled in the art. Examples of methods used to measure trimethylamine include gas chromatography (GC), mass spectrometry, solid phase extraction methods using fiber adsorbents, and combinations thereof.

[0050] The polysaccharide of the present invention can be combined with a nonionic, anionic, cationic, or amphoteric surfactant or mixture of these surfactants that can be either soluble or insoluble in the composition, and optionally combined with a compatible solvent which may also be used in the cleansing composition that can be either a single solvent or a blend of solvents to produce a personal care composition, household care composition, or other composition. Personal care compositions include hair care, skincare, sun care, and oral care products. Household care compositions include dishwashing detergents, laundry detergents and fabric softeners, industrial grade soap bars and liquid soaps, textile products such as wipes, insect repellants.

[0051] Examples of the surfactants useful in these compositions are anionic, nonionic, zwitterionic, cationic, or amphoteric type of surfactants, and blends thereof. The anionic, nonionic, zwitterionic, cationic, or amphoteric surfactant can be soluble or insoluble in the present invention and (when used)

are present in the composition in the amount of from 0.01 to about 75 wt % by weight of the cleansing composition.

[0052] Anionic surfactants useful in the functional system composition include alkyl and alkyl ether sulfates, alkyl sulfosuccinates, and fatty acids as nonlimiting examples and generally any anionic surfactants typically used in cleansing, conditioning, and detergent compositions.

[0053] Preferred anionic surfactants are sodium or ammonium C₁₂-C₁₄ alkyl sulfates, and sodium or ammonium C₁₂-C₁₄ alkyl ether sulfates having 1 to 3 moles ethylene oxide. An especially preferred anionic surfactant system comprises from about 4 to about 15% sodium lauryl sulfate and from about 3 to about 10% sodium lauryl ether sulfate, by weight of the composition.

[0054] Nonionic surfactants, can be broadly defined as compounds containing a hydrophobic moiety and a nonionic hydrophilic moiety. Examples of the hydrophobic moiety can be alkyl, alkyl aromatic, dialkyl siloxane, polyoxyalkylene, and fluoro-substituted alkyls. Examples of hydrophilic moieties are polyoxyalkylenes, phosphine oxides, sulfoxides, amine oxides, and amides. Nonionic surfactants such as alkylpolyglucosides and other nonionic surfactants commonly used in cleansing, conditioning, and sulfate free formulations are also useful in this invention.

[0055] Zwitterionic surfactants are exemplified by those which can be broadly described as derivative of aliphatic quaternary ammonium, phosphonium, and sulfonium compounds.

[0056] Examples of amphoteric surfactants which can be used in the personal care composition of the present invention are those which are broadly described as derivatives of aliphatic secondary and tertiary amines in which the

aliphatic radical can be straight or branched chain and wherein one of the aliphatic substituents contains from about 8 to about 18 carbon atoms and one contains an anionic water solubilizing group, e.g., carboxy, sulfonate, sulfate, phosphate, or phosphonate.

[0057] According to the present invention, the solvent used in the personal care or householdcare system should be compatible with the other components of the cleansing composition. Examples of the solvents that may be used in the present invention are water, water-lower alkanols mixtures, and polyhydric alcohols having from 3 to 6 carbon atoms and from 2 to 6 hydroxyl groups. Preferred solvents are water, polyethylene glycol, propylene glycol, water-polyethylene glycol, water-propylene glycols, water-glycerine, sorbitol-water, water-fragrance and water-ethanol. The solvent (when used) in the present invention is present in the composition at a level of from 0.1 % to 99 % by weight of the composition.

[0058] In certain instances, an active ingredient or benefiting agent is optional because the polymer can be the active ingredient component. An example of this is the use of the polymer in an aqueous solution as a conditioner for hair or skin conditioning, as a fabric conditioner, or as an antimicrobial agent.

[0059] In accordance with the present invention, the composition may be used in a personal care product, a household care product or an institutional care product. The composition is a personal care product when it contains at least one active personal care ingredient or benefiting agent, the personal care active ingredient or benefiting agent includes, but is not limited to, analgesics, anesthetics, antibiotic agents, antifungal agents, antiseptic agents, antidandruff agents, antibacterial agents, vitamins, hormones, anti-diarrhea agents,

corticosteroids, anti-inflammatory agents, vasodilators, kerolytic agents, dry-eye compositions, wound-healing agents, anti-infection agents, UV absorbers, moisturizers, humectants, emolliency, lubricating, softening, hair-detangling, hair relaxers, hair sculpturing, hair removing, dead-skin removing, as well as solvents, diluents, adjuvants and other ingredients such as water, ethyl alcohol, isopropyl alcohol, propylene glycol, higher alcohols, glycerine, sorbitol, mineral oil, preservatives, surfactants, propellants, fragrances, essential oils, and viscosifying agents.

[0060] Personal care compositions include hair care, skin care, sun care, nail care, and oral care compositions. Examples of active personal care ingredients or benefiting agents that may suitably be included, but not limited to, in the personal care products according to the present invention are as follows:

- 1) Perfumes, which give rise to an olfactory response in the form of a fragrance and deodorant perfumes which in addition to providing a fragrance response can also reduce body malodor;
- 2) Skin coolants, such as menthol, menthyl acetate, menthyl pyrrolidone carboxylate N-ethyl-p-menthane-3-carboxamide and other derivatives of menthol, which give rise to a tactile response in the form of a cooling sensation on the skin;
- 3) Emollients, such as isopropylmyristate, silicone materials, mineral oils and vegetable oils which give rise to a tactile response in the form of an increase in skin lubricity;
- 4) Deodorants other than perfumes, whose function is to reduce the level of or eliminate micro flora at the skin surface, especially those

responsible for the development of body malodor. Precursors of deodorants other than perfume can also be used;

5) Antiperspirant actives, whose function is to reduce or eliminate the appearance of perspiration at the skin surface;

6) Moisturizing agents, that keep the skin moist by either adding moisture or preventing from evaporating from the skin;

7) Sunscreen active ingredients that protect the skin and hair from UV and other harmful light rays from the sun. In accordance with this invention a therapeutically effective amount will normally be from 0.01 to 10% by weight, preferable 0.1 to 5% by weight of the composition;

8) Hair treatment agents, that condition the hair, cleanse the hair, detangles hair, acts as styling agent, volumizing and gloss agents, color retention agent, anti-dandruff agent, hair growth promoters, hair dyes and pigments, hair perfumes, hair relaxer, hair bleaching agent, hair moisturizer, hair oil treatment agent, and antifrizzing agent; and

9) Oral care agents, such as dentifrices and mouth washes, that clean, whiten, deodorize and protect the teeth and gum.

[0061] In accordance with the present invention, the composition may be used in a household care composition. The household care composition additionally comprises and at least one active household care ingredient or benefit agent. The household care active ingredient or benefit agent must provide some benefit to the user. Examples of active ingredients that may suitably be included, but not limited to, according to the present invention are as follows:

- 1) Perfumes, which give rise to an olfactory response in the form of a fragrance and deodorant perfumes which in addition to providing a fragrance response can also reduce odor;
- 2) Insect repellent agent whose function is to keep insects from a particular area or attacking skin;
- 3) Bubble generating agent, such as surfactant that generates foam or lather;
- 4) Pet deodorizer or insecticides such as pyrethrins that reduces pet odor;
- 5) Pet shampoo agents and actives, whose function is to remove dirt, foreign material and germs from the skin and hair surfaces;
- 6) Industrial grade bar, shower gel, and liquid soap actives that remove germs, dirt, grease and oil from skin, sanitizes skin, and conditions the skin;
- 7) Disinfecting ingredients that kill or prevent growth of germs in a house or public facility;
- 8) A laundry softener active, which reduces static and makes fabric feel softer;
- 9) Laundry or detergent or fabric softener ingredients that reduce color loss during the wash, rinse, and drying cycle of fabric care;
- 10) Toilet bowl cleaning agents, which remove stains, kills germs, and deodorizes;
- 11) Laundry prespotter actives which helps in removing stains from clothes;
- 12) Fabric sizing agent which enhances appearance of the fabric; and
- 13) Wipes to clean and condition the skin

[0062] The above lists of personal care and household care active ingredients or benefit agents are only examples and are not complete lists of active ingredients that can be used. Other ingredients that are used in these types of products are well known in the industry. In addition to the above ingredients conventionally used, the composition according to the present invention can optionally also include ingredients such as a colorant, preservative, antioxidant, nutritional supplements, alpha or beta hydroxy acid, activity enhancer, emulsifiers, functional polymers, viscosifying agents (such as salts, i.e., NaCl, NH₄Cl, and KCl, water-soluble polymers, i.e., hydroxyethylcellulose and hydroxypropylmethylcellulose, and fatty alcohols, i.e., cetyl alcohol), alcohols having 1-6 carbons, fats or fatty compounds, antimicrobial compound, zinc pyrithione, silicone material, hydrocarbon polymer, emollients, oils, surfactants, medicaments, flavors, fragrances, suspending agents, and mixtures thereof.

[0063] In accordance with the present invention, examples of functional polymers that can be used in blends with the anionically, nonionic, amphoteric, or cationically modified polysaccharide of this invention include water-soluble polymers such as acrylic acid homopolymers such as carbomers, vinylpyrrolidone homopolymers and cationic vinylpyrrolidone copolymers; cationic acrylamide copolymers such as acrylamide copolymers with cationic monomers such as acrylamidopropyl trimethyl ammonium chloride, acryloxyethyl trimethyl ammonium chloride, or diallyldimethyl ammonium chloride, and anionic and amphoteric acrylic acid copolymers, hydrophobically modified carbomers, vinylpyrrolidone homopolymers and cationic vinylpyrrolidone copolymers; nonionic, cationic, anionic, and amphoteric cellulosic polymers such as hydroxyethylcellulose, hydroxypropylcellulose, carboxymethylcellulose, hydroxypropylmethylcellulose,

cationic hydroxyethylcellulose, cationic carboxymethylhydroxyethylcellulose, and cationic hydroxypropylcellulose; acrylamide homopolymers and anionic, cationic, amphoteric, and hydrophobic acrylamide copolymers, polyethylene glycol polymers and copolymers, hydrophobic polyethers, hydrophobic polyetheracetals, hydrophobically-modified polyetherurethanes and other polymers referred to as associative polymers, hydrophobic cellulosic polymers, polyethyleneoxide-propylene oxide copolymers, and nonionic, anionic, hydrophobic, amphoteric, and cationic polysaccharides such as xanthan, chitosan, starch, carboxymethyl guar, alginates, gum arabic, nonionic, cationic, anionic, and amphoteric guar polymers such as hydroxypropyl guar, hydrophobic guar polymers, carboxymethyl guar hydroxypropyltrimethylammonium chloride, guar hydroxypropyltrimethylammonium chloride, and hydroxypropyl guar hydroxypropyltrimethylammonium chloride.

[0064] In accordance with the invention, the silicone materials which can be used are polyorganosiloxanes that can be in the form of polymers, oligomers, oils, waxes, resins, or gums or polyorganosiloxane polyether copolyols, amodimethicones, cationic polydimethylsiloxane materials and any other silicone material that is used in personal care compositions, household care compositions or institutional care compositions.

[0065] The polysaccharides of use in this invention can be used as conditioning agents in shampoos, 2-in-1 shampoos, 3-in1 shampoo (cleansing, conditioning and styling), conditioners, hair colors and relaxers, body washes, shave products, bar soaps, body lotions, sunscreens, antifrizz and hair styling formulations. The polysaccharides of use in this invention can also be used to improve hair volume, manageability, hair repair, or color retention, skin

moisturization and moisture retention, fragrance retention, sunscreen longevity on hair, skin, and fabrics, flavor enhancement and antimicrobial performance in oral care applications, and improve fabric abrasion resistance and colorfastness in household applications.

[0066] The polymers of this invention possess an ability to deliver formulations having improved clarity across a range of surfactant systems and across a range of polymer concentrations, in personal care and household products.

[0067] It has also been demonstrated that the polymers of this invention can deliver conditioning effects in addition to high clarity in personal care products and in other surfactant-based products, such as household products.

[0068] It has also been demonstrated that the polymers of this invention enhance deposition of conditioning oils onto keratin substrates, such as skin and hair, improving the conditioned state of the substrate.

[0069] It has also been demonstrated that the polymers of this invention enhance deposition of any dispersed phase ingredients onto the treated substrate, the dispersed phase ingredients including benefit agents such as antidandruff, fragrance, sunscreen or sun protection factors (SPFs).

[0070] The invention is further demonstrated by the following examples. The examples are presented to illustrate the invention, parts and percentages being by weight, unless otherwise indicated.

STANDARD TESTING METHODS & PROCEDURES**[0071] Aqueous Polymer Solution Preparation and Measurement of Percent Transmittance and Viscosity**

[0072] One gram of polymer was added to 99 grams deionized water and stirred with a mechanical stirrer at 600rpm. For galactomannan polymer compositions that were treated with borate salts, 10wt% citric acid solution was added to the dispersion to reduce the pH of the solution to 5.5 to effect dissolution of the polymer in water. The mixture was stirred at ambient temperature for an additional 50 minutes and the final solution was left to stand overnight at ambient temperature. The solution was then analyzed for optical clarity by measuring the % transmittance of light of 600nm wavelength through the sample on a Cary 5E spectrometer. A separate sample of the solution was placed in a suitable glass container and maintained at 25C for 2 hours prior to measuring the viscosity on a Brookfield LVT Model with the appropriate spindle at 30rpm.

[0073] Surfactant solution transmittance

[0074] The optical clarity of the aqueous polymer solutions and shampoo formulations were measured on a Cary spectrometer, at a wavelength of 600nm. This specific percent transmittance data is shown since the percentage transmittance of light through a sample at a wavelength of 600nm has been correlated with the optical clarity of a solution. In the absence of any absorbance at 600nm, an optically clear solution is considered to have a percent transmittance greater than 95%.

[0075] Optical Clarity of Aqueous Polymer Solutions and Shampoo Formulations

[0076] Optical Clarity. The percent transmittance data at 600nm for selected samples in water, in the shampoo formulations 1-4 and in shampoo formulation 5, are shown in Tables 4 and 5, respectively. This specific percentage transmittance data is shown since the percentage transmittance of light through a sample at a wavelength of 600nm has been correlated with the optical clarity of a solution. In the absence of any absorbance at 600nm, an optically clear solution is considered to have a percent transmittance @ 600 nm greater than 95%, preferably greater than 97% and more preferably greater than 99%.

[0077] The percent transmittance was measured at a wavelength of 600nm for (1) a 1wt% aqueous solution of the polymers of the invention and comparative polymers, and (2) in the surfactant compositions in Table 1 (also referred to as Shampoo Formulations 1-4) and Table 2 (referred to as shampoo formulation 5). Shampoo formulations 2 contains 0.2wt% of each polymer in a surfactant composition containing: 12wt% sodium laureth sulfate (2 ethylene oxide spacers)/2wt% cocamidopropyl betaine/1wt% sodium chloride. This specific percentage transmittance data was chosen because the percentage transmittance of light through a sample at a wavelength of 600nm has been correlated with the optical clarity of a solution visible to the eye. In the absence of any absorbance at 600nm, an optically clear solution is considered to have a percent transmittance @ 600nm greater than 90%, preferably greater than 92%, and more preferably greater than 95%.

[0078] Insoluble Content of polymer

[0079] Isolation of insolubles from cationic guar.

[0080] A 0.5% - 0.8% solution of cationic guar was prepared in deionized water and stirred for 1 to 2 hours. The pH was adjusted to approximately 5 with hydrochloric acid. The solution was stirred for an additional 1 to 2 hours, allowed to stand in a refrigerator for at least 16 hours, and stirred again.

[0081] The solution was centrifuged in portions and the nearly clear supernatant layer was removed. The precipitates were dispersed in water and combined. The solutions were centrifuged again and the supernatant was removed. The dispersion and centrifugation was repeated as least three times. The total dilution of the precipitate by repeated dispersion was at least 1000 times by volume. All solutions and precipitates were kept refrigerated when not being processed.

[0082] The final precipitate and a portion of the original supernatant solution were freeze dried for further analysis. The concentration of insolubles in the cationic guar was calculated by dividing the weight of the freeze dried precipitate by the original weight of sample.

[0083] **Soluble content of polymer**

[0084] The water-soluble content of the polymer was then calculated by subtracting the insoluble weight of the polymer measured as described above, from the original polymer weight.

[0085] **Wt% Nitrogen and Total % protein**

[0086] The nitrogen content of the polysaccharide compositions was determined using elemental analysis using inductively coupled plasma technique. The resulting data correlated well with Kjeldahl measurements of nitrogen content and estimates of nitrogen content using NMR measurements of the cationic substitution level. The protein content was then calculated by multiplying the

%Nitrogen by 6.25 per standard methods for conversion of nitrogen content to protein content.(Food energy: Methods of Analysis and Conversion Factors, Chapter 2: Methods of food Analysis; Food and Agricultural Organization of the United Nations)

Galactose/ mannose ratio Measurements

The anomeric protons of galactose and mannose units were identified in the proton NMR spectrum of the acid hydrolysates of the various polymers, and the galactose/mannose ratio was determined by standard methods. (*p. 4592-4593 in J.O. Duus et al, Chem. Rev. 2000, 100, 4589-4614.*)

Molecular weight Determinations

Size exclusion chromatography was used for molecular weight analysis. Weight average molecular weights were determined using a light scattering detector. Separations were effected using an oxalic acid mobile phase at pH 2 on a column.

Cationic Substitution and hydroxypropyl Substitution Measurements

[0087] The degree of cationic and hydroxypropyl substitution was measured using proton NMR according to standard methods, on an acid hydrolysate of the polymer sample.

[0088] SHAMPOO PREPARATION A: Shampoo formulations 1, 2, 3, 4

[0089] The conditioning shampoo formulations referred to in Table 4 were prepared by combining 73 parts by weight (pbw) of the following surfactant premix composition shown in Table 1 with 6.7 pbw deionized water and 13.3 pbw of the polysaccharides or modified polysaccharides of use in the invention, as a 1.5wt% aqueous solution, using a Caframo overhead mechanical stirrer with a dispersion blade, stirring at 600 rpm. After allowing the composition to mix for 45 minutes at ambient temperature, the formulation was allowed to remain at ambient

temperature overnight. The viscosity and pH value of the formulation was recorded, with pH values ranging from 5.5-6.0.

[0090] Four pbw of a sodium chloride salt solution (25wt %) and 3pbw of water was then added to the shampoo, and stirring commenced for an additional 15 minutes. The shampoo compositions were maintained at ambient temperature overnight, and the viscosity of each shampoo was measured using a Brookfield LVT viscometer with a Brookfield LVT viscometer, spindle 4, at 30 rpm.

[0091] Table 1. Premix and Shampoo Formulation Compositions

Ingredient	INCI Name	wt% Active in Shampoo 1 Formulation	wt% Active in Shampoo 2 Formulation	Shampoo 1 & 2 premix	wt% Active in Shampoo 3 Formulation	Shampoo 3 premix	wt% Active in Shampoo 4 Formulation	Shampoo 4 premix
Deionized water	Deionized water	qs to 100	qs to 100	2308.00	qs to 100	1089.33	qs to 100	1409.33
Standapol® ES-2	Sodium laureth sulfate-2EO (25%)	12.00	12.00	5760.00	10.00	1600.00	8.00	1280.00
Amphosol® CA	Cocamidopropyl Betaine (30%)	2.00	2.00	800.00	2.00	266.67	2.00	266.67
Kathon® CG	Biocide	0.10	0.10	12.00	0.10	4.00	0.10	4.00
	polymer	0.5%	0.2wt%	8880.00	0.2wt%	2960.00	0.2wt%	2960.00

[0092]

[0093] 1. Standapol ES-2 sodium laureth sulfate (2EO) Cognis

[0094] 2. Amphosol CA cocamidopropyl betaine, Stepan Chemical Co.

[0095] 3. Kathon CG preservative: Dow Chemical Co.

[0096] SHAMPOO PREPARATION B, Shampoo 5

[0097] A series of sulfate free shampoos were prepared with the premix in Table 2 to produce Shampoo formulation 5 in Table %.

Table 2. Shampoo 5 Premix and Composition

Ingredient	INCI Name	wt% As-is in Shampoo 5 Formulation	Parts in premix
Deionized water	Deionized water	qs to 100	1592.00
Amphosol® CA (Stepan Chemical)	Cocamidopropyl betaine (30%)	15.00	600.00
Maprosyl® 30B (Stepan Chemical)	Sodium lauroylsarcosinate (30%)	10.00	400.00
Mackam® 1L (Cognis)	Sodium lauroamphoacetate (35%)	6.00	240.00
Glycerin	Glycerin, anhydrous	1.00	40.00
Plantaren® 2000 N UP (Cognis)	Alkylpolyglucosides	2.00	80.00
Disodium EDTA	Disodium EDTA	0.10	4.00
Kathon® CG (Dow Chemical)	Biocide	0.10	4.00
			2960.00
	Polymer	0.50	

[0098] SHAMPOO PREPARATION, Shampoo 6

[0099] A series of shampoos were prepared with the silicone microemulsion (Dow Corning® 1784 emulsion, available from Dow Corning Corporation) using the premix for formulation 2 in Table 1, with 0.4pbw Carbomer 980 (Carbopol 980, available from Lubrizol Corporation), and 1.5wt% active silicone (Dow Corning® 1784 emulsion, available from Dow Corning Corporation) and 0.2wt% polymer.

These shampoo formulations and data are shown in Table 5.

[00100] Silicone deposition from Shampoo formulation 6 was measured as described below, as a model for assessing deposition effectiveness of the polymers of the invention for deposition of benefit agents from personal care formulations, household formulations, and industrial formulations. Silicone deposition was measured by treating virgin brown hair with the shampoo formulation 6 containing the polymers of the invention and polymers in comparative examples. The silicone deposition data is shown in Table 5.

[00101] Conditioning Performance Measurements-Deposition Measurements

[00102] In order for a conditioning shampoo to perform on hair, deposition of a material must occur, to reduce interfiber friction in the wet and dry states, reduce comb energies in the wet and dry state.

[00103] Wet and dry hair compatibility measurements are typical test methods used to measure conditioning performance in shampoo and conditioner applications. In skin care applications, skin lubricity or reduced friction or softer feel of the skin, reduced water vapor transmission and improved skin elasticity are test methods used to measure skin conditioning. In surfactant-based household cleansing product formulations where conditioning performance is desired, such as dish detergents, fabric softeners, and antistatic products, conditioning refers to imparting a softer feel to fabric and eliminating static effects, eliminating fabric fiber breakage or deformation known as pilling. Imparting color retention properties to fabrics is also important and can be measured.

[00104] Wet/Dry Comb Performance Measurement - Virgin Brown European Hair and Lightly Bleached Medium Brown hair conditions:

[00105] Measured at constant temperature and humidity (72°F and 50%

relative humidity).

[00106] Prewash Procedure:

[00107] Each tress washed twice with sodium lauryl sulfate, SLS, or other anionic surfactants, e.g., sodium lauryl ether sulfate (SLES) using 0.1g-5g surfactant/gram tress, washing twice then air drying overnight at 73°F and 50% relative humidity. The twice washed tress was hand combed 5 times with large teeth comb and 5 times with small teeth comb (10 times total).

[00108] The following protocol was used for bleached and virgin hair. Two to three tresses were used, and the average reported from the two to three tresses combed 8 times per tress, with more precombing of the tresses prior to measurement as described above.

[00109] Shampoo Procedure

1. Each tress was shampooed twice with 0.1g shampoo per 1 gram tress (all tresses were 3.0g).
2. Each shampooed tress was hand combed twice with a large teeth comb.
3. The hand combed tress was loaded into a Instron instrument and the crosshead was lowered to bottom stop. The tress was combed twice with small teeth comb and placed into double-combs.

The Instron was run under standard conditions.

After the test was run, the tress was sprayed with DI water to keep moist.

4. After the eight tests were finished, the tress was hung up overnight.
5. The next day, each tress was dry combed tested eight time. No hand combing of dry tresses was done.

6. Averaged wet comb energy for 16 Instron runs and reported average with standard deviation.

7. Averaged dry comb energy for 15 Instron runs and reported average with standard deviation.

[00110] Silicone deposition onto hair tresses from shampoos and zinc deposition onto artificial skin can be measured by several techniques. One nondestructive technique used for quantifying silicone deposition onto hair and one technique quantifying zinc deposition onto solid substrates such as artificial skin are described below.

[00111] Zinc and Silicone Deposition Measurements on Vitro-Skin Substrate.

The vitro-skin was cut into 2.5 cm disks, and the disks were analyzed under vacuum via x-ray fluorescence spectroscopy on a Bruker model S4 Explorer X-ray Fluorescence (SRF) Spectrometer for zinc (Zn). The approximate detection limit for each element is 50 parts per million (0.0050 wt%). This method had been previously verified with direct measurement of inorganic ions in the ashed model skin substrate using inductively coupled plasma (ICP).

Silicone Deposition Measurement

[00112] For total silicone deposited on hair tresses, each 2-5 gram hair tress sample was weighed to the nearest mg and extracted with approximately 150 ml of methylene chloride. The samples were shaken for 1.5 hours at room temperature. The methylene chloride supernatant was filtered using Whatman # 41 filter paper and evaporated to dryness. Each sample was then dissolved into 2 ml of chloroform-d and quantitatively transferred to a 5-ml volumetric flask. Each sample was examined in a NICOLET MAGNA 550 FT-IR with 150 co-added scans at 4 cm⁻¹ resolution and 0.4747 velocity using a 0.1 cm-fixed path salt cell.

A chloroform-d reference spectrum was used to subtract out the solvent bands (diff=1.0). The silicone level was determined by measuring the peak height of the Si-CH₃ stretch at 1260 cm⁻¹ (baseline 1286 and 1227 cm⁻¹) followed by conversion to mg/ml of silicone using a low level calibration curve extending from 10 - 300 parts per million (ppm). Each sample was corrected for dilution volume and sample weight. All values are reported to the nearest ppm.

Silicone Mapping Along Tress Length

[00113] The relative concentration of the silicone deposit along the length of a hair tress was mapped using a surface infrared technique, attenuated total reflectance-infrared spectroscopy (ATR-IR). The ATR-IR technique uses the ratio of the peak height of the silicone band near 796.5cm⁻¹ (tangent baseline), to an area slice of a hair reference band from 940.1cm⁻¹ to 919.9cm⁻¹ (tangent baseline) to determine the relative surface silicone level according to equation 1. This method of surface silicone measurement was shown to have a correlation with total extracted silicone levels across a range of 300ppm to 4000ppm.

[00114] Ratio: Peak Height at 796.5cm⁻¹/ Peak Area (940.1cm⁻¹ to 919.9cm⁻¹) = Relative Surface Silicone Level (detection limit = 0.05) (eq 1)

[00115] The technique may be used to measure approximately 10-20 strands of hair in one measurement with a 1 mm circular spot. A bundle of fibers from each tress is positioned on a Golden Gate* diamond ATR accessory of the Thermo-Nicolet MAGNA* 760 FTIR spectrometer equipped with a deuterated triglycine sulfate (DTGS) detector. Infrared spectra are collected at 12 different locations on the hair tress starting from the top and working towards the bottom of the tress.

EXAMPLES

Comparative Example 1

[00116] An amount of guar splits, water and caustic solution as shown in Table 3 were charged to the mixer. The temperature was raised to between 40-60°C. The 3-chloro-2-hydroxypropyltrimethylammonium chloride (quat reagent), additional caustic solution, water, and sodium borate decahydrate were then added, and the reaction was allowed to proceed for 1 hour. After cooling to ambient temperature, the crude product was washed with water, and dried and ground.

Example 2

[00117] Example 2 was prepared by the same process as Example 1, except that the surfactants polyoxyethylene sorbitan monooleate and polyoxyethylene sorbitan monolaurate, were added in the first step.

Comparative Example 3

[00118] The prescribed amount of guar splits, water and hydrogen peroxide solution as shown in Table 3 were charged to the mixer. The mixture was processed at a temperature between 40-60°C for up to 3 hours. The 3-chloro-2-hydroxypropyltrimethylammonium chloride (quat reagent), additional caustic and water, and sodium borate decahydrate were then added, and the mixture was processed at a temperature between 40-60°C for up to 2 hours. After cooling to ambient temperature, the crude product was washed with water, and dried and ground.

Comparative Example 4

[00119] 100 parts of guar splits and 152 parts of 18% caustic solution were charged to the mixer. The temperature was raised to 65°C and held there for 1 hour. After cooling to ambient temperature, the splits were washed with water followed by 30%, 60% and 80% isopropanol. The splits were then returned to the mixer. The temperature was raised to 41°C, and vacuum was applied to remove the isopropanol. The process for Example 3 was then followed to convert the guar gum into cat guar.

Examples 5, 6, 9, 10, 15

[00120] Examples 5, 6, 9, 10 and 15 were prepared by the same process as Example 3, except that the polysorbate surfactants Tween 20 and Tween 80 were added in the first step. These examples demonstrate a cationic polygalactomannan product of the invention produced by the process of the invention.

[00121] Example 5a was prepared by the same process as Example 5 with its ingredients shown in Table 3, except that propylene oxide was reacted with the guar splits at 70°C for up to 3 hours prior to addition of the quat reagent. This example demonstrates a mixed derivative, cationic hydroxypropyl guar product of the invention, prepared by the process of the invention.

Comparative Examples 7 – 8

[00122] Comparative Example 7 was prepared by the same process as in Example 3 with its ingredients shown in Table 3. Comparative Example 8 came from Comparative Example 7 where a portion of the product received additional

washing.

Examples 11-14

[00123] Examples 11, 12, and 14 were prepared by the same process as Comparative Example 8, except that various surfactants as indicated in Table 3 were added. Higher purity splits were used in Examples 7, 8, 11, 12, and 14.

Table 3. Example Reaction Compositions

Example	Comp Ex 1	Ex 2	Comp 3	Comp 4	Ex 5	Ex 5a	Ex 6	Comp Ex 7	Ex 9	Ex 10	Ex 11	Ex 12	Ex 14	Ex 15
Guar splits (99%)	100	100						100			100	100	100	
Guar splits (93%)			100	100	100	100	100		100	100				100
Water	59	59	51	40	59	82	58	56	60	64	62	62	62	40
Surfactant	0	5 (1)			5 (1)	5 (1)	0.85 (2)	0	5 (1)	5 (1)	5 (1)	5 (3)	0.8 (4)	5 (1)
30% Hydrogen peroxide			3	2	2	1	2	3		1	2	2	2	1
50% Sodium hydroxide	21	21	22	23	21	22	20	20	23	24	21	21	21	40
Propylene oxide						20								
65% 3-Chloro-2- Hydroxypropyltri methylammonium chloride (Quat 188)	36	36	46	48	40	54	34	33	53	54	36	36	36	40
Sodium borate decahydrate (Borax)	1	1	1	1	1	1	1	1	1	1	1	1	1	1
80% Acetic Acid										4				4

1. 3 parts Polyoxyethylene (20) sorbitan monolaurate (Tween® 20)/ 2 parts Polyoxyethylene (20) sorbitan monoleate (Tween® 80)
2. 0.51 parts Polyoxyethylene (20) sorbitan monolaurate (Tween® 20)/ 0.3 parts Polyoxyethylene (20) sorbitan monoleate (Tween® 80)
3. Sodium laureth-13-carboxylate anionic surfactant (Sandopan® LS 24N surfactant available from Clariant Corp) (69%)
4. Mixture 0.4 parts lauric acid/ 0.4 parts oleic acid

[00124] Example 13 came from Example 12 where a portion of the product was washed with water containing 2% of a sodium laureth-13-carboxylate anionic surfactant (Sandopan® LS 24N surfactant available from Clariant Corp).

Examples 16-22

[00125] Examples 16-22 represent comparative Examples of commercial cationic guar polymers.

Examples 23-28

[00126] Examples 23, 24 and 26 were replicates of Example 5 produced at a larger scale.

[00127] Example 25 is a replicate of comparative Example 3 produced at a larger scale.

[00128] Example 27 is a replicate of comparative Example 11 produced at a larger scale.

[00129] The improved clarity of the products of the invention when used at a concentration of 0.5wt% (Shampoo 1) and 0.2wt% (Shampoo 2) is demonstrated in Table 4. The polymer of the invention in Examples 2, 5, 6, 9, 10, 11, 13 and 15 produced shampoo formulations with the highest clarity, relative to the comparative control polymers. This conclusion is drawn by comparing the % transmittance of Shampoo 2 in Table 4 for the following: a) Shampoo 2 containing polymers of the invention in Example 2 has higher % transmittance when compared with Comparative Example 1, b) Shampoo 2 containing polymers of the invention in Examples 5, 6, 9, 10, and 15 have higher % transmittance when compared with comparative example 3, and c) Shampoo 2 containing polymers of

the invention in Examples 11, 12, 13, and 14 have higher % transmittance when compared with Comparative Example 8.

[00130] It is instructive to discuss the % transmittance of these polymers in aqueous solution at a concentration of 1wt% polymer and in surfactant composition Shampoo 2 at a concentration of 0.2wt% polymer.

[00131] As shown by the aqueous solution clarity of the 1% polymer solution in comparative Example 4, it is shown that caustic extraction of the guar as defined in US 5489674 does improve aqueous solution clarity of the polymer, as well as reducing protein content of the polymer. However, increasing aqueous polymer solution clarity by caustic extraction did not deliver improved clarity of the Comparative Example 4 in shampoo formulation 1, as shown by its low % transmittance in shampoo 1 when the polymer is present at a concentration of 0.5wt%.

[00132] By using the % transmittance as a measure of clarity of shampoo 1 in Table 4, it is apparent that the higher optical transmittance for Example 2 relative to comparative Example 1 and for Example 5 relative to Comparative Example 3 demonstrate the improved clarity in surfactant-based systems such as shampoo formulation 1, provided by the polymer of the invention in Examples 2 and 5. Comparison of the optical clarity of shampoo 1 formulation containing Example 6 relative to Example 5 demonstrates that the concentration of surfactant in the process affects the clarity of the resulting polymer in the surfactant system of shampoo 1 and other surfactant systems. Comparison of the optical clarity of shampoo 1 formulation containing comparative Example 8 with Comparative Example 7 demonstrates that extra washing at the end of the process does not improve the clarity of the standard processed polymer in surfactant-based

systems.

[00133] In shampoo formulation 2 in Table 4, the polymers of the invention in Examples 5, 9, 10, 11, 13, and 15 have higher clarity than either of the comparative control polymers in Examples 3, or 8. Similarly, in shampoo formulation 2, the polymers of the invention in Examples 5, 9, 10, 11, 13, and 15 have higher clarity than the Comparative controls in Examples 16, 18, 19, and 22.

[00134] The % transmittance values for the shampoo formulations 2, 3, and 4 in Table 4 demonstrate the impact of decreasing surfactant concentration on optical clarity of the shampoo. Shampoo formulations 2-4 containing the polymer of the invention in Example 11 consistently have higher % transmittance values, correlated with optical clarity, than the corresponding shampoos containing the polymer in comparative Example 8 or any of the comparative Examples 16, 18, 19, or 22.

[00135] Polymers of the invention in Examples 2, 5, 6, 9, 10, 11, 12, 13, and 14 demonstrate the impact of a variety of surfactant charge types and structures in the process for producing the product of the invention, as well as their use in a post washing procedure (Example 13).

[00136] Polymer of the invention in Example 5a demonstrates a cationic hydroxypropyl guar of the invention.

[00137] The % transmittance of 1% aqueous solutions of the polymers of the invention in Examples 2, 5, 5a, 6, 9, 10, 11, 12, 14, and 15 is less than 60% when measured at 600nm wavelength, similar to the % transmittance for the polymers in comparative Examples 1, 3, and 8, 16, 18, 19, 20, and 22. Unexpectedly, the polymers of the invention in Examples 2, 5, 5a, 9, 10, 11, 13, 15, 23, and 24 have aqueous solution transmittance of less than 55% when the polymer is present at a

concentration of 1wt%, but % transmittance values of 85% or higher in shampoo formulation 2 in Table 4, which consists of 12% sodium lauryl ether sulfate, 2% cocamidopropyl betaine surfactants and 1wt% sodium chloride. In addition, the polymer of the invention in Examples 11, 15, 23, and 24 deliver shampoos having % transmittance values of 85-90% in shampoo formulations 2-4 in Table 4 and in the sulfate-surfactant-free shampoo formulation 5 in Table 5, when the polymer is present at 0.2wt% and 0.5wt% in the formulations, respectively. The comparative Example 8 shows only 83-85% transmittance in shampoo formulations 2-4 in Table 4 and less than 75% transmittance in shampoo formulation 5 in Table 5 when the polymer is present at 0.2wt% and 0.5wt% in the formulations, respectively. The polymers in comparative Examples 16-22 show less than 80% transmittance in shampoo formulations 2-4 and less than 80% transmittance in shampoo formulation 5 when the polymer is present at 0.2wt% and 0.5wt% in the formulations, respectively. The polymer of comparative Example 20 is one exception, in that the polymer of comparative Example 20 had >80% transmittance when the polymer is present in solution at a concentration of 1wt%, making this polymer different from the polymers of the invention, which have <60% transmittance in aqueous solution when the polymer is present at a concentration of 1wt%.

[00138] The polymer of comparative Example 21 shows properties similar to the polymers of the invention in Examples 11, 23, 24, 26 and 27 in terms of its low % transmittance in aqueous solution, and >85% transmittance in the shampoo formulations 2-4 in Table 4 and shampoo 5 in Table 5. However, the polymers of the invention in Examples 26 and 27 have an insoluble content >0.4wt%, greater than the insoluble content of the polymer of comparative example 21. In addition,

the polymers of the invention demonstrate better performance as deposition agents for dispersed phase components, or benefit agents, such as silicone or zinc, onto substrates such as hair. For example, in Table 5, the polymers of the invention in Example 11, 23, and 24 in shampoo formulation 6 lead to 40-80%-improvement in silicone deposited onto the hair substrate relative to the shampoo formulation 6 containing the comparative polymer in example 8 and greater than 40%-80% improvement in silicone deposition onto hair when compared with the polymer in comparative Example 21.

[00139] In summary, the polymers of the invention are improvements over the polymers in the comparative Examples.

[00140] In addition, the protein content for the polymers of the invention in Examples 2, 5, 6, 9, 10, 11, 12, 14, and 15 is similar to the protein content of their comparative examples 1, 3, and 8. Yet the clarity of shampoo formulation 2 containing the polymers of the invention in Examples 2, 5, 6, 9, 10, 11, 12, 14, and 15 is greater than the clarity of the shampoos containing the respective comparative control polymers in Examples 1, 3, and 8.

[00141] The low shampoo clarity of the shampoo containing the polymer of Comparative Example 4 demonstrates that the process of US 5756720 reduces protein content and improves aqueous solution clarity of the polymer but not surfactant-based formulation clarity.

TABLE 4. Polymer Compositions and Shampoo Performance-Shampoos 1-4

example	Cationic Substitution	Hydroxypropyl Substitution	Gel/Man ratio	Molecular weight	%T@ 600nm polymer @1%	Visc@ 1wt%	% protein	Nitrogen Total	%T@ 600nm Shampoo 1 (polymer)= 0.5wt%	Shampoo 1 Visc/cps	%T@ 600nm Shampoo 2 (polymer)= 0.2wt%	Shampoo 2 Visc/cps	%T@ 600nm Shampoo 3 (polymer)= 0.2wt%	Shampoo 3 Visc/cps	%T@ 600nm Shampoo 4 (polymer)= 0.2wt%	Shampoo 4 Visc/cps	Polymer Wt% Insolubles
1	0.166		0.643		24	75400	1.31	1.59	31	12340	82	6379					
2	0.189		0.585		26	68200	1.31	1.54	42	11320	72	6319					
3	0.203		0.587	329,000	41	38	1.19	1.67	61	6260	86	4159					
4	0.239		0.588	404,000	75	67	0.66	1.77	48	12700							
5	0.190		0.557	441,000	39	72	1.38	1.63	89	6040	89	4592					
5a	0.267	0.54	0.71		19	459	1.06	2.16	97	3323							
6	0.174		0.963	387,000	33	38	1.44	1.5	85	9120							
7	0.162		0.815	301,000	35	26	1.31	1.34	94	4760							
8					37	25					83	7280	83	1448	85	383	
9	0.233		0.592		41	50	1.13	1.87			90	3539					
10	0.25		0.569	953,000	45	1025	1.25	1.95			88	4849					
11	0.171		0.543	328,000	39	34	1.31	1.22	88	4960	93	7950	89	1378	87	335	
12	0.172		0.652	287,000	41	26	1.38	1.49	73	8420							
13					43	24			70	8400	91	3159					
14	0.173		0.653	305,000	32	23	1.44	1.52	61	7000							
15	0.186		0.566	590,000	51	360	1.36	1.54			83	7620	86	1960	83	652	
16 (1)	0.147		0.587	300,000	22	59	1.19	1.16			68	5300	72	1768	80	430	
17 (1)	0.171		0.574		41	29	1.00	1.35	95	10378							
18 (1)	0.198		0.605	1,140,000	45	4060	1.06	1.23			47	9280	50	2768	30	1015	
19 (1)	0.225		0.576	1,070,000	40	3700	1.00	1.81			77	10200	72	2792	68	1116	
20 (2)	0.231		0.632	837,000	56	960	0.25	1.7			97	8760	99	2352	97	844	
21 (2)	0.168		0.645	311,000	40	48	0.75	1.29			95	6080	95	1700	92	426	0.5
22 (2)	0.14		0.624	1,030,000	35	5260	1.06	1.1			53	11800	58	3620	56	1280	
23	0.182		0.593	313,000	22	54	0.75	1.41			94	6320	94	1648	92	434	
24	0.175		0.591	300,000	43	39	0.89	1.56			96	6390	96	1656	95	439	
25	0.172		0.586	334,000	52	34	0.81	1.85	42	10820							0.9
26	0.171		0.567	334,000	52	40	1.00	1.58			96	3431					1
27	0.168		0.651	255,000	55	18	0.69	1.33			98	3534					0.4

1. Cationic guar commercially available from Ashland Inc.

2. Cationic guar commercially available from Rhodia *

TABLE 5. Polymer Compositions and Shampoo Performance-Shampoos 5 and 6

example	Cationic substitution	Gal/Man ratio	Molecular weight	%T@ 600nm polymer @1%	Visc/cps @ 1wt%	% protein	Nitrogen Total	%T@ 600nm Shampoo [polymer]= 0.2wt%	Shampoo 2 Visc/cps	%T@ 600nm Shampoo [polymer]= 0.2wt%	Shampoo 5 Visc/cps	ppm Silicone deposit on VB Hair from Shampoo 6	Shampoo 6 Visc/cps	Polymer Wt% Insolubles
1	0.196	0.943		24	75400	1.31	1.59	62	8379					
2	0.189	0.965		20	69200	1.31	1.54	72	8319					
3	0.203	0.987	529,000	40	38	1.19	1.67	86	4159					
5	0.198	0.957	441,000	39	72	1.38	1.63	89	4599					
5a	0.267	0.94		19		1.06	2.16	97						
8				37	25			83	7280	74	57	431	7860	
9	0.233	0.992		41	50	1.13	1.87	90	3539					
10	0.25	0.968	953,000	45	1025	1.25	1.96	88	4849					
11	0.171	0.943	325,000	39	34	1.31	1.42	93	7360	93	46	770	8000	
13				43	24			91	3159					
15	0.196	0.966	560,000	51	360	1.38	1.64	88	7620	86	152	753		
16 (1)	0.147	0.987	300,000	22	59	1.19	1.16	68	5600	46	53	677		
17 (1)	0.171	0.974		41	29	1.00	1.36	35	10378					
18 (1)	0.158	0.905	1,140,000	46	4060	1.06	1.23	47	9280	40	890	941	29450	
19 (1)	0.225	0.976	1,070,000	40	3700	1.00	1.81	77	10200	72	880	1320	28700	
20 (2)	0.231	0.932	837,000	86	960	0.25	1.7	97	8760	96	366	970	18020	
21 (2)	0.168	0.945	311,000	40	48	0.75	1.29	95	6080	92	57	538	13780	0.3
22 (2)	0.14	0.924	1,030,000	36	5260	1.06	1.1	53	11600	13	588	653	31200	
23	0.182	0.993	313,000	22	54	0.75	1.41	94	6520	93	53	997	14800	
24	0.175	0.991	320,000	43	39	0.69	1.36	96	6380	92	53	756	14760	
25	0.172	0.966	334,000	52	34	0.81	1.35							0.9
26	0.171	0.967	334,000	52	40	1.00	1.38	96	3431					1
27	0.168	0.951	255,000	55	18	0.69	1.33	98	3334					0.4

1. Cationic guar commercially available from Ashland Inc.

2. Cationic guar commercially available from Rhodia *

[00142] The wt% insoluble fraction of the polymers of the invention is shown to be $\geq 0.4\text{wt}\%$, as shown in polymers of the invention in Examples 26 and 27. This amount of insoluble fraction is seen to be greater than the insoluble content of the comparative Example 21.

[00143] The results set forth in Tables 4-5 demonstrate the surprising benefit of the polymers of the present invention in providing an increased level of clarity, as measured by % transmittance values greater than 85% at 600nm wavelength, in the final shampoo formulation, with a diagnostic shampoo composition consisting of: 12% sodium lauryl ether sulfate(2EO)/2% cocamidopropyl betaine (CAPB)/1% NaCl and 0.2wt% polymer, whereas the aqueous polymer solution has % transmittance values of $<60\%$ transmittance, when the polymer is present at a concentration of 1wt%. The results in Tables 4 and 5 demonstrate the performance of the polymers of the invention across a broad range of molecular weights, cationic substitution levels, and nonionic substitution, and across a range of polymer structures, as defined by the ratio of galactose/mannose units in the polymer. The surprising benefits of the polymers of the invention are observed across broad ranges of cationic substitution, molecular weight, galactose/mannose ratios, and polymer protein content.

[00144] The results set forth in Table 5 also demonstrate the enhanced performance of the polymers of the invention as deposition agents for dispersed phase components, or benefit agents, such as silicone or zinc, onto substrates such as hair or skin.

[00145] It is not intended that the examples given here should be construed to limit the invention, but rather they are submitted to illustrate some of the specific

embodiments of the invention. Various modifications and variations of the present invention can be made without departing from the scope of the appended claims.

We claim:

1. A polysaccharide polymer comprising a water soluble and water insoluble fraction wherein the water insoluble fraction constitutes between 0.4 wt% to 3 of the composition;

said polysaccharide polymer having an aqueous polymer solution clarity at 1 wt% of less than 60% transmittance at 600nm and clarity greater than 80% light transmittance at wavelength of 600 nm in a surfactant system composed of 12 wt% sodium laureth sulfate/2 wt% cocamidopropyl betaine/1 wt% sodium chloride when the polysaccharide polymer is present at a concentration of 0.2% by weight of the composition.

2. The composition in claim 1 wherein said polysaccharide polymer is polygalactomannan.

3. The composition in claim 2 wherein the polygalactomannan comprises guar.

4. The composition in claim 2 wherein said polygalactomannan polymer has a weight average molecular weight of from about 5000 to about 10 million.

5. The composition in claim 4 wherein said polygalactomannan polymer is derivatized with a functional moiety selected from the group consisting of anionic moieties, cationic moieties and nonionic moieties, and combinations thereof.

6. The composition in claim 5 wherein said moiety is a cationic moiety.
7. The composition in claim 5 wherein the moiety is a combination of a cationic and nonionic moieties, and said nonionic moiety is a hydroxyalkyl group.
8. A process for forming a modified polysaccharide polymer comprising reacting a polysaccharide polymer with caustic, water, and a surfactant and further a derivatizing moiety selected from the group consisting of cationic, anionic, nonionic and amphoteric moieties and mixtures thereof.
9. The process in claim 8 wherein said polysaccharide is further reacted with at least one of an oxidizing agent, a proteolytic enzyme or a hydrolytic enzyme..
10. The process in claim 9 wherein said oxidizing agent is selected from the group consisting of peroxides, peracids, persulfates, permanganates, perchlorates, hypochlorate, and oxygen.
11. The process in claim 10 wherein said oxidizing agent is a peroxide.
12. The process in claim 11 wherein said derivatizing moiety is cationic and said surfactant is a nonionic surfactant.
13. The process in claim 12 wherein the nonionic surfactant is a polysorbate surfactant or mixture of polysorbate surfactants.

14. The process in claim 13 wherein the polysaccharide is polygalactomannan.
15. The process in claim 14 wherein said polygalactomannan comprises guar splits.
16. A personal care or household care composition comprising the polygalactomannan composition in claim 6.
17. The process in claim 11 wherein said derivatizing moiety is a mixture of cationic and nonionic moieties, and said surfactant is a nonionic surfactant.
18. The process in claim 14 wherein said polygalactomannan is selected from the group consisting of guar, locust bean, cassia, fenugreek, honey locust and flame tree.
19. A personal care or household care composition comprising the cationic polygalactomannan polymer produced by the process of claim 15.
20. A process for preparing a derivatized polygalactomannan comprising reacting polygalactomannan for sufficient time and sufficient temperature in the presence of water, caustic and at least one surfactant and an oxidizing agent and a derivatizing moiety selected from the group consisting of anionic compounds, nonionic compounds, amphoteric compounds, tertiary amine compounds, quaternary ammonium compounds, and mixtures thereof.

21. The process of claim 20 wherein the oxidizing agent is a peroxide.
22. The process in claim 20 wherein said surfactant is a nonionic surfactant.
23. The process in claim 22 wherein said surfactant is a polysorbate surfactant.
24. The process in claim 23 wherein the surfactant comprises a blend of polysorbate surfactants.
25. The product produced by the process of claim 20.
26. A personal care or household care composition comprising the cationic polygalactomannan composition of claim 25.
27. A personal care or household care composition comprising the polygalactomannan composition of claim 7.
28. A personal care or household care composition comprising the polygalactomannan composition of claim 25, wherein the polygalactomannan polymer contains both cationic and hydroxyalkyl moieties.