



Office de la Propriété
Intellectuelle
du Canada

Un organisme
d'Industrie Canada

Canadian
Intellectual Property
Office

An agency of
Industry Canada

CA 2496423 C 2011/02/15

(11)(21) **2 496 423**

(12) **BREVET CANADIEN
CANADIAN PATENT**

(13) **C**

(86) Date de dépôt PCT/PCT Filing Date: 2003/08/07
(87) Date publication PCT/PCT Publication Date: 2004/03/04
(45) Date de délivrance/Issue Date: 2011/02/15
(85) Entrée phase nationale/National Entry: 2005/02/21
(86) N° demande PCT/PCT Application No.: GB 2003/003466
(87) N° publication PCT/PCT Publication No.: 2004/018610
(30) Priorité/Priority: 2002/08/22 (GB0219568.3)

(51) Cl.Int./Int.Cl. *C11D 17/00* (2006.01),
C11D 1/86 (2006.01), *C11D 1/94* (2006.01),
C11D 3/00 (2006.01), *C11D 3/48* (2006.01),
C11D 1/62 (2006.01)
(72) Inventeurs/Inventors:
LU, ROBERT ZHONG, US;
WHITE, PAMELA, US
(73) Propriétaire/Owner:
RECKITT BENCKISER INC, US
(74) Agent: FETHERSTONHAUGH & CO.

(54) Titre : COMPOSITIONS LIQUIDES, A PHASES MULTIPLES POUR NETTOYER ET/OU DESINFECTER DES SURFACES DURES

(54) Title: MULTI-PHASE LIQUID HARD SURFACE CLEANING AND/OR DISINFECTING COMPOSITIONS

(57) **Abrégé/Abstract:**

Liquid cleaning and/or disinfecting composition which is separated into two phases at rest are combined and dispersed within each other upon shaking, comprising cationic surfactant, ionionic surfactant, an irritation mitigating surfactant selected from amphoteric or anionic surfactants and mixtures thereof, an electrolyte, optional adjuvants and water.



(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property
Organization
International Bureau



(43) International Publication Date
4 March 2004 (04.03.2004)

PCT

(10) International Publication Number
WO 2004/018610 A1

(51) International Patent Classification⁷: C11D 17/00,
3/00, 1/86, 1/94

(74) Agents: MCKNIGHT, John Crawford et al.; Reckitt
Benckiser plc, Group Patents Department, Dansom Lane,
Hull HU8 7DS (GB).

(21) International Application Number:
PCT/GB2003/003466

(81) Designated States (*national*): AE, AG, AL, AM, AT, AU,
AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU,
CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH,
GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC,
LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW,
MX, MZ, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RU, SC,
SD, SE, SG, SK, SL, SY, TJ, TM, TN, TR, TT, TZ, UA,
UG, US, UZ, VC, VN, YU, ZA, ZM, ZW.

(22) International Filing Date: 7 August 2003 (07.08.2003)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:
0219568.3 22 August 2002 (22.08.2002) GB

(84) Designated States (*regional*): ARIPO patent (GH, GM,
KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW),
Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM),
European patent (AT, BE, BG, CH, CY, CZ, DE, DK, EE,
ES, FI, FR, GB, GR, HU, IE, IT, LU, MC, NL, PT, RO,
SE, SI, SK, TR), OAPI patent (BF, BJ, CF, CG, CI, CM,
GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

(71) Applicant (*for all designated States except MN, US*):
RECKITT BENCKISER INC [US/US]; 1655 Valley
Road, Wayne, NJ 07474 (US).

(71) Applicant (*for MN only*): **RECKITT BENCKISER (UK)
LTD** [GB/GB]; 103-105 Bath Road, Slough, Berkshire SL1
3UH (GB).

(72) Inventors; and

(75) Inventors/Applicants (*for US only*): **LU, Robert, Zhong**
[US/US]; Reckitt Benckiser Inc, One Phillips Parkway,
Montvale, NJ 07645 (US). **WHITE, Pamela** [US/US];
Reckitt Benckiser Inc, One Phillips Parkway, Montvale NJ
07645 (US).

Declarations under Rule 4.17:

- *as to applicant's entitlement to apply for and be granted a
patent (Rule 4.17(ii)) for all designations*
- *of inventorship (Rule 4.17(iv)) for US only*

Published:

- *with international search report*

*For two-letter codes and other abbreviations, refer to the "Guid-
ance Notes on Codes and Abbreviations" appearing at the begin-
ning of each regular issue of the PCT Gazette.*

(54) Title: MULTI-PHASE LIQUID HARD SURFACE CLEANING AND/OR DISINFECTING COMPOSITIONS

(57) Abstract: Liquid cleaning and/or disinfecting composition which is separated into two phases at rest are combined and dispersed within each other upon shaking, comprising cationic surfactant, ionionic surfactant, an irritation mitigating surfactant selected from amphoteric or anionic surfactants and mixtures thereof, an electrolyte, optional adjuvants and water.

WO 2004/018610 A1

5

**MULTI-PHASE LIQUID HARD SURFACE CLEANING AND/OR DISINFECTING
COMPOSITIONS**

10

The present invention relates to a liquid cleaning and/or disinfecting composition which is separated into two phases at rest where the phases are temporarily dispersed within each other upon shaking.

15

20

25

30

A recurring problem is that when cleaning hard surfaces, such as may be found in the kitchen or bathroom area, or win the cleaning of soft surfaces, such as textiles, as well as soiled garments and fabrics, is that both inorganic and organic stains and soils need to be treated and removed. Whereas surfactants and soaps are usually effective in removing organic stains and soils from such surfaces, they are usually less effective, or ineffective, in removing inorganic stains and soils. In order to remove inorganic stains and soils, including for example limescale, it is therefore necessary to use compounds, often in aqueous solution, which are suitable for dissolving or detaching this dirt. Depending on the nature of the dirt, these might be acid, neutral or alkaline compounds. In order to detach deposits of limescale, the buildup upon hard surfaces which is usually attributable to hardness-forming elements in water, it is preferred to use acid containing aqueous solutions. In order to remove other types of organic stains and soils, for example stains and soils containing clay and/or pigment, it is preferable to use aqueous solutions of ingredients which produce a pH value in the neutral or alkaline range in aqueous solution. In both cases, however, it has been found that the addition of surface-active agents to aqueous solutions used for removing inorganic stains and soils (if they are also required to remove organic stains and soils) can lead to a significant reduction in their effectiveness against inorganic stains and soils. Thus, providing an aqueous based composition effective against both inorganic stains and soils is not a trivial technical matter.

25448-405

The prior art has proposed various compositions of the type to which this invention is generally related which are disclosed, inter alia, in WO 99/47635, GB2134916, WO 99/47634, WO 00/24852, WO 00/71665, WO 01/21752, WO 01/21753, GB1247189, EP116422 and EP175485. Notwithstanding the

5 availability of such prior art compositions, they are not without shortcomings and thus remains a real and continuing need in the art for further improvements to multiphase compositions. The compositions of the present invention overcome many of the problems attendant upon prior art compositions.

An embodiment of the invention provides a composition which

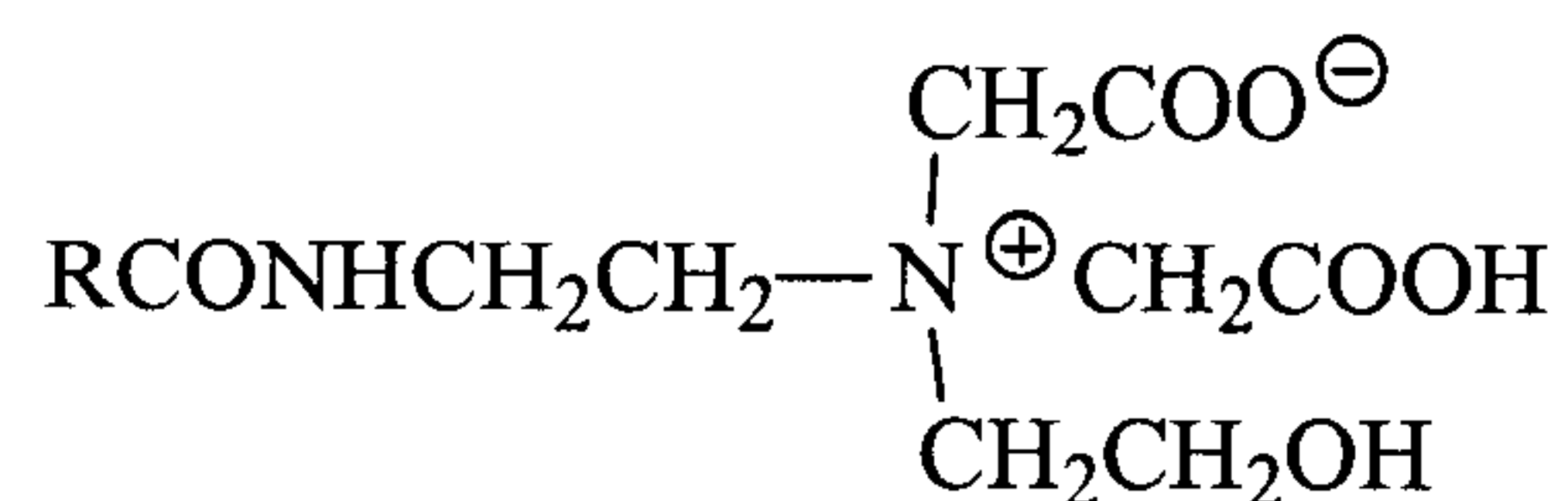
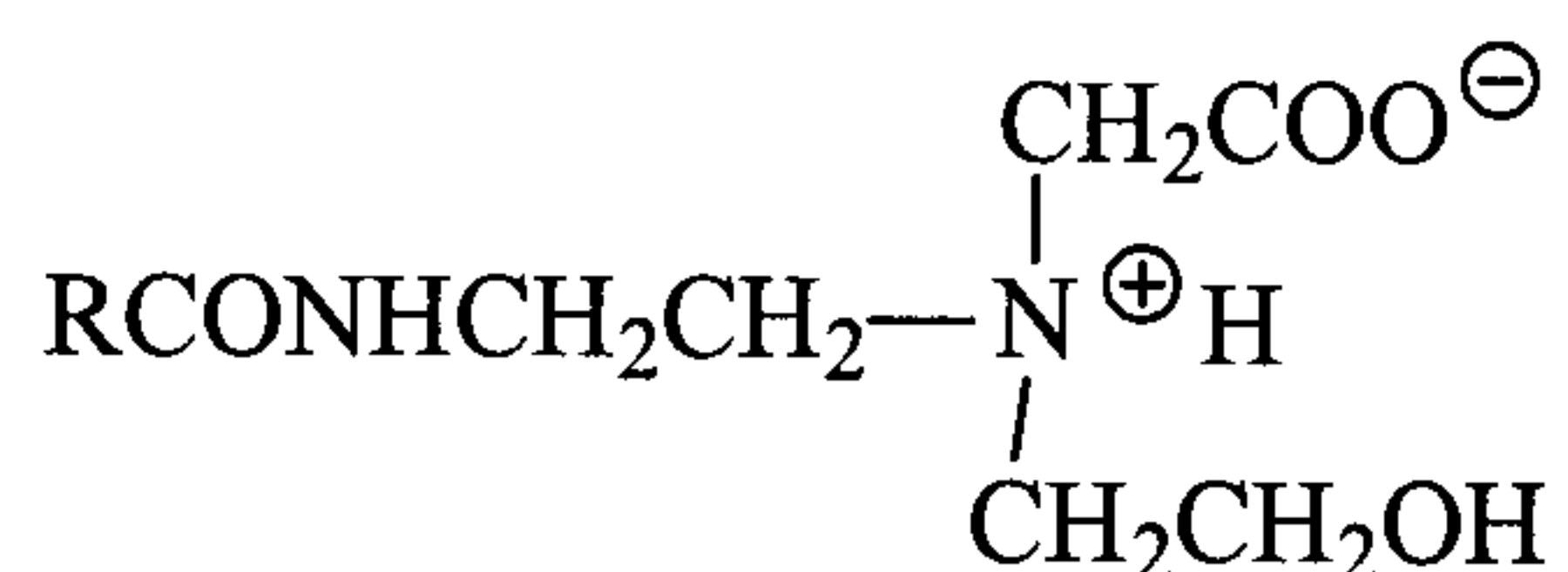
10 separates into at least two aqueous phases upon standing comprising:

(a) 0.01 - 10%wt. of at least one cationic surfactant having germicidal properties;

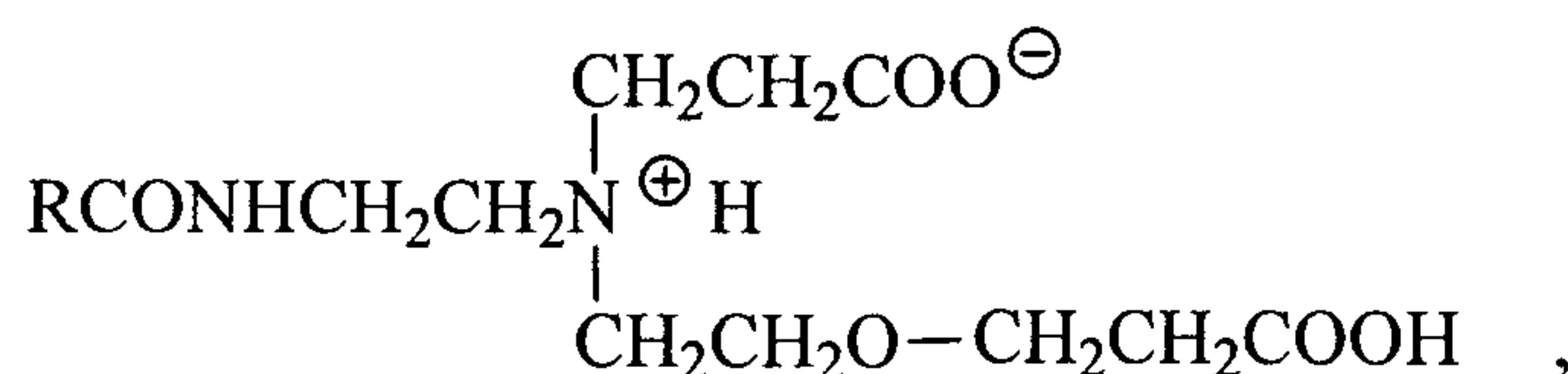
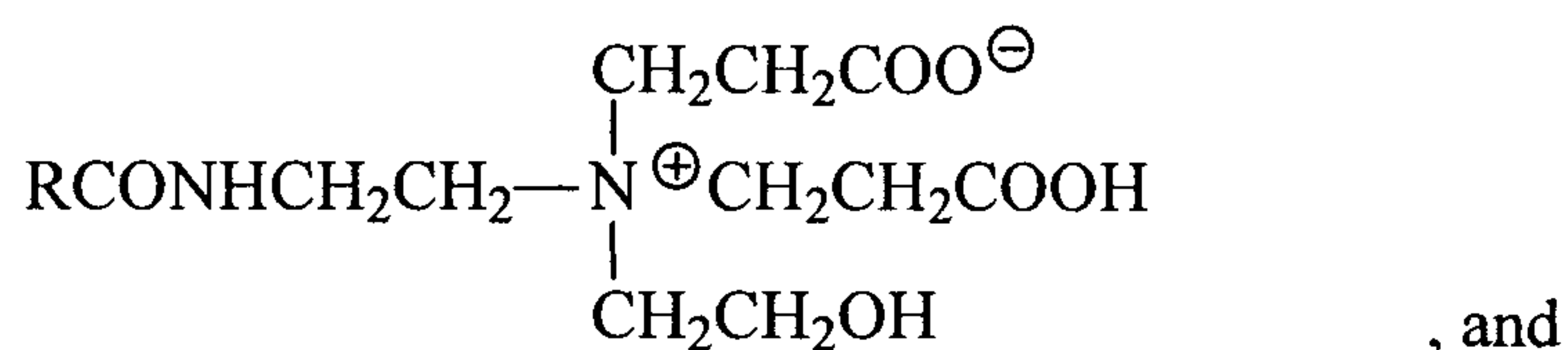
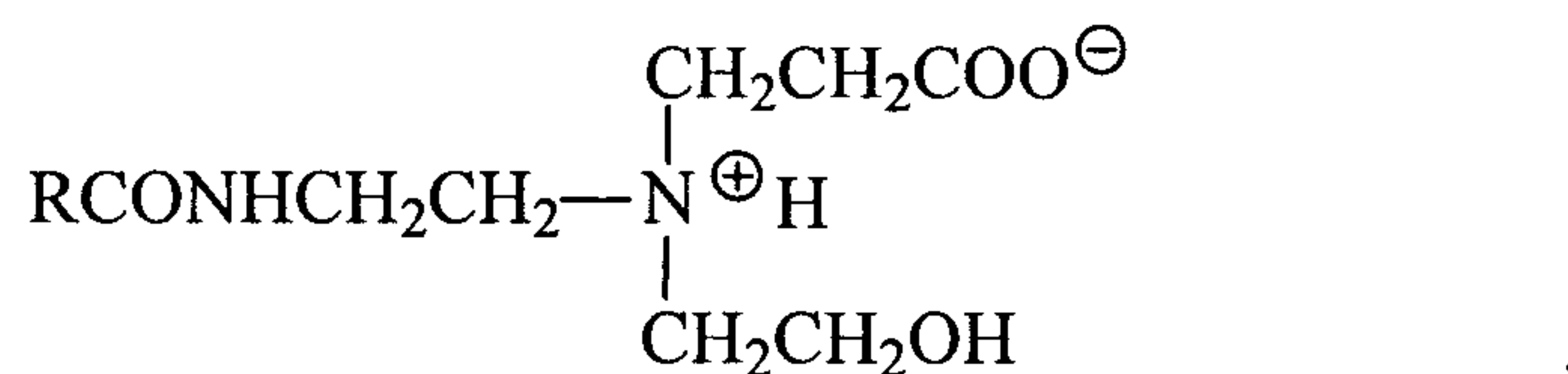
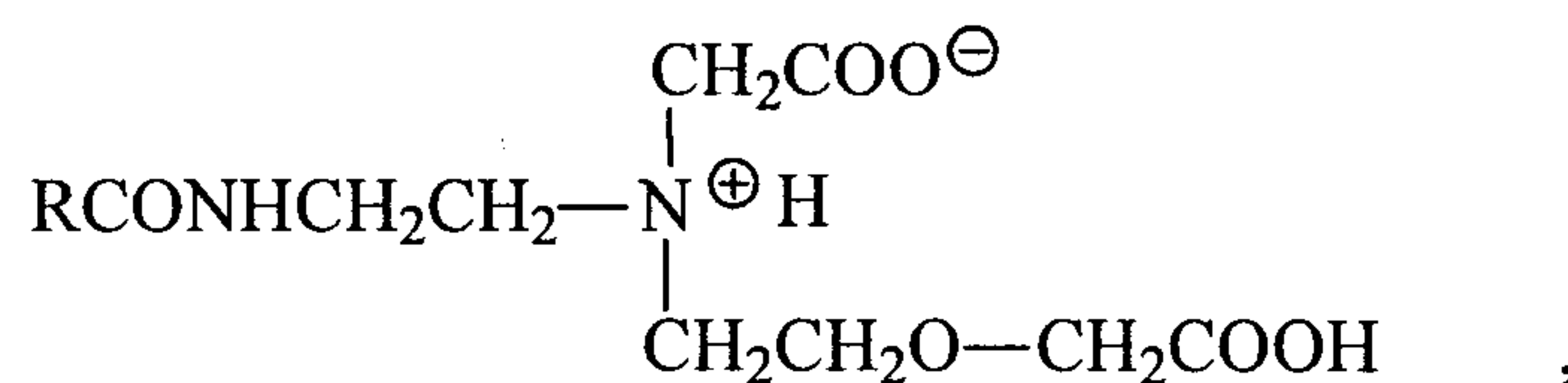
(b) 0.1 - 10%wt. of at least one nonionic surfactant;

(c) 0.1 - 10%wt. at least one component having irritation mitigating

15 properties comprising one or more amphoteric surfactants selected from the group of compounds having the formulas



25448-405



wherein R is C₈ to C₂₄ alkyl, optionally with one or more anionic surfactants;

5 (d) at least one electrolyte;

(e) optionally, one or more constituents for improving the aesthetic or functional features of the composition;

and the remainder water.

The present inventors have discovered a liquid cleaning and/or
 10 disinfecting compositions which separates into at least at least two aqueous phases upon standing, which compositions include one or more components which have irritation mitigating properties which reduce the potential for ocular

25448-405

irritation. Herein, applicants have found new and inventive compositions which separate into at least two aqueous phases upon standing comprising:

(a) 0.01 - 10%wt. of at least one cationic surfactant having germicidal properties;

5 (b) 0.1 - 10%wt. of at least one nonionic surfactant;

(c) 0.1 - 10%wt. at least one component having irritation mitigating properties selected from the group consisting of amphoteric surfactant, anionic surfactant, and mixtures thereof;

(d) at least one electrolyte;

10 (e) optionally, one or more constituents for improving the aesthetic or functional features of the inventive compositions;

and the remainder to 100%wt. water.

The present inventors have surprisingly found that good cleaning and/or sanitization and/or disinfection and clear and stable phase separation into a plurality of liquid layers, even at elevated temperatures upon resting can be
15 obtained with a low level amount of electrolyte while simultaneously providing a composition having a low eye irritation level.

In general, when left in a quiescent state, the inventive compositions separate into two (or more) distinct aqueous phases, each comprising a proportion
20 of the total volume

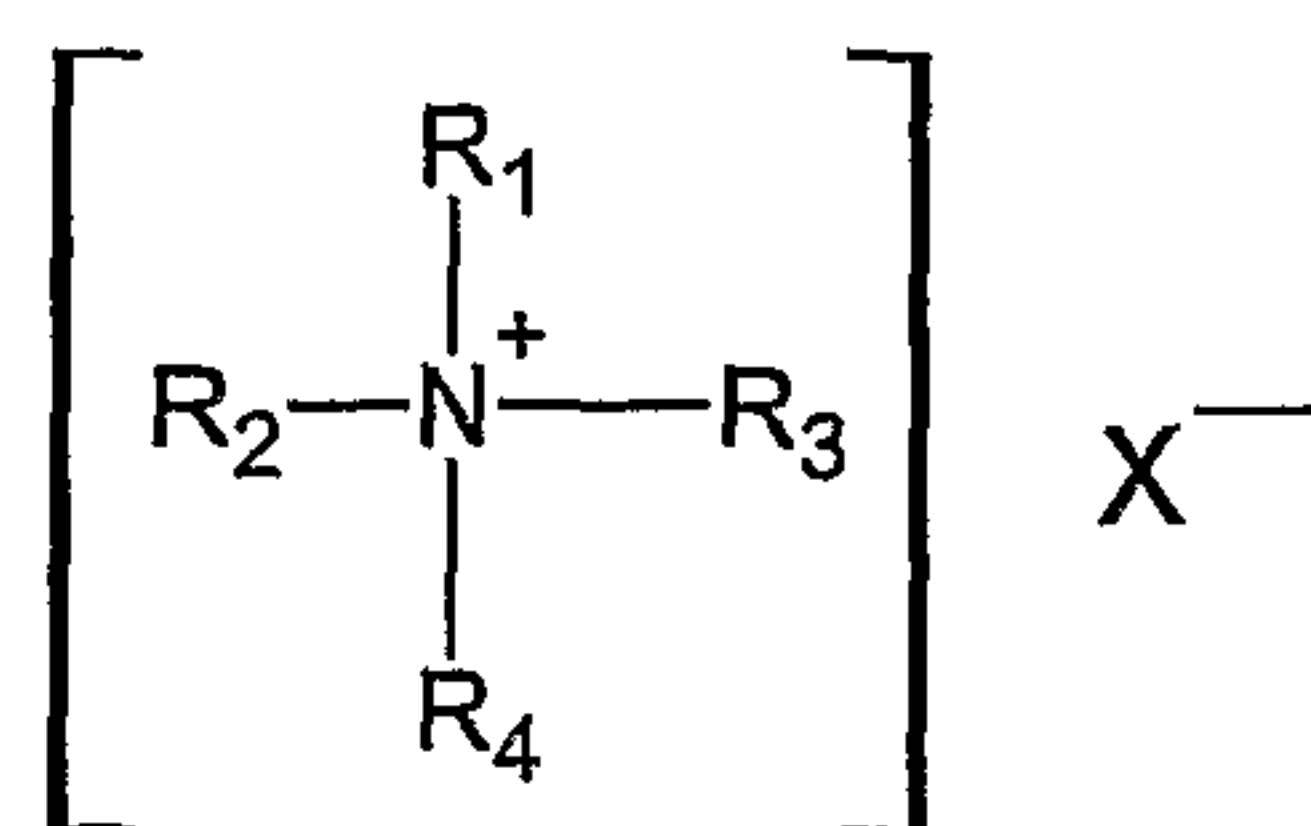
25448-405

of the inventive compositions. Advantageously when the composition separates into two aqueous phases, namely an upper aqueous phase and a lower aqueous phase the respective volume ratios of the upper aqueous phase:lower aqueous phase is in the volume%/volume% varies from 20:80 – 80:20, preferably is in the range of 60:40 – 40:60, and most preferably is in the range of 45:55 – 55:45, and especially preferably is about 50:50. The respective volume ratios may be adjusted by controlling the amount of the first and second aqueous phases, but is most readily adjusted by controlling the amounts of the nonionic surfactant(s) and/or electrolyte(s) present in the inventive compositions.

10 Generally, the majority (in excess of 50%wt.) of the (a) at least one cationic surfactant having germicidal properties is found in the upper aqueous phase; the majority (in excess of 50%wt.) of (b) at least one nonionic surfactant is found in the upper aqueous phase; and the majority (in excess of 50%wt.) of the (c) at least one component having irritation mitigating properties selected from the group of amphoteric surfactant, anionic
15 surfactant, and mixtures thereof, is found in the upper aqueous phase. The electrolyte(s) (in excess of 50%wt., preferably at least 75%wt.) is generally found the lower aqueous phase. When present, the dye can be selected so that the upper layer will have the color of the dye and the lower layer will not have color.

 The inventive compositions include (a) at least one cationic surfactant having
20 germicidal properties. Useful cationic surfactants having germicidal properties may be any one or more of those described in, for example, *McCutcheon's Detergents and Emulsifiers*, North American and International Editions, 2001; *Kirk-Othmer, Encyclopedia of Chemical Technology*, 4th Ed., Vol. 23, pp. 478-541.

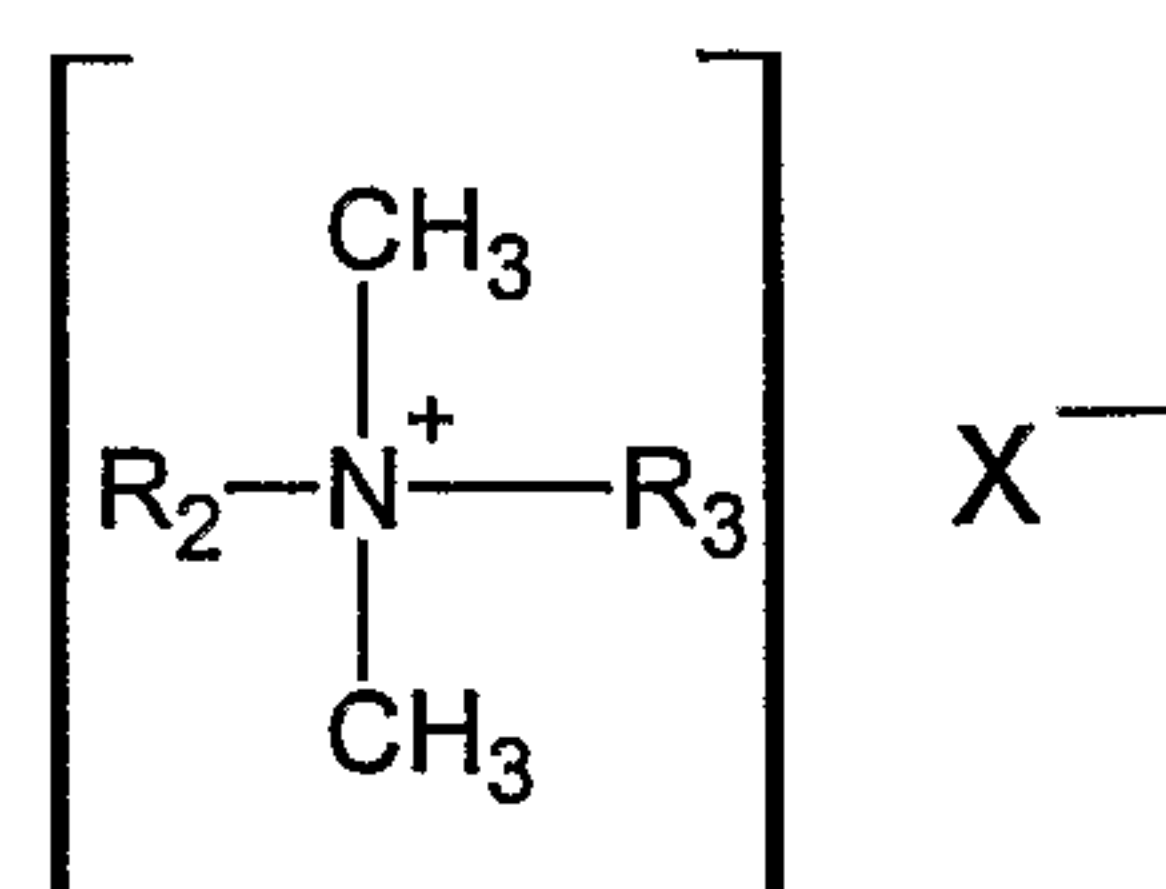
25 Examples of preferred cationic surfactant compositions useful in the practice of the instant invention are those which provide a germicidal effect to the concentrate compositions, and especially preferred are quaternary ammonium compounds and salts thereof, which may be characterized by the general structural formula:



where at least one of R_1 , R_2 , R_3 and R_4 is an alkyl, aryl or alkylaryl substituent of from 6 to 26 carbon atoms, and the entire cation portion of the molecule has a molecular weight of at least 165. The alkyl substituents may be long-chain alkyl, long-chain alkoxyaryl, long-chain alkylaryl, halogen-substituted long-chain alkylaryl, long-chain alkylphenoxyalkyl, arylalkyl, etc. The remaining substituents on the nitrogen atoms other than the above mentioned alkyl substituents are hydrocarbons usually containing no more than 12 carbon atoms. The substituents R_1 , R_2 , R_3 and R_4 may be straight-chained or may be branched, but are preferably straight-chained, and may include one or more amide, ether or ester linkages. The counterion X may be any salt-forming anion which permits water solubility of the quaternary ammonium complex.

Exemplary quaternary ammonium salts within the above description include the alkyl ammonium halides such as cetyl trimethyl ammonium bromide, alkyl aryl ammonium halides such as octadecyl dimethyl benzyl ammonium bromide, N-alkyl pyridinium halides such as N-cetyl pyridinium bromide, and the like. Other suitable types of quaternary ammonium salts include those in which the molecule contains either amide, ether or ester linkages such as octyl phenoxy ethoxy ethyl dimethyl benzyl ammonium chloride, N-(laurylcocoaminoformylmethyl)-pyridinium chloride, and the like. Further particularly effective types of quaternary ammonium compounds which are useful as germicides include those in which the hydrophobic radical is characterized by a substituted aromatic nucleus as in the case of lauryloxyphenyltrimethyl ammonium chloride, cetylaminophenyltrimethyl ammonium methosulfate, dodecylphenyltrimethyl ammonium methosulfate, dodecylphenyltrimethyl ammonium chloride, chlorinated dodecylbenzyltrimethyl ammonium chloride, and the like.

Preferred quaternary ammonium compounds which act as germicides and which are found to be useful in the practice of the present invention include those which have the structural formula:



5 wherein R₂ and R₃ are the same or different C₈-C₁₂ alkyl, or R₂ is C₁₂₋₁₆ alkyl, C₈₁₈alkylethoxy, C₈₋₁₈alkylphenoxyethoxy and R₃ is benzyl, and X is a halide, for example chloride, bromide or iodide, or is a methosulfate or saccharinate anion. The alkyl groups recited in R₂ and R₃ may be straight-chained or branched, but are preferably substantially linear.

10 Exemplary useful quaternary germicides include compositions which include a single quaternary compound, as well as mixtures of two or more different quaternary compounds. Such useful quaternary compounds are available under the BARDAC®, BARQUAT®, HYAMINE®, CATIGENE, LONZABAC®, BTC®, and ONYXIDE® trademarks, which are more fully described in, for example, *McCutcheon's Functional*
 15 *Materials*, North American and International Editions, 2001, and the respective product literature from the suppliers identified below. For example, BARDAC® 205M is described to be a liquid containing alkyl dimethyl benzyl ammonium chloride, octyl decyl dimethyl ammonium chloride; didecyl dimethyl ammonium chloride, and dioctyl dimethyl ammonium chloride (50% active) (also available as 80% active (BARDAC®
 20 208M)); described generally in *McCutcheon's* as a combination of alkyl dimethyl benzyl ammonium chloride and dialkyl dimethyl ammonium chloride); BARDAC® 2050 is described to be a combination of octyl decyl dimethyl ammonium chloride/didecyl dimethyl ammonium chloride, and dioctyl dimethyl ammonium chloride (50% active) (also available as 80% active (BARDAC® 2080)); BARDAC® 2250 is described to be
 25 didecyl dimethyl ammonium chloride (50% active); BARDAC® LF (or BARDAC® LF-80), described as being based on dioctyl dimethyl ammonium chloride (BARQUAT® MB-50, MX-50, OJ-50 (each 50% liquid) and MB-80 or MX-80 (each 80% liquid) are

25448-405

each described as an alkyl dimethyl benzyl ammonium chloride; BARDAC® 4250 and BARQUAT® 4250Z (each 50% active) or BARQUAT® 4280 and BARQUAT® 4280Z (each 80% active) are each described as alkyl dimethyl benzyl ammonium chloride/alkyl dimethyl ethyl benzyl ammonium chloride; and BARQUAT® MS-100 described as

5 being a mixture of tetradecyl dimethyl benzyl ammonium chloride/dodecyl dimethyl benzyl ammonium chloride/hexadecyl dimethyl benzyl ammonium chloride (100% solid (powder)). Also, HYAMINE® 1622, described as diisobutyl phenoxy ethoxy ethyl dimethyl benzyl ammonium chloride (available either as 100% actives or as a 50% actives solution); HYAMINE® 3500 (50% actives), described as alkyl dimethyl benzyl

10 ammonium chloride (also available as 80% active (HYAMINE® 3500-80)); and HYAMINE® 2389 described as being based on methyldodecylbenzyl ammonium chloride and/or methyldodecylxylene-bis-trimethyl ammonium chloride. (BARDAC®, BARQUAT® and HYAMINE® are presently commercially available from Lonza, Inc., Fairlawn, NJ). BTC® 50 NF (or BTC® 65 NF) is described to be alkyl dimethyl benzyl

15 ammonium chloride (50% active); BTC® 99 is described as didecyl dimethyl ammonium chloride (50% active); BTC® 776 is described to be myristalkonium chloride (50% active); BTC® 818 is described as being octyl decyl dimethyl ammonium chloride, didecyl dimethyl ammonium chloride, and dioctyl dimethyl ammonium chloride (50% active) (available also as 80% active (BTC® 818-80%)); BTC® 824 and BTC® 835 are

20 each described as being of alkyl dimethyl benzyl ammonium chloride (each 50% active); BTC® 885 is described as a combination of BTC® 835 and BTC® 818 (50% active) (available also as 80% active (BTC® 888)); BTC® 1010 is described as didecyl dimethyl ammonium chloride (50% active) (also available as 80% active (BTC® 1010-80)); BTC® 2125 (or BTC® 2125 M) is described as alkyl dimethyl benzyl ammonium

25 chloride and alkyl dimethyl ethylbenzyl ammonium chloride (each 50% active) (also available as 80% active (BTC® 2125-80 or BTC® 2125 M)); BTC® 2565 is described as alkyl dimethyl benzyl ammonium chlorides (50% active) (also available as 80% active (BTC® 2568)); BTC® 8248 (or BTC® 8358) is described as alkyl dimethyl benzyl ammonium chloride (80% active) (also available as 90% active (BTC® 8249));

30 ONYXIDE® 3300 is described as n-alkyl dimethyl benzyl ammonium saccharinate (95% active). CATIGENE[™] series is described as mixtures of alkyl dimethyl benzyl ammonium

chlorides/alkyl dimethyl ethyl benzyl ammonium chlorides/dialkyl dimethyl ammonium chlorides. (BTC®, ONYXIDE®, and CATIGENE are presently commercially available from Stepan Company, Northfield, IL (CATIGENE from Stepan Europe)). Polymeric quaternary ammonium salts based on these monomeric structures are also considered
5 desirable for the present invention. One example is POLYQUAT®, which is described as being a 2-butenyldimethyl ammonium chloride polymer.

In certain preferred embodiments of the invention, only one cationic surfactant having germicidal properties is included, while according to other preferred embodiments of the invention a plurality of cationic surfactants are necessarily included. When a
10 plurality of cationic surfactants are present, advantageously they are a mixture of a dialkyl quaternary ammonium compounds (for example, when R₁ and R₂ are each from about C₁₀ to C₁₆ and R₃ and R₄ are each methyl; further examples are described above and are well known to those skilled in the art) and an alkyl benzyl quaternary ammonium compound (examples of which are described above and are well known to those skilled in
15 the art) are present as the (a) at least one cationic surfactant having germicidal properties. In either instance, while stable compositions are formed with defined phase separation it has been found that using more than one cationic surfactant provides increased phase separation at room temperature and reduced phase shrinkage at elevated temperature, and compositions comprising a plurality of cationic surfactants is usually preferred over those
20 comprising a single cationic surfactant.

The inventive compositions comprise 0.01 – 10%wt. of (a) at least one cationic surfactant having germicidal properties; desirably 0.5 – 4%wt., especially wherein the (a) at least one cationic surfactant is a mixture of cationic surfactants based on dialkyl quaternary ammonium compounds.

25 The inventive compositions also necessarily comprise (b) at least one nonionic surfactant, and virtually all known art nonionic surfactants may be used in the present inventive compositions. Illustrative examples of suitable nonionic surfactants for use as the (b) at least one nonionic surfactant include, inter alia, condensation products of alkylene oxide groups with an organic hydrophobic compound, such as an aliphatic
30 compound or with an alkyl aromatic compound. The nonionic synthetic organic detergents generally are the condensation products of an organic aliphatic or alkyl

aromatic hydrophobic compound and hydrophilic ethylene oxide groups. Practically any hydrophobic compound having a carboxy, hydroxy, amido, or amino group with a free hydrogen attached to the nitrogen can be condensed with ethylene oxide or with the polyhydration product thereof, polyethylene glycol, to form a water soluble nonionic detergent. Further, the length of the polyethenoxy hydrophobic and hydrophilic elements may be varied to adjust these properties. Illustrative examples of such a nonionic surfactants include the condensation product of one mole of an alkyl phenol having an alkyl group containing from 6 to 12 carbon atoms with from about 5 to 25 moles of an alkylene oxide. Another example of such a nonionic surfactant is the condensation product of one mole of an aliphatic alcohol which may be a primary, secondary or tertiary alcohol having from 6 to 18 carbon atoms with from 1 to about 10 moles of alkylene oxide. Preferred alkylene oxides are ethylene oxides or propylene oxides which may be present singly, or may be both present.

Still further illustrative examples of nonionic surfactants include primary and secondary linear and branched alcohol ethoxylates, such as those based on C₆-C₁₈ alcohols which further include an average of from 2 to 80 moles of ethoxylation per mol of alcohol. Examples include the Genapol® series of linear alcohol ethoxylates from Clariant Corp., Charlotte, NC. The 26-L series is based on the formula RO(CH₂CH₂O)_nH wherein R is a mixture of linear, even carbon-number hydrocarbon chains ranging from C₁₂H₂₅ to C₁₆H₃₃ and n represents the number of repeating units and is a number of from 1 to about 12, such as 26-L-1, 26-L-1.6, 26-L-2, 26-L-3, 26-L-5, 26-L-45, 26-L-50, 26-L-60, 26-L-60N, 26-L-75, 26-L-80, 26-L-98N, and the 24-L series, derived from synthetic sources and typically contain about 55% C₁₂ and 45% C₁₄ alcohols, such as 24-L-3, 24-L-45, 24-L-50, 24-L-60, 24-L-60N, 24-L-75, 24-L-92, and 24-L-98N. From product literature, the single number following the "L" corresponds to the average degree of ethoxylation (numbers between 1 and 5) and the two digit number following the letter "L" corresponds to the cloud point in °C of a 1.0 wt.% solution in water.

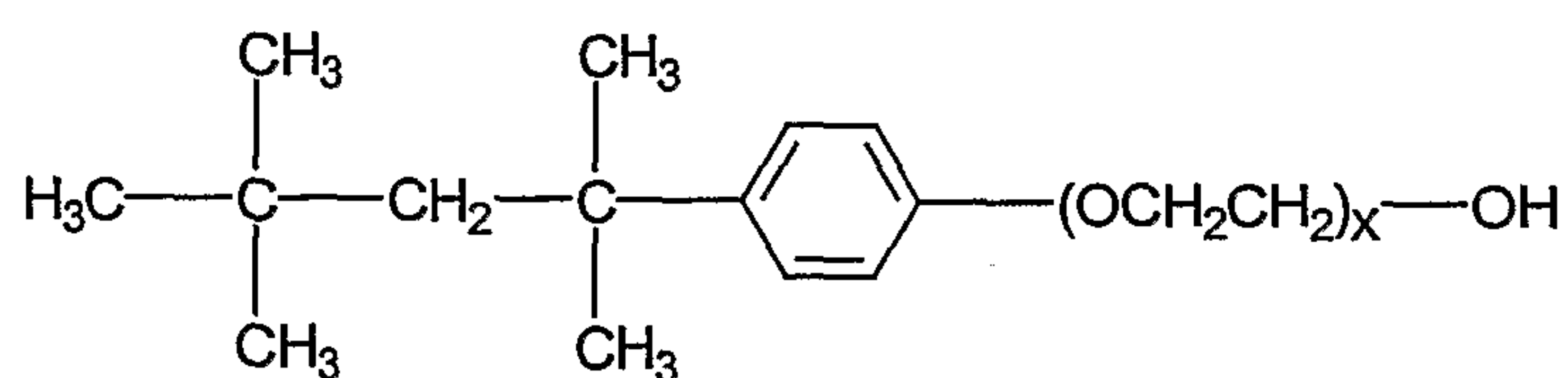
Further examples of useful nonionic surfactants include secondary C₁₂-C₁₅ alcohol ethoxylates, including those which have from about 3 to about 10 moles of ethoxylation. Such are available in the Tergitol® series of nonionic surfactants (Dow Chemical, Midland, MI), particularly those in the Tergitol® "15-S-" series. Further

exemplary nonionic surfactants include linear primary C₁₁-C₁₅ alcohol ethoxylates, including those which have from about 3 to about 10 moles of ethoxylation. Such are available in the Tomadol® series of nonionic surfactants under the following tradenames: Tomadol 1-3 (linear C₁₁ alcohol with 3 moles (average) of ethylene oxide); Tomadol 1-5
5 (linear C₁₁ alcohol with 5 moles (average) of ethylene oxide); Tomadol 1-7 (linear C₁₁ alcohol with 7 moles (average) of ethylene oxide); Tomadol 1-9 (linear C₁₁ alcohol with 9 moles (average) of ethylene oxide); Tomadol 23-1 (linear C₁₂₋₁₃ alcohol with 1 mole (average) of ethylene oxide); Tomadol 23-3 (linear C₁₂₋₁₃ alcohol with 3 moles (average) of ethylene oxide); Tomadol 23-5 (linear C₁₂₋₁₃ alcohol with 5 moles (average) of
10 ethylene oxide); Tomadol 23-6.5 (linear C₁₂₋₁₃ alcohol with 6.6 moles (average) of ethylene oxide); Tomadol 25-12 (linear C₁₂₋₁₅ alcohol with 11.9 moles (average) of ethylene oxide); Tomadol 25-3 (linear C₁₂₋₁₅ alcohol with 2.8 moles (average) of ethylene oxide); Tomadol 25-7 (linear C₁₂₋₁₅ alcohol with 7.3 moles (average) of ethylene oxide); Tomadol 25-9 (linear C₁₂₋₁₅ alcohol with 8.9 moles (average) of ethylene oxide);
15 Tomadol 45-13 (linear C₁₄₋₁₅ alcohol with 12.9 moles (average) of ethylene oxide); Tomadol 45-2.25 (linear C₁₄₋₁₅ alcohol with 2.23 moles (average) of ethylene oxide); Tomadol 45-7 (linear C₁₄₋₁₅ alcohol with 7 moles (average) of ethylene oxide); Tomadol 91-2.5 (linear C₉₋₁₁ alcohol with 2.7 moles (average) of ethylene oxide); Tomadol 91-6 (linear C₉₋₁₁ alcohol with 6 moles (average) of ethylene oxide); Tomadol 91-8 (linear C₉₋₁₁ alcohol with 8.3 moles (average) of ethylene oxide) (Tomah Products, Inc., Milton,
20 WI).

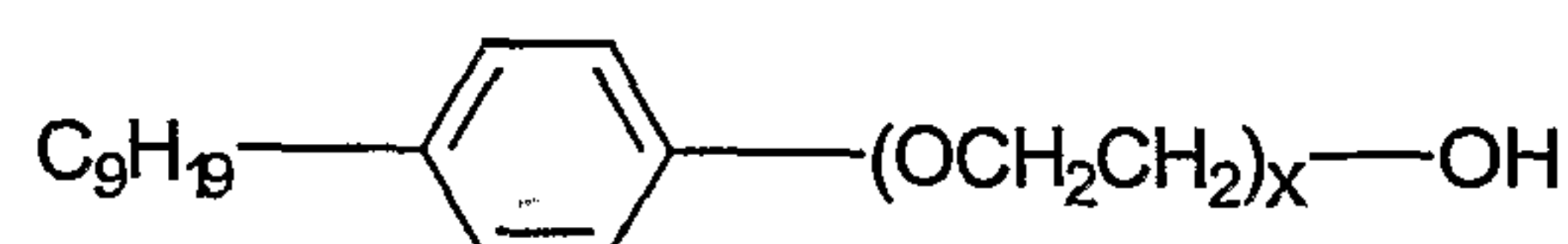
Further examples of useful nonionic surfactants include C₆-C₁₅ straight chain alcohols ethoxylated with about 1 to 13 moles of ethylene oxide, particularly those which include about 3 to about 6 moles of ethylene oxide. Examples of such nonionic
25 surfactants include Alfonic® 810-4.5, which is described as having an average molecular weight of 356, an ethylene oxide content of about 4.85 moles and an HLB of about 12; Alfonic® 810-2, which is described as having an average molecular weight of 242, an ethylene oxide content of about 2.1 moles and an HLB of about 12; and Alfonic® 610-3.5, which is described as having an average molecular weight of 276, an ethylene oxide
30 content of about 3.1 moles, and an HLB of 10.

Further examples of suitable nonionic surfactants for use as the (b) at least one nonionic surfactant include alkyl glucosides, alkyl polyglucosides and mixtures thereof. Alkyl glucosides and alkyl polyglucosides can be broadly defined as condensation articles of long chain alcohols, e.g., C₈-C₃₀ alcohols, with sugars or starches or sugar or starch polymers i.e., glycosides or polyglycosides. These compounds can be represented by the formula (S)_n—O—R wherein S is a sugar moiety such as glucose, fructose, mannose, and galactose; n is an integer of from about 1 to about 1000, and R is a C₈₋₃₀ alkyl group. Examples of long chain alcohols from which the alkyl group can be derived include decyl alcohol, cetyl alcohol, stearyl alcohol, lauryl alcohol, myristyl alcohol, oleyl alcohol and the like. Commercially available examples of these surfactants include decyl polyglucoside (available as APG 325 CS from Henkel) and lauryl polyglucoside (available as APG 600 CS and 625 CS from Henkel).

A further class of nonionic surfactants which may find use in the present inventive compositions include ethoxylated octyl and nonyl phenols include those having one of the following general structural formulas:



or,



in which the C₉H₁₉ group in the latter formula is a mixture of branched chained isomers, and x indicates an average number of ethoxy units in the side chain. Particularly suitable non-ionic ethoxylated octyl and nonyl phenols include those having from about 7 to about 13 ethoxy groups. Such compounds are commercially available under the trade name Triton® X (Dow Chemical, Midland, MI), as well as under the tradename Igepal® (Rhodia, Princeton, NJ). One exemplary and particularly preferred nonylphenol ethoxylate is Igepal® CO-630.

Still further examples of suitable nonionic surfactants for use as the (b) at least one nonionic surfactant include which may be advantageously included in the inventive

compositions are alkoxy block copolymers, and in particular, compounds based on ethoxy/propoxy block copolymers. Polymeric alkylene oxide block copolymers include nonionic surfactants in which the major portion of the molecule is made up of block polymeric C₂-C₄ alkylene oxides. Such nonionic surfactants, while preferably built up from an alkylene oxide chain starting group, and can have as a starting nucleus almost any active hydrogen containing group including, without limitation, amides, phenols, thiols and secondary alcohols.

One group of such useful nonionic surfactants containing the characteristic alkylene oxide blocks are those which may be generally represented by the formula (A):



where EO represents ethylene oxide,

PO represents propylene oxide,

y equals at least 15,

(EO)_{x+z} equals 20 to 50% of the total weight of said compounds, and,

the total molecular weight is preferably in the range of about 2000 to 15,000.

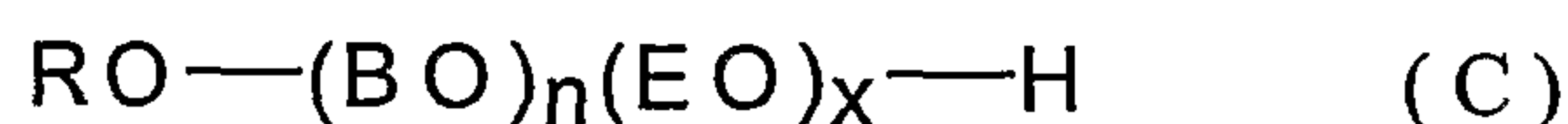
Another group of nonionic surfactants for use in the new compositions can be represented by the formula (B):



wherein R is an alkyl, aryl or aralkyl group, where the R group contains 1 to 20 carbon atoms, the weight percent of EO is within the range of 0 to 45% in one of the blocks a, b, and within the range of 60 to 100% in the other of the blocks a, b, and the total number of moles of combined EO and PO is in the range of 6 to 125 moles, with 1 to 50 moles in the PO rich block and 5 to 100 moles in the EO rich block.

Further nonionic surfactants which in general are encompassed by Formula B include butoxy derivatives of propylene oxide/ethylene oxide block polymers having molecular weights within the range of about 2000-5000.

Still further useful nonionic surfactants containing polymeric butoxy (BO) groups can be represented by formula (C) as follows:



5

wherein R is an alkyl group containing 1 to 20 carbon atoms,
n is about 5-15 and x is about 5-15.

Also useful as the nonionic block copolymer surfactants, which also include polymeric butoxy groups, are those which may be represented by the following formula (D):

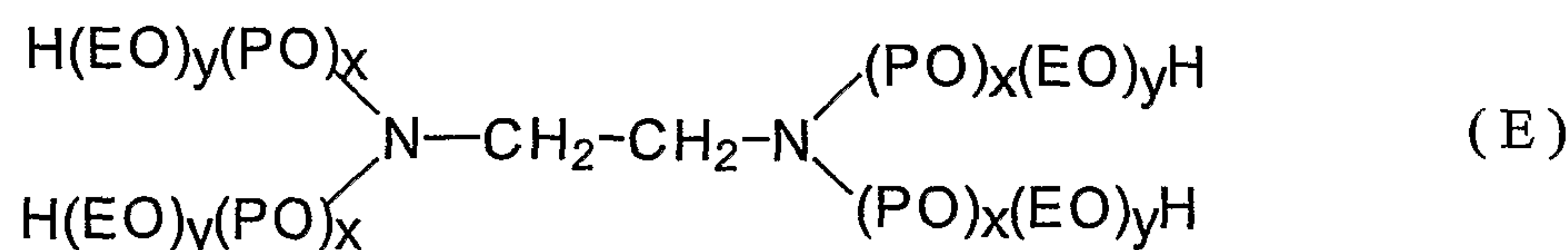
10



wherein n is about 5-15, preferably about 15,
x is about 5-15, preferably about 15, and
y is about 5-15, preferably about 15.

15

Still further useful nonionic block copolymer surfactants include ethoxylated derivatives of propoxylated ethylene diamine, which may be represented by the following formula:



20 where (EO) represents ethoxy,
(PO) represents propoxy,

the amount of (PO)_x is such as to provide a molecular weight prior to ethoxylation of about 300 to 7500, and the amount of (EO)_y is such as to provide about 20% to 90% of the total weight of said compound.

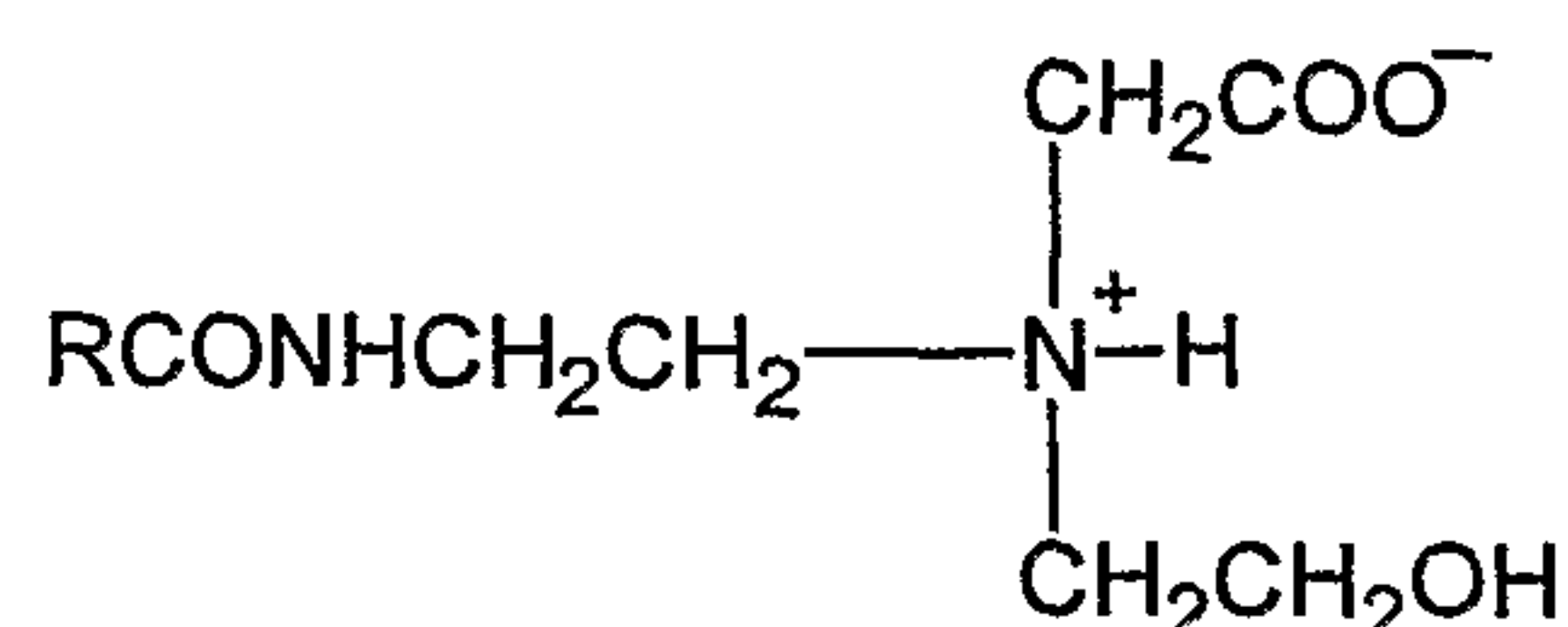
25

The inventive compositions most desirably include (b) at least one alcohol ethoxylated based nonionic surfactant in an amount of from 0.1 – 10%wt., but more preferably in an amount of from 0.2 – 4.0%wt.. The present inventors have found that the amount, and type of nonionic surfactant(s) present in the inventive composition influences the volume of the upper aqueous phase with larger volumes being attained by

increasing the amount of the nonionic surfactants present in the compositions. Especially preferred surfactant systems are described with reference to one or more of the Examples, below.

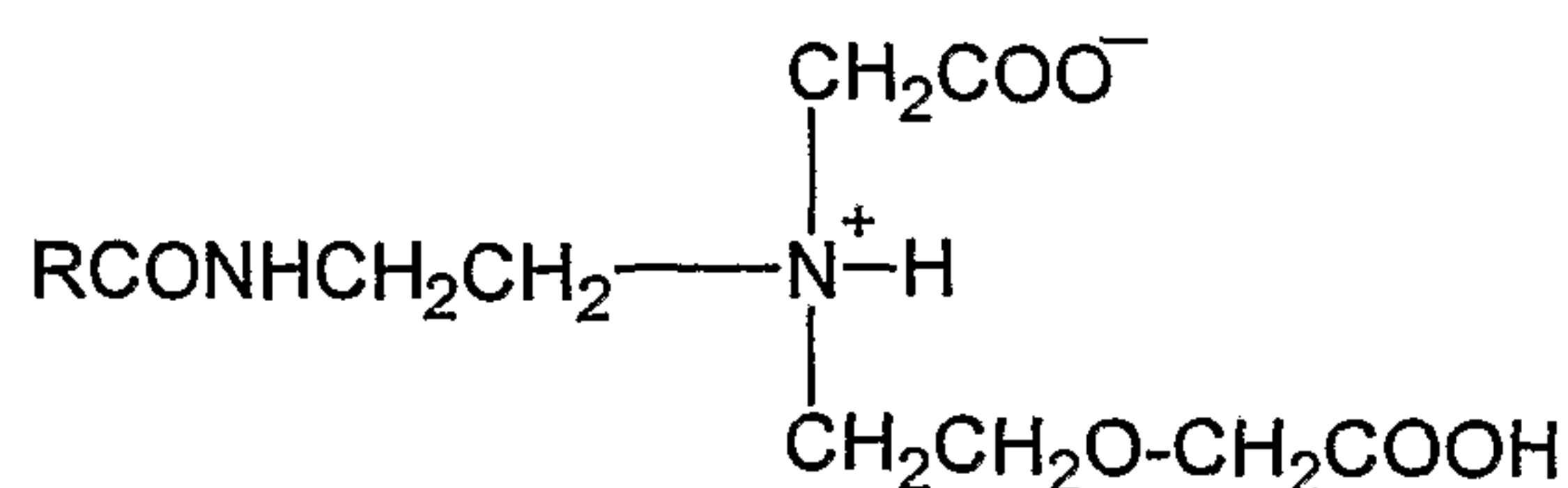
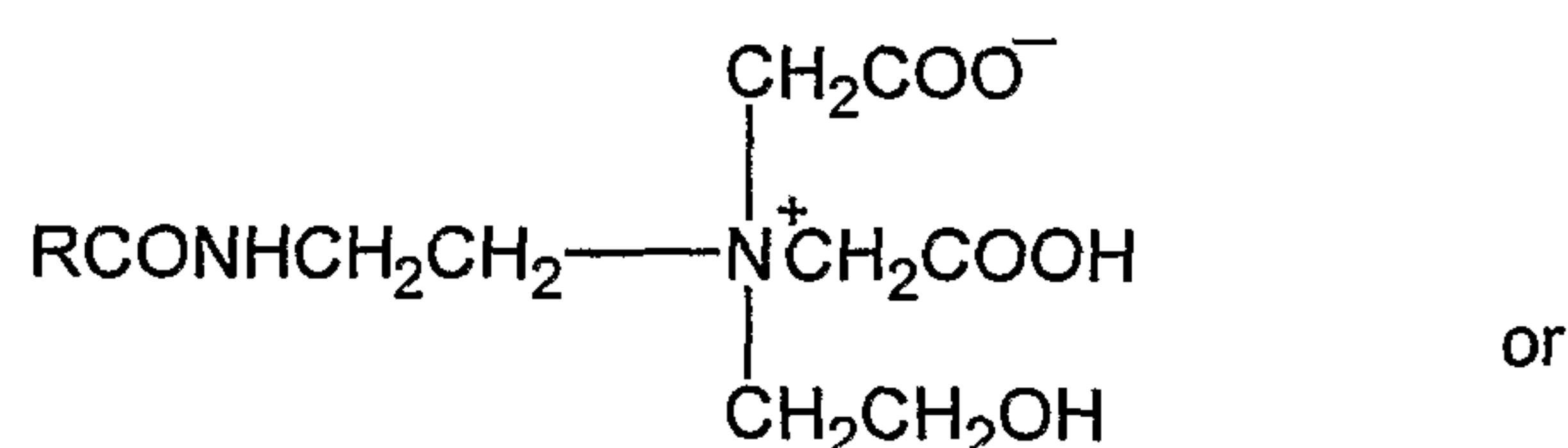
5 Various chemical compounds may be used as the (c) at least one component which may provide irritation mitigating properties selected from the group of amphoteric surfactant, anionic surfactant, and mixtures thereof. It is hypothesized that the presence of at least one amphoteric surfactant, or at least one anionic surfactant, or mixtures thereof function to mitigate the irritation potential of the compositions of which they form a part.

10 Amphoteric surfactants can be used as a component of (c) at least one component having irritation mitigating properties either with or without the anionic surfactant. Exemplary amphoteric surfactants include alkylampho(mono)acetates having the formula



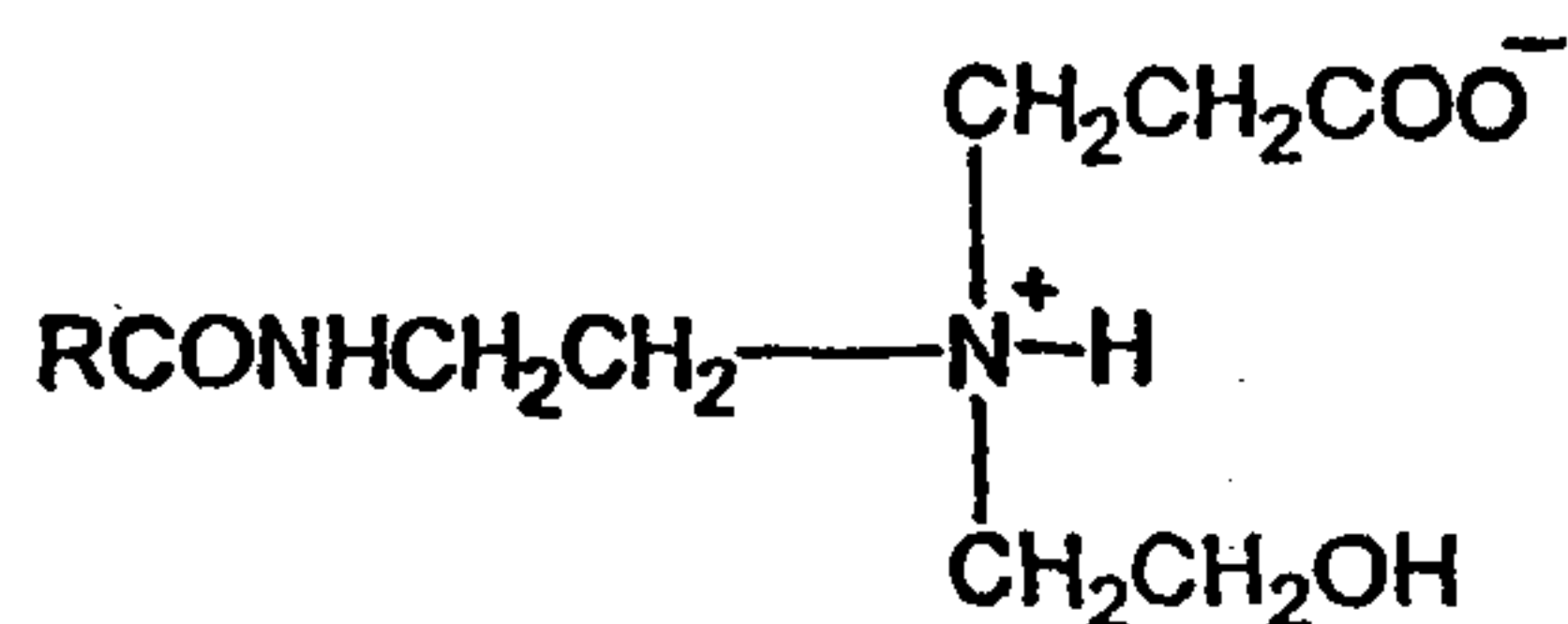
15

as well as one or more alkylampho(di)acetates according to the formula/ae

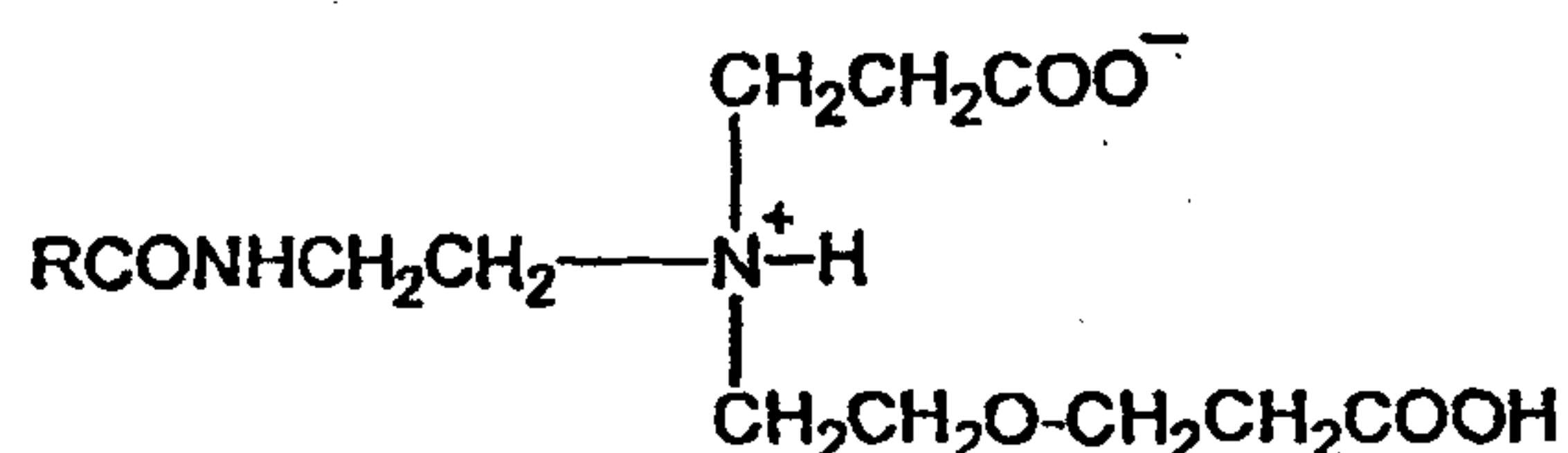
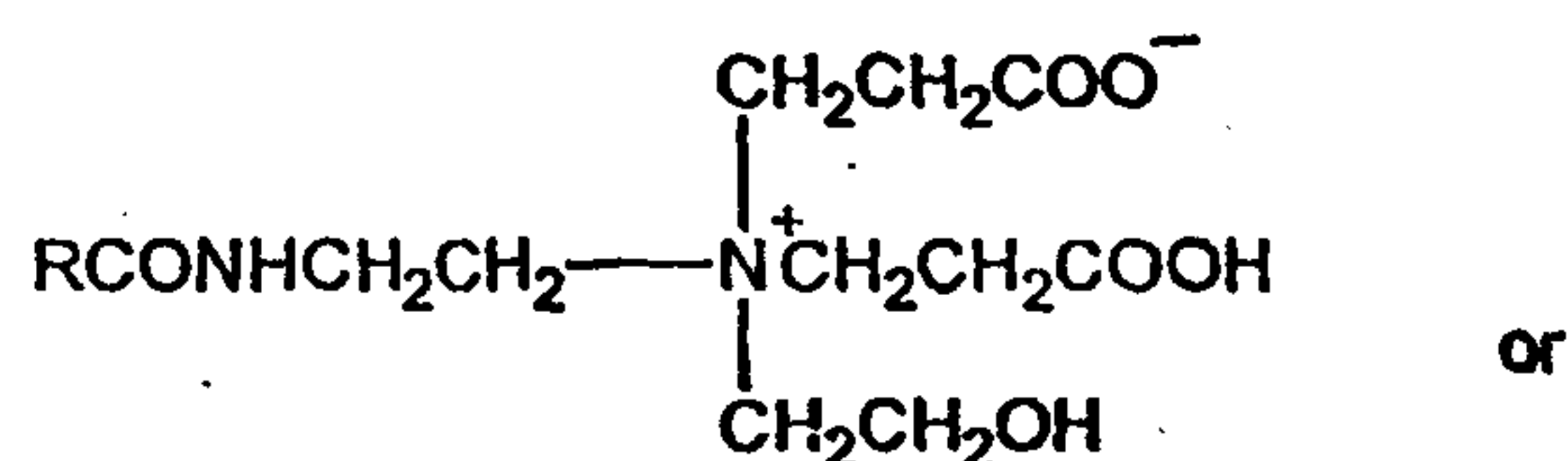


as well as alkylampho(mono)propionates according to the formula

25448-405



as well as one or more alkylampho(di)propionates according to the formula/ae



5

- In the above formulae, R represents a C₈ to C₂₄ alkyl group, and is preferably a C₁₀ to C₁₆ alkyl group. Examples of these amphoteric surfactants can be found under the tradename Miranol from Rhodia (Cranbury, NJ). Some examples include Miranol C2M-Conc. NP, described to be disodium cocoamphodiacetate; Miranol FA-NP, described to be sodium cocoamphotacetate; Miranol DM, described to be sodium steroamphoacetate; Miranol HMA, described to be sodium lauroamphoacetate; Miranol C2M, described to be cocoamphodiprioponic acid; Miranol C2M-SF, described to be disodium cocoamphodipropionate; Miranol CM-SF Conc., described as being
- 10 cocoamphopropionate; MirataineTM H2C-HA, described as sodium lauiminodipropionate; Miranol Ultra L-32, described as sodium lauroamphoacetate; and Miranol Ultra C-37, described as sodium cocoamphoacetate. Other amphoteric surfactants are also available under the tradename Amphoterger from Lonza (Fair Lawn, NJ) such as Amphoterger K described to sodium cocoamphopropionate; Amphoterger K-2, described as disodium
- 15

cocoamphodipropionate; Amphoterger W, described to be sodium cocoamphoacetate; and Amphoterger W-2, described to be disodium cocoamphodiaceate.

Anionic surfactants can be used as a component of (c) at least one component having irritation mitigating properties either with or without the amphoteric surfactant.

5 Examples of anionic surfactants include alcohol sulfates and sulfonates, alcohol phosphates and phosphonates, alkyl ester sulfates, alkyl diphenyl ether sulfonates, alkyl sulfates, alkyl ether sulfates, sulfate esters of an alkylphenoxy polyoxyethylene ethanol, alkyl monoglyceride sulfates, alkyl sulfonates, alkyl ether sulfates, alpha-olefin
10 sulfonates, beta-alkoxy alkane sulfonates, alkyl ether sulfates, ethoxylated alkyl sulfonates, alkylaryl sulfonates, alkylaryl sulfates, alkyl monoglyceride sulfonates, alkyl carboxylates, alkyl ether carboxylates, alkyl alkoxy carboxylates having 1 to 5 moles of ethylene oxide, alkylpolyglycolethersulfates (containing up to 10 moles of ethylene oxide), sulfosuccinates, octoxynol or nonoxynol phosphates, taurates, fatty taurides, fatty acid amide polyoxyethylene sulfates, acyl glycerol sulfonates, fatty oleyl glycerol
15 sulfates, alkyl phenol ethylene oxide ether sulfates, paraffin sulfonates, alkyl phosphates, isethionates, N-acyl taurates, alkyl succinamates and sulfosuccinates, alkylpolysaccharide sulfates, alkylpolyglucoside sulfates, alkyl polyethoxy carboxylates, and sarcosinates or mixtures thereof.

Further examples of anionic surfactants include water soluble salts or acids of the
20 formula $(\text{ROSO}_3)_x\text{M}$ or $(\text{RSO}_3)_x\text{M}$ wherein R is preferably a $\text{C}_6\text{-C}_{24}$ hydrocarbyl; preferably an alkyl or hydroxyalkyl having a $\text{C}_{10}\text{-C}_{20}$ alkyl component, more preferably a $\text{C}_{12}\text{-C}_{18}$ alkyl or hydroxyalkyl, and M is H or a mono-, di- or tri-valent cation, e. g., an alkali metal cation (e. g., sodium, potassium, lithium), or ammonium or substituted ammonium (e. g., methyl-, dimethyl-, and trimethyl ammonium cations and quaternary
25 ammonium cations, such as tetramethyl-ammonium and dimethyl piperdinium cations and quaternary ammonium cations derived from alkylamines such as ethylamine, diethylamine, triethylamine, and mixtures thereof, and the like) and x is an integer, preferably 1 to 3, most preferably 1. Materials sold under the Hostapur and Biosoft trademarks are examples of such anionic surfactants.

30 Further examples of anionic surfactants include alkyl-diphenyl-ethersulphonates and alkyl-carboxylates. Other anionic surfactants can include salts (including, for

25448-405

example, sodium, potassium, ammonium, and substituted ammonium salts such as mono-, di- and triethanolamine salts) of soap, C₆-C₂₀ linear alkylbenzenesulfonates, C₆-C₂₂ primary or secondary alkanesulfonates, C₆-C₂₄ olefinsulfonates, sulfonated polycarboxylic acids prepared by sulfonation of the pyrolyzed product of alkaline earth metal citrates, e. g., as described in British patent specification No. 1,082,179, C₆-C₂₄ alkylpolyglycoethersulfates (containing up to 10 moles of ethylene oxide); alkyl ester sulfates such as C₁₄₋₁₆ methyl ester sulfates; acyl glycerol sulfonates, fatty oleyl glycerol sulfates, alkyl phenol ethylene oxide ether sulfates, paraffin sulfonates, alkyl phosphates, isethionates such as the acyl isethionates, N-acyl taurates, alkyl succinamates and sulfosuccinates, monoesters of sulfosuccinate (especially saturated and unsaturated C₁₂-C₁₈ monoesters) diesters of sulfosuccinate (especially saturated and unsaturated C₆-C₁₄ diesters), acyl sarcosinates, sulfates of alkylpolysaccharides such as the sulfates of alkylpolyglucoside (the nonionic nonsulfated compounds being described below), branched primary alkyl sulfates, alkyl polyethoxy carboxylates such as those of the formula $RO(CH_2CH_2O)_kCH_2COO^-M^+$ wherein R is a C₈-C₂₂ alkyl, k is an integer from 0 to 10, and M is a soluble salt-forming cation. Resin acids and hydrogenated resin acids are also suitable, such as rosin, hydrogenated rosin, and resin acids and hydrogenated resin acids present in or derived from tall oil. Further examples are given in "Surface Active Agents and Detergents" (Vol. I and II by Schwartz, Perry and Berch). A variety of such surfactants are also generally disclosed in U. S. Patent No. 3,929,678 to Laughlin, *et al.* at column 23, line 58 through column 29, line 23.

The inventive compositions comprise (d) at least one electrolyte. The electrolyte(s) are typically alkali and alkali metal salts and include, for example, sodium chloride, sodium carbonate, sodium bicarbonate, sodium citrate, and the like. The amount of electrolyte can range from about 0.01 to about 5.0wt%, preferably are present in amounts of from 0.05 – 5%wt., and most preferably are present in the amounts recited amongst the Examples. The quantity of the electrolyte present in the compositions functions to divide the compositions into at least two phases and it is to be understood that the effective amounts of the electrolyte will depend upon the specific electrolyte used

and upon the identity and quantity of the other constituents present in the inventive compositions.

The inventive compositions optionally comprise (e) optionally, one or more constituents for improving the aesthetic or functional features of the inventive compositions. By way of non-limiting example such further constituents include one or more coloring agents, fragrances and fragrance solubilizers, viscosity modifying agents, other surfactants, pH adjusting agents and pH buffers including organic and inorganic salts, optical brighteners, opacifying agents, hydrotropes, antifoaming agents, enzymes, anti-spotting agents, anti-oxidants, preservatives, and anti-corrosion agents. When one or more of the optional constituents is added, i.e., fragrance and/or coloring agents, the esthetic and consumer appeal of the product is often favorably improved. The use and selection of these optional constituents is well known to those of ordinary skill in the art. When present, the one or more optional constituents present in the inventive compositions do not exceed about 10%wt., preferably do not exceed 5%wt.

Where the inventive compositions are to be used in conjunction wherein they are to be sprayed, particularly by use of manually operable trigger spray device, the inventors have found that the inclusion of one or more organic solvents may be beneficial. By way of non-limiting example exemplary useful organic solvents which may optionally be included in the inventive compositions include those which are at least partially water-miscible such as alcohols (e.g., low molecular weight alcohols, such as, for example, ethanol, propanol, isopropanol, and the like), glycols (such as, for example, ethylene glycol, propylene glycol, hexylene glycol, and the like), water-miscible ethers (e.g. diethylene glycol diethylether, diethylene glycol dimethylether, propylene glycol dimethylether), water-miscible glycol ether (e.g. propylene glycol monomethylether, propylene glycol monoethylether, propylene glycol monopropylether, propylene glycol monobutylether, ethylene glycol monobutylether, dipropylene glycol monomethylether, diethyleneglycol monobutylether), lower esters of monoalkylethers of ethylene glycol or propylene glycol (e.g. propylene glycol monomethyl ether acetate), and mixtures thereof. Glycol ethers having the general structure R_a-R_b-OH , wherein R_a is an alkoxy of 1 to 20 carbon atoms, or aryloxy of at least 6 carbon atoms, and R_b is an ether condensate of propylene glycol

and/or ethylene glycol having from one to ten glycol monomer units. Of course, mixtures of two or more organic solvents may be used in the organic solvent constituent.

The inventive compositions are largely aqueous in nature and the remaining balance of the compositions is water. Water is added to order to provide to 100% by weight of the compositions of the invention. The water may be tap water, but is preferably distilled and is most preferably deionized water. If the water is tap water, it is preferably substantially free of any undesirable impurities such as organics or inorganics, especially minerals salts which are present in hard water which may thus undesirably interfere with the operation of the constituents present in the aqueous compositions according to the invention.

The inventive compositions may be produced according to any of a number of methods. In general terms, the components can be added in any order although it may be preferred to add first the water, then the cationic and nonionic surfactant(s), then any dye and/or fragrance, and finally the electrolyte(s). Alternatively, components forming the upper layer can be mixed as one admixture and the components forming the lower layer can be mixed as another admixture and then the two admixtures can be added to one container to form the biphasic system. Thus, for example, a first premix can be made containing, for example, amphoteric surfactant, a majority of at least one cationic surfactant having germicidal properties, a majority of the nonionic surfactant, dye (if desired), fragrance (if desired), and water. A second premix can be made containing at least one electrolyte, a very minor portion of at least one cationic surfactant having germicidal properties, a very minor portion of nonionic surfactant, and water. Thereafter the first and second premixes may be combined to form the inventive compositions.

The compositions of the present invention can be used as a ready to use composition, supplied in a pour bottle or trigger bottle having a trigger pump spray device (in either use, a suitable container containing an amount of the two phase composition is first shaken to intermix the two layers and then the intermixed composition is then ready for use, either pouring on a surface and wiping, spraying on a surface and wiping, pouring on a wipe and then wiping a surface or spraying on a wipe and then wiping the surface) or can be supplied as a concentrate suitable for dilution in a larger container of water (after the concentrate is shaken to temporarily intermix the two

25448-405

layers). The compositions of the present invention will have good cleaning properties against dirt and stains commonly found in household, commercial and residential settings.

5

Examples

Various examples of the compositions of the present invention, including certain particularly preferred compositions are described below in Table 1. The individual constituents were used "as supplied" commercially, and identified by both tradename (as appropriate) and with the weigh percentage actives in the commercial preparation of the constituent in following parenthesis; no reported weight percentages are to understood as representing 100%wt. of the named constituent.

Table 1								
	Ex. 1	Ex. 2	Ex. 3	Ex. 4	Ex. 5	Ex. 6	Ex. 7	Ex. 8
Components (% active)	Wt%	Wt%	Wt%	Wt%	Wt%	Wt%	Wt%	Wt%
Stepanate™ SXS (40%) ¹	1.00	1.00	1.00	1.00	1.00	0.60	0.00	1.00
BTC 8358 (80%) ²	2.00	2.00	2.00	2.00	2.00	1.50	1.50	2.00
BTC 1010 (50%) ³	-	-	-	-	1.00	-	-	2.00
Bardac™ 2250 (50%) ⁴	-	-	-	1.00	-	1.80	2.00	-
Tomadol™ 45-7 ⁵	2.00	-	1.50	1.50	1.50	1.50	1.50	1.20
Alfonic™ 810-4.5 ⁶	-	1.50	-	-	-	-	-	-
NaCl ⁷	0.30	0.20	-	0.40	0.40	0.15	1.50	0.10
Na Citrate ⁸	-	-	7.00	-	-	2.00	-	-
Na ₂ CO ₃ ⁹	0.30	0.20	-	0.80	0.80	-	1.00	0.80
NaHCO ₃ ¹⁰	1.80	1.00	-	0.30	0.30	1.50	1.00	0.80
Dye (1% aqueous soln.)	0.20	0.50	0.30	0.30	0.30	0.30	0.30	0.30
Fragrance	0.30	0.30	0.30	0.30	0.30	0.30	0.30	0.30
DI Water	92.10	93.30	87.90	92.40	92.40	90.35	90.90	91.50
Separation starts (minutes)	~20	~10	1-2	1-2	1-2	2-3	~8	~15
Upper layer at RT	80%	30%	40%	40%	30%	40%	52%	60%
Upper layer at 120°F overnight	—*	—	21%	40%	30%	30%	33%	61%

25448-405

Table 1								
	Ex. 9	Ex. 10	Ex. 11	Ex. 12	Ex. 13	Ex. 14	Ex. 15	Ex. 16
Components (% active)	Wt%	Wt%	Wt%	Wt%	Wt%	Wt%	Wt%	Wt%
Miranol Ultra L-32 (32%) ¹¹	1.50	2.00	-	-	-	2.20	2.20	2.00
Miranol C2M NP (40%) ¹²	-	-	2.00	2.00	2.00	-	-	
BTC 8358 (80%)	2.00	0.50	0.80	0.50	0.52	0.65	0.60	0.50
BTC 1010 (50%)	2.00	2.40	2.00	2.40	2.40	2.40	2.40	2.40
Tomadol 45-7	1.00	-	1.00	-	-	-	-	
Genapol™ 26-L-50 ¹³	-	-	-	0.40	1.20	-	1.20	
Genapol 26-L-60 ¹⁴	-	1.20	-	0.80	-	1.20	-	
Genapol 26-L-80 ¹⁶								1.20
NaCl	0.80	-	0.10	0.26	0.26	0.25	0.19	0.20
Na Citrate	-	0.35	-	-	-	-	-	
Na ₂ CO ₃	1.20	-	1.00	-	-	-	-	
NaHCO ₃	1.20	-	-	-	-	-	-	
Dye (1% aqueous soln.)	0.30	0.30	0.30	0.28	0.28	0.28	0.28	0.28
Fragrance	0.30	0.30	0.30	0.30	0.30	0.30	0.30	0.30
DI Water	89.70	92.95	92.50	93.06	93.04	92.72	92.83	93.12
Separation starts (minutes)	~5	~5	1-2	-	1-2	1-2	1-2	-
Upper layer at RT	54%	56%	42%	44%	41%	48%	43%	38%
Upper layer at 120°F overnight	39%	26%	26%	35%	35%	42%	40%	36%

Table 1								
	Ex. 17	Ex. 18	Ex. 19	Ex. 20	Ex. 21	Ex. 22	Ex. 23	Ex. 24
Components (% active)	Wt%	Wt%	Wt%	Wt%	Wt%	Wt%	Wt%	Wt%
Miranol Ultra L-32 (32%)	1.76	1.76	1.60	1.00	1.00	1.00	0.80	2.00
BTC 8358 (80%)	0.48	0.48	0.43	0.40	0.40	0.40	0.40	0.50
BTC 1010 (50%)	1.92	1.92	1.73	1.80	2.00	2.20	2.10	2.40
Genapol 26-L-50								0.40
Genapol 26-L-60	-	1.00	-	-	-	-	-	
Genapol 26-L-80	1.00	-	1.00	-	-	-	-	0.80
Unitol™ L/80 ¹⁶	-	-	-	1.20	1.20	1.05	1.05	
NaCl	0.40	0.19	0.44	0.70	0.64	0.50	0.72	0.20
Dye (1% aqueous soln.)	0.20	0.20	0.20	0.08	0.23	0.23	0.23	0.28
Fragrance	0.28	0.28	0.28	0.28	0.28	0.28	0.28	0.30
DI Water	93.96	94.17	94.32	94.54	94.25	94.34	94.42	93.12
Separation starts (minutes)	~ 10	~10	15	-	-	-	-	-
Upper layer at RT	38%	44%	37%	48%	46%	43%	38%	43%
Upper layer at 120°F overnight	30%	40%	26%	24%	29%	43%	39%	41%

Table 1						
	Ex. 25	Ex. 26	Ex. 27	Ex. 28	Ex. 29	Ex. 30
Components (% active)	Wt%	Wt%	Wt%	Wt%	Wt%	Wt%
Miranol Ultra L-32 (32%)	2.20	2.20	2.20	2.20	1.50	1.50
BTC 8358 (80%)	0.60	0.85	0.60	0.60	1.00	1.00
BTC 1010 (50%)	2.00	1.80	1.60	1.80	1.20	1.20
Genapol 26-L-50	1.50	1.50	1.50	1.50	--	--
Unitol L/80 ¹⁶	--	--	--	--	1.00	1.00
NaCl	0.19	0.38	0.16	0.18	1.20	1.80
Dye (1% aqueous soln.)	0.28	0.28	0.28	0.28	0.22	0.16
Fragrance	0.30	0.30	0.30	0.30	0.28	0.28
DI Water	92.93	92.69	93.36	93.14	93.60	93.06
Separation starts (minutes)	--	--	--	--	--	--
Upper layer at RT	49%	51%	49%	48%	--	37%
Upper layer at 120°F overnight	30%	29%	27%	29%	--	20%

"RT" indicates room temperature, (approx. 68°F, 20°C)

* "--" indicates not evaluated, or not present in the formulation

- 5 ¹ sodium xylene sulfonate (ex. Stepan)
- ² n-alkyl dimethyl benzyl ammonium chloride (n-alkyl: 50% C₁₄; 40% C₁₂; 10% C₁₆; (ex. Stepan)
- ³ didecyl dimethyl ammonium chloride (ex. Stepan)
- ⁴ didecyl dimethyl ammonium chloride (ex. Lonza)
- 10 ⁵ linear C₁₄₋₁₅ alcohol with 7 moles (average) of ethylene oxide (ex. Tomah)
- ⁶ C₈-C₁₀ straight-chain alcohols ethoxylated with about 4.85 moles of ethylene oxide (ex. Sasol)
- ⁷ sodium chloride
- ⁸ sodium citrate
- 15 ⁹ sodium carbonate
- ¹⁰ sodium bicarbonate
- ¹¹ sodium lauroamphoacetate (ex. Rhodia)
- ¹² disodium cocoamphodiacetate (ex. Rhodia)
- ¹³ linear alcohol ethoxylate (ex. Clariant)
- 20 ¹⁴ linear alcohol ethoxylate (ex. Clariant)
- ¹⁵ linear alcohol ethoxylate (ex. Clariant)
- ¹⁶ ethoxylated lauryl alcohol (ex. Oxiteno)

25 Further examples of compositions of the present invention which are particularly suited for being dispensed in a ready to use form from a spray dispenser, such as a trigger spray container, including certain particularly preferred compositions are described below in Table 2. Further constituents present in the compositions according to Table 2, not previously described with reference to Table 1 are described following Table 2.

25448-405

Table 2								
	Ex. 31	Ex. 32	Ex. 33	Ex. 34	Ex. 35	Ex. 36	Ex. 37	Ex. 38
Components (% active)	Wt%	Wt%	Wt%	Wt%	Wt%	Wt%	Wt%	Wt%
Rhodapon™ BOS ¹⁷ (40%)	0.84	—	0.93	0.81	0.88	0.86	0.82	—
Hostapur™ SAS ¹⁸ (60%)	—	0.70	—	—	—	—	—	—
Stepanate SXS ¹⁹ (40%)	0.26	0.29	—	—	—	—	—	—
Biosoft™ D40 ²⁰ (40%)	—	—	—	—	—	—	—	1.25
BTC 8358 (80%)	0.40	0.40	0.40	0.40	0.40	0.40	0.30	0.30
BTC 1010 (50%)	2.0	2.0	2.0	1.5	1.5	1.5	2.2	2.2
Genapol 26-L-50	0.5	0.5	0.5	0.5	0.55	0.55	0.30	0.30
Dowanol PnB ²¹	—	—	0.5	0.5	—	—	—	—
Na citrate	0.40	0.4	0.7	0.7	0.55	0.60	0.55	0.55
citric acid	1.5	1.5	1.8	2.0	1.8	1.8	1.8	1.8
Dye (1%)	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25
Fragrance	0.22	0.22	0.22	0.22	0.22	0.22	0.28	0.28
DI Water	93.63	93.74	92.70	93.12	93.85	93.82	93.50	93.07
Separation starts (minutes)	—	—	—	—	—	30	—	—
Upper layer at RT	37%	45%	55%	49%	84%	64%	38%	40%
Upper layer at 120°F overnight	23%	25%	—	22%	—	22%	27%	—

Table 2						
	Ex. 39	Ex. 40	Ex. 41	Ex. 42	Ex. 43	Ex. 44
Components (% active)	Wt%	Wt%	Wt%	Wt%	Wt%	Wt%
Rhodapon BOS (40%)	0.86	0.86	0.86	0.98	—	0.85
Hostapur SAS (60%)	—	—	—	—	—	—
Stepanate SXS (40%)	—	—	—	—	1.0	0.26
Biosoft D40 (40%)	—	—	—	—	1.5	—
BTC 8358 (80%)	0.3	0.3	0.4	0.4	0.4	0.4
BTC 1010 (50%)	2.2	2.2	1.5	2.0	2.0	2.0
Genapol 26-L-50	0.3	0.3	0.4	0.4	0.4	0.4
Dowanol PnB	—	—	—	—	—	—
Na citrate	0.55	0.55	0.7	0.7	0.7	0.4
citric acid	1.8	1.8	2.2	1.8	1.8	1.8
Dye (1% aqueous soln.)	0.25	0.25	0.20	0.25	0.25	0.25
Fragrance	0.25	0.22	0.22	0.22	0.22	0.22
DI Water	93.49	93.52	93.42	93.15	91.63	93.32
Separation starts (minutes)	—	20	—	12	—	—
Upper layer at RT	35%	50%	41%	45%	10%	37%
Upper layer at 120°F overnight	—	—	18%	20%	10%	23%

¹⁷ sodium alkane sulfonate5 ¹⁹ sodium xylene sulfonate²⁰ linear alkylbenzene sulfonate, sodium (Stepan)²¹ propylene glycol n-butyl ether (DOW)

25448-405

Cleaning Efficacy

Certain of the compositions indicated above were diluted with water at a respective weight ratio of composition:water of 1:64. These diluted compositions were then subjected to the protocol of ASTM D-4488-89 Annex A5 for particulate soil, which evaluated the efficacy of the cleaning compositions on vinyl tile samples. The soil applied was a particulate soil sample containing natural humus, paraffin oil, used crankcase motor oil, Portland cement, silica, lampblack carbon, iron oxide, bandy black clay, stearic acid, and oleic acid. produced according to the protocol. Each of the soiled test vinyl tile samples were placed into the apparatus and the center of each tile was wetted with a 20 milliliter sample of a test formulation and allowed to stand for 1 minute. When approximately 30 seconds had elapsed, a further 50 milliliter sample was applied to the sponge (water dampened, then wrung to remove excess water) of a Gardner Abrasion Tester apparatus. Thereafter the apparatus was cycled 10 times, which provided 20 strokes of the sponge across the face of each of the vinyl test tiles. Each test was replicated three times using three vinyl tile samples. The reflectance values of the cleaned samples were evaluated utilizing a Minolta Chroma Meter CF-110, with Data Processor DP-100, which evaluated spectrophotomic characteristics of the sample. The results are shown on the following Table.

20

	Dilution	Soil Removal %	+ Δ %
Ex. 15	1:16	73.90	14.60
Ex. 15	1:64	49.40	12.90
PineSol™	1:64	57.71	8.33
Mr Clean™	1:64	47.50	23.40

The composition according to Ex. 29 described on Table 1 was evaluated for cleaning efficacy of greasy soils in accordance with the testing protocol outlined according to ASTM D4488 A2 Test Method, which evaluated the efficacy of the cleaning compositions on masonite wallboard samples painted with wall paint. The soil applied was a greasy soil sample containing vegetable oil, food shortening and animal fat. The sponge (water dampened) of a Gardner Abrasion Tester apparatus was squirted with a 15 gram sample of a tested cleaning composition, and the apparatus was cycled 10 times.

25

The evaluation of cleaning compositions was “paired” with one side of each of the test samples treated with a composition according to the invention, and the other side of the same sample treated with a comparative example’s composition, thus allowing a “side-by-side” comparison to be made. The cleaning efficacy of the tested compositions was evaluated utilizing a Minolta Chroma Meter CF-110, with Data Processor DP-100, which evaluated spectrophotometric characteristics of the sample. The results are reported on the following Table. Each of the tested formulations on the following tables were evaluated without further dilution with water.

	Dilution	Soil Removal %	±Δ%
Ex. 29	none	73.96	1.20
Practice 2 in 1 trigger spray (ex. Bom Bril (Brazil))	none	74.86	2.26
Ex. 29	none	72.58	1.78
Bref 2 in 1 trigger spray (ex. Henkel (Brazil))	none	71.14	2.07

10

Antimicrobial Efficacy

Certain of the compositions of the present invention exhibited good antimicrobial activity as evaluated using the AOAC Use Dilution Testing protocol.

Table 3		
	Organism	Results
Ex. 8 - dilution 1:64		
	<i>Staphylococcus aureus</i>	0/10
	<i>Salmonella</i>	1/10
	<i>Psuedomonas</i>	0/10
Ex. 9 - dilution 1:64		
	<i>Staphylococcus aureus</i>	1/10
	<i>Salmonella</i>	0/10
	<i>Psuedomonas</i>	1/10
Ex. 13 - dilution 1:16		
	<i>Staphylococcus aureus</i>	0/10
	<i>Salmonella</i>	0/10
	<i>Psuedomonas</i>	1/10
Ex. 14 - dilution 1:16		
	<i>Staphylococcus aureus</i>	0/10
	<i>Salmonella</i>	0/10
	<i>Psuedomonas</i>	1/10
Ex. 15 - dilution 1:16		
	<i>Staphylococcus aureus</i>	0/10

	<i>Salmonella</i>	0/10
	<i>Psuedomonas</i>	2/10
Ex. 25 - dilution 1:16		
	<i>Staphylococcus aureus</i>	0/10
	<i>Salmonella</i>	0/10
	<i>Psuedomonas</i>	0/10
Ex. 26 - dilution 1:16		
	<i>Staphylococcus aureus</i>	0/9
	<i>Salmonella</i>	0/10
	<i>Psuedomonas</i>	0/10
Ex. 27 - dilution 1:16		
	<i>Staphylococcus aureus</i>	0/10
	<i>Salmonella</i>	0/10
	<i>Psuedomonas</i>	0/9
Ex. 28 - dilution 1:16		
	<i>Staphylococcus aureus</i>	0/10
	<i>Salmonella</i>	0/10
	<i>Psuedomonas</i>	0/9

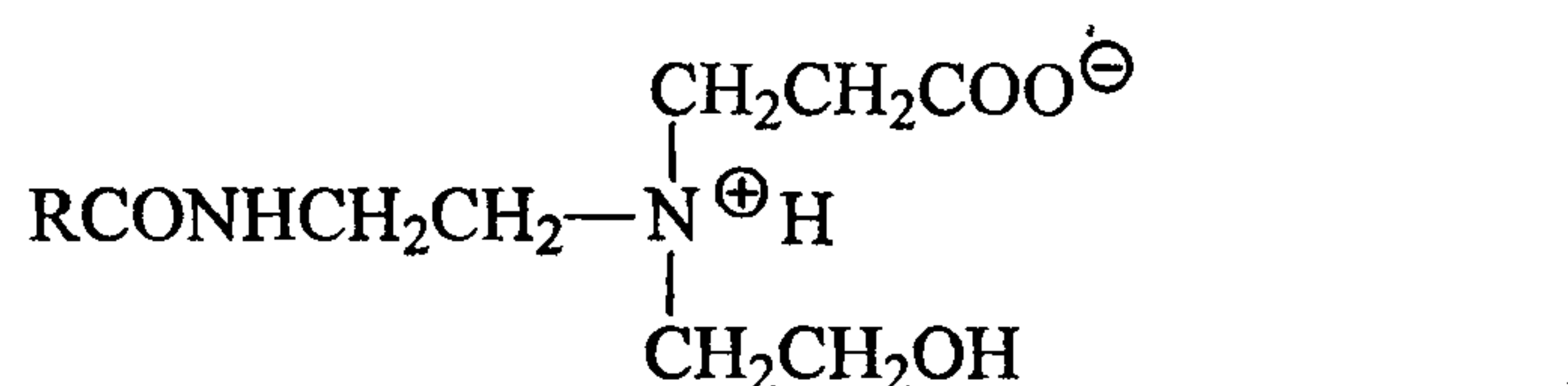
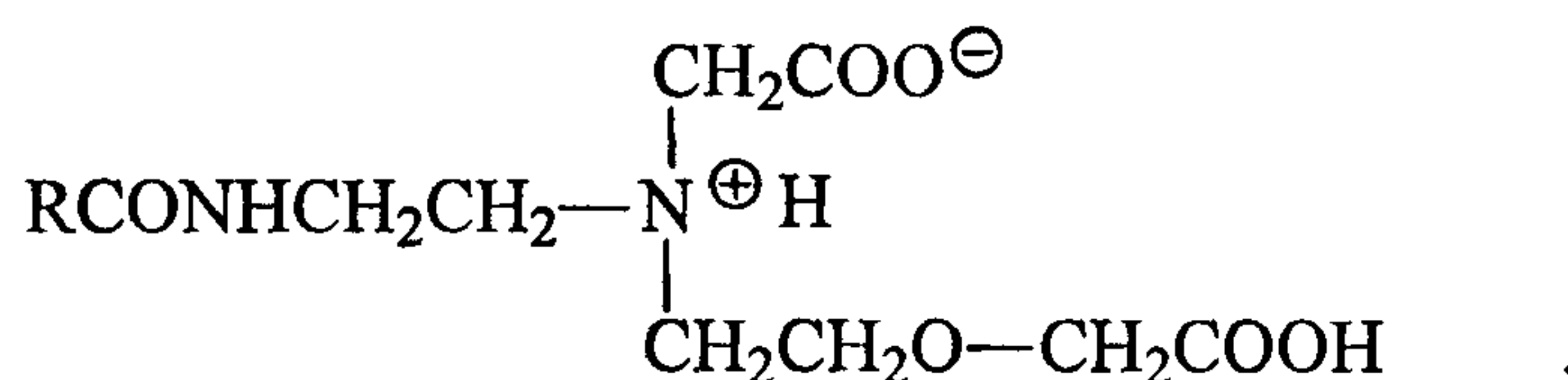
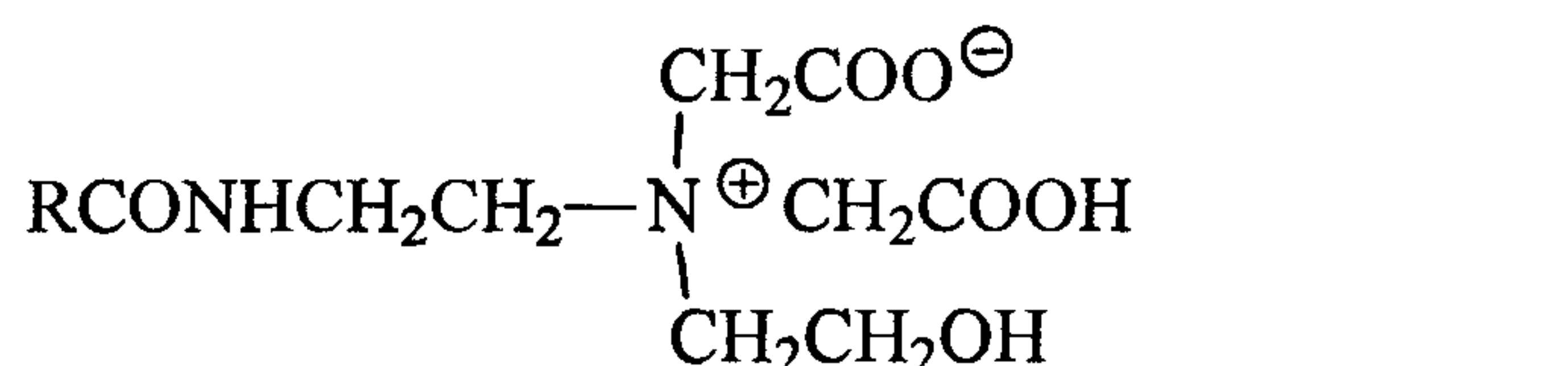
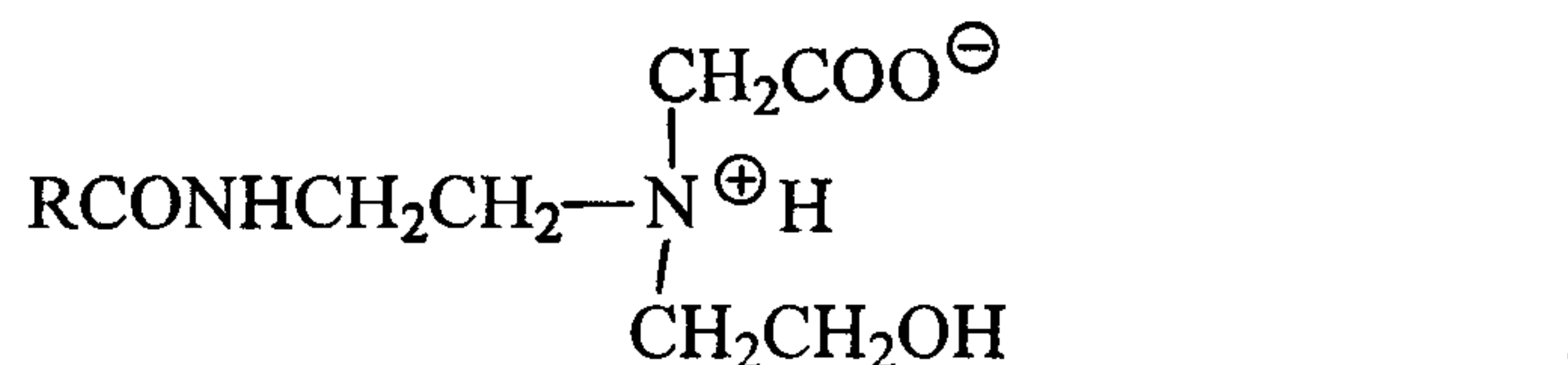
While the invention is susceptible of various modifications and alternative forms, it is to be understood that specific embodiments thereof have been shown by way of example in the drawings which are not intended to limit the invention to the particular forms disclosed; on the contrary the intention is to cover all modifications, equivalents and alternatives falling within the scope and spirit of the invention as expressed in the appended claims.

25448-405

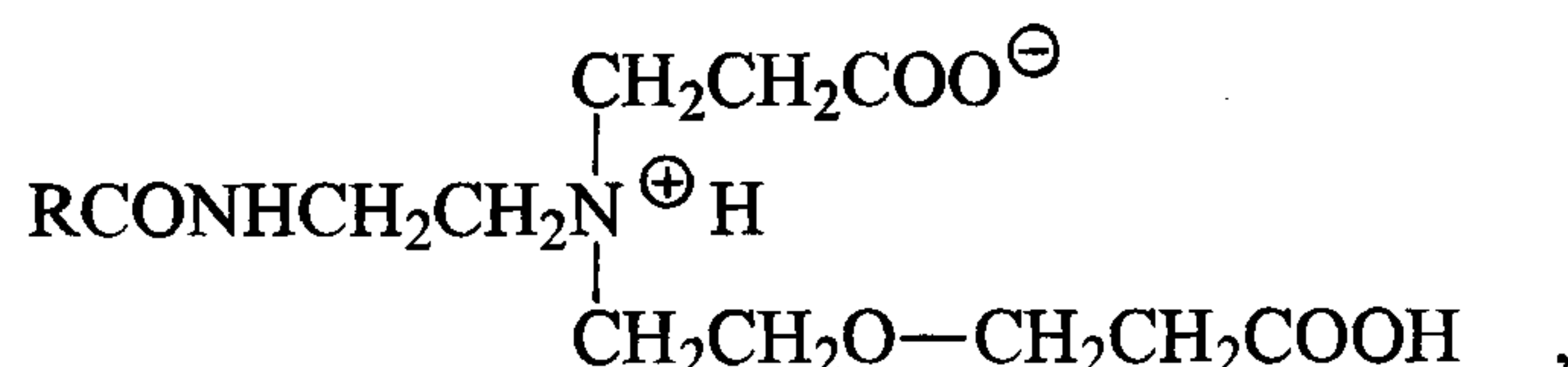
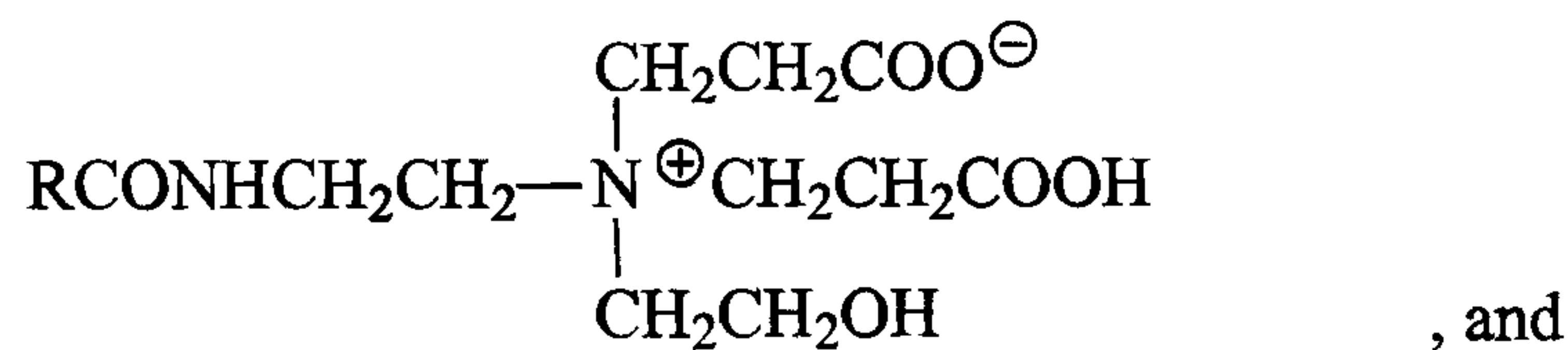
CLAIMS:

1. A composition which separates into at least two aqueous phases upon standing comprising:

- (a) 0.01 - 10%wt. of at least one cationic surfactant having
5 germicidal properties;
- (b) 0.1 - 10%wt. of at least one nonionic surfactant;
- (c) 0.1 - 10%wt. at least one component having irritation mitigating properties comprising one or more amphoteric surfactants selected from the group of compounds having the formulas



25448-405



wherein R is C₈ to C₂₄ alkyl, optionally with one or more anionic surfactants;

5 (d) at least one electrolyte;

(e) optionally, one or more constituents for improving the aesthetic or functional features of the composition;

and the remainder water.

2. The composition according to claim 1 wherein in excess of 50%wt.
10 of the (a) at least one cationic surfactant having germicidal properties is found in the upper aqueous phase.

3. The composition according to claim 1 wherein in excess of 50%wt. of the (c) at least one component having irritation mitigating properties is found in the upper aqueous phase.

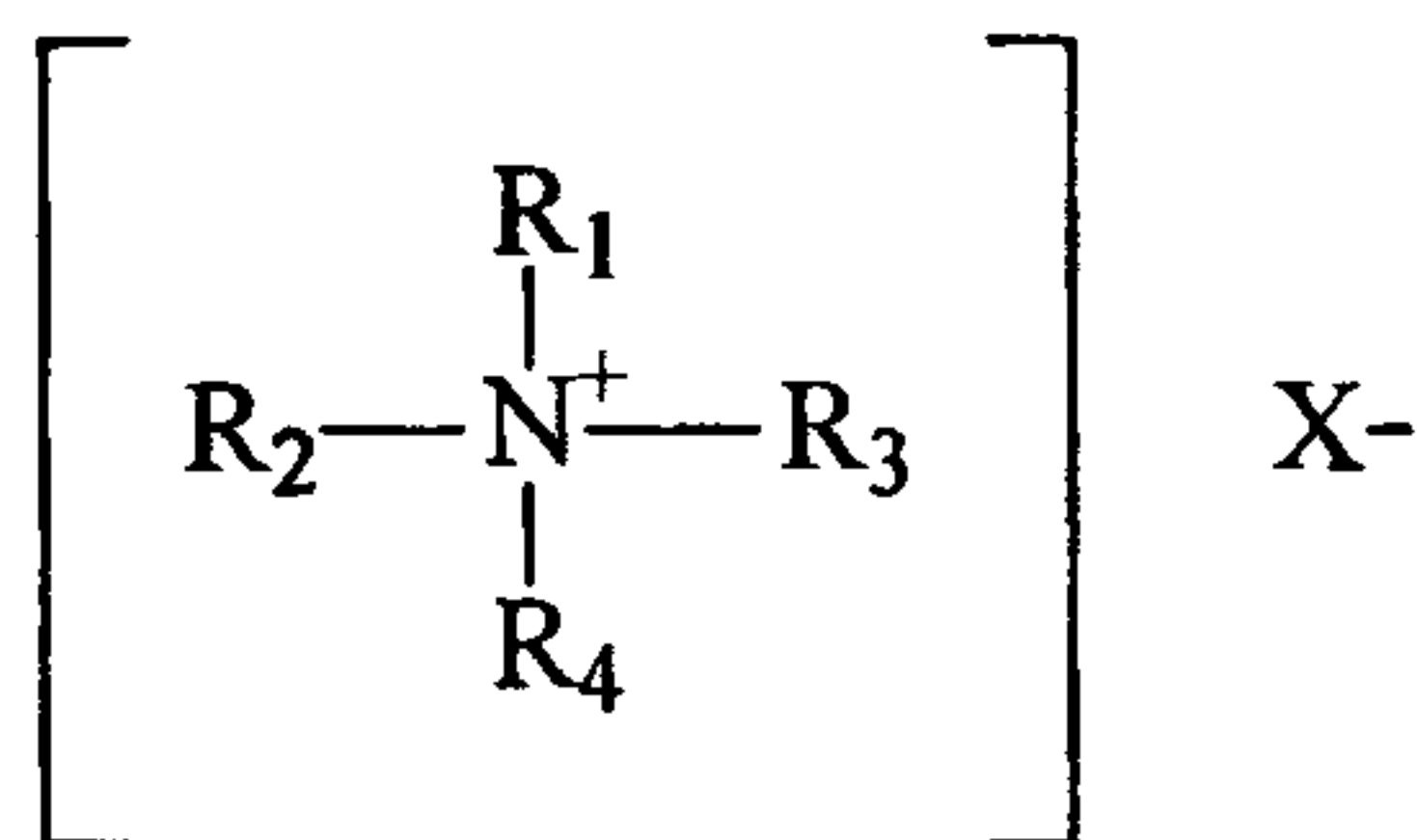
15 4. The composition according to claim 1 wherein the (d) at least one electrolyte is present in an amount of from about 0.01 to about 5.0wt%.

5. The composition according to claim 1 wherein the (c) at least one component having irritation mitigating properties further comprises an anionic surfactant.

25448-405

6. The composition according to claim 5 wherein the anionic surfactant is selected from: sodium alkane sulfonate, sodium xylene sulfonate, alkyl benzene sulfonate, salts thereof, and mixtures thereof.

7. The composition according to claim 1 wherein the (a) at least one
5 cationic surfactant having germicidal properties has the formula



wherein R_1 , R_2 , R_3 and R_4 are independently a branched or straight-chained hydrocarbon, amide, ether or ester group and wherein at least one of R_1 , R_2 , R_3 and R_4 is an alkyl, aryl or alkylaryl substituent of from 6 to 26 carbon
10 atoms, X is an anion and the entire cation portion of the molecule has a molecular weight of at least 165.

8. The composition according to claim 1 wherein (a) comprises two cationic surfactants having germicidal properties.

9. The composition according to claim 1 containing (e) at least one
15 constituent for improving the aesthetic or functional features of the composition selected from coloring agents, fragrances and fragrance solubilizers, viscosity modifying agents, other surfactants, pH adjusting agents and pH buffers, optical brighteners, opacifying agents, hydrotropes, antifoaming agents, enzymes, anti-spotting agents, anti-oxidants, preservatives, and anti-corrosion agents.

20 10. The composition according to claim 9 wherein the pH adjusting agents and pH buffers comprise organic salts or inorganic salts.