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(54) **Titre : COMPOSITION D'HUILE LUBRIFIANTE COMPRENANT UN PRODUIT DE REACTION DE COPOLYMER DE
POLYETHER**

(54) **Title: LUBRICATING OIL COMPOSITION COMPRISING A COPOLYMER-POLYETHER REACTION PRODUCT**

(57) **Abrégé/Abstract:**

An oil-soluble lubricating oil additive composition prepared by the process which comprises reacting a copolymer, with at least one polyether aromatic compound.



ABSTRACT OF THE DISCLOSURE

An oil-soluble lubricating oil additive composition prepared by the process which comprises reacting a copolymer, with at least one polyether aromatic compound.

LUBRICATING OIL COMPOSITION COMPRISING A COPOLYMER-POLYETHER REACTION PRODUCT

FIELD OF THE INVENTION

5 The present invention is directed to an improved dispersant additive composition that is used in engine oils; and it is also directed to the process of making the same.

BACKGROUND OF THE INVENTION

It is known to employ nitrogen containing dispersants and/or detergents in the
10 formulation of lubricating oil compositions. Many of the known dispersant/detergent compounds are based on the reaction of an alkenylsuccinic acid or anhydride with an amine or polyamine to produce an alkenylsuccinimide or an alkenyl succinamic acid as determined by selected conditions of reaction. One problem facing the lubricant manufacturer is dispersancy of particulate matter in internal combustion engines.
15 Failure to have adequate particulate matter dispersancy may result in filter plugging, sludge accumulation, and oil thickening.

DESCRIPTION OF THE RELATED ART

Liu et al., U.S. Patent No. 6,117,825, discloses a lubricating oil composition that
20 comprises a major amount of an oil of lubricating viscosity; and a minor amount of a synergistic combination of an antioxidant-dispersant additive and a dispersant additive, said combination comprising: (i) a polyisobutylene succinimide (PIBSAD) and (ii) an ethylene-propylene succinimide (LEPSAD).

25 Nalesnik, U.S. Patent No. 5,139,688, discloses an additive composition comprising an oxidized ethylene copolymer or terpolymer of a C₃-C₁₀ alpha-monoolefin and, optionally, a non-conjugated diene or triene which has been reacted with a formaldehyde compound and with an amino-aromatic polyamine compound.

30 Günther et al., U.S Patent No. 6,512,055, discloses a copolymer obtained by free radical copolymerization of at least one monoethylenically unsaturated C₄-C₆ dicarboxylic acid or anhydride thereof, an oligomer, and one monoethylenically unsaturated compound.

Günther et al., U.S. Patent No. 6,284,716, discloses a lubricating oil composition comprising a lubricant oil and a copolymer obtained by free radical copolymerization of at least one monoethylenically unsaturated C₄-C₆ dicarboxylic acid or anhydride thereof, an oligomer, and one monoethylenically unsaturated compound, wherein the
5 copolymer is further reacted with an amine.

Harrison et al., U.S. Patent No. 5,792,729, discloses a dispersant terpolymer and polysuccinimide compositions derived from the terpolymers. The terpolymer is
10 obtained by free radical copolymerization of an unsaturated acidic reagent, a 1-olefin, and a 1,1-disubstituted olefin in the presence of a free radical initiator.

Barr et al., U.S. Patent No. 5,670,462, discloses a lubricating oil additive composition that is the reaction product of (i) a copolymerized olefin and unsaturated carboxylic
15 acylating agent monomer with a free radical initiator and (ii) a succinimide prepared from an acyclic hydrocarbyl substituted succinic acylating agent and a polyamine wherein the hydrocarbyl substituted succinic acylating agent is prepared by reacting a polyolefin and an acylating agent under conditions such that at least 75 mole % of the starting polyolefin is converted to the hydrocarbyl-substituted succinic acylating
20 agent.

Harrison et al., U.S. Patent No. 6,451,920, discloses copolymerizing a polyalkene and an unsaturated acidic reagent, followed by reacting any unreacted polyalkene with the unsaturated acidic reagent at elevated temperatures in the presence of a strong acid.
25

Chung et al., U.S. Patent Nos. 5,427,702 and 5,744,429, disclose a mixture of derivatized ethylene-alpha olefin copolymers, wherein functional groups are grafted onto the copolymer. The functionalized copolymer is mixed with at least one of an amine, alcohol, including polyol, amino alcohol etc. to form multi-functional viscosity
30 index improver additive components.

Harrison et al., U.S. Patent No. 5,112,507, discloses novel copolymers of unsaturated acidic reactants and high molecular weight olefins wherein at least 20% of the total

high molecular weight olefin comprises the alkylvinylidene isomer which copolymers are useful as dispersants in lubricating oils and fuels and also may be used to prepare polysuccinimides and other post-treated additives useful in lubricating oils and fuels.

5

SUMMARY OF THE INVENTION

In its broadest embodiment, the present invention is directed to an oil-soluble lubricating oil additive composition prepared by the process which comprises reacting

(A) at least one of the following copolymers:

10

(i) a copolymer obtained by free radical copolymerization of components comprising:

15

(a) at least one monoethylenically unsaturated C₃-C₂₈ monocarboxylic acid or ester thereof, or C₄-C₂₈ dicarboxylic acid, anhydride or ester thereof;

20

(b) at least one 1-olefin comprising about 2 to 40 carbon atoms or at least one polyolefin comprising about 4 to 360 carbon atoms and having a terminal copolymerizable group in the form of a vinyl, vinylidene or alkyl vinylidene group or mixtures thereof; and

25

(c) at least one monoolefin compound which is copolymerizable with the monomers of (a) and (b) and is selected from the group consisting of:

30

(1) an alkyl vinyl ether and an allyl alkyl ether where the alkyl group is hydroxyl, amino, dialkylamino or alkoxy substituted or is unsubstituted, and containing from about 1 to about 40 carbon atoms;

- 5
- (2) an alkyl amine and an N-alkylamide of a monoethylenically unsaturated mono- or dicarboxylic acid of from about 3 to about 10 carbon atoms where the alkyl substituent contains from about 1 to about 40 carbon atoms;
- (3) an N-vinylcarboxamide of carboxylic acids of from about 1 to about 8 carbon atoms;
- 10
- (4) an N-vinyl substituted nitrogen-containing heterocyclic compound; and
- 15
- (5) at least one 1-olefin comprising from about 2 to about 40 carbon atoms or at least one polyolefin comprising from about 4 to about 360 carbon atoms and having a terminal copolymerizable group in the form of a vinyl, vinylidene or alkyl vinylidene group or mixtures thereof, provided that the olefin employed is not the same as the olefin employed in (i)(b);
- 20
- (ii) a copolymer obtained by reacting compound (i)(a) and compound(i)(b) in the presence of a free radical initiator;
- 25
- (iii) a copolymer obtained by (a) reacting compound (i)(a) with compound (i)(b) or (i)(c) in a non-free radical catalyzed reaction in the presence of copolymer (i) or copolymer (ii) or both; or by (b) contacting copolymer (i) or copolymer (ii) or both with the non-free radical catalyzed reaction product of compound (i)(a) and compound (i)(b) or (i)(c), wherein the copolymer of (i), (ii) or (iii); with
- 30
- (B) at least one polyether aromatic compound capable of being reacted with at least two monocarboxylic acids or esters thereof, or with at least two dicarboxylic acids, anhydrides or esters thereof, or mixtures thereof.

The present invention is also directed to a lubricating oil composition comprising a major amount of an oil of lubricating viscosity and a minor amount of the lubricating oil additive composition prepared by the process which comprises reacting

5

(A) at least one of the following copolymers:

(i) a copolymer obtained by free radical copolymerization of components comprising:

10

(a) at least one monoethylenically unsaturated C_3 - C_{28} monocarboxylic acid or ester thereof, or C_4 - C_{28} dicarboxylic acid, anhydride or ester thereof;

15

(b) at least one 1-olefin comprising about 2 to about 40 carbon atoms or at least one polyolefin comprising from about 4 to about 360 carbon atoms and having a terminal copolymerizable group in the form of a vinyl, vinylidene or alkyl vinylidene group or mixtures thereof; and

20

(c) at least one monoolefin compound which is copolymerizable with the monomers of (a) and (b) and is selected from the group consisting of:

25

(1) an alkyl vinyl ether and an allyl alkyl ether where the alkyl group is hydroxyl, amino, dialkylamino or alkoxy substituted or is unsubstituted, and containing from about 1 to about 40 carbon atoms;

30

(2) an alkyl amine and an N-alkylamide of a monoethylenically unsaturated mono- or dicarboxylic acid of from about 3 to about 10 carbon atoms where

- the alkyl substituent contains from about 1 to about 40 carbon atoms;
- 5 (3) an N-vinylcarboxamide of carboxylic acids of from about 1 to about 8 carbon atoms;
- (4) an N-vinyl substituted nitrogen-containing heterocyclic compound; and
- 10 (5) at least one 1-olefin comprising from about 2 to about 40 carbon atoms or at least one polyolefin comprising from about 4 to about 360 carbon atoms and having a terminal copolymerizable group in the form of a vinyl, vinylidene or alkyl vinylidene group or mixtures
- 15 thereof, provided that the olefin employed is not the same as the olefin employed in (i)(b);
- (ii) a copolymer obtained by reacting compound (i)(a) and compound(i)(b) in the presence of a free radical initiator;
- 20 (iii) a copolymer obtained by (a) reacting compound (i)(a) with compound (i)(b) or (i)(c) in a non-free radical catalyzed reaction in the presence of copolymer (i) or copolymer (ii) or both; or by (b) contacting copolymer (i) or copolymer (ii) or both with the non-free radical
- 25 catalyzed reaction product of compound (i)(a) and compound (i)(b) or (i)(c); with
- (B) at least one polyether aromatic compound capable of being reacted with at least two monocarboxylic acids or esters thereof, or with at least two
- 30 dicarboxylic acids, anhydrides or esters thereof, or mixtures thereof.

The present invention is also directed to a method of making a lubricating oil additive composition which comprises reacting

(A) at least one of the following copolymers:

5 (i) a copolymer obtained by free radical copolymerization of components comprising:

10 (a) at least one monoethylenically unsaturated C₃-C₂₈ monocarboxylic acid or ester thereof, or C₄-C₂₈ dicarboxylic acid, anhydride or ester thereof;

15 (b) at least one 1-olefin comprising from about 2 to about 40 carbon atoms or at least one polyolefin comprising from about 4 to about 360 carbon atoms and having a terminal copolymerizable group in the form of a vinyl, vinylidene or alkyl vinylidene group or mixtures thereof; and

20 (c) at least one monoolefin compound which is copolymerizable with the monomers of (a) and (b) and is selected from the group consisting of:

25 (1) an alkyl vinyl ether and an allyl alkyl ether where the alkyl group is hydroxyl, amino, dialkylamino or alkoxy substituted or is unsubstituted, and containing from about 1 to about 40 carbon atoms;

30 (2) an alkyl amine and an N-alkylamide of a monoethylenically unsaturated mono- or dicarboxylic acid of from about 3 to about 10 carbon atoms where the alkyl substituent contains from about 1 to about 40 carbon atoms;

(3) an N-vinylcarboxamide of carboxylic acids of from about 1 to about 8 carbon atoms;

- (4) an N-vinyl substituted nitrogen-containing heterocyclic compound; and
- 5 (5) at least one 1-olefin comprising from about 2 to about 40 carbon atoms or at least one polyolefin comprising from about 4 to about 360 carbon atoms and having a terminal copolymerizable group in the form of a vinyl, vinylidene or alkyl vinylidene group or mixtures thereof, provided that the olefin employed is not the same as the olefin employed in (i)(b);
- 10 (ii) a copolymer obtained by reacting compound (i)(a) and compound(i)(b) in the presence of a free radical initiator;
- 15 (iii) a copolymer obtained by (a) reacting compound (i)(a) with compound (i)(b) or (i)(c) in a non-free radical catalyzed reaction in the presence of copolymer (i) or copolymer (ii) or both; or by (b) contacting copolymer (i) or copolymer (ii) or both with the non-free radical catalyzed reaction product of compound (i)(a) and compound (i)(b) or (i)(c); with
- 20 (B) at least one polyether aromatic compound capable of being reacted with at least two monocarboxylic acids or esters thereof, or with at least two dicarboxylic acids, anhydrides or esters thereof, or mixtures thereof.
- 25

Accordingly, the present invention relates to multi-functional lubricating oil additives which are useful as dispersants in an internal combustion engine.

30 DETAILED DESCRIPTION OF THE INVENTION

While the invention is susceptible to various modifications and alternative forms, specific embodiments thereof and are herein described in detail. It should be understood, however, that the description herein of specific embodiments is not

intended to limit the invention to the particular forms disclosed, but on the contrary, the intention is to cover all modifications, equivalents, and alternatives falling within the scope of the invention as defined by the appended claims.

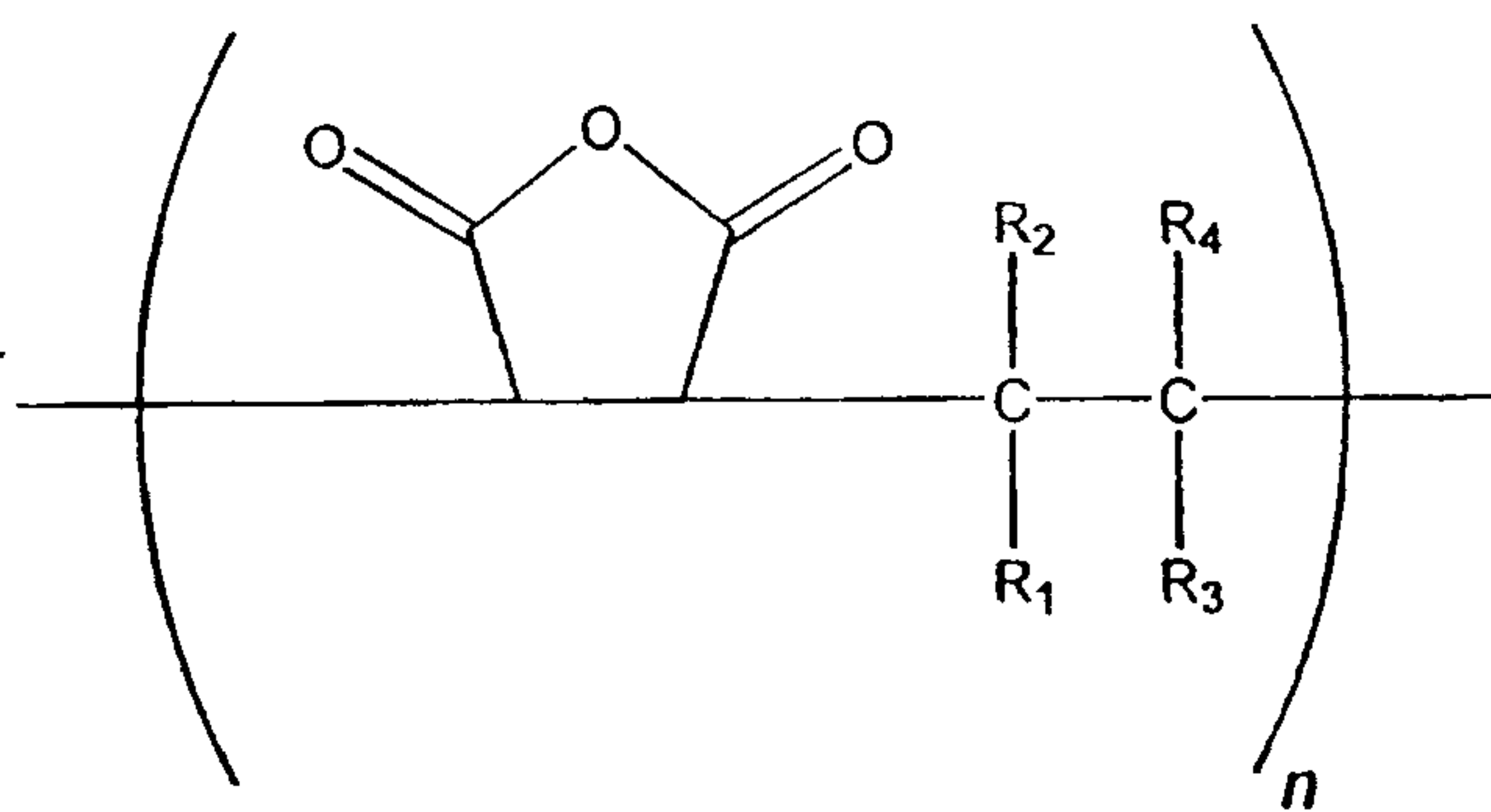
5 Definitions

The following terms used with the description are defined as such:

The term "PIB" is an abbreviation for polyisobutene.

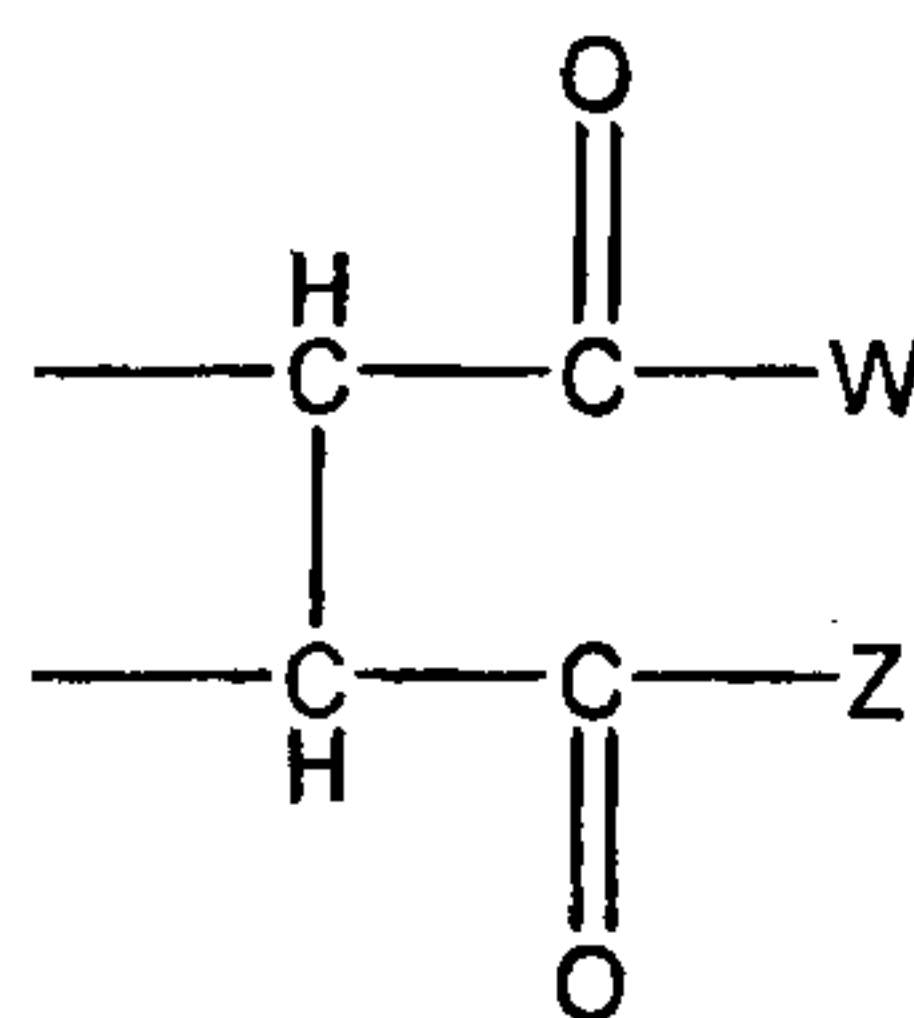
- 10 The term "PIBSA" is an abbreviation for polyisobutenyl or polyisobutyl succinic anhydride.

The term "polyPIBSA" refers to a class of copolymers employed within the scope of the present invention which are copolymers of polyisobutene and a monoethylenically
 15 unsaturated C₃-C₂₈ monocarboxylic acid or ester thereof, or a C₄-C₂₈ dicarboxylic acid, anhydride or ester thereof which have carboxyl groups, preferably succinic groups, and polyisobutyl groups. The preferred polyPIBSA is a copolymer of polyisobutene and maleic anhydride having the general formula:



- 20 wherein n is one or greater; R_1 , R_2 , R_3 and R_4 are selected from hydrogen, methyl and polyisobutyl having at least about 8 carbon atoms, preferably at least about 30 carbon atoms and more preferably at least about 50 carbon atoms wherein either R_1 and R_2 are hydrogen and one of R_3 and R_4 is methyl and the other is polyisobutyl, or R_3 and R_4 are hydrogen and one of R_1 and R_2 is methyl and the other is polyisobutyl. The
 25 polyPIBSA copolymer may be alternating, block, or random.

The term "succinic group" refers to a group having the formula:



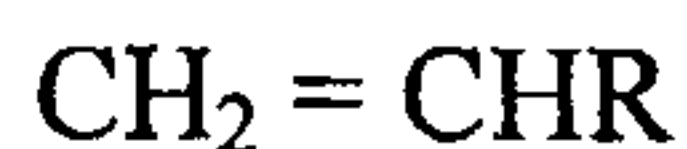
wherein W and Z are independently selected from the group consisting of --OH, --Cl, --O--alkyl or taken together are --O-- to form a succinic anhydride group. The term
 5 "--O--alkyl" is meant to include alkoxy of from about 1 to about 40 carbon atoms, preferably from about 1 to about 8 carbon atoms.

The term "degree of polymerization" refers to the average number of repeating structural units in the polymer chain.

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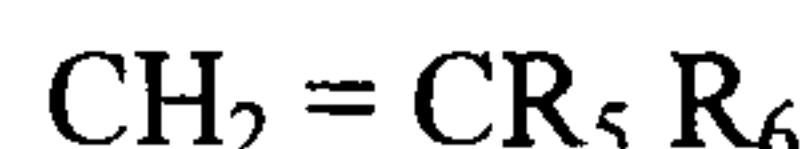
The term "terpolymer" refers to a polymer derived from the free radical copolymerization of at least 3 monomers.

The term "1-olefin" refers to a monounsaturated olefin that has the double bond in the
 15 1-position. They can also be called alpha-olefins, and have the following structure:



where R is the rest of the olefin molecule.

The term "1,1-disubstituted olefin" refers to a disubstituted olefin, also called a
 20 vinylidene olefin, that has the following structure:



wherein R₅ and R₆ are the same or different, and constitute the rest of the olefin molecule. Preferably, either R₅ or R₆ is a methyl group, and the other is not.

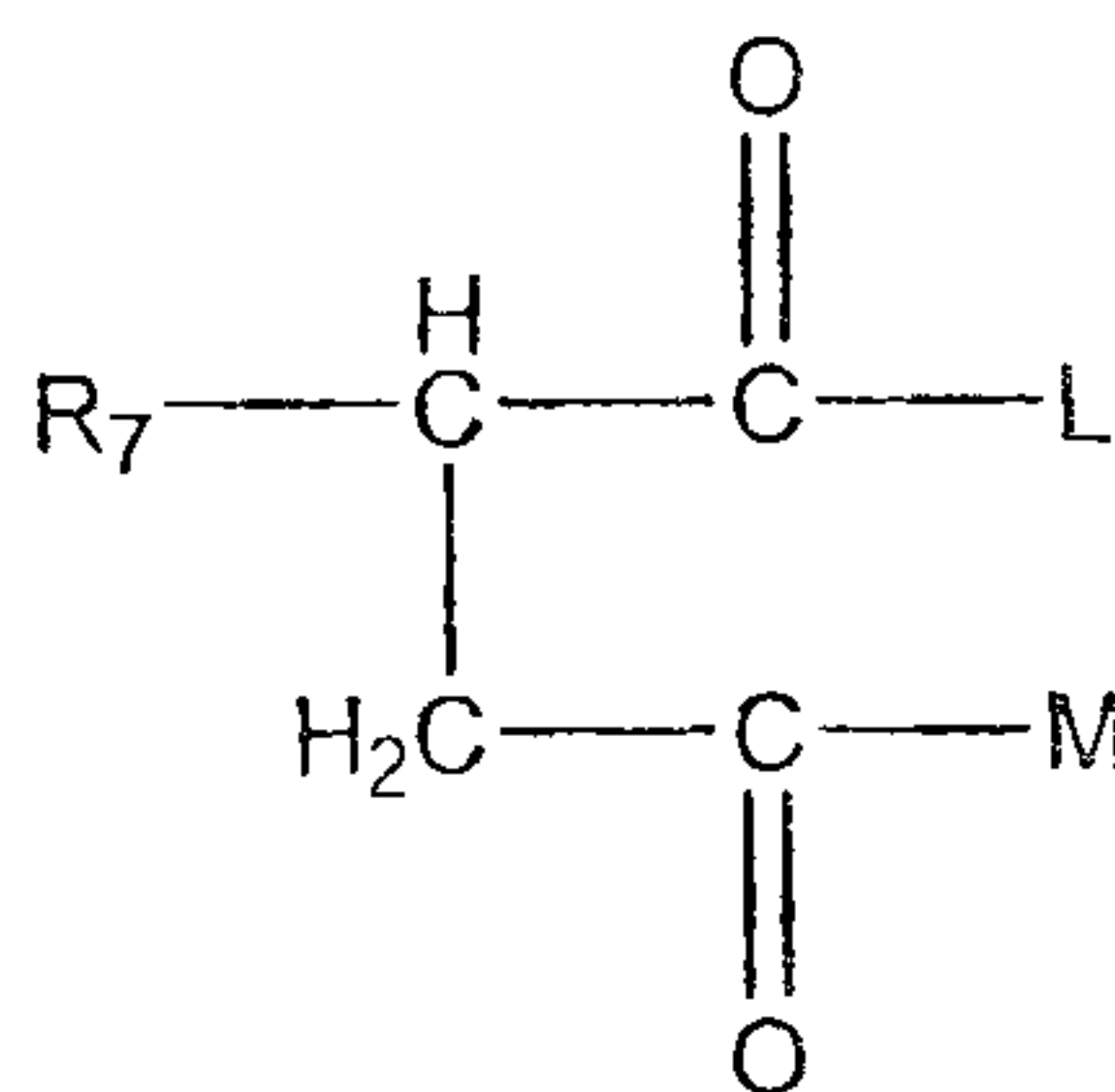
25 The term "succinimide" is understood in the art to include many of the amide, imide, etc. species which are also formed by the reaction of a succinic anhydride with an amine. The predominant product, however, is succinimide and this term has been generally accepted as meaning the product of a reaction of an alkenyl- or alkyl-substituted succinic acid or anhydride with an amine. Alkenyl or alkyl succinimides

are disclosed in numerous references and are well known in the art. Certain fundamental types of succinimides and related materials encompassed by the term of art "succinimide" are taught in U.S. Patent Nos. 2,992,708; 3,018,291; 3,024,237; 3,100,673; 3,219,666; 3,172,892; and 3,272,746.

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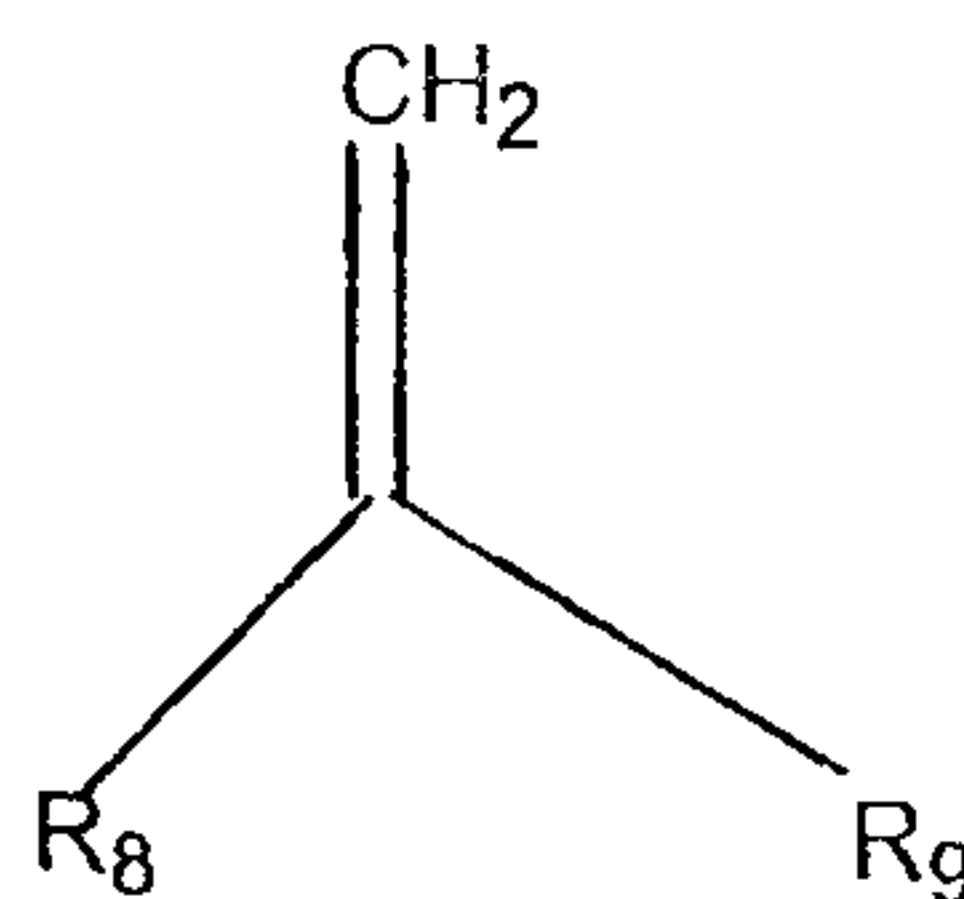
The term "polysuccinimide" refers to the reaction product of a succinic group-containing copolymer with an amine.

- 10 The term "alkenyl or alkylsuccinic acid derivative" refers to a structure having the formula:



- wherein R₇ is selected from hydrogen, methyl and polyisobutyl having at least about 8 carbon atoms, preferably at least about 30 carbon atoms and more preferably at least about 50 carbon atoms; wherein L and M are independently selected from the group consisting of --OH, --Cl, --O--alkyl or taken together are --O-- to form an alkenyl or alkylsuccinic anhydride group.
- 15

- The term "alkylvinylidene" or "alkylvinylidene isomer" refers to an olefin having the following vinylidene structure:
- 20



wherein R₈ is alkyl or substituted alkyl. R₈ generally has at least about 5 carbon atoms, preferably about 30 carbon atoms, and more preferably at least about 50 carbon atoms and R₉ is lower alkyl of from about 1 to about 6 carbon atoms.

25

The term "soluble in lubricating oil" refers to the ability of a material to dissolve in aliphatic and aromatic hydrocarbons such as lubricating oils or fuels in essentially all proportions.

- 5 The term "high molecular weight olefins" refers to olefins (including polymerized olefins having a residual unsaturation) of sufficient molecular weight and chain length to lend solubility in lubricating oil to their reaction products. Typically olefins having about 30 carbons or more suffice.
- 10 The term "high molecular weight polyalkyl" refers to polyalkyl groups of sufficient molecular weight such that the products prepared having such sufficient molecular weight are soluble in lubricating oil. Typically these high molecular weight polyalkyl groups have at least about 30 carbon atoms, preferably at least about 50 carbon atoms. These high molecular weight polyalkyl groups may be derived from high molecular
- 15 weight polyolefins.

The term "amino" refers to $-NR_{10}R_{11}$ wherein R_{10} and R_{11} are independently hydrogen or a hydrocarbyl group.

- 20 The term "alkyl" refers to both straight- and branched-chain alkyl groups.

The term "lower alkyl" refers to alkyl groups having from about 1 to about 6 carbon atoms and includes primary, secondary and tertiary alkyl groups. Typical lower alkyl groups include, for example, methyl, ethyl, n-propyl, isopropyl, n-butyl, sec-butyl,

25 t-butyl, n-pentyl, iso-pentyl, n-hexyl and the like.

The term "polyalkyl" refers to an alkyl group that is generally derived from polyolefins which are polymers or copolymers of mono-olefins, particularly 1-mono-olefins, such as ethylene, propylene, butylene, and the like. Preferably, the

30 mono-olefin employed will have from about 2 to about 24 carbon atoms, and more preferably, from about 3 to about 12 carbon atoms. More preferred mono-olefins include propylene, butylene, particularly isobutylene, 1-octene and 1-decene.

Preferred, polyolefins prepared from such mono-olefins include polypropylene, polybutene, especially polyisobutene.

The Lubricating Oil Additive Composition

5 One embodiment of the present invention is an oil-soluble lubricating oil additive composition prepared by the process which comprises reacting

(A) at least one of the following copolymers:

- 10 (i) a copolymer obtained by free radical copolymerization of components comprising:
 - (a) at least one monoethylenically unsaturated C_3-C_{28} monocarboxylic acid or ester thereof, or C_4-C_{28} dicarboxylic
 15 acid, anhydride or ester thereof;
 - (b) at least one 1-olefin comprising about 2 to 40 carbon atoms or at least one polyolefin comprising about 4 to 360 carbon atoms and having a terminal copolymerizable group in the form of a
 20 vinyl, vinylidene or alkyl vinylidene group or mixtures thereof; and
 - (c) at least one monoolefin compound which is copolymerizable with the monomers of (a) and (b) and is selected from the group
 25 consisting of:
 - (1) an alkyl vinyl ether and an allyl alkyl ether where the alkyl group is hydroxyl, amino, dialkylamino or alkoxy substituted or is unsubstituted, and containing 1 to
 30 40 carbon atoms;
 - (2) an alkyl amine and an N-alkylamide of a monoethylenically unsaturated mono- or dicarboxylic

acid of 3 to 10 carbon atoms where the alkyl substituent contains 1 to 40 carbon atoms;

5 (3) an N-vinylcarboxamide of carboxylic acids of 1 to 8 carbon atoms;

(4) an N-vinyl substituted nitrogen-containing heterocyclic compound; and

10 (5) at least one 1-olefin comprising about 2 to 40 carbon atoms or at least one polyolefin comprising about 4 to about 360 carbon atoms and having a terminal copolymerizable group in the form of a vinyl, vinylidene or alkyl vinylidene group or mixtures
15 thereof, provided that the olefin employed is not the same as the olefin employed in (i)(b);

(ii) a copolymer obtained by reacting compound (i)(a) and compound (i)(b) in the presence of a free radical initiator;

20

(iii) a copolymer obtained by (a) reacting compound (i)(a) with compound (i)(b) or (i)(c) in a non-free radical catalyzed reaction in the presence of copolymer (i) or copolymer (ii) or both; or by (b) contacting copolymer (i) or copolymer (ii) or both with the non-free radical
25 catalyzed reaction product of compound (i)(a) and compound (i)(b) or (i)(c); with

(B) at least one polyether aromatic compound capable of being reacted with at least two monocarboxylic acids or esters thereof, or dicarboxylic acids, anhydrides or esters thereof.
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Copolymer (i)

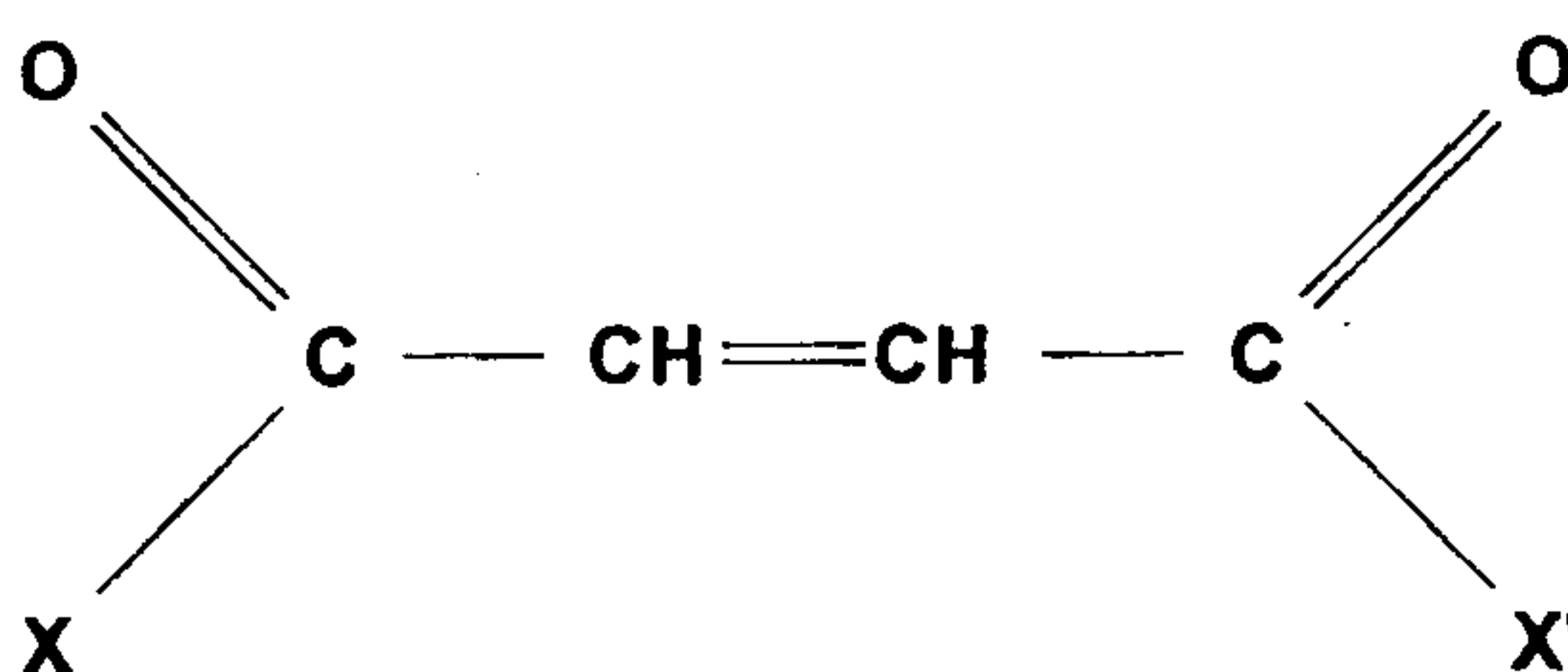
(a) The Monoethylenically Unsaturated Monocarboxylic Acid or Ester Thereof or Dicarboxylic Acid, Anhydride or Ester Thereof

In the present invention, at least one monoethylenically unsaturated C₃-C₂₈

5 monocarboxylic acid or ester thereof, or C₄-C₂₈ dicarboxylic acid, anhydride or ester thereof is used to prepare the copolymers of copolymer (i). Preferably the at least one monoethylenically unsaturated C₃-C₂₈ monocarboxylic acid or ester thereof, or C₄-C₂₈ dicarboxylic acid, anhydride or ester thereof is a dicarboxylic acid, anhydride or ester thereof.

10

The general formula of the preferred dicarboxylic acid, anhydride or ester thereof is as follows:



wherein X and X' are the same or different, provided that at least one of X and X' is a
 15 group that is capable of reacting to esterify alcohols, form amides or amine salts with ammonia or amines, form metal salts with reactive metals or basically reacting metal compounds and otherwise function as acylating agents. Typically, X and/or X' is --OH, --O-hydrocarbyl, OM⁺ where M⁺ represents one equivalent of a metal, ammonium or amine cation, --NH₂, --Cl, --Br, and taken together X and X' can be
 20 --O-- so as to form an anhydride. Preferably X and X' are such that both carboxylic functions can enter into acylation reactions. Maleic anhydride is a preferred reactant. Other suitable reactants include electron-deficient olefins such as monophenyl maleic anhydride; monomethyl, dimethyl, monochloro, monobromo, monofluoro, dichloro and difluoro maleic anhydride; N-phenylmaleimide and other substituted maleimides, isomaleimides; fumaric acid, maleic acid, alkyl hydrogen maleates and fumarates,
 25 dialkyl fumarates and maleates, fumaronilic acids and maleanic acids; and maleonitrile and fumaronitrile.

Suitable monomers for (a) are monoethylenically unsaturated dicarboxylic acids or anhydrides of from about 4 to 28 carbon atoms selected from the group consisting of maleic acid, fumaric acid, itaconic acid, mesaconic acid, methylenemalonic acid, citraconic acid, maleic anhydride, itaconic anhydride, citraconic anhydride and
 5 methylenemalonic anhydride and mixtures of these with one another, among which maleic anhydride is preferred.

Other suitable monomers are monoethylenically unsaturated C₃-C₂₈-monocarboxylic acids selected from the group consisting of acrylic acid, methacrylic acid,
 10 dimethacrylic acid, ethylacrylic acid, crotonic acid, allylacetic acid and vinylacetic acid, among which acrylic and methacrylic acid are preferred.

Another group of suitable monomers is C₁-C₄₀ alkyl esters of monoethylenecially unsaturated C₃-C₁₀ mono- or C₄-C₁₀ dicarboxylic acids such as ethyl acrylate, butyl
 15 acrylate, 2-ethyl acrylate, decyl acrylate, docedyl acrylate, loctadecyl acrylate and the esters of industrial alcohol mixtures of from about 14 to 28 carbon atoms, ethyl methacrylate, 2-ethylhexyl methacrylate, decyl methacrylate, octadecyl methacrylate, monobutyl maleate, dibutyl maleate, monodecyl maleate, didodecyl maleate, monooctadecyl maleate, and dioctadecyl maleate.

20

(b) The 1-Olefin or Polyolefin

In the present invention at least one 1-olefin comprising about 2 to 40 carbon atoms or at least one polyolefin comprising about 4 to 360 carbon atoms and having a terminal copolymerizable group in the form of vinyl, vinylidene or alkyl vinylidene group is
 25 employed.

Suitable 1-olefins for preparing copolymer (i) comprise from about 2 to about 40 carbon atoms, preferably from about 6 to about 30 carbon atoms, such as decene, dodecene, octadecene and mixtures of C₂₀-C₂₄ -1-olefins and C₂₄-C₂₈-1-olefins, more
 30 preferably from about 10 to about 20 carbon atoms. Preferably 1-olefins, which are also known as alpha olefins, with number average molecular weights in the range 100-4,500 or more are preferred, with molecular weights in the range of 200-2,000 being more preferred. For example, alpha olefins obtained from the thermal cracking

of paraffin wax. Generally, these olefins range from about 5 to about 20 carbon atoms in length. Another source of alpha olefins is the ethylene growth process which gives even number carbon olefins. Another source of olefins is by the dimerization of alpha olefins over an appropriate catalyst such as the well known Ziegler catalyst. Internal
5 olefins are easily obtained by the isomerization of alpha olefins over a suitable catalyst such as silica. Preferably, 1-olefins from C₆-C₃₀ are used because these materials are commercially readily available, and because they offer a desirable balance of the length of the molecular tail, and the solubility of the terpolymer in nonpolar solvents. Mixtures of olefins may also be employed.

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Suitable polyolefins for preparing copolymer (i) are polyolefins comprising about 4 to about 360 carbon atoms. These polymers have a number average molecular weight (M_n) of from about 56 to about 5000 g/mol. Examples of these are oligomers of ethylene, of butene, including isobutene, and of branched isomers of pentene, hexene,
15 octene and of decene, the copolymerizable terminal group of the oligomer being present in the form of a vinyl, vinylidene or alkylvinylidene group, oligopropenes and oligopropene mixtures of from about 9 to about 200 carbon atoms and in particular oligoisobutenes, as obtainable, for example, according to DE-A 27 02 604, corresponding U.S. Patent No. 4,152,499, are preferred. Mixtures of the stated
20 oligomers are also suitable, for example, mixtures of ethylene and other alpha olefins. Other suitable polyolefins are described in U.S. Patent No. 6,030,930. The molecular weights of the oligomers may be determined in a conventional manner by gel permeation chromatography.

25 The copolymerizable polyolefin that is reacted with the unsaturated mono- or di-carboxylic reactant are polymers comprising a major amount of C₂-C₈ mono-olefin, e.g., ethylene, propylene, butylene, isobutylene and pentene. These polymers can be homopolymers such as polyisobutylene as well as copolymers of 2 or more such olefins such as copolymers of: ethylene and propylene, butylene, and isobutylene, etc.
30

The polyolefin polymer usually contains from about 4 to about 360 carbon atoms, although preferably 8 to 200 carbon atoms; and more preferably from about 12 to about 175 carbon atoms.

Since the high molecular weight olefins used to prepare the copolymers of the present invention are generally mixtures of individual molecules of different molecular weights, individual copolymer molecules resulting will generally contain a mixture of high molecular weight polyalkyl groups of varying molecular weight. Also, mixtures of copolymer molecules having different degrees of polymerization will be produced.

The copolymers of the present invention have an average degree of polymerization of 1 or greater, preferably from about 1.1 to about 20, and more preferably from about 1.5 to about 10.

(c) The Mono-olefin Compound

The present invention employs at least one monoolefin compound which is copolymerizable with the monomers of (a) and (b) and is selected from the group consisting of:

- (1) an alkyl vinyl ether and an allyl alkyl ether where the alkyl group is hydroxyl, amino, dialkylamino or alkoxy substituted or is unsubstituted, and containing from about 1 to about 40 carbon atoms;

Suitable monomers include the following: vinyl and allyl alkyl ethers where the alkyl radical is of about 1 to about 40 carbon atoms are also suitable, and the alkyl radical may carry further substituents, such as hydroxyl, amino, dialkylamino or alkoxy. Examples are methyl vinyl ether, ethyl vinyl ether, propyl vinyl ether, isobutyl vinyl ether, 2-ethylhexyl vinyl ether, decylvinyl ether, dodecyl vinyl ether, octadecyl vinyl ether, 2-(diethylamino)ethyl vinyl ether, 2-(di-n-butylamino)ethyl vinyl ether, and the corresponding allyl ethers.

- (2) an alkyl amine and an N-alkylamide of a monoethylenically unsaturated mono- or dicarboxylic acid of from about 3 to about 10 carbon atoms where the alkyl substituent contains from about 1 to about 40 carbon atoms;

Another group of monomers comprises C₁-C₄₀ alkyl amines and C₁-C₄₀
 -N- alkylamides of monoethylenically unsaturated C₃ -C₁₀ -mono- or dicarboxylic
 acids, such as dimethylaminoethyl acrylate, diethylaminoethyl acrylate,
 dibutylaminoethyl methacrylate, acrylamide, methacrylamide, N-tert-butylacrylamide,
 5 N-octylacrylamide, N,N' -dibutylacrylamide, N-dodecylmethacrylamide and N-
 octadecylmethacrylamide.

- (3) an N-vinylcarboxamide of carboxylic acids of from about 1 to about 8 carbon
 atoms;

10

Another group of monomers includes the following: N-vinylcarboxamides of
 carboxylic acids of from about 1 to about 8 carbon atoms, such as N-
 vinylformamide, N-vinyl-N-methylformamide, N-vinylacetamide, N-vinyl-N-
 methylacetamide, N-vinyl-N-ethylacetamide, N-vinyl-N-methylpropionamide
 15 and N-vinylpropionamide.

- (4) an N-vinyl substituted nitrogen-containing heterocyclic compound; Another
 group of monomers includes the following: N-vinyl compounds of nitrogen-
 containing heterocycles, such as N-vinylimidazole, N-vinylmethylimidazole,
 20 N-vinylpyrrolidone and N-vinylcaprolactam.

- (5) at least one 1-olefin comprising about 2 to 40 carbon atoms or at least one
 polyolefin comprising from about 4 to about 360 carbon atoms and having a
 terminal copolymerizable group in the form of a vinyl, vinylidene or alkyl
 25 vinylidene group or mixtures thereof, provided that the olefin employed is not
 the same as the olefin employed in (i)(b);

Suitable 1-olefins comprise about 2 to 40 carbon atoms, preferably from about 8 to
 about 30 carbon atoms, such as decene, dodecene, octadecene and mixtures of C₂₀-C₂₄
 30 -1-olefins and C₂₄-C₂₈ -1-olefins. Preferably 1-olefins, which are also known as alpha
 olefins, with number average molecular weights in the range of from about 28 to
 about 560 are preferred, with molecular weights in the range of from about 112 to
 about 420 being more preferred. For example, alpha olefins obtained from the thermal

cracking of paraffin wax may be employed. Generally, these olefins range from about 5 to about 20 carbon atoms in length. Another source of alpha olefins is the ethylene growth process which gives even number carbon olefins. Another source of olefins is by the dimerization of alpha olefins over an appropriate catalyst such as the well known Ziegler catalyst. Internal olefins are easily obtained by the isomerization of alpha olefins over a suitable catalyst such as silica. Preferably, 1-olefins from C₁₀-C₃₀ are used because these materials are commercially readily available, and because they offer a desirable balance of the length of the molecular tail, and the solubility of the terpolymer in nonpolar solvents. Mixtures of olefins are also suitable.

Preparation of Copolymer (i)

Copolymer reactant (i) may be prepared from well known methods which are described in the art including, but not limited to, those methods which are disclosed in the following patents: Harrison et al., U.S. Patent No. 5,792,729; Günther et al., U.S. Patent No. 6,284,716; and Günther et al., U.S. Patent No. 6,512,055.

In one embodiment of the present invention the copolymer reactant is a polyalkenyl succinic anhydride terpolymer. These terpolymers are composed of at least one of monomers (a) to (c) as described herein.

Typically, the terpolymers of this invention contain at least one monomer from each group (a) to (c). In general, these components react to form terpolymers which can be random terpolymers or alternating terpolymers or block terpolymers and can be prepared by known procedures for making copolymers. Additionally, it is possible to form a small percentage of copolymers which are composed of monomers (a) and (b) and monomers (a) and (c). Component (a), the monocarboxylic acid or ester thereof or dicarboxylic acid or anhydride or ester thereof, is selected from those disclosed above, preferably maleic anhydride. Component (b), the 1-olefin or polyolefin, is preferably polybutene. Component (c), the mono-olefin, is preferably a linear alpha olefin containing from about 12 to 18 carbon atoms.

The degree of polymerization of the terpolymers can vary over a wide range. Preferably, the degree of polymerization is from about 2 to about 10. In general, terpolymer degree of polymerization decreases as the polymerization temperature increases.

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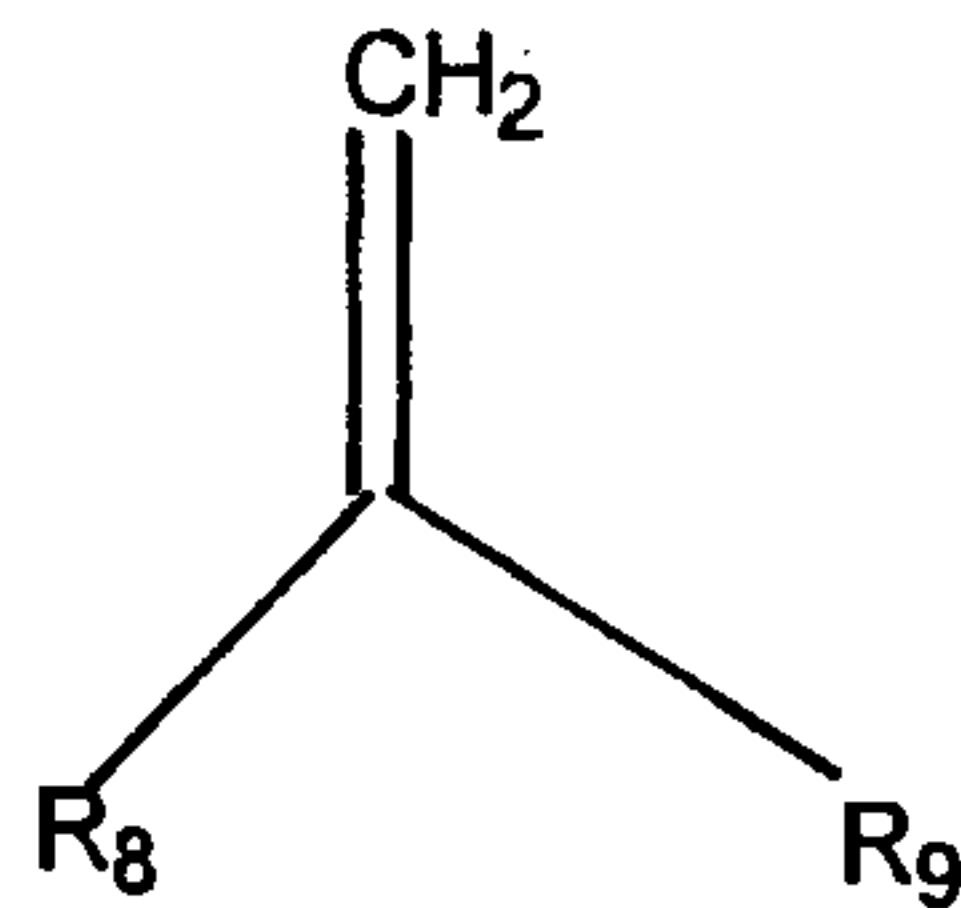
The terpolymerization is conducted in the presence of a suitable free radical initiator. Examples of suitable polymerization initiators are peroxide compounds, such as tertbutyl perpivalate, tertbutyl perneoccanoate, tert-butylperethylhexanoate, tertbutylperisobutyrate, di-tert-butyl peroxide, di-tert-amyl peroxide, diacetyl
10 peroxydicarbonate and dicyclohexyldicarbonate, or azo compounds, such as 2,2' - azobisisobutyronitrile. The initiators may be used alone or as a mixture with one another. Redox co-initiators may also be present. Preferably, the initiator is a peroxide type initiator, e.g., di(t-butyl) peroxide, dicumyl peroxide or azo type initiator, e.g., isobutylnitrile type initiators. Procedures for preparing poly 1-olefin copolymers are,
15 for example, described in U.S. Patent Nos. 3,560,455 and 4,240,916. Those procedures could be used to prepare terpolymers. Both patents also describe a variety of initiators.

Copolymer (i), wherein a second olefin is employed in the reaction, can be prepared
20 in the same manner as copolymer (ii) which is described below.

Copolymer (ii)

In another embodiment of the present invention, the copolymer reactant is a copolymer obtained by reacting (a) at least one monoethylenically unsaturated C₃-C₂₈
25 monocarboxylic acid or ester thereof, or a C₄-C₂₈ dicarboxylic acid, anhydride or ester thereof and (b) at least one copolymerizable polymer composed of at least 3 olefin molecules of propene or of a branched 1-olefin of from about 4 to about 10 carbon atoms, having a number average molecular weight M_n of from about 112 to about 5000, and having a terminal copolymerizable group in the form of a vinyl, vinylidene
30 or alkyl vinylidene group in the presence of a free radical initiator.

Thus, preferred copolymers of the present invention are prepared by reacting a "reactive" high molecular weight olefin in which a high proportion of unsaturation, at least about 20% is in the alkylvinylidene configuration, e.g.,



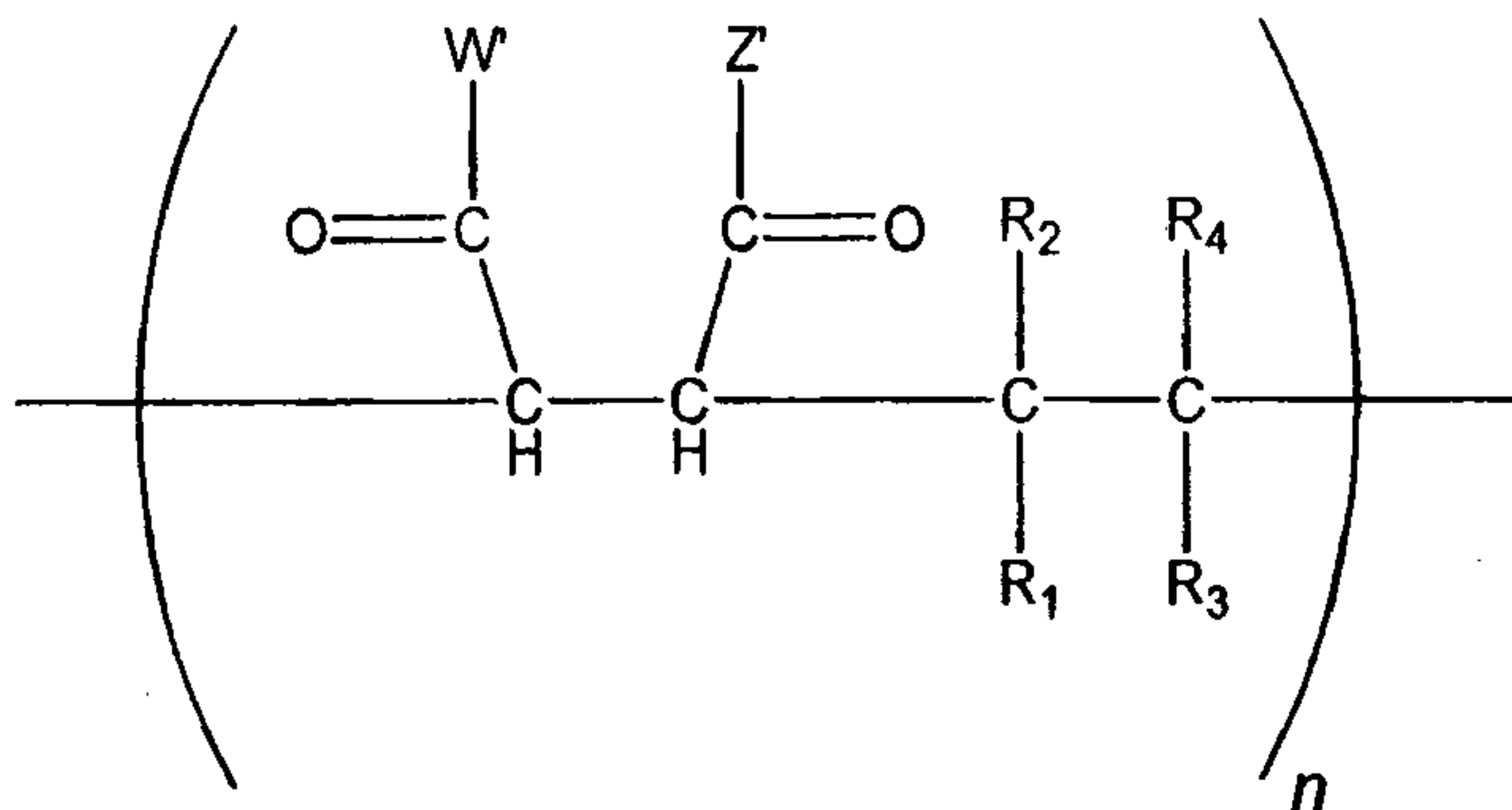
5 wherein R_8 and R_9 are an alkyl or substituted alkyl of sufficient chain length to give the resulting molecule stability in lubricating oils and fuels, thus R_8 generally has at least about 30 carbon atoms, preferably at least about 50 carbon atoms and R_9 is a lower alkyl of from about 1 to about 6 carbon atoms, with an unsaturated acidic reactant in the presence of a free radical initiator.

10

Typically, the copolymer product has alternating polyalkylene and succinic groups and has an average degree of polymerization of 1 or greater.

The preferred copolymers (ii) of the present invention have the general

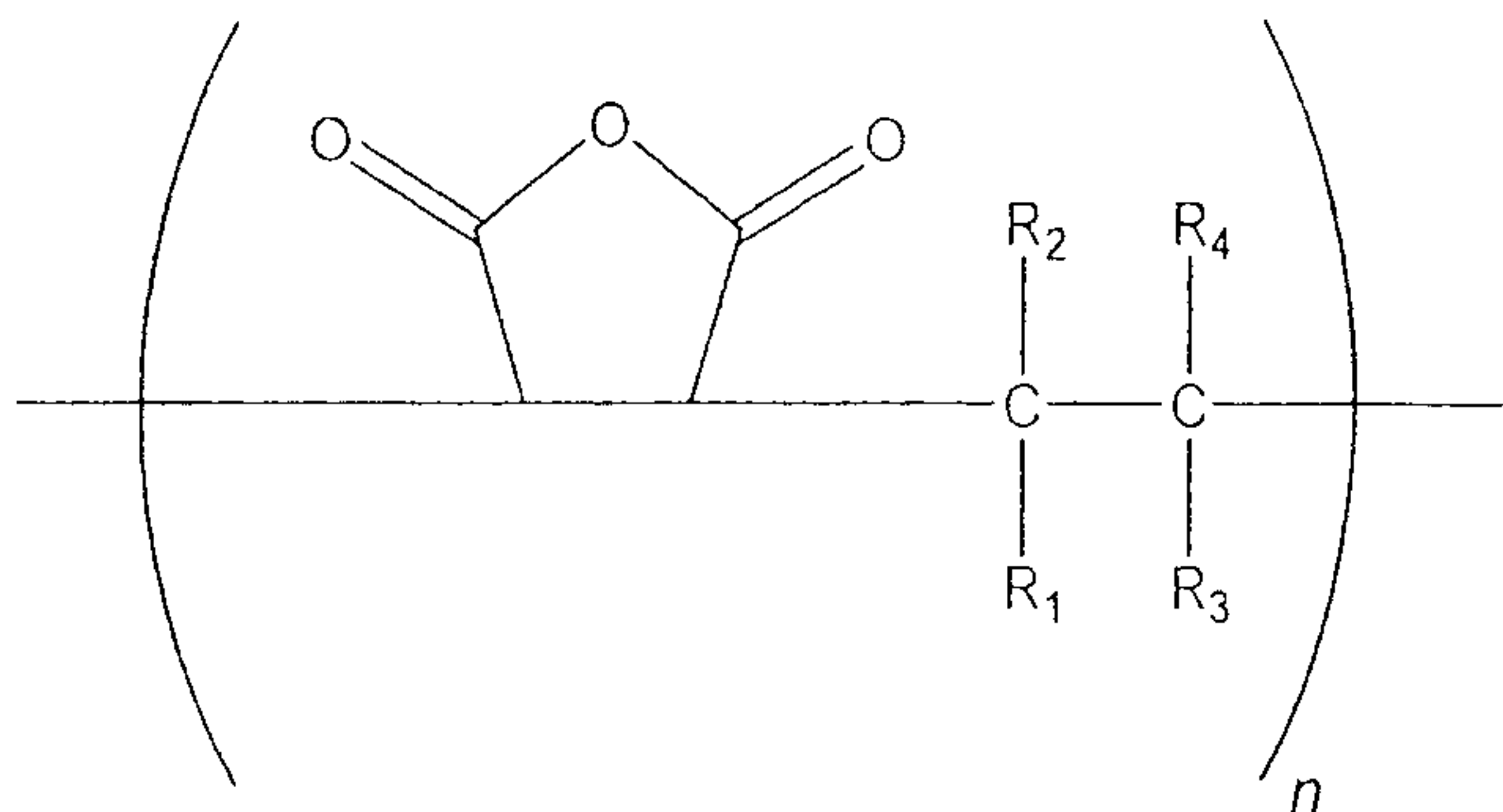
15 formula:



wherein W' and Z' are independently selected from the group consisting of --OH, --O--alkyl or taken together are --O-- to form a succinic anhydride group, n is one or greater; and R_1 , R_2 , R_3 and R_4 are selected from hydrogen, alkyl of from about 1 to about 40 carbon atoms, and high molecular weight polyalkyl wherein either R_1 and R_2 are hydrogen and one of R_3 and R_4 is lower alkyl having from about 1 to about 6 carbon atoms and the other is high molecular weight polyalkyl, or R_3 and R_4 are hydrogen and one of R_1 and R_2 is lower alkyl having from about 1 to 6 carbon atoms and the other is high molecular weight polyalkyl.

Copolymer (ii) may be alternating, block, or random.

In a preferred embodiment, when maleic anhydride is used as the reactant, the
 5 reaction produces copolymers predominately of the following formula:



wherein n is from about 1 to about 100, preferably from about 2 to about 20, more preferably from about 2 to about 10, and R₁, R₂, R₃ and R₄ are selected from hydrogen, lower alkyl of from about 1 to about 6 carbon atoms and higher molecular weight polyalkyl, wherein either R₁ and R₂ are hydrogen and one of R₃ and R₄ is
 10 lower alkyl having from about 1 to about 6 carbon atoms and the other is high molecular weight polyalkyl or R₃ and R₄ are hydrogen and one of R₁ and R₂ is lower alkyl and the other is high molecular weight polyalkyl.

15 Preferably, the high molecular weight polyalkyl group has at least about 30 carbon atoms (more preferably at least about 50 carbon atoms). Preferred high molecular weight polyalkyl groups include polyisobutyl groups. Preferred polyisobutyl groups include those having number average molecular weights of from about 500 to about 5000, more preferably from about 900 to about 2500. Preferred lower alkyl groups
 20 include methyl and ethyl; especially preferred lower alkyl groups include methyl.

A particularly preferred class of olefin polymers comprises the polybutenes, which are prepared by polymerization of isobutene. These polybutenes are readily available commercial materials well known to those skilled in the art. Disclosures thereof
 25 and disclosures of suitable polybutenes will be found, for example, in U.S. Patent Nos. 4,152,499 and 4,605,808.

Preferably, 1,1-disubstituted olefins are used to provide a high molecular weight, oil soluble tail in the terpolymer. Preferably the 1,1-disubstituted olefin has a number average M_n of from about 500 to about 5000. One particularly useful 1,1-disubstituted olefin is a 1,1-disubstituted polyisobutylene, such as methylvinylidene polyisobutylene.

Preferably the copolymerizable polymer comprises a high molecular weight polyalkyl group which is derived from a high molecular weight olefin. The high molecular weight olefins used in the preparation of the copolymers of the present invention are of sufficiently long chain length so that the resulting composition is soluble in and compatible with mineral oils, fuels and the like; and the alkylvinylidene isomer of the high molecular weight olefin comprises at least about 20% of the total olefin composition. Preferably, the alkyl vinylidene isomer comprises at least 50%, more preferably at least 70%, of the total olefin composition.

Such high molecular weight olefins are generally mixtures of molecules having different molecular weights and can have at least one branch per 6 carbon atoms along the chain, preferably at least one branch per 4 carbon atoms along the chain, and particularly preferred that there be about one branch per 2 carbon atoms along the chain. These branched chain olefins may conveniently comprise polyalkenes prepared by the polymerization of olefins of from about 3 to about 6 carbon atoms, and preferably from olefins of from about 3 to about 4 carbon atoms, and more preferably from propylene or isobutylene. The addition-polymerizable olefins employed are normally 1-olefins. The branch may be of from about 1 to about 4 carbon atoms, more usually of from about 1 to about 2 carbon atoms and preferably methyl.

The preferred alkylvinylidene isomer comprises a methyl- or ethylvinylidene isomer, more preferably the methylvinylidene isomer.

The especially preferred high molecular weight olefins used to prepare the copolymers of the present invention are polyisobutenes which comprise at least about 20% of the more reactive methylvinylidene isomer, preferably at least about 50% and more preferably at least about 70%. Suitable polyisobutenes include those prepared

using BF_3 catalysis. The preparation of such polyisobutenes in which the methylvinylidene isomer comprises a high percentage of the total composition is described in U.S. Patent Nos. 4,152,499 and 4,605,808.

5 *Preparation of Copolymer (ii)*

As noted above, copolymer (ii) of the present invention is prepared by reacting an olefin and an unsaturated acidic reactant in the presence of a free radical initiator. The process of the preparation of copolymer (ii) is described in Harrison, U.S. Patent No. 5,112,507.

10

The reaction may be conducted at a temperature of about -30°C to about 210°C , preferably from about 40°C to about 160°C . The degree of polymerization is inversely proportional to temperature. Accordingly, for the preferred high molecular weight copolymers, it is advantageous to employ lower reaction temperatures.

15

The reaction may be conducted neat, that is, both the high molecular weight olefin, acidic reactant and the free radical initiator are combined in the proper ratio, and then stirred at the reaction temperature.

20

Alternatively, the reaction may be conducted in a solvent. Suitable solvents include those in which the reactants and free radical initiator are soluble and include acetone, tetrahydrofuran, chloroform, methylene chloride, dichloroethane, toluene, dioxane, chlorobenzene, xylenes, or the like. After the reaction is complete, volatile components may be stripped off. When a solvent is employed, it is preferably inert to the reactants and products formed and is generally used in an amount sufficient to ensure efficient mixing.

25

30

Alternatively, the reaction may be conducted in a diluent, such as mineral oil, as long as the diluent does not contain constituents that interfere with the free radical polymerization, e.g., sulfur compounds, antioxidants and the like.

In general, the copolymerization can be initiated by any free radical initiator. Such initiators are well known in the art. However, the choice of free radical initiator may be influenced by the reaction temperature employed.

- 5 The preferred free-radical initiators are the peroxide-type polymerization initiators and the azo-type polymerization initiators. Radiation can also be used to initiate the reaction, if desired.

The peroxide-type free-radical initiator can be organic or inorganic, the organic
 10 having the general formula: $R_{12} OOR_{13}$ where R_{12} is any organic radical and R_{13} is selected from the group consisting of hydrogen and any organic radical. Both R_{12} and R_{13} can be organic radicals, preferably hydrocarbon, aryl, and acyl radicals, carrying, if desired, substituents such as halogens, etc. Preferred peroxides include di-tert-butyl peroxide, dicumyl peroxide, and di-tert-amyl peroxide.

15

Examples of other suitable peroxides, which in no way are limiting, include benzoyl peroxide; lauroyl peroxide; other tertiary butyl peroxides; 2,4-dichlorobenzoyl peroxide; tertiary butyl hydroperoxide; cumene hydroperoxide; diacetyl peroxide; acetyl hydroperoxide; diethylperoxycarbonate; tertiary butyl perbenzoate; and the
 20 like.

The azo-type compounds, typified by alpha, alpha' -azobisisobutyronitrile, are also well-known free-radical promoting materials. These azo compounds can be defined as those having present in the molecule group $--N=N--$ wherein the balances are satisfied
 25 by organic radicals, at least one of which is preferably attached to a tertiary carbon. Other suitable azo compounds include, but are not limited to, p-bromobenzenediazonium fluoroborate; p-tolyldiazoaminobenzene; p-bromobenzenediazonium hydroxide; azomethane and phenyldiazonium halides. A suitable list of azo-type compounds can be found in U.S. Patent No. 2,551,813, issued
 30 May 8, 1951 to Paul Pinkney.

The amount of initiator to employ, exclusive of radiation, of course, depends to a large extent on the particular initiator chosen, the high molecular olefin used and the

reaction conditions. The usual concentrations of initiator are between 0.001:1 and 0.2:1 moles of initiator per mole of acidic reactant, with preferred amounts between 0.005:1 and 0.10:1.

- 5 The polymerization temperature must be sufficiently high to break down the initiator to produce the desired free-radicals. For example, using benzoyl peroxide as the initiator, the reaction temperature can be between about 75°C and about 90°C, preferably between about 80°C and about 85°C higher and lower temperatures can be employed, a suitable broad range of temperatures being between about 20°C and
10 about 200°C, with preferred temperatures between about 50°C and about 150°C.

The reaction pressure should be sufficient to maintain the solvent in the liquid phase. Pressures can therefore vary between about atmospheric and 100 psig or higher.

- 15 The reaction time is usually sufficient to result in the substantially complete conversion of the acidic reactant and high molecular weight olefin to copolymer. The reaction time is suitable between one and 24 hours, with preferred reaction times between 2 and 10 hours.
- 20 As noted above, the subject reaction is a solution-type polymerization reaction. The high molecular weight olefin, acidic reactant, solvent and initiator can be brought together in any suitable manner. The important factors are intimate contact of the high molecular weight olefin and acidic reactant in the presence of a free-radical producing material. The reaction, for example, can be conducted in a batch system where the
25 high molecular weight olefin is added all initially to a mixture of acidic reactant, initiator and solvent or the high molecular weight olefin can be added intermittently or continuously to the reactor. Alternatively, the reactants may be combined in other orders; for example, acidic reactant and initiator may be added to high molecular weight olefin in the reactor. In another manner, the components in the reaction
30 mixture can be added continuously to a stirred reactor with continuous removal of a portion of the product to a recovery train or to other reactors in series. In yet another manner, the reaction may be carried out in a batch process, wherein the high molecular weight olefin is added initially to the reactor, and then the acidic reactant

and the initiator are added gradually over time. The reaction can also suitably take place in a tubular-type reactor where the components are added at one or more points along the tube.

5 Copolymer (iii)

In one embodiment, copolymer reactant (iii) is obtained by a copolymer obtained by (a) reacting compound (i)(a) with compound (i)(b) or (i)(c) in a non-free radical catalyzed reaction in the presence of copolymer (i) or copolymer (ii) or both; or by (b) contacting copolymer (i) or copolymer (ii) or both with the non-free radical catalyzed
10 reaction product of compound (i)(a) and compound (i)(b) or (i)(c).

Preparation of Copolymer (iii)

A process for the preparation of copolymer (iii) is described, for example, in Harrison et al., U.S. Patent No. 6,451,920.

15

In process step (a) above, any unreacted olefin, generally the more hindered olefins, i.e., the beta-vinylidene, that do not react readily with the monoethylenically unsaturated C₃-C₂₈ monocarboxylic acid or ester thereof, or C₄-C₂₈ dicarboxylic acid
20 or an anhydride or ester thereof, under free radical conditions, are reacted with monoethylenically unsaturated C₃-C₂₈ monocarboxylic acid or ester thereof, or C₄-C₂₈ dicarboxylic acid or an anhydride or ester thereof, under thermal conditions, i.e., at temperatures of from about 180°C to about 280°C. These conditions are similar to those used for preparing thermal process PIBSA. Optionally, this reaction takes place
25 in the presence of a strong acid, such as sulfonic acid. See for example U.S. Patent No. 6,156,850.

Optionally, a solvent may be used to dissolve the reactants. The reaction solvent must be one which dissolves both the acidic reactant and the high molecular weight olefin.
30 It is necessary to dissolve the acidic reactant and high molecular weight olefin so as to bring them into intimate contact in the solution polymerization reaction. It has been found that the solvent must also be one in which the resultant copolymers are soluble.

Suitable solvents include liquid saturated or aromatic hydrocarbons having from about 6 to about 20 carbon atoms; ketones having from about 3 to about 5 carbon atoms; and liquid saturated aliphatic dihalogenated hydrocarbons having from about 1 to about 5 carbon atoms per molecule, preferably from about 1 to about 3 carbon atoms per molecule. By "liquid" is meant liquid under the conditions of polymerization. In the dihalogenated hydrocarbons, the halogens are preferably on adjacent carbon atoms. By "halogen" is meant F, Cl and Br. The amount of solvent must be such that it can dissolve the acidic reactant and high molecular weight olefin in addition to the resulting copolymers. The volume ratio of solvent to high molecular weight olefin is suitably between 1:1 and 100:1 and is preferably between 1.5:1 and 4:1.

Suitable solvents include the ketones having from about 3 to about 6 carbon atoms and the saturated dichlorinated hydrocarbons having from about 1 to about 5, more preferably from about 1 to about 3, carbon atoms.

15

Examples of suitable solvents include, but are not limited to:

1. ketones, such as: acetone; methylethylketone; diethylketone; and methylisobutylketone;
2. aromatic hydrocarbons, such as: benzene; xylene; and toluene;
3. saturated dihalogenated hydrocarbons, such as: dichloromethane; dibromomethane; 1-bromo-2-chloroethane; 1,1-dibromoethane; 1,1-dichloroethane; 1,2-dichloroethane; 1,3-dibromopropane; 1,2-dibromopropane; 1,2-dibromo-2-methylpropane; 1,2-dichloropropane; 1,1-dichloropropane; 1,3-dichloropropane; 1-bromo-2-chloropropane; 1,2-dichlorobutane; 1,5-dibromopentane; and 1,5-dichloropentane; or
4. mixtures of the above, such as: benzenemethylethylketone.

30

The copolymer is conveniently separated from solvent and any unreacted acidic reactant by conventional procedures such as phase separation, solvent distillation,

precipitation and the like. If desired, dispersing agents and/or co-solvents may be used during the reaction.

The polyisobutenyl succinic anhydride (PIBSA), which may be directly added to
5 copolymer reactant (i) or (ii), is generally prepared by a number of well-known processes including the method disclosed within. For example, there is a well-known thermal process (see, e.g., U.S. Patent No. 3,361,673), an equally well-known chlorination process (see, e.g., U.S. Patent No. 3,172,892), a combination of the thermal and chlorination processes (see, e.g., U.S. Patent No. 3,912,764), catalytic
10 strong acid processes (see, e.g., U.S. Patent Nos. 3,819,660 and 6,156,850), and free radical processes (see, e.g., U.S. Patent Nos. 5,286,799 and 5,319,030). Such compositions include one-to-one monomeric adducts (see, e.g., U.S. Patent Nos. 3,219,666 and 3,381,022), as well as high succinic ratio products, adducts having alkenyl-derived substituents adducted with at least 1.3 succinic groups per alkenyl-
15 derived substituent (see, e.g., U.S. Patent No. 4,234,435).

Polyalkylene succinic anhydrides also can be produced thermally also from high methylvinylidene polybutene as disclosed in U.S. Patent No. 4,152,499. This process is further discussed in U.S. Patent No. 5,241,003 for the case where the succinic ratio
20 is less than 1.3 and in EP 0 355 895 for the case where the succinic ratio is greater than 1.3. European Applications EP 0 602 863 and EP 0 587 381, and U.S. Patent No. 5,523,417 disclose a procedure for washing out the polymaleic anhydride resin from polyalkylene succinic anhydride prepared from high methylvinylidene polybutene. A polyalkylene succinic anhydride with a succinic ratio of 1.0 is disclosed. One
25 advantage of polyalkylene succinic anhydride from high methylvinylidene polybutene is that it can be prepared essentially free of chlorine. U.S. Patent No. 4,234,435 teaches a preferred polyalkene-derived substituent group with a number average (M_n) in the range of from about 1500 to about 3200. For polybutenes, an especially preferred number average (M_n) range is from about 1700 to about 2400. This patent
30 also teaches that the succinimides must have a succinic ratio of at least 1.3. That is, there should be at least 1.3 succinic groups per equivalent weight of polyalkene-derived substituent group. Most preferably, the succinic ratio should be from 1.5 to 2.5.

Other suitable alkenyl succinic anhydrides includes those described in U.S. Patent No. 6,030,930. Typical alkenyl used in the preparation are ethylene and 1-butene copolymers.

5

(B) The Polyether Aromatic Compound

In one embodiment of the present invention, the copolymer is reacted with a polyether aromatic compound.

- 10 Typically, the polyether aromatic compound will have at least two functional groups, each capable of reacting with a monocarboxylic acid or ester thereof, or dicarboxylic acid, anhydride or ester thereof, or mixtures thereof.

Suitable polyether aromatic compounds include, but are not limited to, the following:

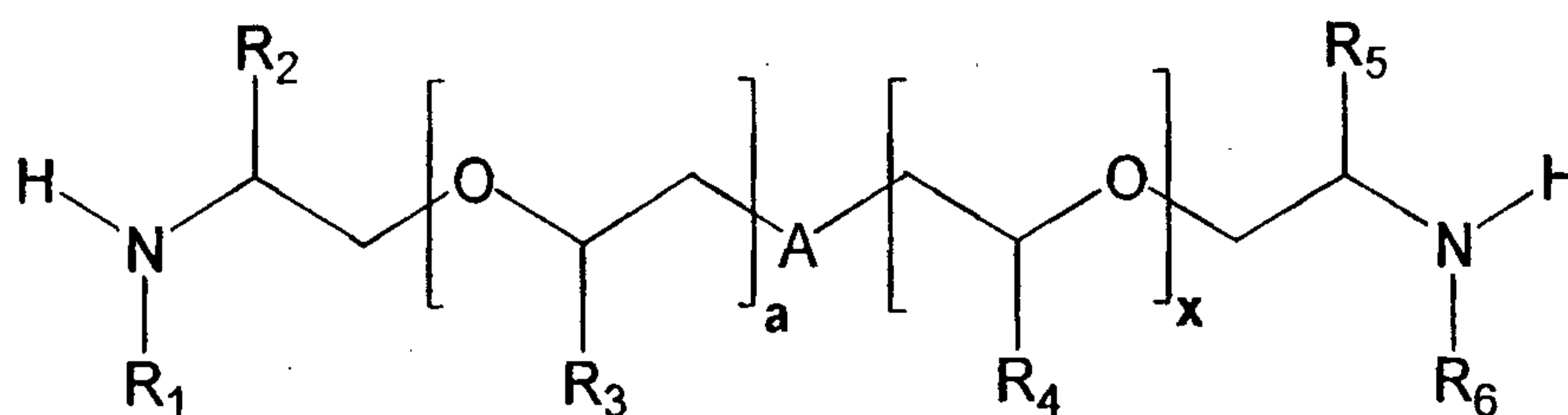
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Polyether Aromatic Compounds Derived from an Aromatic Aminic Compound

In one embodiment, the polyether aromatic compound is derived from an aromatic compound containing at least one amine group and wherein the polyether is capable of reacting with a monocarboxylic acid or ester thereof, or dicarboxylic acid,

20 anhydride or ester thereof.

Examples of suitable polyether aromatic amines include compounds having the following structure:



25

Fig. I

- in which A represents an aromatic aminic moiety wherein the ether groups are linked through at least one amine group on the aromatic moiety; R₁ and R₆ are independently hydrogen, alkyl, alkaryl, aralkyl, or aryl or mixtures thereof; R₂, R₃, R₄, and R₅ are independently hydrogen or alkyl containing from about 1 to about 6 carbon atoms or
- 30 mixtures thereof; and a and x are independently integers from about 1 to about 50.

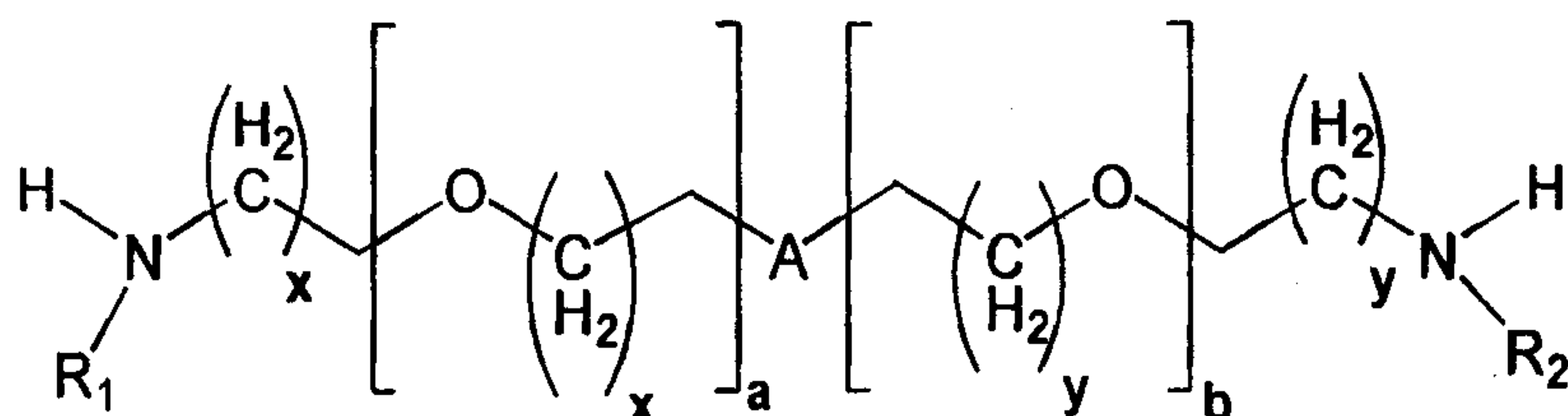


Fig. II

in which A represents an aromatic aminic moiety wherein the ether groups are linked through at least one aminic functionality on the aromatic moiety; R₁ and R₂ are independently hydrogen, alkyl, alkaryl, aralkyl, or aryl or mixtures thereof; a and b are independently integers from about 1 to about 50; and x and y are independently integers from 1 to 4.

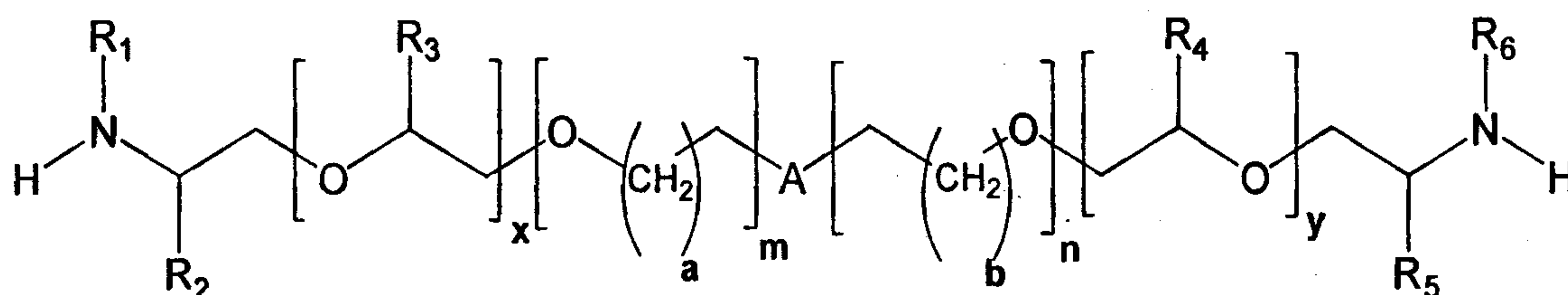


Fig. III

in which A represents an aromatic aminic moiety wherein the ether groups are linked through at least one aminic functionality on the aromatic moiety; R₁ and R₆ are independently hydrogen, alkyl, alkaryl, aralkyl, or aryl or mixtures thereof; R₂, R₃, R₄, and R₅ are independently hydrogen or alkyl containing from about 1 to about 6 carbon atoms or mixtures thereof; a and b are independently an integer from 1 to 4; and x and y are independently integers from about 1 to about 50; and m and n are independently integers from about 1 to about 50.

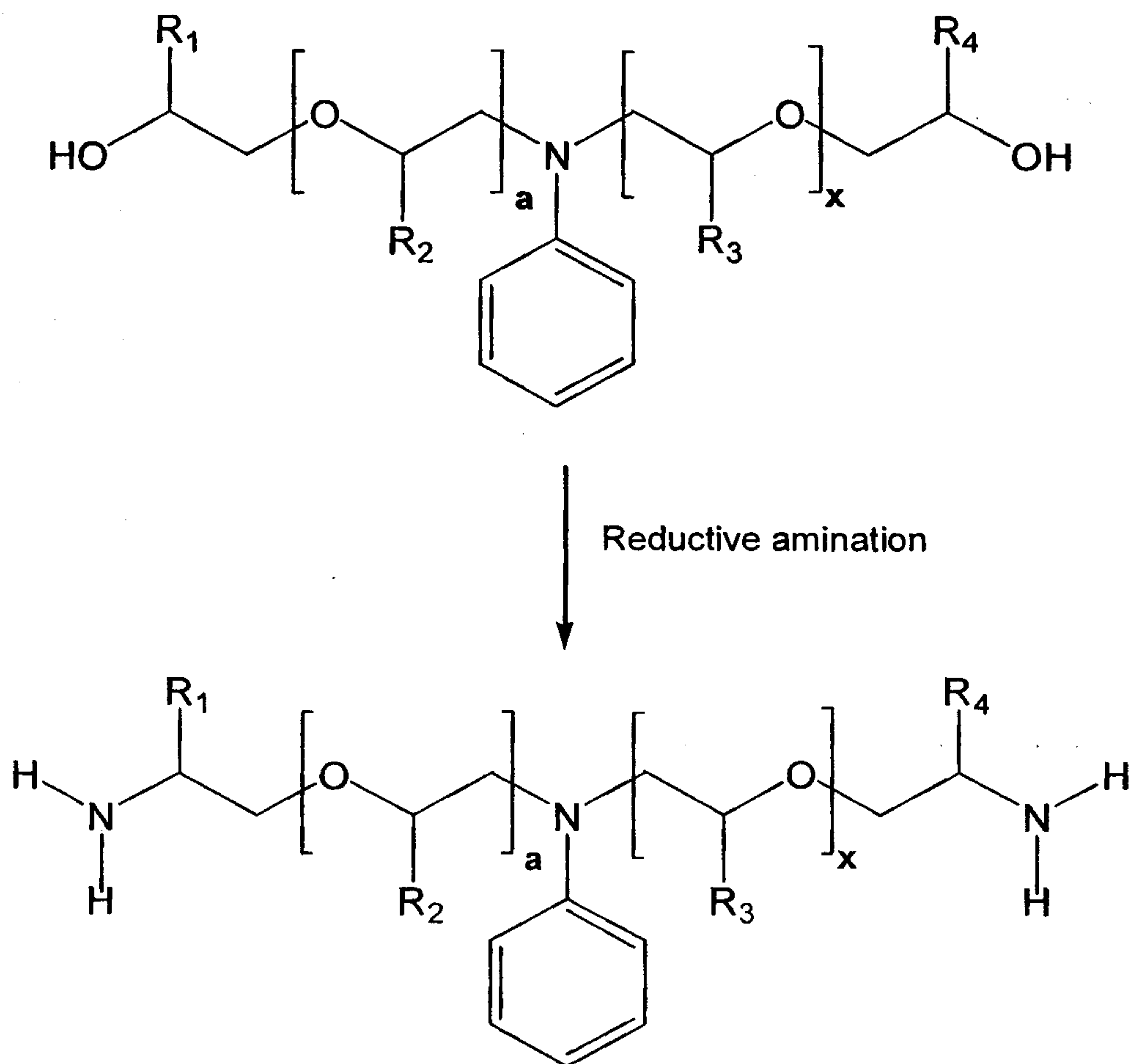
Furthermore, in one embodiment of the present invention, the polyether aromatic amine, wherein the polyether is capable of reacting with a monocarboxylic acid or ester thereof, or dicarboxylic acid, anhydride or ester thereof, can be a random, block, or alternating copolymer.

A general procedure for preparing polyether hydrocarbylamines can be found, for example, in U.S. Patent No. 4,847,417.

In general, the polyether aromatic amines employed in this invention may be synthesized by reacting an aromatic amine compound, such as aniline, with an alkylene

oxide compound to form polyether groups on a primary or secondary nitrogen(s) of the aromatic amine compound, e.g., aniline. Ethylene or propylene carbonate can also be used to form polyether groups on the primary or secondary nitrogen(s) of the aromatic amine compound. The terminal hydroxyl groups of the polyether moieties can be

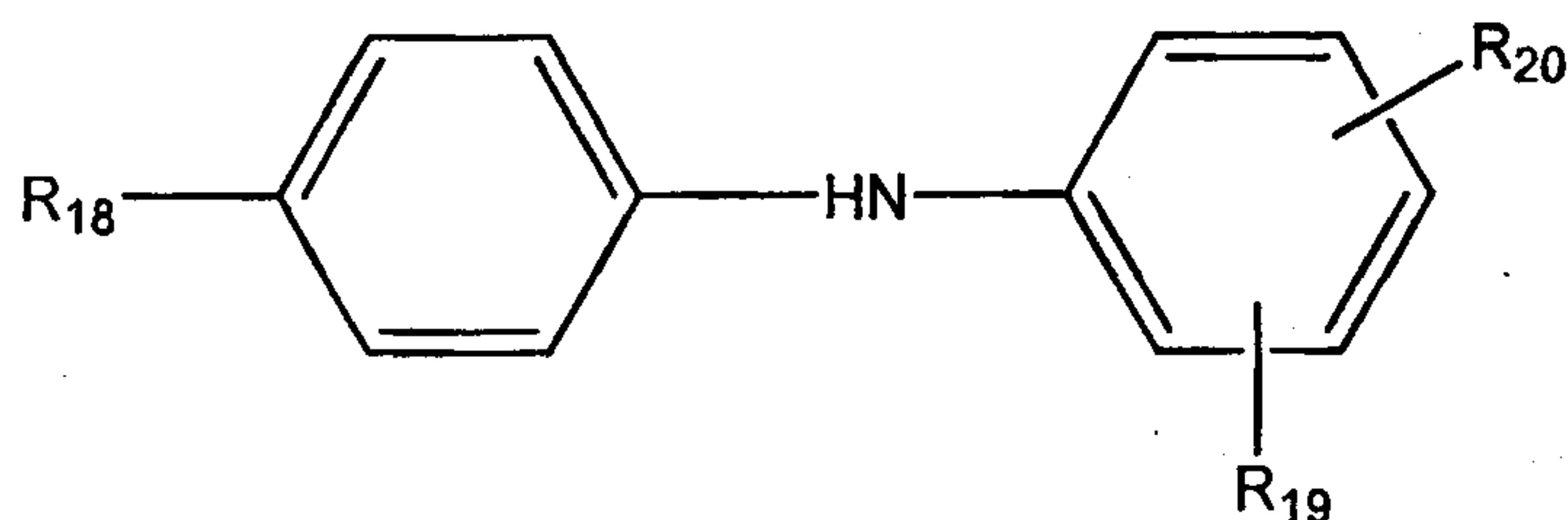
5 converted to amino groups via reductive amination or cyanoalkylation, utilizing techniques well known in the art.



in which R_1 , R_2 , R_3 , and R_4 are independently hydrogen or alkyl containing from about 1 to 6 carbon atoms or mixtures thereof.

Examples of other aromatic amines which may be used in the present invention to synthesize suitable polyether aromatic amines include the following:

(a) an N-arylphenylenediamine represented by the formula:



5

10

R_{18} is H, --NHaryl, --NHalkaryl, or a branched or straight chain hydrocarbyl radical having from about 4 to about 24 carbon atoms selected from alkyl, alkenyl, alkoxyl, aralkyl or alkaryl; R_{19} is --NH₂, --(NH(CH₂)_n)_mNH₂, --NHalkyl, --NHaralkyl, --CH₂ --aryl--NH₂, in which n and m each have a value from about 1 to about 10; and R_{20} is hydrogen, alkyl, alkenyl, alkoxyl, aralkyl, or alkaryl, having from about 4 to about 24 carbon atoms.

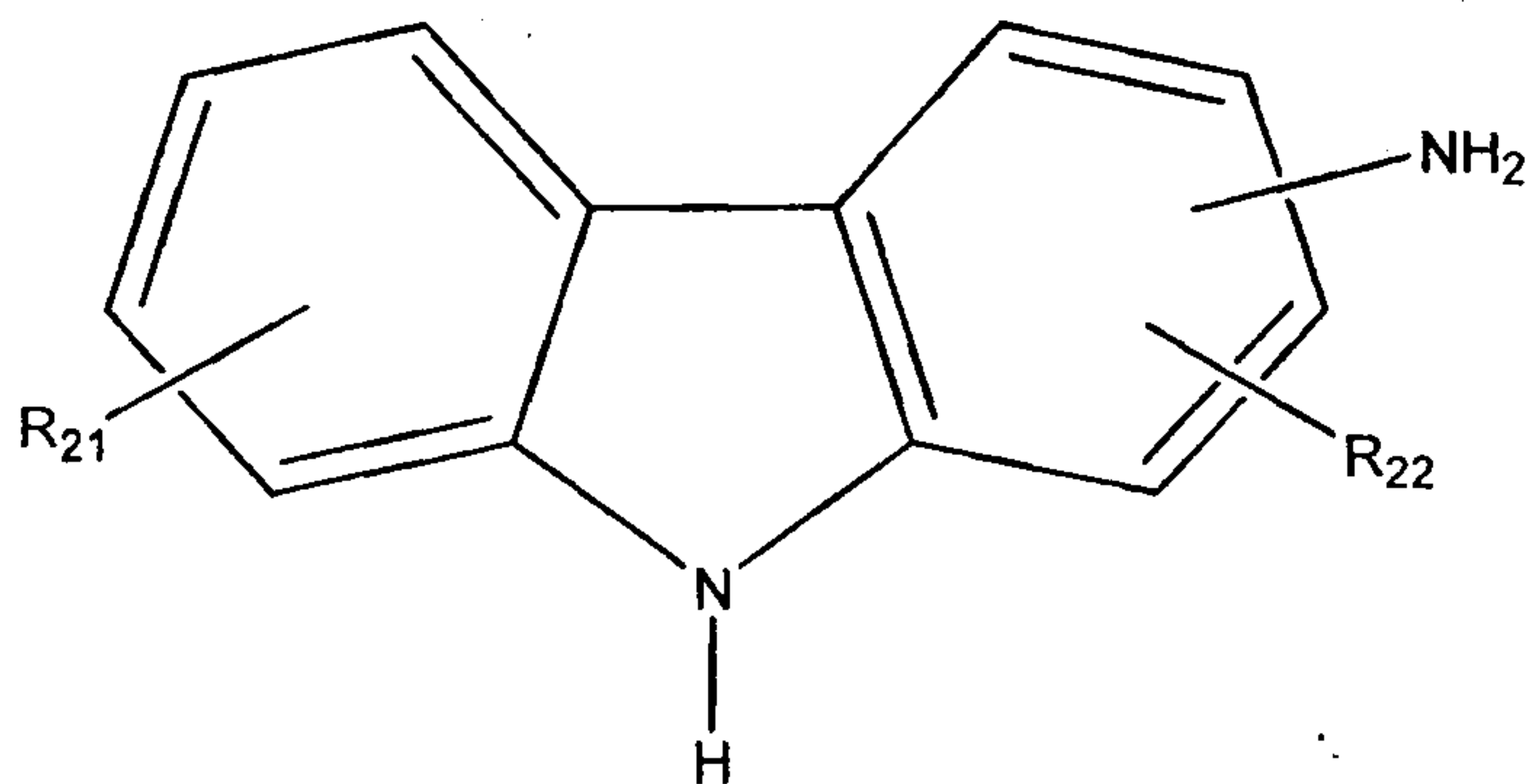
Particularly preferred N-arylphenylenediamines are N-phenylphenylenediamines (NPPDA), for example,

15

N-phenyl-1,4-phenylenediamine, N-phenyl-1,3-phenylenediamine, and N-phenyl-1,2-phenylenediamine and N-naphthyl-1,4-phenylenediamine. Other derivatives of NPPDA may also be included, such as N-propyl-N'-phenylphenylenediamine.

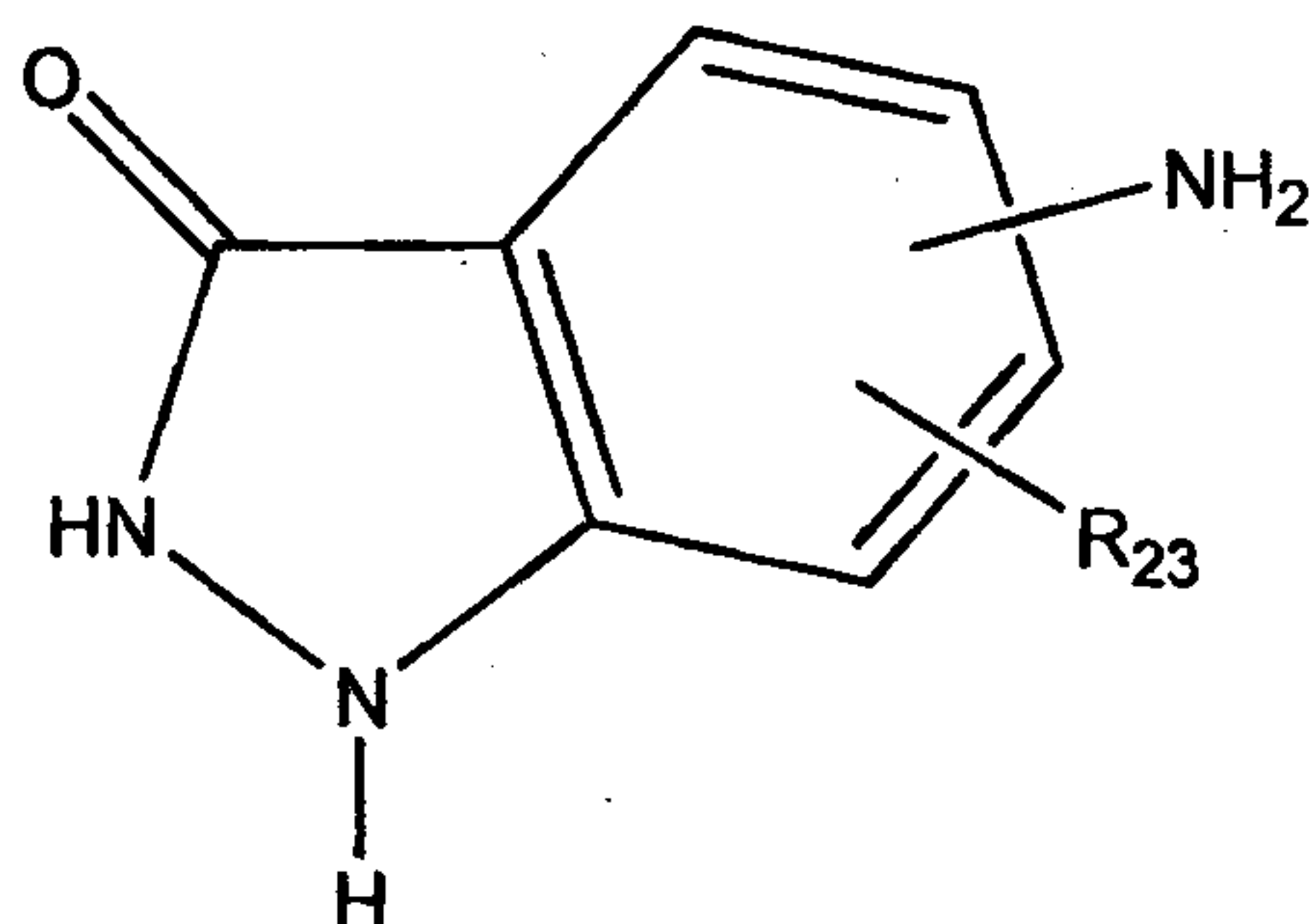
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(b) aminocarbazole represented by the formula:



in which R_{21} and R_{22} each independently represent hydrogen or an alkyl or alkenyl radical having from about 1 to about 14 carbon atoms,

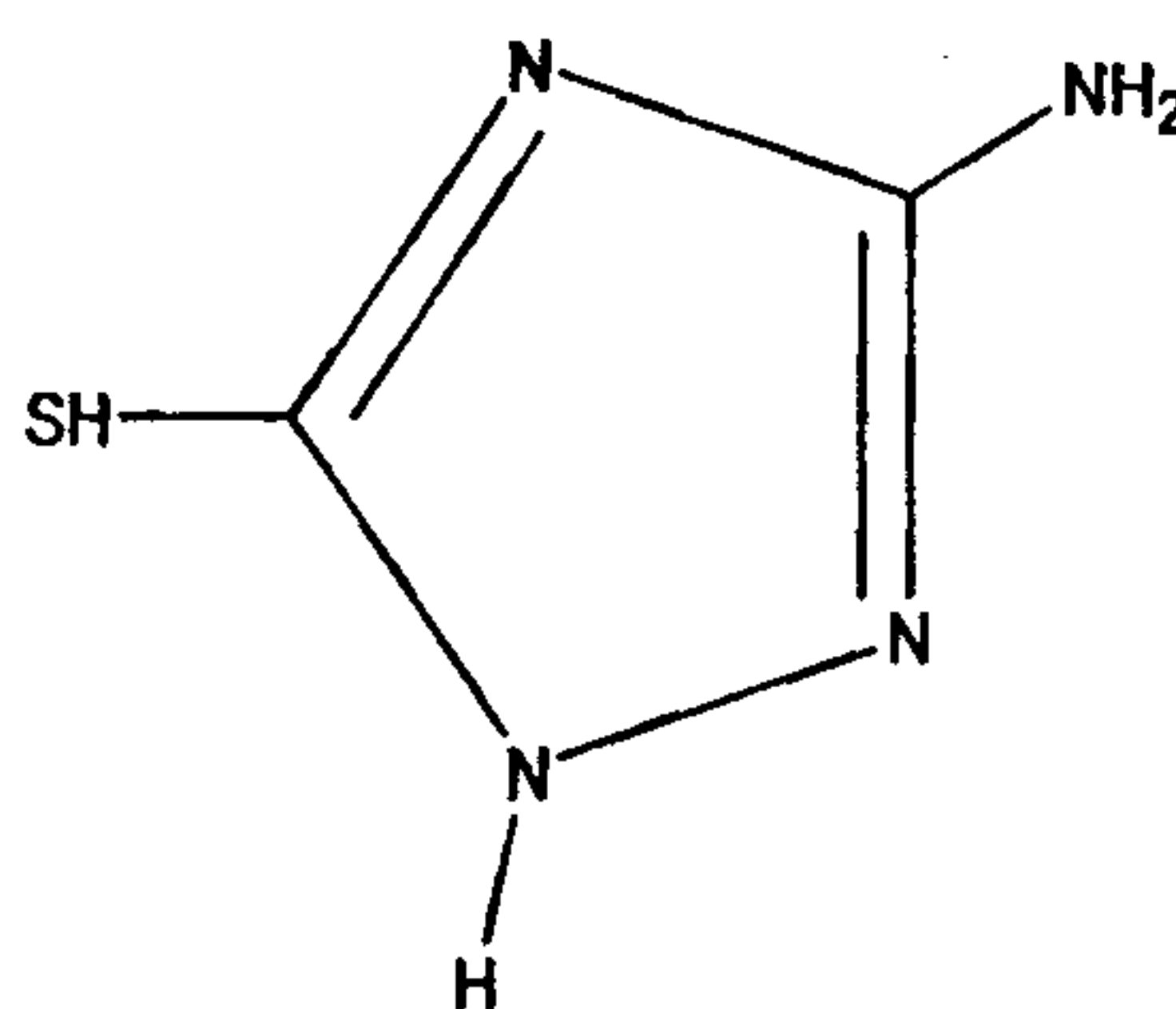
- (c) an amino-indazolinone represented by the formula:



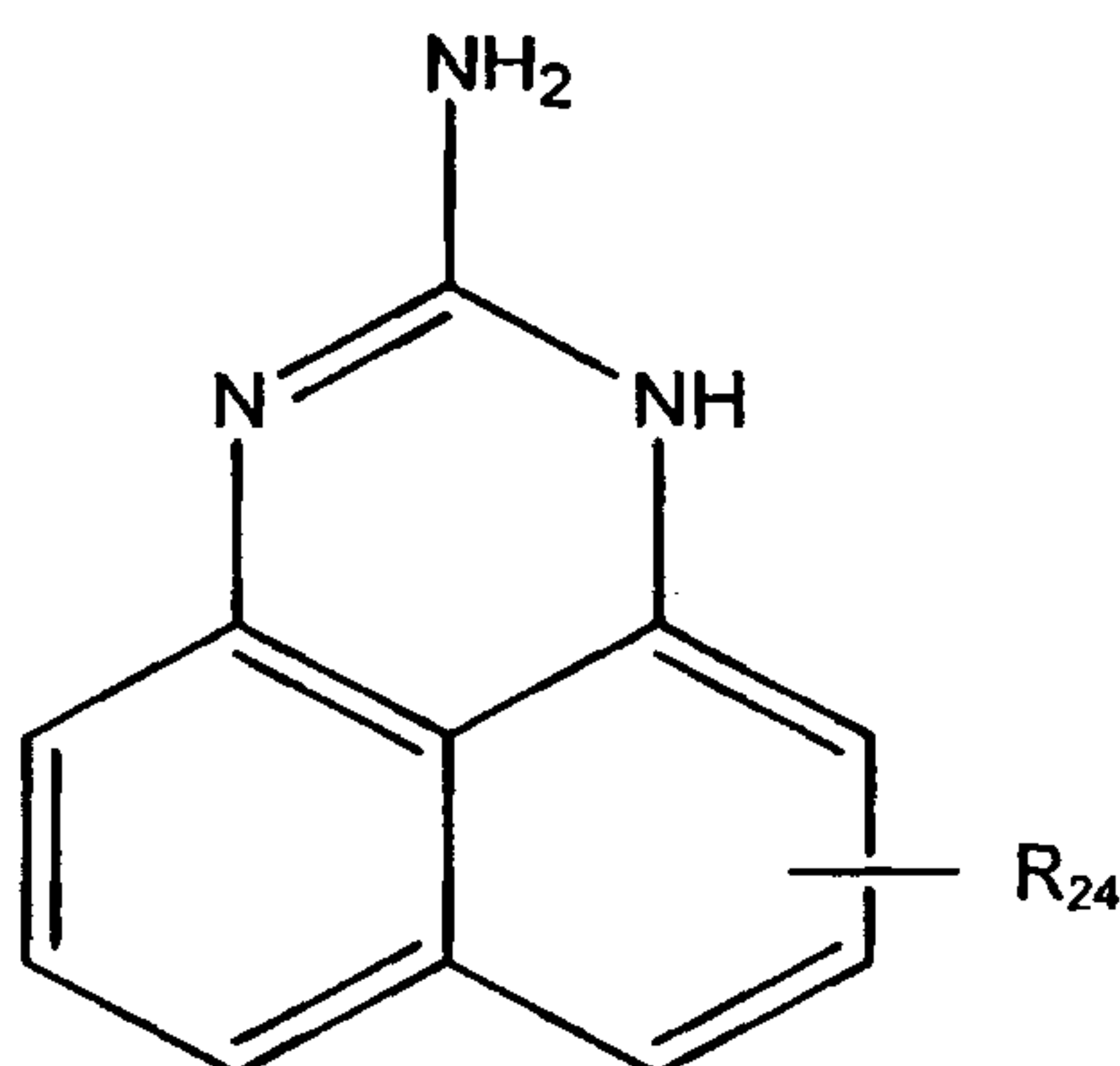
in which R_{23} is hydrogen or an alkyl radical having from about 1 to about 14 carbon atoms; and

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- (d) an aminomercaptotriazole represented by the formula:



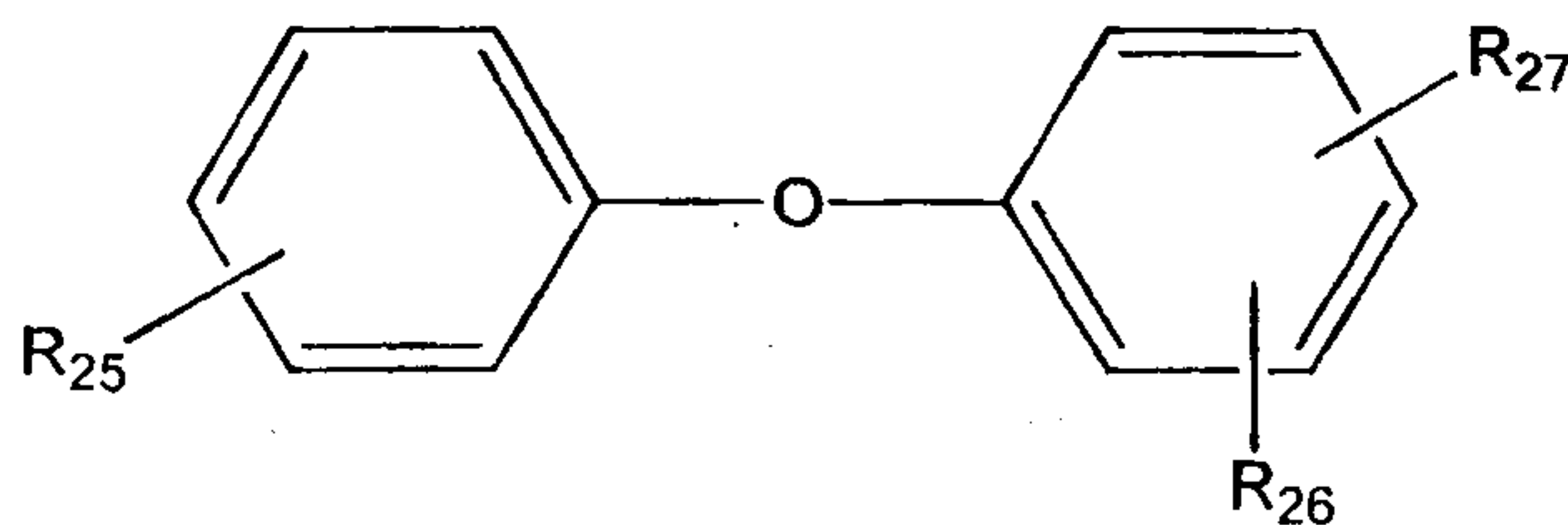
- (e) an aminoperimidine represented by the formula:



10

in which R_{24} represents hydrogen or an alkyl radical having from about 1 to about 14 carbon atoms;

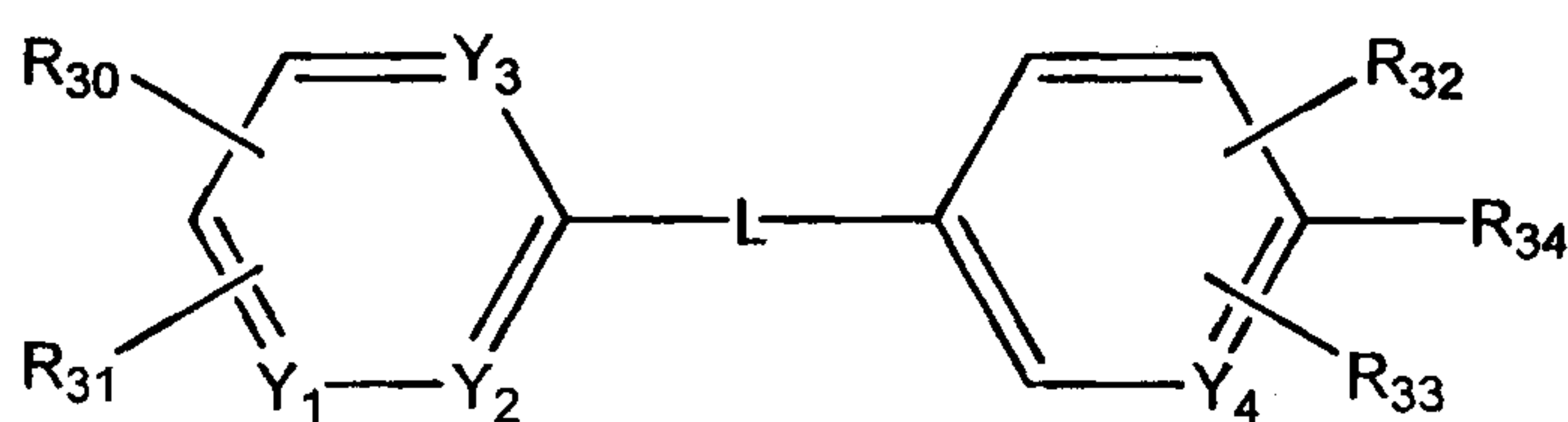
- (f) an aryloxyphenyleneamine represented by the formula:



in which R_{25} is H, --NHaryl, -NHalkaryl, or branched or straight chain radical having from about 4 to about 24 carbon atoms that can be alkyl, alkenyl, alkoxyl, aralkyl or alkaryl; R_{26} is --NH₂, --(NH(CH₂)_n)_m NH₂, --NHalkyl, or --NHaralkyl, in which n and m each have a value from about 1 to about 10; and R_{27} is hydrogen, alkyl, alkenyl, alkoxyl, aralkyl, or alkaryl, having from about 4 to about 24 carbon atoms; provided that when R_{25} is hydrogen or a branched or straight chain radical having from about 4 to about 24 carbon atoms selected from alkyl, alkenyl, alkoxyl, aralkyl or alkaryl, then R_{26} must be NH₂ or --(NH(CH₂)_n)_mNH₂, -CH₂-(CH₂)_n-NH₂, or -CH₂-aryl-NH₂.

A particularly preferred aryloxyphenyleneamine is 4-phenoxyaniline;

- (g) an aromatic amine comprising two aromatic groups, linked by a group, L, represented by the following formula:



wherein L is selected from -O-, -N=N-, -NH-, -CH₂NH-, -C(O)NR₂₈-, -C(O)O-, -SO₂-, -SO₂NR₂₉- or -SO₂NH-, wherein R₂₈ and R₂₉ independently represent a hydrogen, an alkyl, an alkenyl or an alkoxy group having from about 1 to about 8 carbon atoms;

wherein each Y₁, Y₂, Y₃ and Y₄ are independently N or CH provided that Y₁ and Y₂ may not both be N;

R_{30} and R_{31} independently represent a hydrogen, alkyl, aryl, alkaryl, aralkyl, alkoxy, hydroxyalkyl, aminoalkyl, -OH, -NO₂, -SO₃H, -SO₃Na, CO₂H or salt thereof, -NR₄₁R₄₂ wherein R₄₁ and R₄₂ are independently hydrogen, alkyl, aryl, arylalkyl, or alkaryl;

R_{32} and R_{33} independently represent a hydrogen, an alkyl, an alkenyl or an alkoxy group having from about 1 to about 8 carbon atoms, -OH, -SO₃H or -SO₃Na;

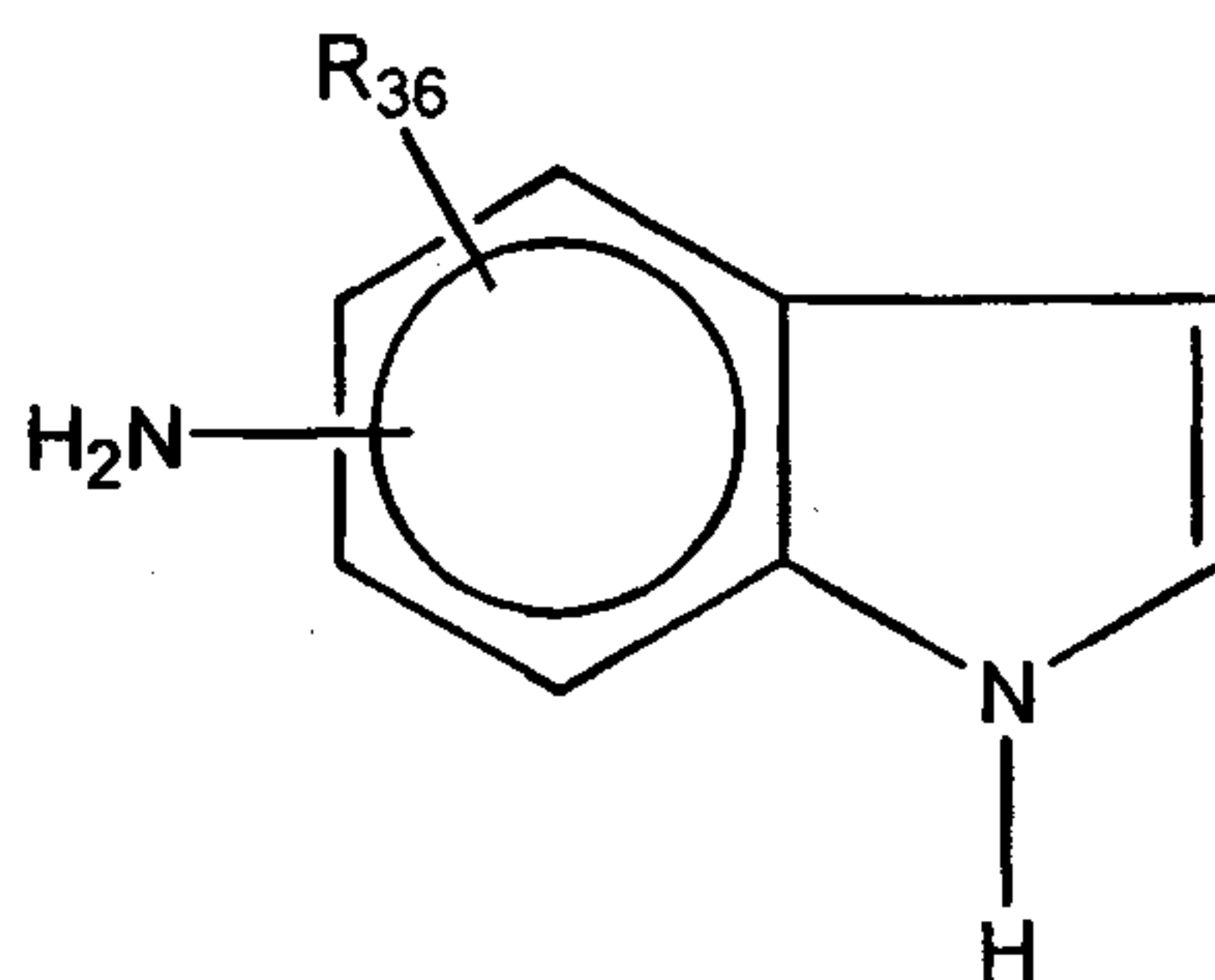
R_{34} represents $-NH_2$, $-NHR_{35}$, wherein R_{35} is an alkyl or an alkenyl group having from about 1 to about 8 carbon atoms, $-CH_2-(CH_2)_n-NH_2$ or $-CH_2$ -aryl- NH_2 and n is from 0 to about 10;

5

provided that when R_{34} is $-NHR_{35}$ wherein R_{35} is an alkyl or an alkenyl group having from about 1 to about 8 carbon atoms, then either L is $-NH-$ or $-CH_2-NH-$; or R_{30} or R_{31} is OH or $-NR_{41}R_{42}$ wherein at least one of R_{41} or R_{42} is hydrogen; or R_{32} or R_{33} is OH .

10

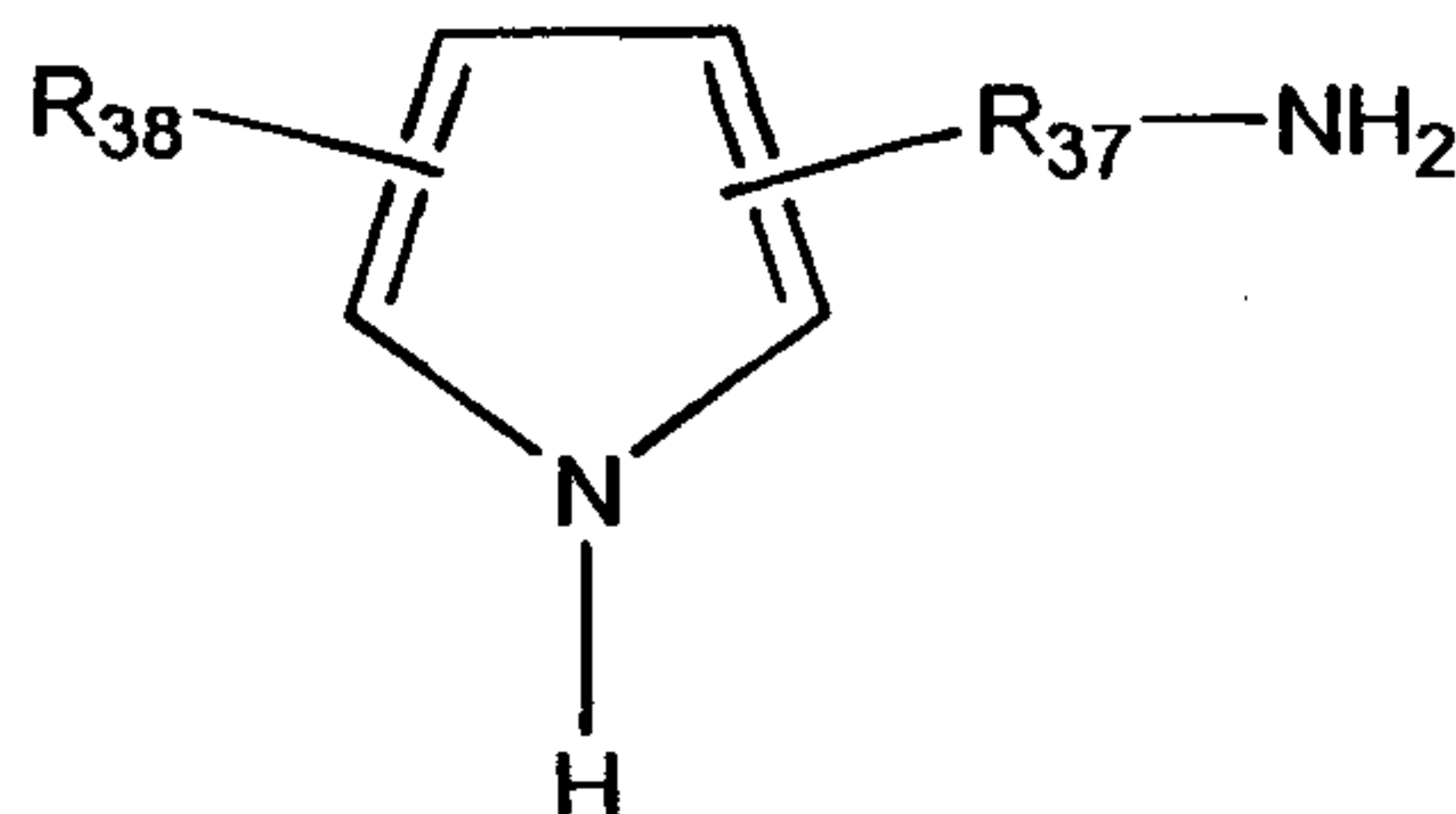
- (h) an aminothiazole selected from the group consisting of aminothiazole, aminobenzothiazole, aminobenzothiadiazole and aminoalkylthiazole;
- (i) an aminoindole represented by the formula:



15

wherein R_{36} represents a hydrogen, an alkyl or an alkenyl group having from about 1 to about 14 carbon atoms;

- (j) an aminopyrrole represented by the formula:



20

wherein R_{37} represents a divalent alkylene group having about 2 to about 6 carbon atoms and R_{38} represents a hydrogen, an alkyl or an alkenyl group having from about 1 to about 14 carbon atoms;

- (k) a ring substituted or unsubstituted aniline, such as nitroaniline or 4-aminoacetanilide;

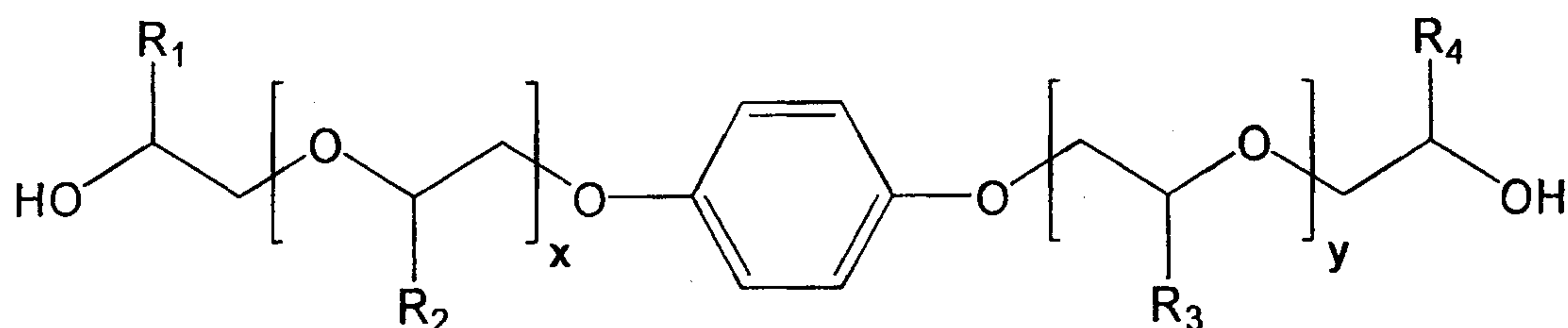
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- (l) an aminoquinoline;
- (m) an aminobenzimidazole;
- 5 (n) a N, N-dialkylphenylenediamine; and
- (o) a benzylamine.

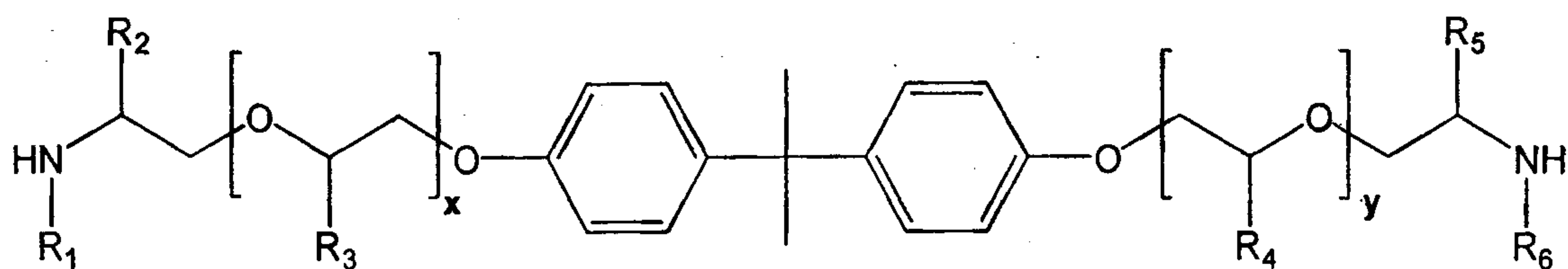
10 *Polyether Aromatic Compounds Derived from an Aromatic Compound Containing at Least Two Hydroxyl Groups*

In one embodiment, the polyether aromatic compound is a polyether aromatic compound which is derived from an aromatic compound containing at least two hydroxyl groups and wherein the polyether is capable of reacting with a
 15 monocarboxylic acid or ester thereof, or dicarboxylic acid, anhydride or ester thereof. In general, the polyether aromatic compound employed in this invention may be synthesized by reacting an aromatic compound containing at least two hydroxyl groups, such as hydroquinone or resorcinol, with an alkylene oxide compound to form polyether groups off the hydroxyl groups. Ethylene or propylene carbonate can also be
 20 used to form polyether groups off the hydroxyl groups. The terminal hydroxyl groups of the polyether moieties can be converted to amino groups via reductive amination or cyanoalkylation, utilizing techniques well known in the art.

Examples of suitable polyether aromatic hydroxyl compounds include compounds
 25 having the following structures:



In which R₁, R₂, R₃, and R₄ are independently hydrogen or alkyl containing from about 1 to about 6 carbon atoms or mixtures thereof; and x and y are independently integers from about 1 to about 50.

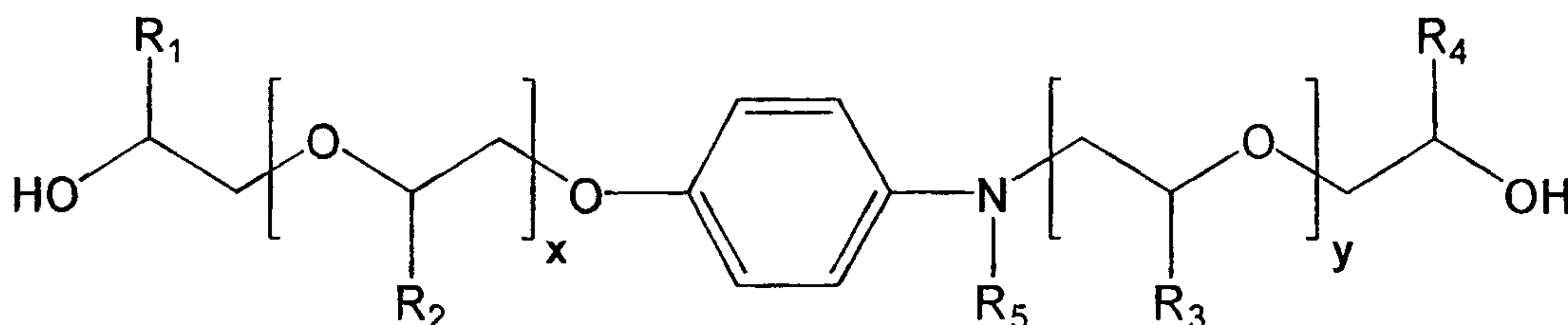


in which R_1 and R_6 are independently hydrogen, alkyl, alkaryl, aralkyl, or aryl or mixtures thereof; R_2 , R_3 , R_4 , and R_5 are independently hydrogen or alkyl containing from about 1 to about 6 carbon atoms or mixtures thereof; and x and y are independently integers from about 1 to about 50.

Typically, these compounds include polyether bisphenol-A, polyether catechol, polyether hydroquinone, and polyether resorcinol.

10 *Polyether Aromatic Compounds Derived from Aromatic Compounds Having at Least One Amine Group and at Least One Hydroxyl Group*

In another embodiment of the present invention, the polyether aromatic compound is derived from an aromatic compound having at least one amine group and at least one hydroxyl group. In general, the polyether aromatic compound employed in this invention may be synthesized by reacting an aromatic compound containing at least one hydroxyl group and at least one amine group, such as 4-aminophenol, with an alkylene oxide compound to form polyether groups off the hydroxyl group(s) and/or amino group(s). Ethylene or propylene carbonate can also be used to form polyether groups off the hydroxyl group(s) and/or amino group(s). The terminal hydroxyl group(s) of the polyether moieties can be converted to amino groups via reductive amination or cyanoalkylation, utilizing techniques well known in the art.



In which R_1 , R_2 , R_3 , and R_4 are independently hydrogen or alkyl containing from about 1 to about 6 carbon atoms or mixtures thereof; R_5 is hydrogen, alkyl, aryl, alkaryl, or aralkyl; and x and y are independently integers from about 1 to about 50.

In one embodiment the preferred polyether aromatic compound is derived from either N-arylphenylenediamine or phenoxyaniline. More preferred, the polyether aromatic compound is derived from N-arylphenylenediamine. Particularly preferred N-arylphenylenediamines are the N-phenylphenylenediamines, such as for example, N-phenyl-1,4-phenylenediamine, N-phenyl-1,3-phenylenediamine, and N-phenyl-1,2-phenylenediamine.

In one embodiment, the preferred polyether aromatic compound is derived from 4-(4-nitrophenylazo)aniline, 4-phenylazoaniline, N-(4-aminophenyl) acetamide, 4-benzoylamine-2,5-dimethoxyaniline, 4-phenoxy aniline, or 3-nitroniline.

(C) Additional Reactants

Optionally, in addition to the ether compound (i.e. polyether aromatic compound) above, the copolymer may also be reacted with (1) at least one other ether compound as defined herein; (2) at least one aromatic compound capable of reacting with at least one monocarboxylic acid or ester thereof; or dicarboxylic acid, anhydride or ester thereof, or mixtures thereof; (3) at least one aliphatic compound capable of reacting with at least one monocarboxylic acid or ester thereof; or dicarboxylic acid, anhydride or ester thereof, or mixtures thereof; or mixtures thereof of (1), (2) or (3).

20

The Ether Compounds

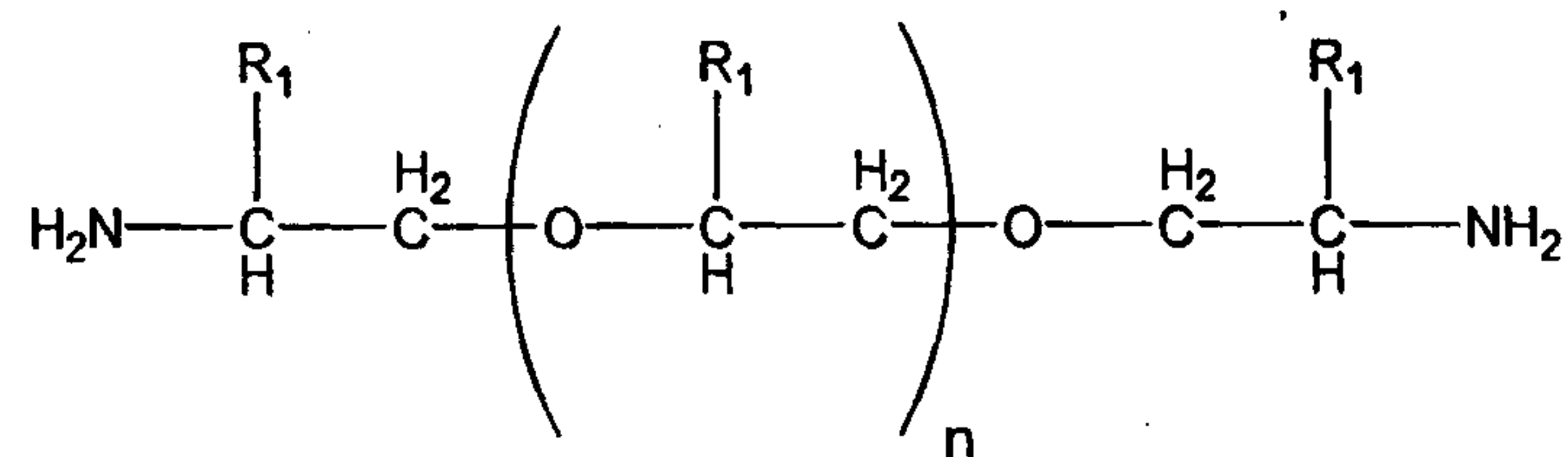
In one embodiment of the present invention, optionally, the copolymer may be further reacted with an ether compound capable of being reacted with at least two monocarboxylic acids or esters thereof, or with at least two dicarboxylic acids, anhydrides, or esters thereof, or mixtures thereof.

25

Suitable ether compounds include, but are not limited to, the following:

Polyether Polyamines

Examples of suitable polyetheramines include compounds having the following structure:



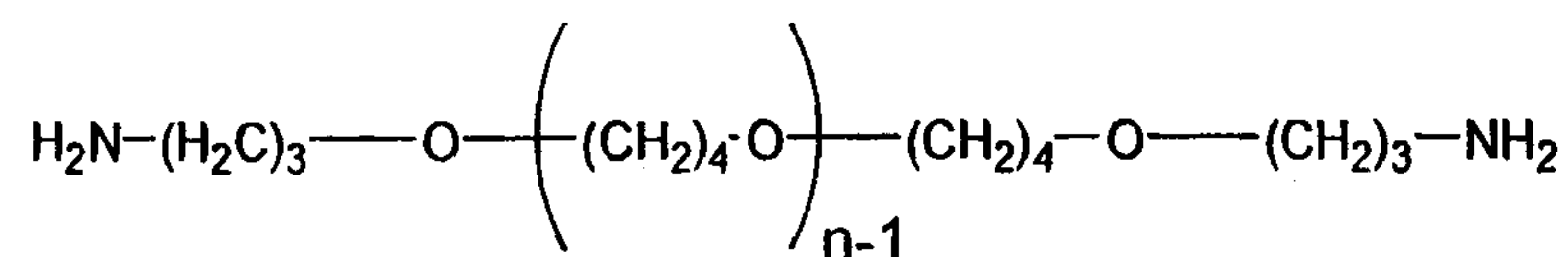
- 5 wherein R_1 is independently hydrogen or a hydrocarbyl group having 1 to 4 carbons, and n is the degree of polymerization. Generally the polyether polyamines suitable for use in the present invention will contain at least about one ether unit, preferably from about 5 to about 100, more preferably from about 10 to 50, and even more preferably from about 15 to about 25 ether units.

10

The polyether polyamines can be based on polymers derived from C_2 - C_6 epoxides such as ethylene oxide, propylene oxide, and butylene oxide. Examples of polyether polyamines are sold under the Jeffamine® brand and are commercially available from Hunstman Corporation located in Houston, Texas.

15

Other examples of suitable polyetheramines include polyoxytetramethylene polyamine compounds having the following structure:



wherein n is the degree of polymerization (i.e., number of monomer ether units).

20

Polyether Amine Derivatives

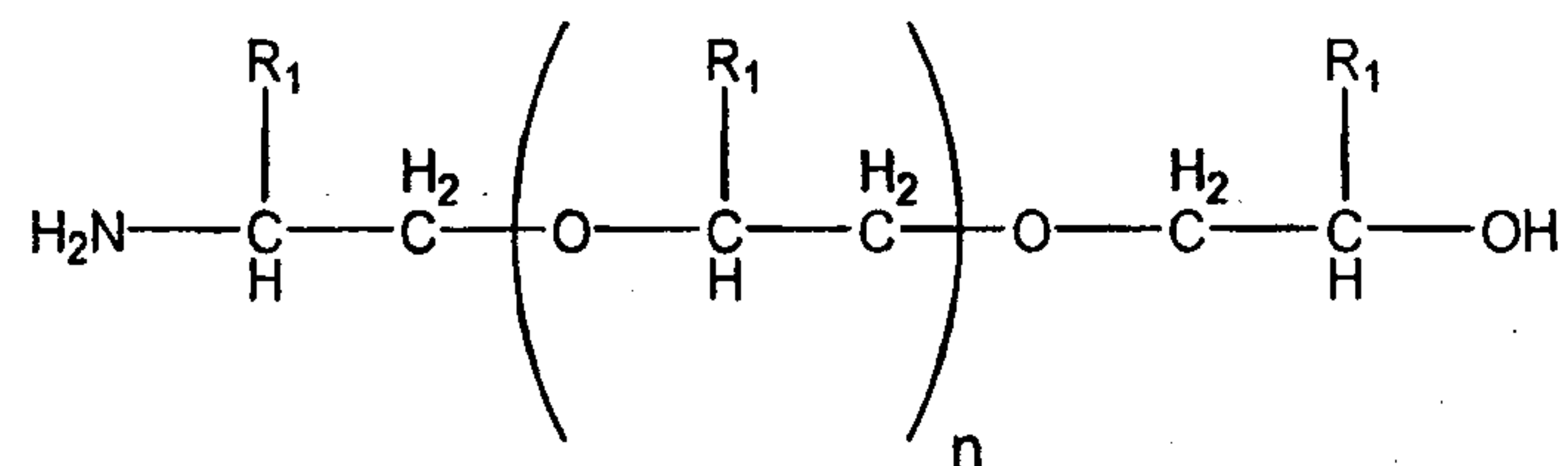
Furthermore, the copolymer reactant may be reacted with a polyether amino alcohol or amino thiol.

25 *Polyether Amino Alcohol*

Typically, amino alcohols may be formed when the alcohol end groups of a compound are not completely converted to amines during reactions, such as reductive amination. Also, one may initiate a polymer chain (i.e. grow propylene or ethylene

oxide) from an amino group and therefore have an amino on one end of the polymer chain (i.e. initiator) and an alcohol terminus, or an amine internally in the molecule with alcohol termini.

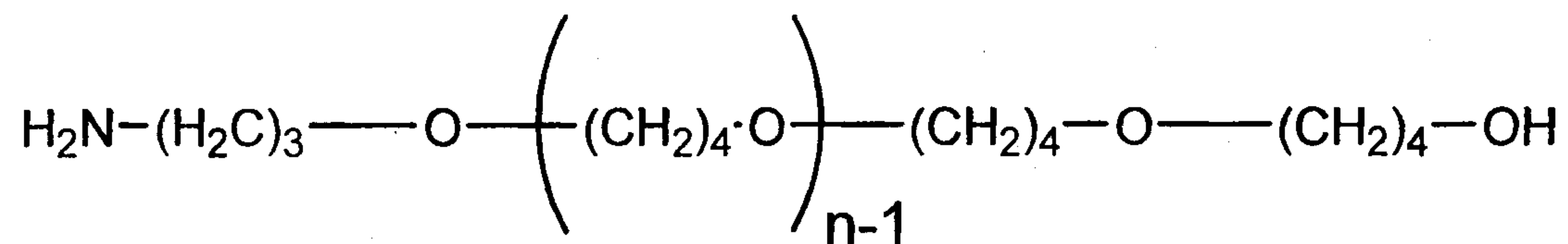
- 5 Examples of suitable polyetheramino alcohols include compounds having the following structure:



- wherein R_1 is independently a hydrogen or hydrocarbyl group, having 1 to 4 carbons, and n is the degree of polymerization. Generally, the polyether amino alcohols, suitable for use in the present invention will contain at least about one ether unit, preferably from about 5 to about 100, more preferably from about 10 to about 50, and even more preferably from about 15 to about 25 ether units.
- 10

Other examples of suitable polyetheramino alcohols include

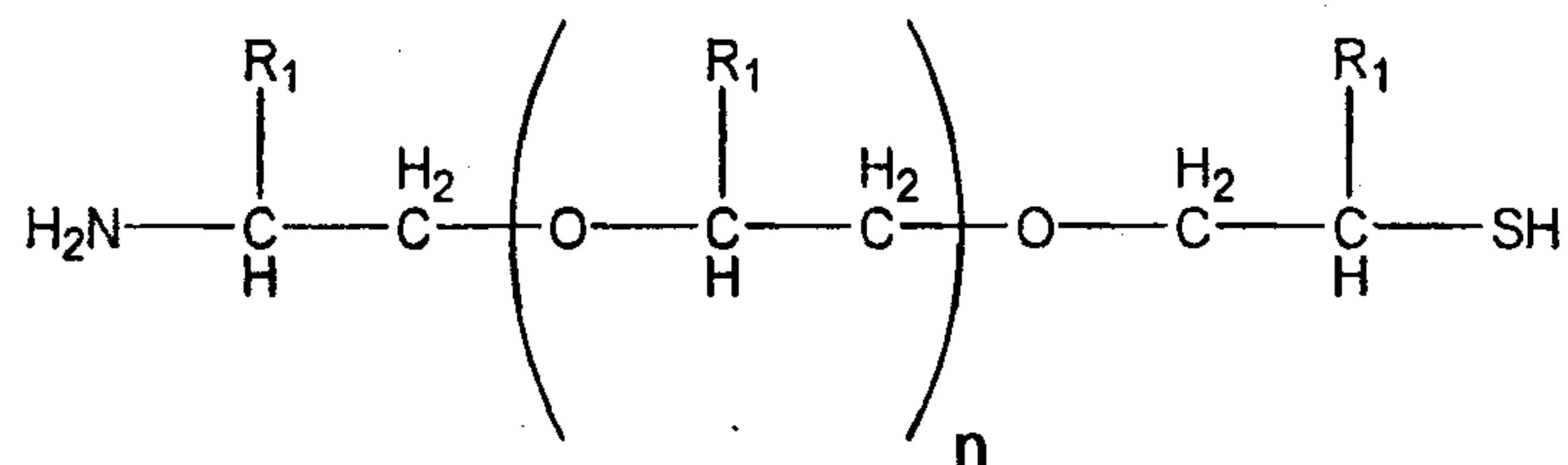
- 15 polyoxytetramethyleneamino alcohol compounds having the following structure:



wherein n is the degree of polymerization.

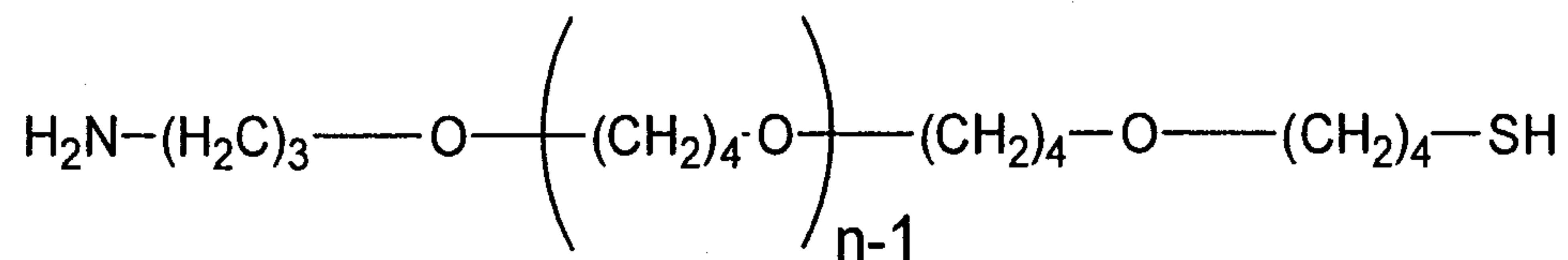
Polyether Amino Thiol

- 20 Examples of suitable polyetheramino thiols include compounds having the following structure:



wherein R_1 is independently a hydrogen or hydrocarbyl group, having 1 to 4 carbons and n is the degree of polymerization.

Other examples of suitable polyetheramino thiols include polyoxytetramethyleneamino thiol having the following structure:



5 wherein n is the degree of polymerization.

Generally, the polyetheramino thiols suitable for use in the present invention will contain at least about one ether unit, preferably from about 5 to about 100, more preferably from about 10 to about 50, and even more preferably from about 15 to
10 about 25 ether units.

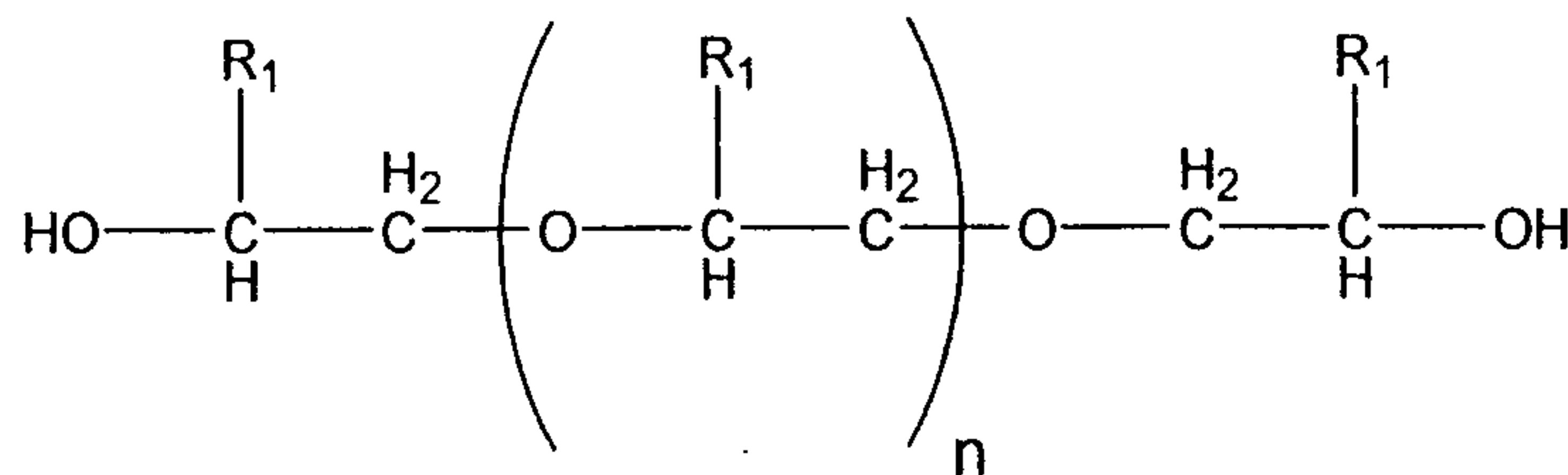
Ether Polyamines

Ether Diamines

In yet another embodiment of the present invention, the copolymer may be reacted
15 with ether diamines. Suitable diamines are reacted with the copolymer, such as decyloxypropyl-1,3-diaminopropane, isodecyloxypropyl-1,3-diaminopropane, isododecyloxypropyl-1,3-diaminopropane, dodecyl/tetradecyloxypropyl-1,3-diaminopropane, isotridecyloxypropyl-1,3-diaminopropane, tetradecyloxypropyl-1,3-diaminopropane.
20

Polyether Polyol

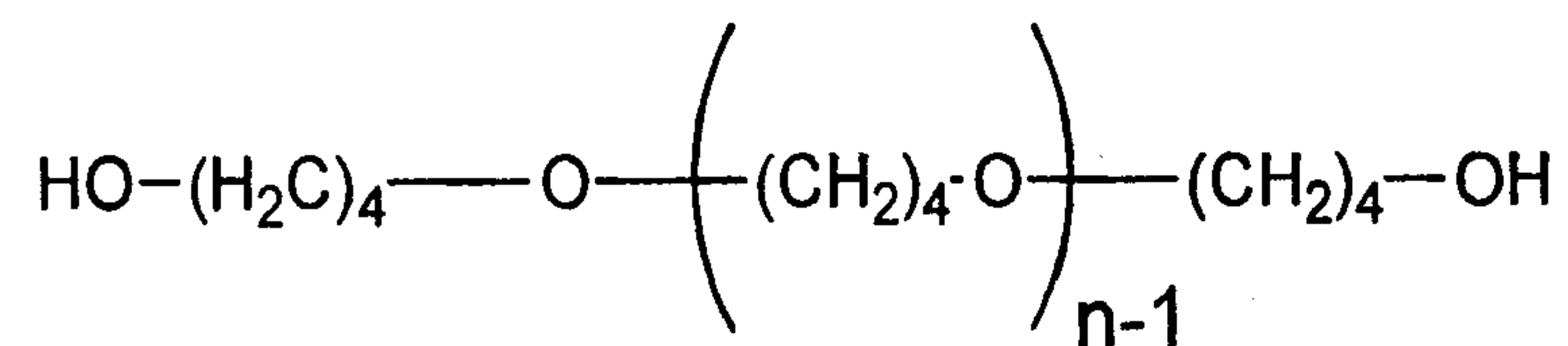
In yet another embodiment of the present invention, the copolymer may be reacted with a polyether containing at least two hydroxyl end groups to form an ester. The polyether polyols have the following structure:



25

wherein R_1 is independently a hydrogen or hydrocarbyl group, having 1 to 4 carbons, and n is the degree of polymerization.

Other examples of suitable polyether polyols include polyoxytetramethylene polyol compounds, such as those referred to as Terathane® which may be purchased from DuPont Corporation, Wilmington, Delaware, having the following structure:



5

wherein n is the degree of polymerization.

Suitable polyether polyols include, but are not limited to, the following:

polyoxyethylene glycol, polyoxypropylene glycol, polyoxybutylene glycol, and
10 polyoxytetramethylene glycol.

The molecular weight of the presently employed polyether polyol will generally range from about 150 to about 5000, preferably from about 500 to about 2000.

15 Generally, the polyether compounds suitable for use in the present invention will contain at least one ether unit preferably from about 5 to about 100, more preferably from about 10 to about 50, and even more preferred from about 15 to about 25 ether units.

20 Generally, the polyether compounds suitable for use in the present invention may be derived from only one ether type or a mixture of ether types, such as poly(oxyethylene-co-oxypropylene) diamine. The mixture of ether units may be block, random, or alternating copolymers. The presently employed ether compounds are capable of reacting with at least two carboxylic acid groups or anhydride
25 derivatives thereof.

Generally, the copolymer may be reacted with a mixture of polyether polyamines, polyether amino alcohols, polyether amino thiols, polyether polyols, or ether diamines to form a mixture of imides, amides and esters.

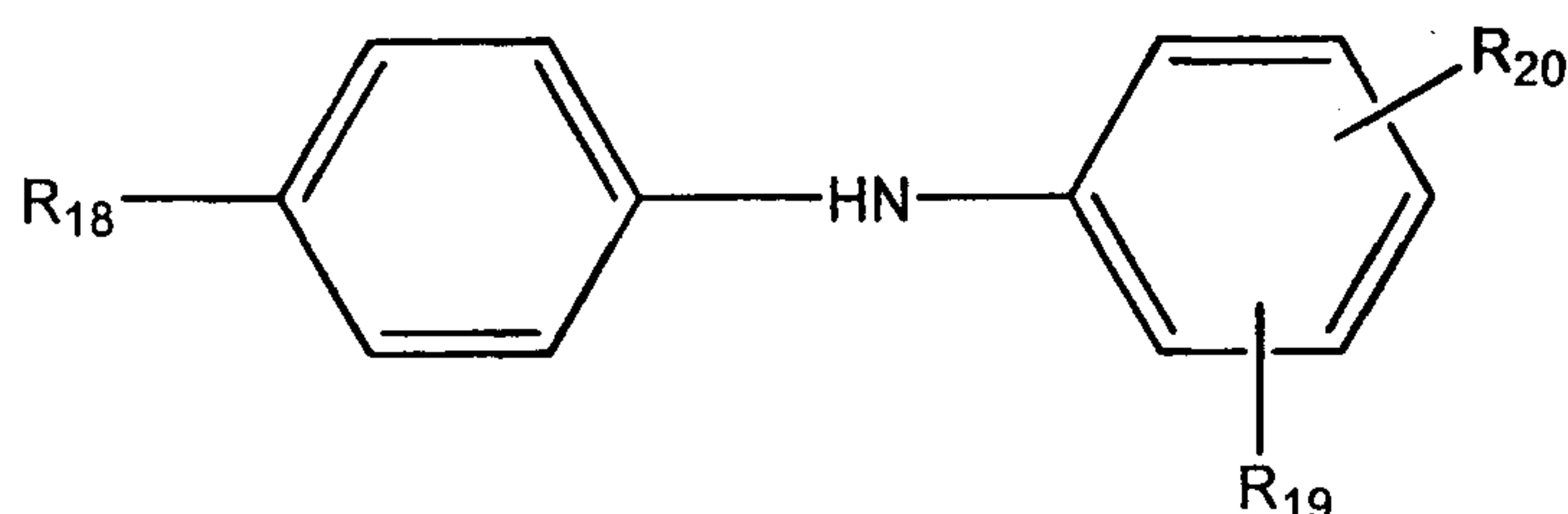
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Aromatic Compounds

Optionally, in addition to the ether compound (i.e. polyether aromatic compound) above, the copolymer may also be reacted with at least one aromatic compound capable of reacting with at least one monocarboxylic acid or ester thereof; or
 5 dicarboxylic acid, anhydride or ester thereof.

Preferably, the aromatic compound is selected from the following group of aromatic compounds consisting of:

- 10 (a) an N-arylphenylenediamine represented by the formula:

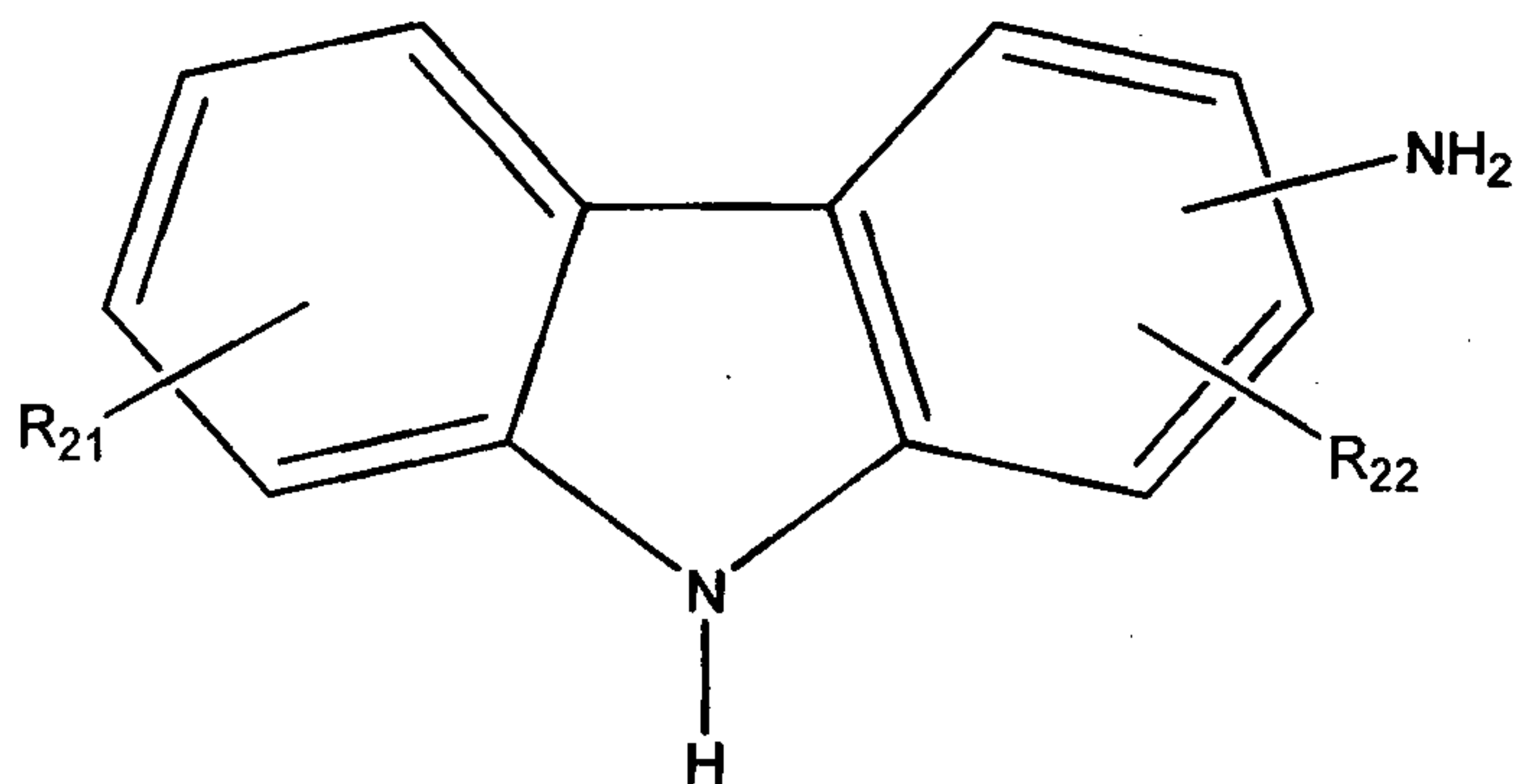


- R_{18} is H, --NHaryl, -NHalkaryl, or a branched or straight chain hydrocarbyl radical having from about 4 to about 24 carbon atoms selected from alkyl, alkenyl, alkoxyl, aralkyl or alkaryl; R_{19} is --NH₂, --(NH(CH₂)_n)_mNH₂, --NHalkyl, --NHaralkyl, --CH₂--aryl--NH₂, in which n and m each have a value
 15 from about 1 to about 10; and R_{20} is hydrogen, alkyl, alkenyl, alkoxyl, aralkyl, or alkaryl, having from about 4 to about 24 carbon atoms.

- Particularly preferred N-arylphenylenediamines are N-phenylphenylenediamines (NPPDA), for example,
 20 N-phenyl-1,4-phenylenediamine, N-phenyl-1,3-phenylenediamine, and N-phenyl-1,2-phenylenediamine and N-naphthyl-1,4-phenylenediamine. Other derivatives of NPPDA may also be included, such as N-propyl-N'-phenylphenylenediamine.

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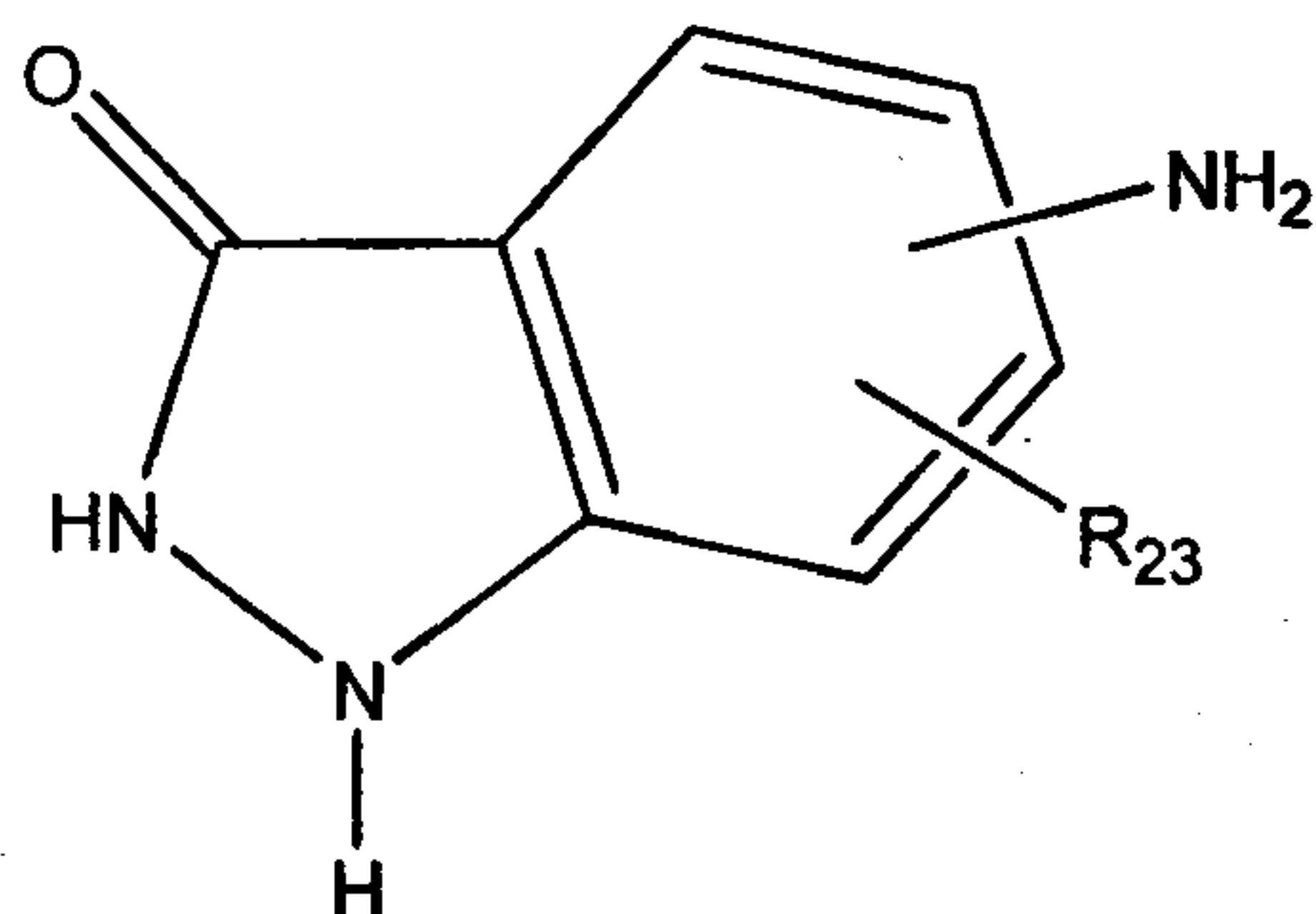
- (b) aminocarbazole represented by the formula:



in which R_{21} and R_{22} each independently represent hydrogen or an alkyl or alkenyl radical having from about 1 to about 14 carbon atoms,

5

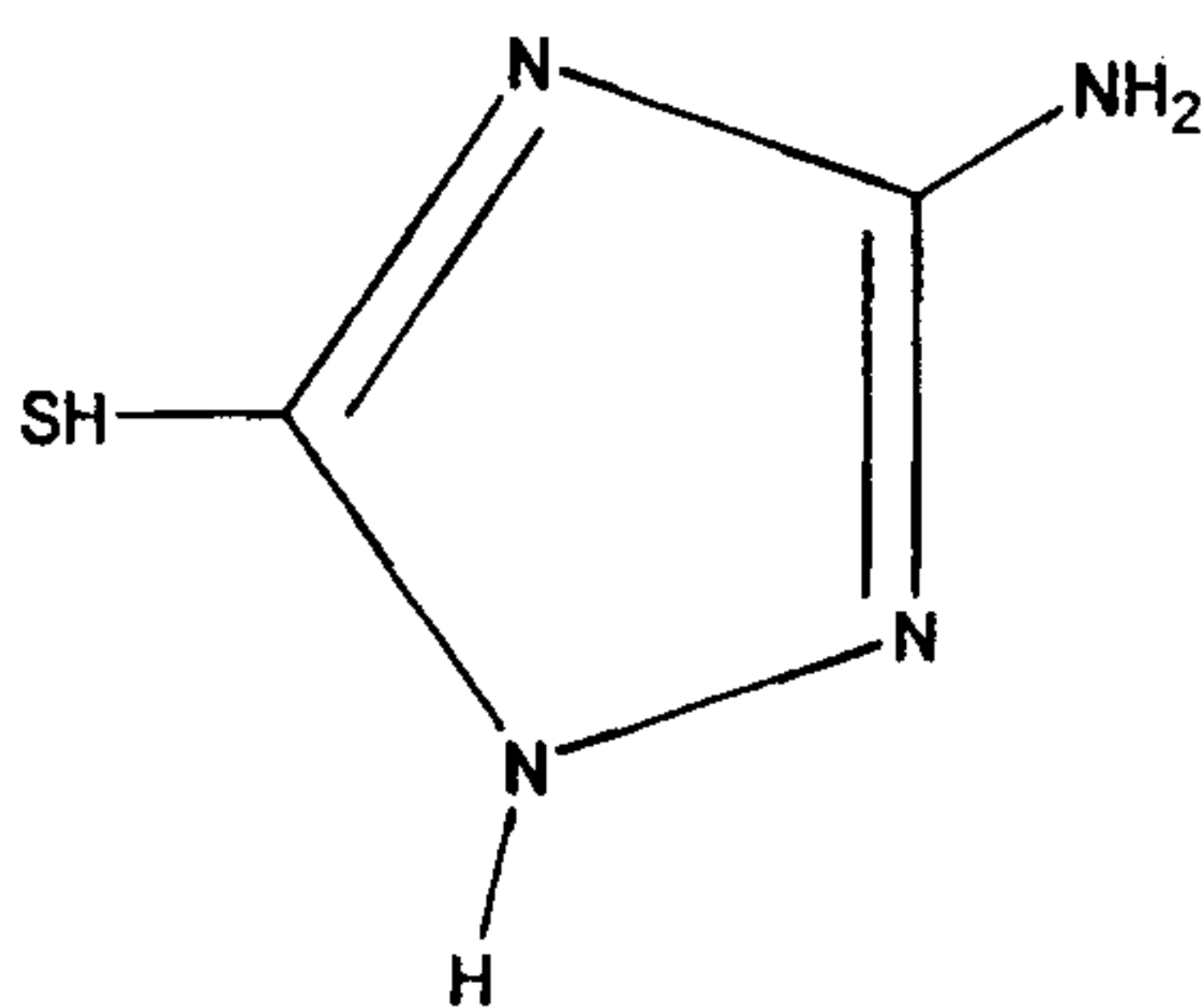
- (c) an amino-indazolinone represented by the formula:



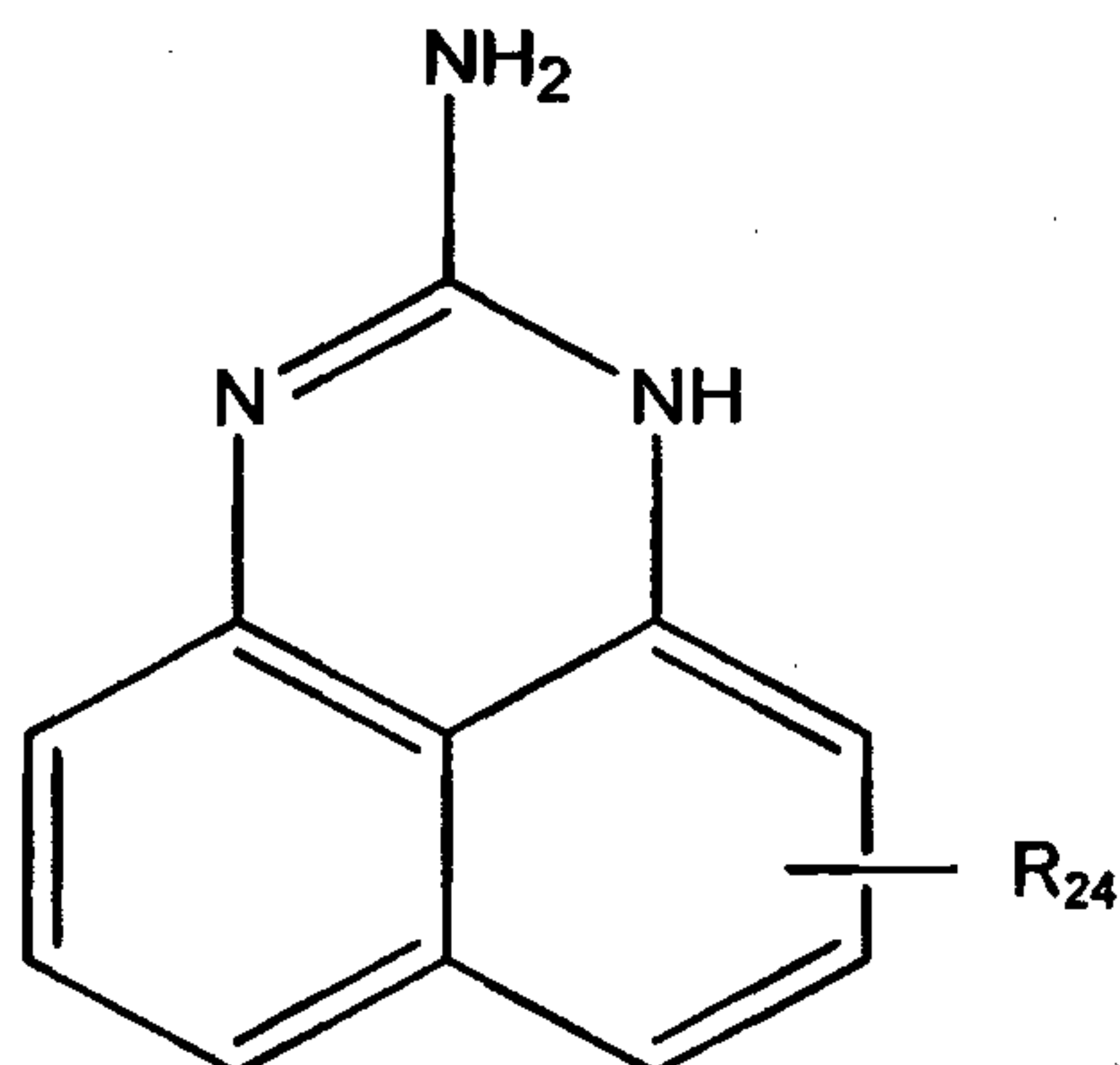
in which R_{23} is hydrogen or an alkyl radical having from about 1 to about 14 carbon atoms; and

10

- (d) an aminomercaptotriazole represented by the formula:



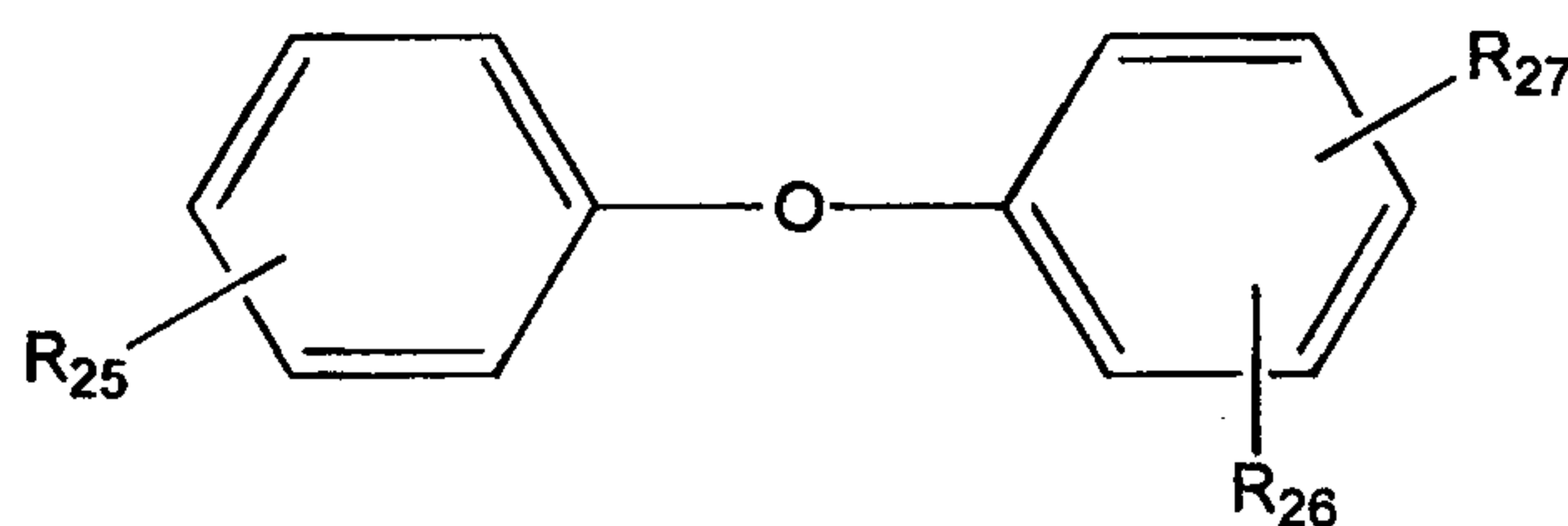
- (e) an aminoperimidine represented by the formula:



in which R_{24} represents hydrogen or an alkyl radical having from about 1 to about 14 carbon atoms;

5

- (f) an aryloxyphenyleneamine represented by the formula:



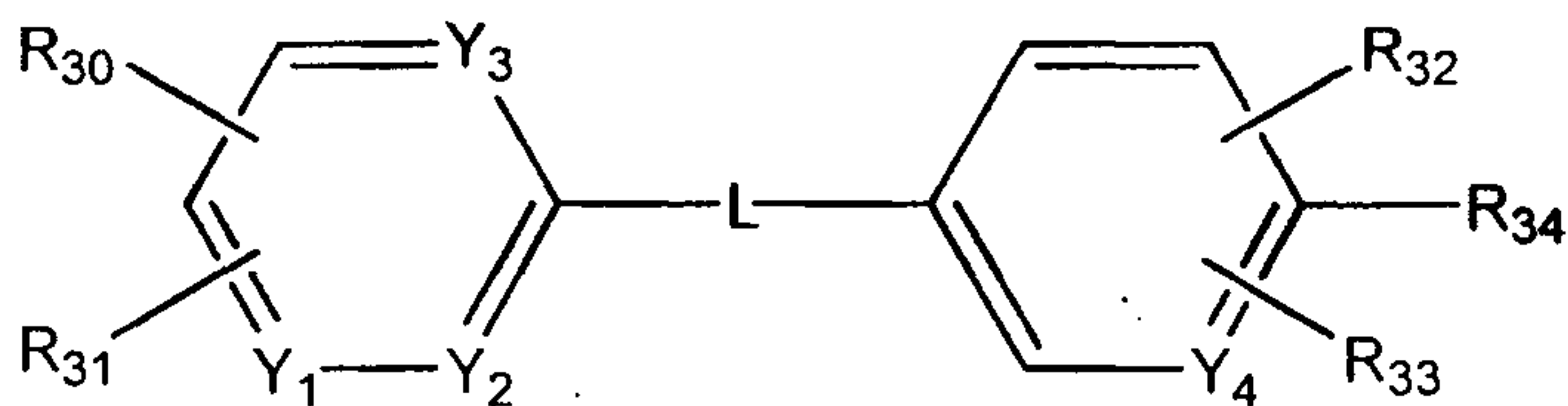
in which R_{25} is H, --NHaryl, --NHalkaryl, or branched or straight chain radical having from about 4 to about 24 carbon atoms that can be alkyl, alkenyl, alkoxy, aralkyl or alkaryl; R_{26} is --NH₂, --(NH(CH₂)_n)_m NH₂, --NHalkyl, or --NHaralkyl, in which n and m each have a value from about 1 to about 10; and R_{27} is hydrogen, alkyl, alkenyl, alkoxy, aralkyl, or alkaryl, having from about 4 to about 24 carbon atoms;

10

15

A particularly preferred aryloxyphenyleneamine is 4-phenoxyaniline;

- (g) an aromatic amine comprising two aromatic groups, linked by a group, L, represented by the following formula:



20

wherein L is selected from --O-, --N=N-, --NH-, --CH₂NH-, --C(O)NR₂₈-, --C(O)O-, --SO₂-, --SO₂NR₂₉- or --SO₂NH-, wherein R_{28} and R_{29} independently represent

a hydrogen, an alkyl, an alkenyl or an alkoxy group having from about 1 to about 8 carbon atoms;

5 wherein each Y_1 , Y_2 , Y_3 and Y_4 are independently N or CH provided that Y_1 and Y_2 may not both be N;

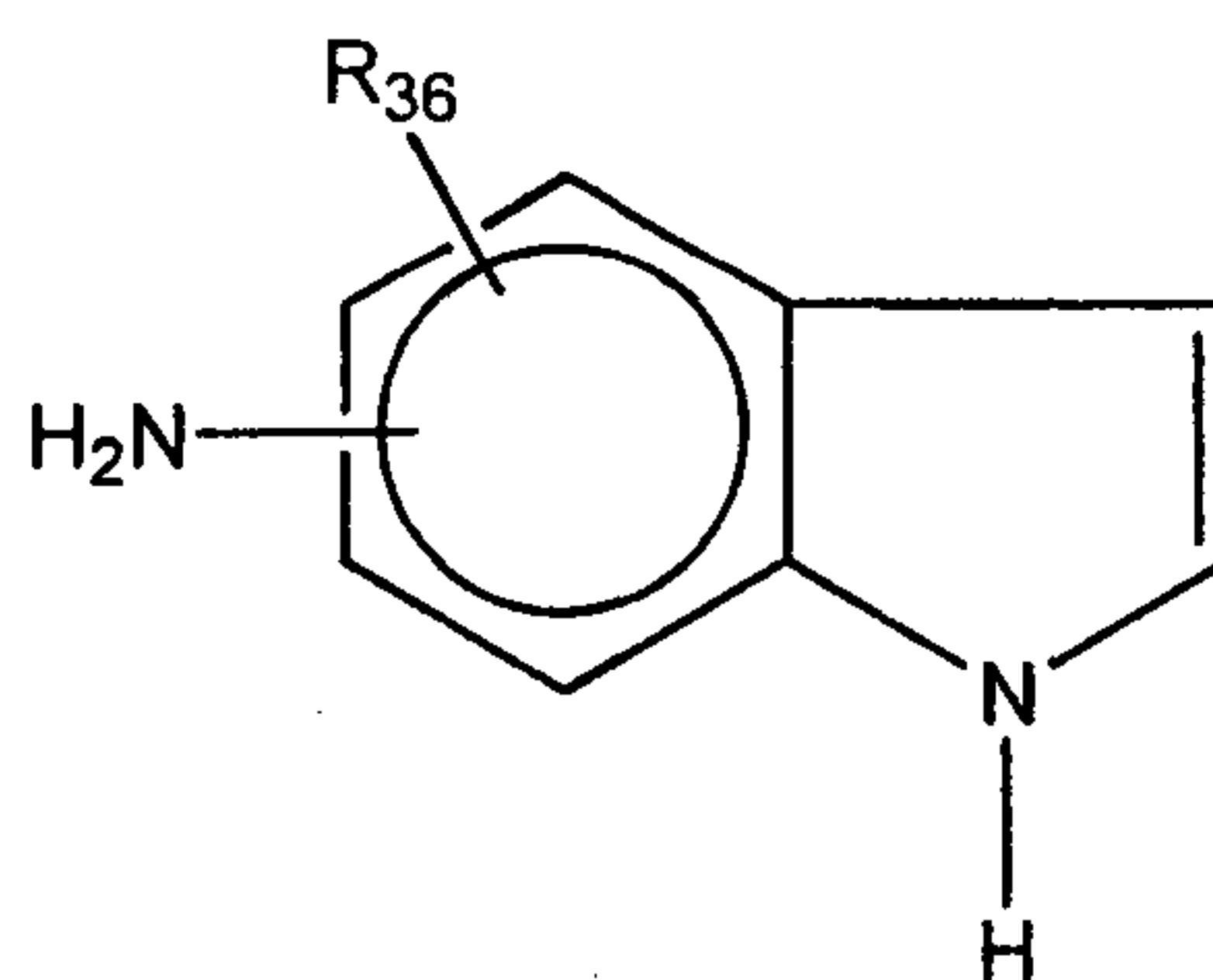
10 R_{30} and R_{31} independently represent a hydrogen, alkyl, aryl, alkaryl, aralkyl, alkoxy, hydroxyalkyl, aminoalkyl, -OH, -NO₂, -SO₃H, -SO₃Na, CO₂H or salt thereof, -NR₄₁R₄₂ wherein R_{41} and R_{42} are independently hydrogen, alkyl, aryl, arylalkyl, or alkaryl;

15 R_{32} and R_{33} independently represent a hydrogen, an alkyl, an alkenyl or an alkoxy group having from about 1 to about 8 carbon atoms, -OH, -SO₃H or -SO₃Na;

R_{34} represents -NH₂, -NHR₃₅, wherein R_{35} is an alkyl or an alkenyl group having from about 1 to about 8 carbon atoms, -CH₂-(CH₂)_n-NH₂ or -CH₂-aryl-NH₂ and n is from 0 to about 10;

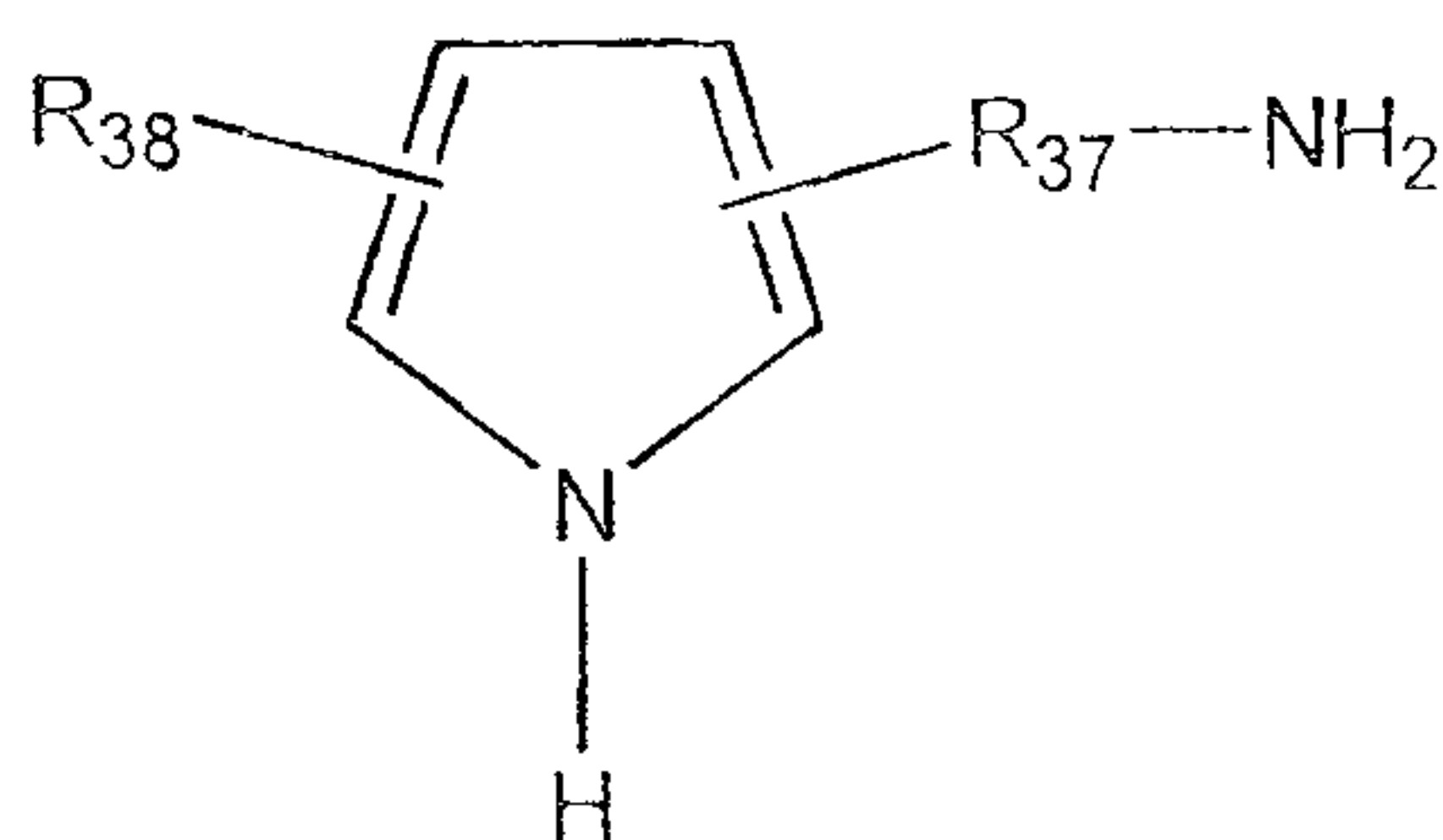
20 (h) an aminothiazole selected from the group consisting of aminothiazole, aminobenzothiazole, aminobenzothiadiazole and aminoalkylthiazole;

(i) an aminoindole represented by the formula:



25 wherein R_{36} represents a hydrogen, an alkyl or an alkenyl group having from about 1 to about 14 carbon atoms;

- (j) an aminopyrrole represented by the formula:



wherein R_{37} represents a divalent alkylene group having about 2 to about 6 carbon atoms and R_{38} represents a hydrogen, an alkyl or an alkenyl group having from about 1 to about 14 carbon atoms;

- (k) a ring substituted or unsubstituted aniline, such as nitroaniline or 4-aminoacetanilide;
- (l) an aminoquinoline;
- (m) an aminobenzimidazole;
- (n) a N, N-dialkylphenylenediamine;
- (o) a benzylamine; and
- (p) a benzyl alcohol.

The compounds described above in (g) – (o) are substantially described, for example, in Published U.S. Patent Application No. US20060025316.

The above-described amine compounds can be used alone or in combination with each other. Other aromatic amines can include such amines as aminodiphenylamine. These additional amines can be included for a variety of reasons.

In one embodiment, the preferred aromatic amine compound is either N-arylphenylenediamine or phenoxyaniline. More preferred, the aromatic amine

compound is N-arylphenylenediamine. Particularly preferred N-arylphenylenediamines are the N-phenylphenylenediamines, such as for example, N-phenyl-1,4-phenylenediamine, N-phenyl-1,3-phenylenediamine, and N-phenyl-1,2-phenylenediamine.

5

In one embodiment, the preferred aromatic compound is 4-(4-nitrophenylazo)aniline, 4-phenylazoaniline, N-(4-aminophenyl) acetamide, 4-benzoylamine-2,5-dimethoxyaniline, 4-phenoxy aniline, or 3-nitroniline.

10 *Aliphatic Compound*

Optionally, in addition to the ether compound (i.e. polyether aromatic compound) above, the copolymer may also be reacted with at least one aliphatic compound capable of reacting with at least one monocarboxylic acid or ester thereof; or dicarboxylic acid, anhydride or ester thereof. Preferably, the aliphatic compound will
15 contain one or more amino functional groups or one or more hydroxyl functional groups or both.

Amino Aliphatic Compound

In addition to the ether compound (i.e. polyether aromatic compound) above,
20 optionally, the copolymer may also be reacted with at least one aliphatic compound which may be an amino aliphatic compound.

The amino aliphatic compound may be selected from the group comprising of (a) aliphatic monoamines, (b) aliphatic diamines, (c) aliphatic polyamines or (d)
25 polyalkylene polyamines. Aliphatic monoamines include methylamine, ethylamine, propylamine and various higher amines. Diamines or polyamines may also be employed. Preferably, they will have only a single reactive amino group, that is, a primary or secondary, and preferably primary group. Suitable examples of diamines include dimethylaminopropylamine, diethylaminopropylamine, dibutyl aminopropyl
30 amine, dimethylaminoethylamine, diethylaminoethylamine, dibutylaminoethylamine, 1-(2-aminoethyl) piperidine, 1-(2-aminoethyl)pyrrolidone, aminoethylmorpholine, and aminopropylmorpholine. Preferably, the aliphatic amine having a single reactive amino group is N,N-dimethylaminopropylamine or aminopropylmorpholine.

Additionally, the amino aliphatic compound could be a polyether containing a single amino end group.

- 5 Preferably, the polyalkylene polyamine has greater than 4 amine nitrogen atoms per mole, up to a maximum of about 12 amine nitrogen atoms per mole. Most preferred are polyamines having from about 5 to about 7 nitrogen atoms per mole. The number of amine nitrogen atoms per mole of polyamine is calculated as follows:

$$10 \quad \begin{array}{l} \text{Number of nitrogen atoms} = \frac{\% \text{ N} \times M_{pa}}{14 \times 100} \\ \text{Per mole of polyamine} \end{array}$$

wherein

% N=percent nitrogen in polyamine or polyamine mixture

M_{pa} =number average molecular weight of the polyamine or polyamine mixture

- Suitable aliphatic polyamines include polyalkylene polyamines. Preferred
 15 polyalkylene polyamines also contain from about 4 to about 40 carbon atoms, there being preferably from 2 to 3 carbon atoms per alkylene unit. The polyamine preferably has a carbon-to-nitrogen ratio of from about 1:1 to about 10:1.

- Examples of suitable include the following: tetraethylene pentamine, pentaethylene
 20 hexamine and heavy polyamine, HPA, (available from Dow Chemical Company, Midland, Michigan). Such amines encompass isomers such as branched-chain polyamines and the previously mentioned substituted polyamines, including hydrocarbyl-substituted polyamines.

- 25 When more than one primary or secondary amino group is present, the reaction conditions and/or stoichiometry should be such that oil solubility is maintained.

Hydroxy Aliphatic Compound

- In addition to the ether compound (i.e. polyether aromatic compound) above,
 30 optionally, the copolymer may also be reacted with at least one aliphatic compound which may be a hydroxy aliphatic compound.

The mono- or multifunctional hydroxyl compounds used according to the process of the present invention may contain primary, secondary or tertiary alcohols.

Suitable hydroxyl aliphatic compounds include, but are not limited to, ethanol, isopropyl alcohol, isobutyl alcohol, tert-butyl alcohol, glycerol and the like. Additionally, the hydroxyl aliphatic compound could be a polyether containing a
5 single hydroxyl end group.

The hydroxyl compound may also contain a hetero atom, such as sulfur (e.g., betamercaptoethanol).

10 Method of Making the Lubricating Oil Additive Composition

The lubricating oil additive composition is prepared by a process comprising charging the reactant copolymer (e.g., at least one of copolymers (i), (ii) and (iii) as described herein) in a reactor, optionally under a nitrogen purge, and heating at a temperature of from about 80°C to about 170°C. Optionally, diluent oil may be charged optionally
15 under a nitrogen purge in the same reactor, thereby producing a diluted copolymer reactant. The amount of diluent oil in the diluted copolymer is up to about 80 weight %, more preferred from about 20 to about 60 weight %, and most preferred from about 30 to about 50 weight %. A polyether aromatic compound is charged, optionally under a nitrogen purge, to the reactor. Optionally, an aromatic compound
20 capable of reacting with at least one monocarboxylic acid or ester thereof, or dicarboxylic acid, anhydride or ester thereof; an aliphatic compound capable of reacting with at least one monocarboxylic acid or ester thereof, or dicarboxylic acid, anhydride or ester thereof; or both are also charged to the reactor. This mixture is heated under a nitrogen purge to a temperature in range from about 130°C to about
25 200°C. Optionally, a vacuum is applied to the mixture for about 0.5 to about 2.0 hours to remove excess water.

The lubricating oil additive composition can also be made using a process comprising simultaneously charging all the reactants (reactant copolymer (i), (ii), or (iii); and the
30 polyether aromatic compound and, optionally, the aromatic compound, and, optionally, the aliphatic compound at the desired ratios into the reactor. One or more of the reactants can be charged at an elevated temperature to facilitate mixing and reaction. A static mixer can be used to facilitate mixing of the reactants as they are

being charged to the reactor. The reaction is carried out for about 0.5 to about 2 hours at a temperature from about 130°C to about 200°C. Optionally a vacuum is applied to the reaction mixture during the reaction period.

- 5 When an aliphatic compound, an aromatic compound or both are employed in the present invention and when more than one functional group is present on the compound(s), the reaction conditions and/or stoichiometry should be such that oil solubility is maintained. For example, when multifunctional aliphatic compounds, aromatic compounds or both are used, the linker group (i.e., the polyether compound)
10 and the copolymer are preferably charged to the reactor first and allowed to react prior to addition of the multifunctional compounds. Furthermore, the stoichiometry should be such that when the multifunctional aliphatic compound, aromatic compound or both are charged to the reactor, there is generally about one molecule of reactive monoethylenically unsaturated mono- or dicarboxylic acid functions per molecule of
15 the multifunctional compound(s). This reaction order and stoichiometry reduces excessive crosslinking by limiting the number of unreacted monoethylenically unsaturated mono- or dicarboxylic acid sites relative to the number of reactive sites on the multifunctional aliphatic compound, aromatic compound or both. Reduction of excessive crosslinking may decrease the probability of gel formation and therefore
20 increase the probability of oil solubility.

In one embodiment of the invention, the non-free radical catalyzed reaction product of compound (i)(a) and compound (i)(b) or (i)(c), which is contacted with either copolymer (i) or copolymer (ii) or both, may be contacted in the presence of optional
25 reactants (i.e. the aromatic compounds and the aliphatic compounds) prior to the addition of component (B) (i.e. the polyether aromatic amino compound).

Lubricating Oil Composition

The lubricating oil additive composition described above is generally added to a base
30 oil that is sufficient to lubricate moving parts, for example internal combustion engines, gears, and transmissions. Typically, the lubricating oil composition of the present invention comprises a major amount of an oil of lubricating viscosity and a minor amount of the lubricating oil additive composition.

The base oil employed may be any of a wide variety of oils of lubricating viscosity. The base oil of lubricating viscosity used in such compositions may be mineral oils or synthetic oils. A base oil having a viscosity of at least 2.5 cSt at 40°C and a pour point
 5 below 20°C, preferably at or below 0°C, is desirable. The base oils may be derived from synthetic or natural sources.

Mineral oils for use as the base oil in this invention include, for example, paraffinic, naphthenic and other oils that are ordinarily used in lubricating oil compositions.
 10 Synthetic oils include, for example, both hydrocarbon synthetic oils and synthetic esters and mixtures thereof having the desired viscosity. Hydrocarbon synthetic oils may include, for example, oils prepared from the polymerization of ethylene, polyalphaolefin or PAO oils, or oils prepared from hydrocarbon synthesis procedures using carbon monoxide and hydrogen gases such as in a Fisher-Tropsch process.
 15 Useful synthetic hydrocarbon oils include liquid polymers of alpha olefins having the proper viscosity. Especially useful are the hydrogenated liquid oligomers of C₆ to C₁₂ alpha olefins such as 1-decene trimer. Likewise, alkyl benzenes of proper viscosity, such as didodecyl benzene, can be used. Useful synthetic esters include the esters of monocarboxylic acids and polycarboxylic acids, as well as mono-hydroxy alkanols
 20 and polyols. Typical examples are didodecyl adipate, pentaerythritol tetracaprate, di-2-ethylhexyl adipate, dilaurylsebacate, and the like. Complex esters prepared from mixtures of mono and dicarboxylic acids and mono and dihydroxy alkanols can also be used. Blends of mineral oils with synthetic oils are also useful.

25 Thus, the base oil can be a refined paraffin type base oil, a refined naphthenic base oil, or a synthetic hydrocarbon or non-hydrocarbon oil of lubricating viscosity. The base oil can also be a mixture of mineral and synthetic oils.

Method of Use of the Present Invention

30 The lubricating oil additive composition of the present invention is added to an oil of lubricating viscosity thereby producing a lubricating oil composition. The lubricating oil composition contacts the engine, improving soot dispersancy, sludge dispersancy or both. Accordingly, the present invention is also directed to a method of improving

soot dispersancy, or sludge dispersancy or both in an internal combustion engine which comprises operating the engine with the lubricating oil composition of the invention.

- 5 Optionally, the lubricating oil additive composition described above may be used as a fuel additive. When used in fuels, the proper concentration of the additive that is necessary to achieve the desired detergency is dependent upon a variety of factors including the type of fuel used, the presence of other detergents or dispersants or other additives, etc. Generally, however, the range of concentration of the additive in the
10 base fuel is 10 to 10,000 weight parts per million, preferably from 30 to 5,000 parts per million of the additive. If other detergents are present, a lesser amount of the additive may be used. The additives described herein may be formulated as a fuel concentrate, using an inert stable oleophilic solvent boiling in the range of about 150-400°F (65.6-204.4°C). Preferred solvents boil in the gasoline or diesel fuel range.
15 Preferably, an aliphatic or an aromatic hydrocarbon solvent is used, such as a benzene, toluene, xylene or higher-boiling aromatics or aromatic thinners. Aliphatic alcohols of about 3 to 8 carbon atoms, such as isopropanol, isobutylcarbinol, n-butanol and the like in combination with hydrocarbon solvents are also suitable for use with the fuel additive. In the fuel concentrate, the amount of the additive will be
20 ordinarily at least 5 percent by weight and generally not exceed 70 percent by weight, preferably from 5 to 50 and more preferably from 10 to 25 weight percent.

The following examples are presented to illustrate specific embodiments of this invention and are not to be construed in any way as limiting the scope of the
25 invention.

EXAMPLES

Example 1 - Preparation of Terpolymer PIBSA (TPP) – Copolymer (i)

2513 grams of high methylvinylidene polyisobutylene having a number average
30 molecular weight (Mn) of about 2300 and a methylvinylidene content of about 78% (which is available from BASF as Glissopal® 2300) was charged to a 4-L reactor equipped with agitator, temperature controller and overhead condenser and receiver. 27.3 grams 1-hexadecene was also charged to the reactor, and the agitated mixture

was heated to 150°C. Traces of moisture were removed by sparging 250 scm³/min nitrogen through the mixture for about an hour. After drying, the nitrogen was fed to the reactor head space at a rate of 30 scm³/min. 178.8 grams maleic anhydride and 16.4 grams dicumyl peroxide in a 50% solution with toluene were fed simultaneously to the reactor over 2 hours. After the maleic anhydride and dicumyl peroxide charging were finished, the temperature of the reactor was maintained at 150°C for another 1.5 hours. The reactor was heated to 190°C. During the heating of the reactor, the pressure was gradually lowered to 20 mm Hg when the temperature of the reactor reached 180°C. The temperature was held at 190°C and the pressure was held at 20 mm Hg for 1 hour during which 15 grams of condensate was collected. The product was cooled and a yield of 2693 grams of copolymer (i) was obtained. The product had a saponification number of 48.3 mg KOH/g.

Example 2 - Preparation of PolyPIBSA 1000 (Copolymer (ii))

4005 grams of high methylvinylidene polyisobutene having a number average molecular weight (M_n) of about 1000 and a methylvinylidene content of about 76% (which is commercially available from BASF and is known as Glissopal 1000) was charged to a reactor and the reactor was heated to a temperature of about 150°C. 589 grams maleic anhydride and 54.14 grams of dicumyl peroxide were fed to the reactor. The temperature of the reactor was maintained at 150°C for 1.0 hour after the maleic anhydride and dicumyl peroxide are charged to the reactor. The reactor was heated to about 200°C over a period of about 1.0 hour, after which a vacuum was applied to reduce the pressure to 0 psia while maintaining the temperature at 200°C. The reactor was held under vacuum pressure for about 1.5 hours at 200°C. The reactor pressure was then increased to ambient conditions and the product was then filtered to provide the neat product.

Example 3 – Preparation of Alpha-Olefin/Maleic Anhydride Copolymer

100 parts by weight Exxon 150 solvent (C₁₀ aromatic solvent) and 81.94 parts by weight of C₁₄₋₂₄ alpha olefin mixture (average molecular weight - 215.3 Daltons) were charged to a stirred reactor. The mixture was heated to 150°C, and the temperature was maintained for about 30 minutes to dehydrate the mixture. The mixture was cooled to 65°C, and 36.5 parts of maleic anhydride were charged to the

reaction mixture. The reactor headspace was purged with nitrogen. The reaction mixture was heated to 150°C. 0.13 parts of di-tert-butyl peroxide were added to the reaction mixture. The reactor temperature was allowed to increase (exotherm) to about 180°C. Once the temperature began to decrease (exotherm passed), the reaction mixture was cooled to 150°C. The peroxide addition step was repeated five more times. After the sixth peroxide addition the reactor was heated to 170°C, and the temperature was maintained for one hour. The aromatic solvent was then stripped from the product under vacuum, and then approximately 276 parts of 100N neutral oil were added to the product.

10

Example 4 – Preparation of Thermal PIBSA

The procedure of Preparation 2 in U.S. Patent No. 5,872,083 ('083 Patent) was employed except that 2300 Mn polybutene, available as Glissopal® 2300 from BASF, was used instead of 2200 Mn polybutene as used in the '083 Patent.

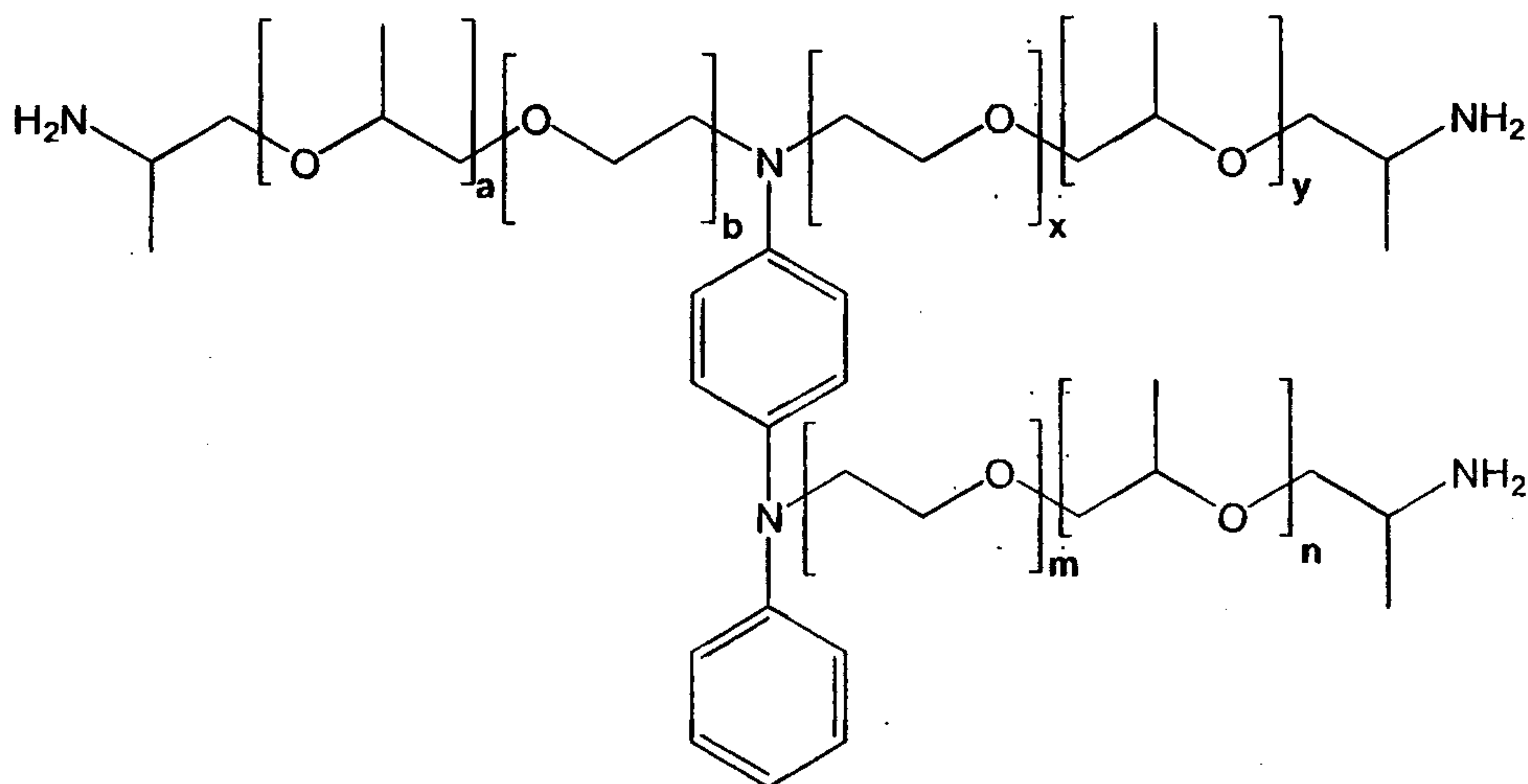
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Example 5 – Synthesis of polyoxyalkyleneamine derivative of N-phenyl-1,4-phenylenediamine

A polyoxyalkyleneamine containing both ethylene oxide and propylene oxide units derived from a N-phenyl-1,4-phenylenediamine (NPPDA) core is a mixture of structures (i) and (ii):

20

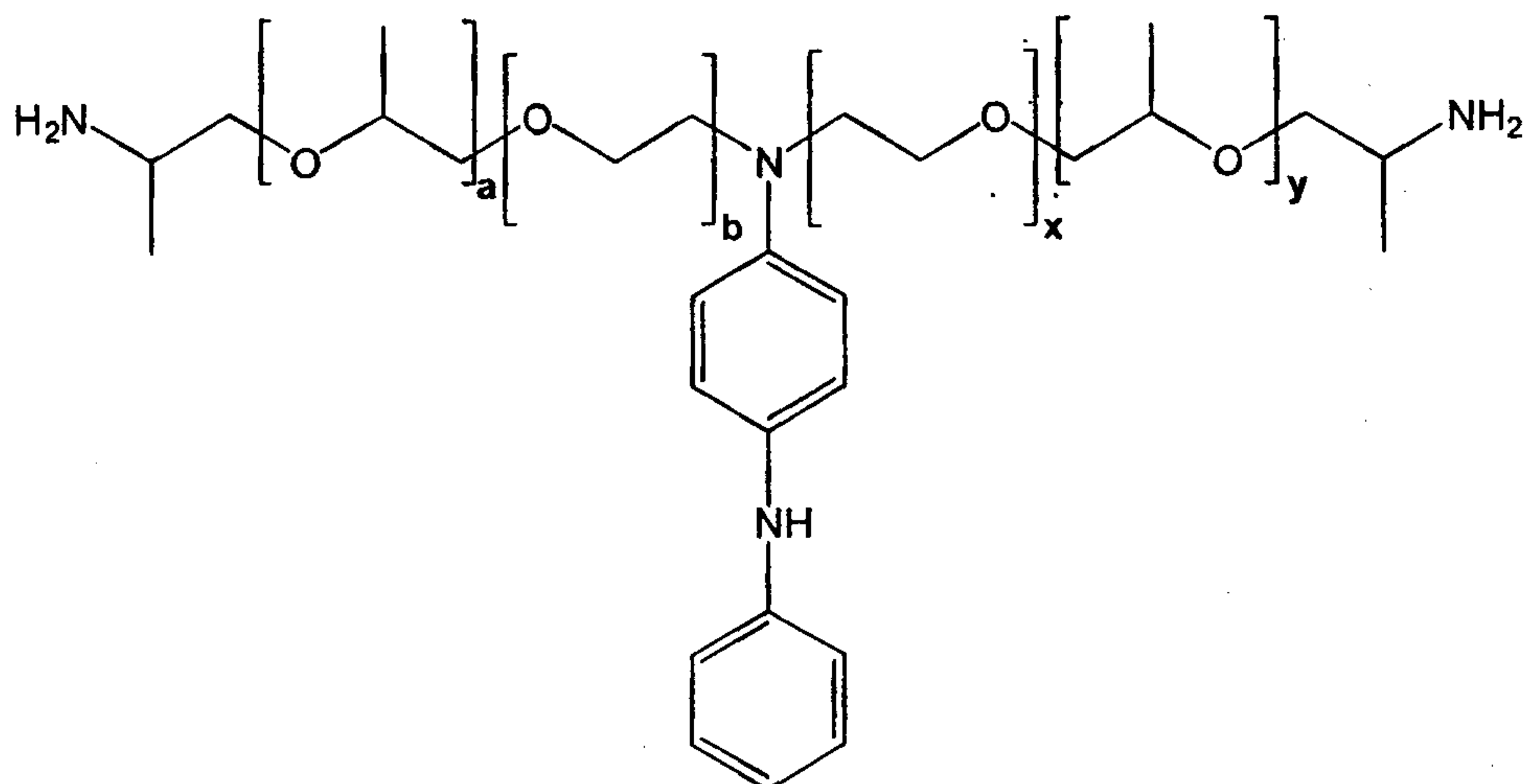
(i)



and

25

(ii)



It is contemplated that the reaction product, derived from the N-phenyl-1,4-phenylenediamine (NPPDA), comprises a mixture of structures (i) and (ii). Such a compound is prepared by reacting 15 moles of ethylene oxide and 5 moles of propylene oxide with N-phenyl-1,4-phenylenediamine to form a mixture of polyetherdiol and polyethertriol. The polyethertriol and polyetherdiol is then reductively aminated with ammonia and hydrogen to provide polyethers with terminal aminic groups, wherein the primary aliphatic amine content is 1.91 meq N/g.

10

Example 6

633.9 grams of Terpolymer PIBSA, prepared as in Example 1, were charged into a 1000 mL stirred glass reactor. A nitrogen purge (~180 mL/min) through the reactor headspace was then started. The reactor was heated to 160°C. When the reactor temperature attained 160°C, 103.65 grams of an ethylene oxide and propylene oxide based polyoxyalkyleneamine, as described in Example 5, and 16.68 grams (0.09 moles) of dodecylamine were added to the reactor sequentially. The reaction mixture was held at 160°C for 1.5 hours. The reactor pressure was then reduced to <20 mmHg (abs) to remove any water generated during the reaction. The vacuum conditions were maintained for 30 minutes.

20

Example 7

684.5 grams of Terpolymer PIBSA, prepared as in Example 1, were charged into a 1000 mL stirred glass reactor. A constant 350 mL/min nitrogen purge through the reactor headspace was then started. The reactor was heated to 160°C. When the

25

reactor temperature attained 160°C, 113.39 grams of an ethylene oxide and propylene oxide based polyoxyalkyleneamine with N-phenyl-1,4-phenylenediamine core - wherein the primary aliphatic amine content is 1.91 meq N/g, prepared as in Example 5, and 10.06 grams (0.0985 moles) of 3-dimethylamino-1-propylamine were added to the reactor sequentially. The reaction mixture was held at 160°C for about 1.8 hours. The reactor pressure was then reduced to <20 mmHg (abs) to remove any water generated during the reaction. The vacuum conditions were maintained for about 30 minutes.

10

Example 8

452.19 grams of PolyPIBSA (saponification number = 36.7 mg KOH/g) made from polybutene having a number average molecular weight of 2095 and prepared under similar conditions as employed in Example 2 above, were charged into a 500 mL stirred glass reactor. A constant 180 mL/min nitrogen purge through the reactor headspace was then started. The reactor was heated to 160°C. When the reactor temperature attained 160°C, 8.99 grams of N-phenyl-1,4-phenylenediamine and 51.87 grams of an ethylene oxide and propylene oxide based polyoxyalkyleneamine with N-phenyl-1,4-phenylenediamine core - wherein the primary aliphatic amine content is 1.91 meq N/g, prepared as in Example 5, were added to the reactor sequentially. The reaction mixture was held at 160°C for about 1.5 hours. The reactor pressure was then reduced to <20 mmHg (abs) to remove any water generated during the reaction. The vacuum conditions were maintained for 30 minutes.

25

Example 9

455.34grams of PolyPIBSA (saponification number = 36.7 mg KOH/g) made from polybutene having a number average molecular weight of 2095 and prepared under similar conditions as employed in Example 2 above, were charged into a 500 mL stirred glass reactor. A nitrogen purge (~180 mL/min) through the reactor headspace was then started. The reactor was heated to 160°C. When the reactor temperature was approximately 160°C, 6.35 grams of 2-ethylhexylamine and 52.23 grams of an ethylene oxide and propylene oxide based polyoxyalkyleneamine with N-phenyl-1,4-phenylenediamine core – wherein the primary aliphatic amine content is 1.91 meq N/g, prepared as in Example 5, were added to the reactor sequentially. The reaction

30

mixture was held at 160°C for about 1.5 hours. The reactor pressure was then reduced to <20 mmHg (abs) to remove any water generated during the reaction. The vacuum conditions were maintained for 30 minutes. The product contained 0.674 wt% nitrogen.

5

Example 10

- 461.0 grams of PIBSA 2300 (saponification number = 35.5 mg KOH/g), as prepared in Example 4, and 158.27 grams of an alpha olefin/maleic anhydride copolymer (saponification number = 96.95 mg KOH/g; alpha olefin average molecular weight
10 ~168 g/mol), as prepared in Example 3, were charged into a 1000 mL stirred glass reactor. A constant 150 mL/min nitrogen purge through the reactor headspace was then started. The reactor was heated to approximately 160°C. When the reactor temperature approached 160°C, 152.71 grams of an ethylene oxide and propylene oxide based polyoxyalkyleneamine with N-phenyl-1,4-phenylenediamine core,
15 prepared as in Example 5, were added to the reactor. The reaction mixture was held at 160°C for about 1.5 hours. The reactor pressure was then reduced to <20 mmHg (abs) to remove any water generated during the reaction. The vacuum conditions were maintained for about 30 minutes.
- 20 Examples 11-16 in Table 1 are examples of making the invention. Examples 11-16 have different concentrations of the reactants (see Table 1) and follow the procedures set forth in Examples 6.

TABLE 1

Example	Copolymer	Copolymer (g)	PIBSA (g)	Polyether	Polyether (g)	Aromatic Compound	Aromatic Compound (g)	Aliphatic Compound	Aliphatic Compound (g)	Diluent Oil (g)
11	Example 1	100	0	Example 5	14.73	NPPDA	2.71	None	0	12.65
12	Example 1	100	0	Example 5	16.94	NPPDA	2.71	None	0	14.86
13	Example 1	100	0	Example 5	14.73	None	0	DMAPA	1.51	11.44
14	Example 1	100	0	Example 5	14.73	None	0	DDA	2.73	12.67
15	Example 2	150	0	Example 5	32.34	None	0	DMAPA	5.75	41.47
16	Example 2	135	0	Example 5+ PPO2000	14.55/24.6	None	0	DMAPA	5.17	47.07

NPPDA – N-phenyl-1,4-phenylenediamine

DMAPA -- 3-dimethylamino-1-propylamine

DDA – Dodecyl amine

PPO 2000 – Polypropyleneoxide diamine, Mn = 2000 g/mol

Examples 6-10, 12, and 14-16, which exemplify the lubricating oil additive composition of the present invention, were evaluated for percent viscosity increase using a soot thickening bench test, which measures the ability of the formulation to disperse and control viscosity increase resulting from the addition of carbon black, a soot surrogate. Using the soot thickening bench test, the viscosity of a fresh oil is measured in centistokes. The fresh oil is then treated with 2 wt% Vulcan™ XC72R carbon black, supplied by Columbia Chemical Co., to form a mixture containing approximately 2 grams Vulcan™ XC72R carbon black and 98 grams fresh oil (test oil). The test oil, which contains carbon black, is then left to sit overnight. It is then homogenized using a high speed tissue homogenizer for approximately 60 seconds to thoroughly mix the carbon black with the fresh oil. The resulting test oil containing carbon black is then degassed at 100°C for 30 minutes. The viscosity of the oil containing carbon black is measured according to methods that are well known in the art. The percent viscosity increase is calculated according to the following formula:

$$\% \text{ viscosity increase} = [(\text{vis}_{\text{cbo}} - \text{vis}_{\text{fo}}) / (\text{vis}_{\text{fo}}) \times 100]$$

vis_{cbo} : viscosity of carbon black in oil

vis_{fo} : viscosity of fresh oil

Using the soot thickening bench test, the percent viscosity increase calculated for the additive composition of Examples 6-10, 12 and 14-16 in a formulated oil was compared to a formulated oil that does not contain the lubricating oil additive composition of the present invention. The formulated oil of the present invention comprises 0.66 wt% of an oxidation inhibitor package, 0.33 wt% pour point depressant, 4.07 wt% of a calcium based detergent package containing a phenate and sulfonates, 2.41 wt% zinc dithiophosphate, 0.03 wt% foam inhibitor, 7.7 wt% viscosity index improver and 85.10 wt% of a lube oil blend which is a mixture of basestocks that consists of 69.24 wt% Exxon150N oil, and 30.76 wt% Exxon600N oil (all of which may be purchased from ExxonMobil Corporation, Fairfax, Virginia) to provide the comparative oil formulation. To prepare the formulated lubricating oil composition of the present invention, approximately 7.6 wt% of the additive composition of Examples 6-10, 12 and 14-16 were top treated to the formulated comparison oil.

The results of the soot thickening bench test are summarized in Table 2.

Table 2: Soot Thickening Bench Test Results

Example	% Viscosity Increase
6	32.8
7	48.1
8	24.4
9	32.6
10	38.3
12	30.8
14	35.8
15	33.9
16	63.3
No Dispersant	283.9

The results of the soot thickening bench test indicate that the percent viscosity
 5 increase using the lubricating oil additive composition of the present invention was
 lower than the percent viscosity increase in a formulated oil that did not contain a
 lubricating oil additive composition of the present invention, which yielded
 approximately a 284% viscosity increase. This test indicates that the lubricating oil
 additive composition of the present invention has good dispersant properties.

10

It is understood that although modifications and variations of the invention can be
 made without departing from the scope thereof, only such limitations should be
 imposed as are indicated in the appended claims.

WHAT IS CLAIMED IS:

1. An oil-soluble lubricating oil additive composition prepared by the process which comprises reacting
 - 5 (A) at least one of the following copolymers:
 - 10 (i) a copolymer obtained by free radical copolymerization of components comprising:
 - 15 (a) at least one monoethylenically unsaturated C₃-C₂₈ monocarboxylic acid or ester thereof, or C₄-C₂₈ dicarboxylic acid, anhydride or ester thereof;
 - 20 (b) at least one 1-olefin comprising 2 to 40 carbon atoms or at least one polyolefin comprising 4 to 360 carbon atoms and having a terminal copolymerizable group in the form of a vinyl, vinylidene or alkyl vinylidene group or mixtures thereof; and
 - 25 (c) at least one monoolefin compound which is copolymerizable with the monomers of (a) and (b) and is selected from the group consisting of:
 - 30 (1) an alkyl vinyl ether and an allyl alkyl ether where the alkyl group is hydroxyl, amino, dialkylamino or alkoxy substituted or is unsubstituted, and containing from 1 to 40 carbon atoms;
 - (2) an alkyl amine and an N-alkylamide of a monoethylenically unsaturated mono- or dicarboxylic acid of from 3 to 10 carbon atoms

where the alkyl substituent contains from 1 to 40 carbon atoms;

5 (3) an N-vinylcarboxamide of carboxylic acids of from 1 to 8 carbon atoms;

(4) an N-vinyl substituted nitrogen-containing heterocyclic compound; and

10 (5) at least one 1-olefin comprising 2 to 40 carbon atoms or at least one polyolefin comprising 4 to 360 carbon atoms and having a terminal copolymerizable group in the form of a vinyl, vinylidene or alkyl vinylidene group or mixtures
15 thereof, provided that the olefin employed is not the same as the olefin employed in (i)(b);

(ii) a copolymer obtained by reacting compound (i)(a) and compound(i)(b) in the presence of a free radical initiator; or

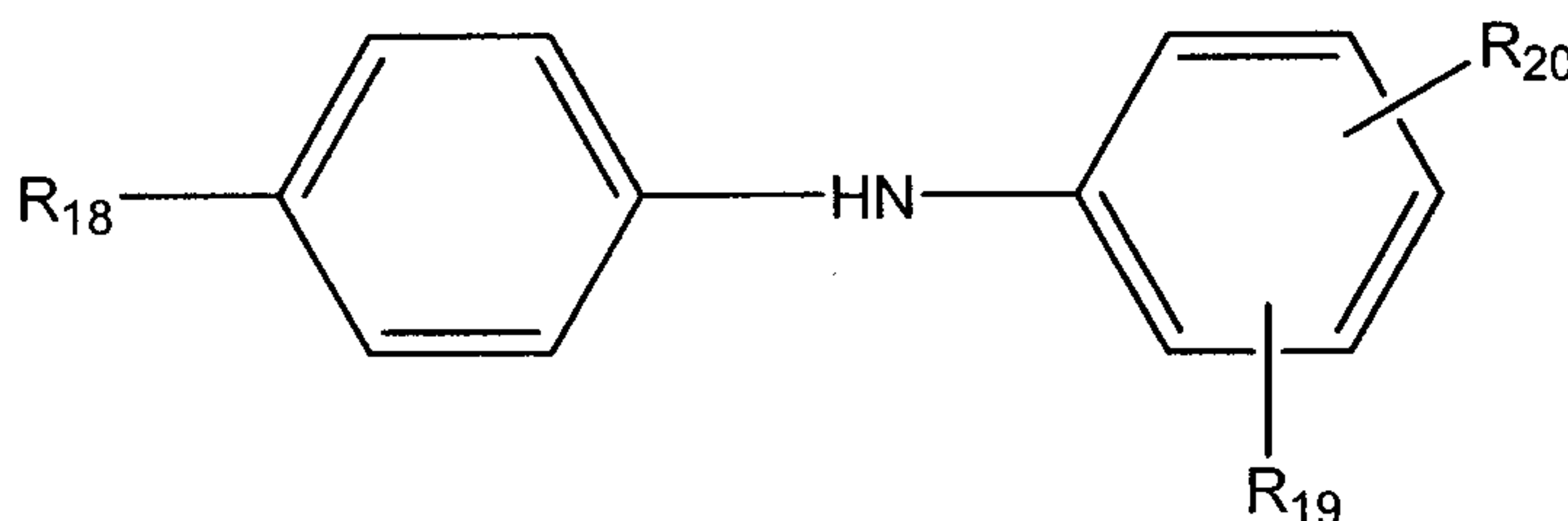
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(iii) a copolymer obtained by (a) reacting compound (i)(a) with compound (i)(b) or (i)(c) in a non-free radical catalyzed reaction in the presence of copolymer (i) or copolymer (ii) or both; or by (b) contacting copolymer (i) or copolymer (ii) or
25 both with the non-free radical catalyzed reaction product of compound (i)(a) and compound (i)(b) or (i)(c); with

(B) at least one polyether aromatic compound capable of being reacted with at least two monocarboxylic acids or esters thereof, or with at
30 least two dicarboxylic acids, anhydrides or esters thereof, or mixtures thereof.

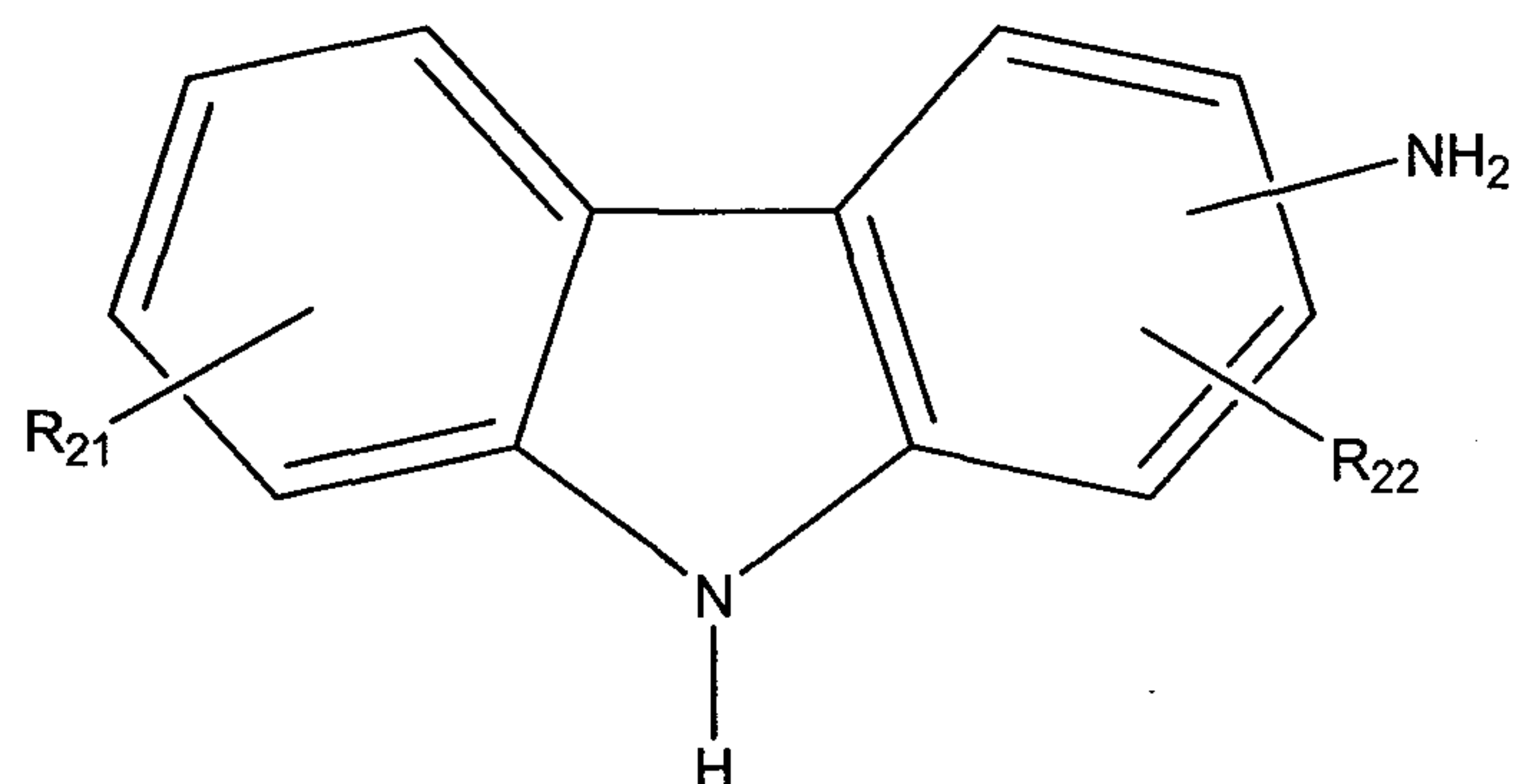
2. The lubricating oil additive composition of claim 1, wherein copolymer (i), (ii) or (iii) is reacted with at least one polyether aromatic compound and additionally with (1) at least one ether compound or (2) at least one aromatic compound capable of being reacted with at least one monocarboxylic acid or ester thereof, or dicarboxylic acid, anhydride or ester thereof, or (3) at least one aliphatic compound capable of being reacted with at least one monocarboxylic acid or ester thereof, or dicarboxylic acid, anhydride or ester thereof, or mixtures of (1), (2) or (3).
3. The lubricating additive composition of claim 1, wherein the polyether aromatic compound is derived from an aromatic amine selected from the group consisting of

(a) an N-arylphenylenediamine represented by the formula:



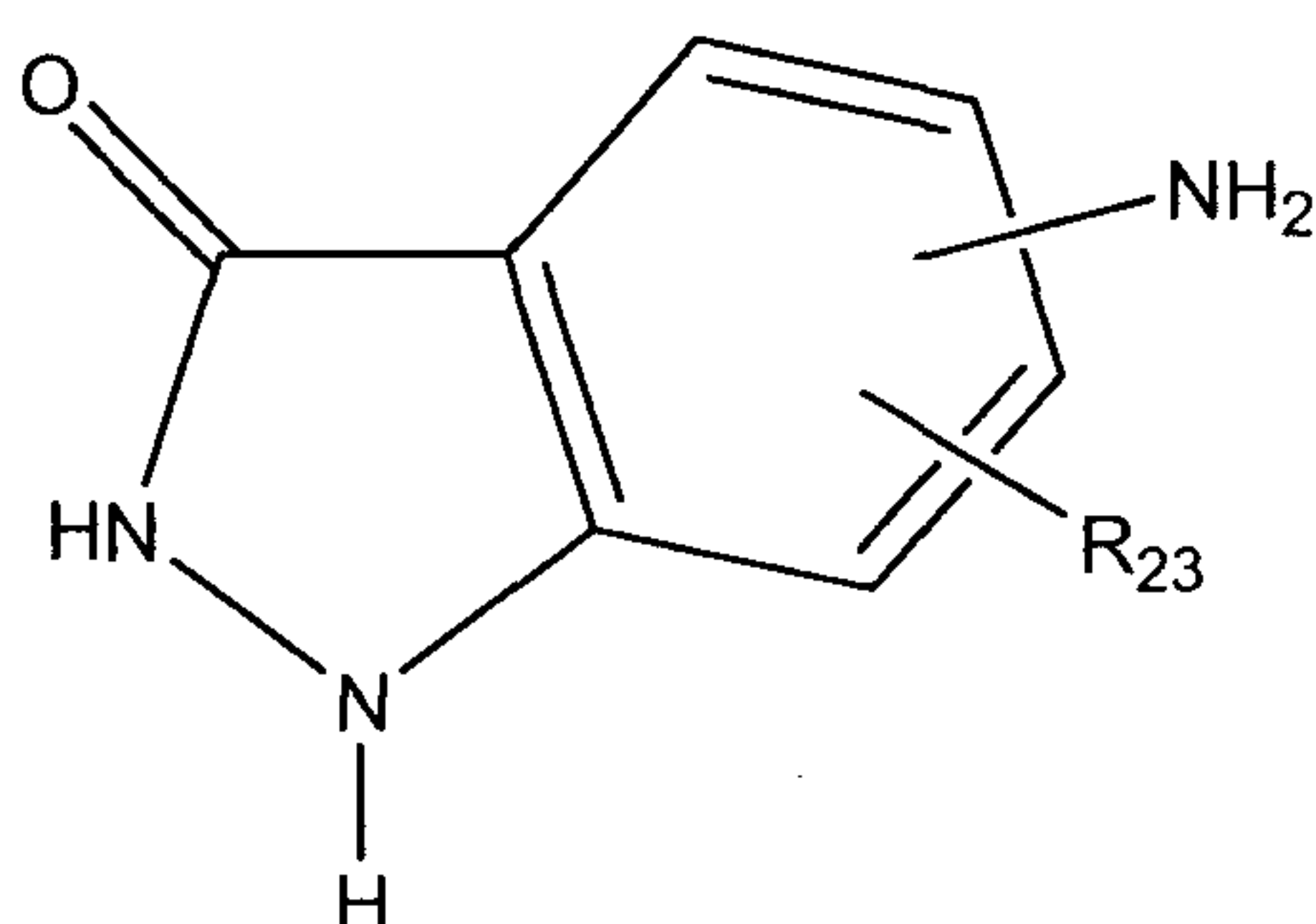
R_{18} is H, --NHaryl, -NHalkaryl, or a branched or straight chain hydrocarbyl radical having from 4 to 24 carbon atoms selected from the group consisting of alkyl, alkenyl, alkoxyl, aralkyl and alkaryl; R_{19} is --NH₂, --(NH(CH₂)_n)_mNH₂, --NHalkyl, --NHaralkyl, --CH₂--aryl--NH₂, in which n and m each have a value from 1 to 10; and R_{20} is hydrogen, alkyl, alkenyl, alkoxyl, aralkyl, or alkaryl, having from 4 to 24 carbon atoms;

(b) aminocarbazole represented by the formula:



5 in which R_{21} and R_{22} each independently represent hydrogen or an alkyl or alkenyl radical having from 1 to 14 carbon atoms;

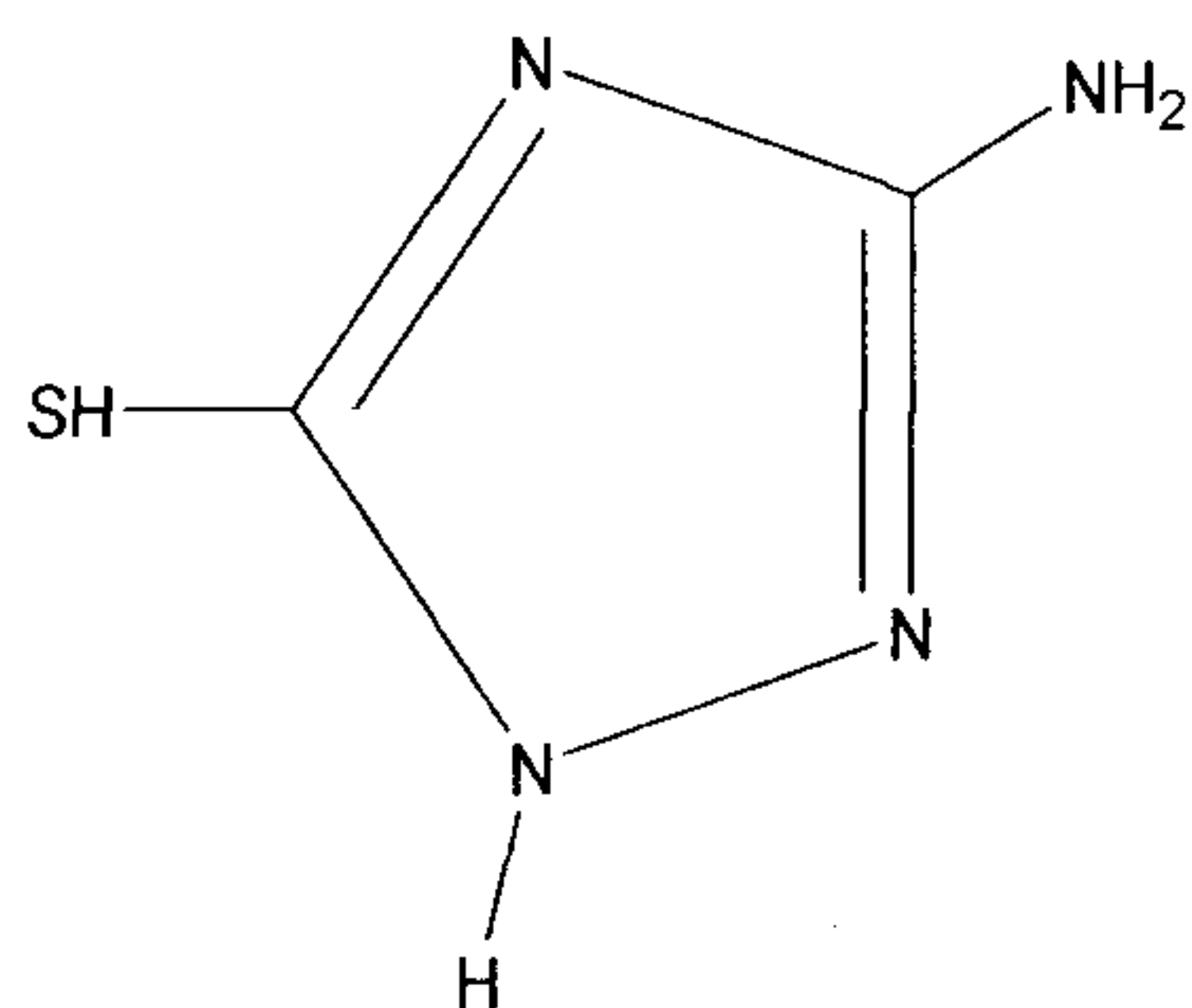
(c) an amino-indazolinone represented by the formula:



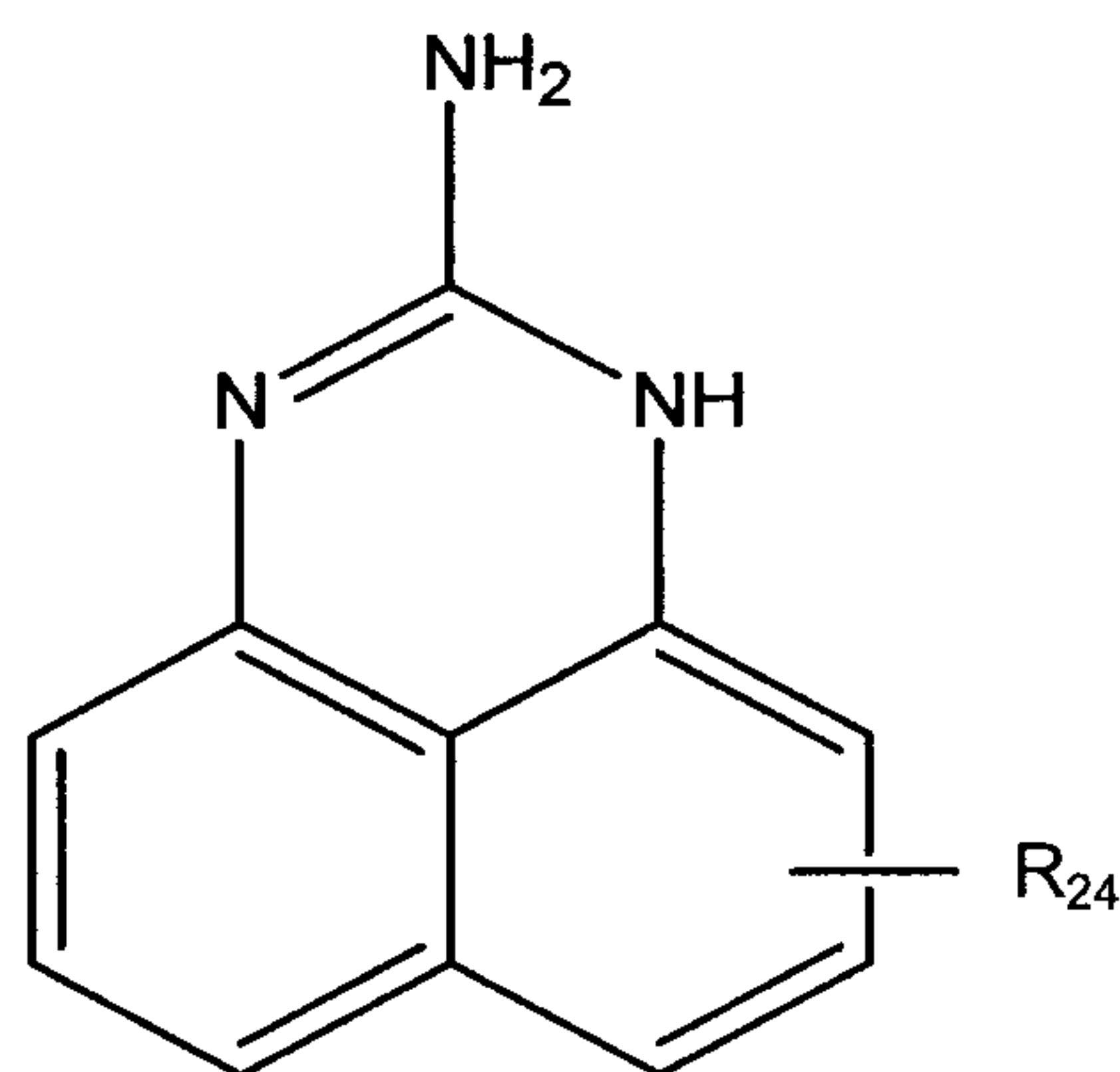
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in which R_{23} is hydrogen or an alkyl radical having from 1 to 14 carbon atoms;

15 (d) an aminomercaptotriazole represented by the formula:



- (e) an aminoperimidine represented by the formula:

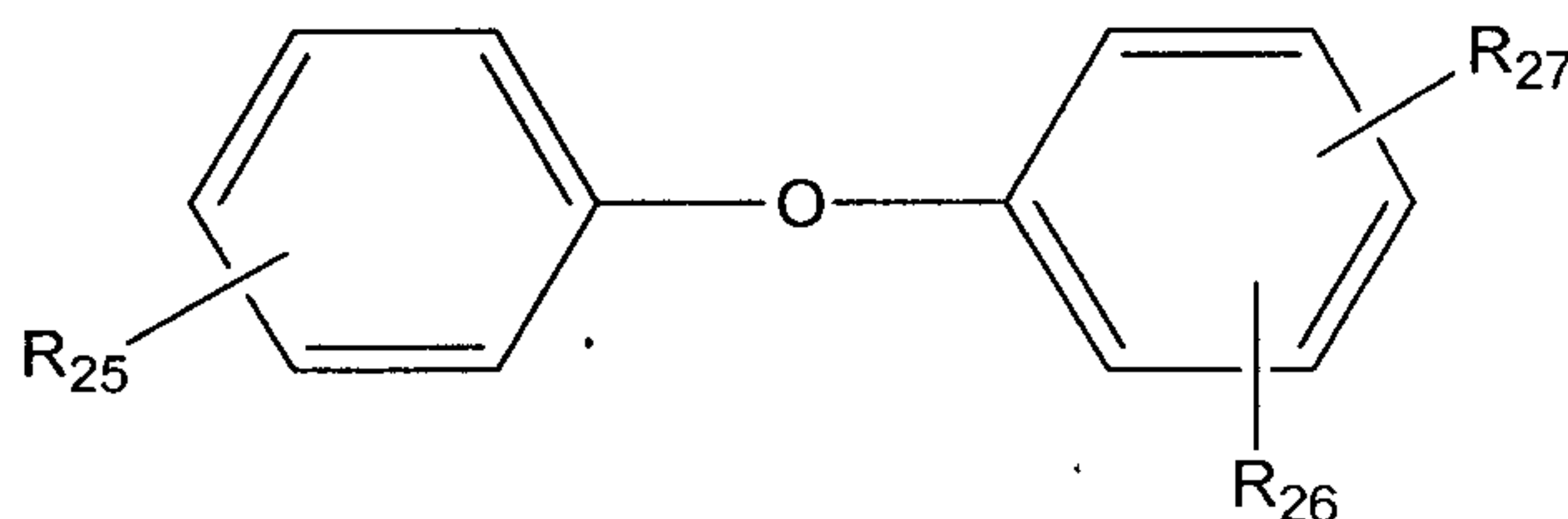


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in which R_{24} represents hydrogen or an alkyl radical having from 1 to 14 carbon atoms;

- (f) an aryloxyphenyleneamine represented by the formula:

10

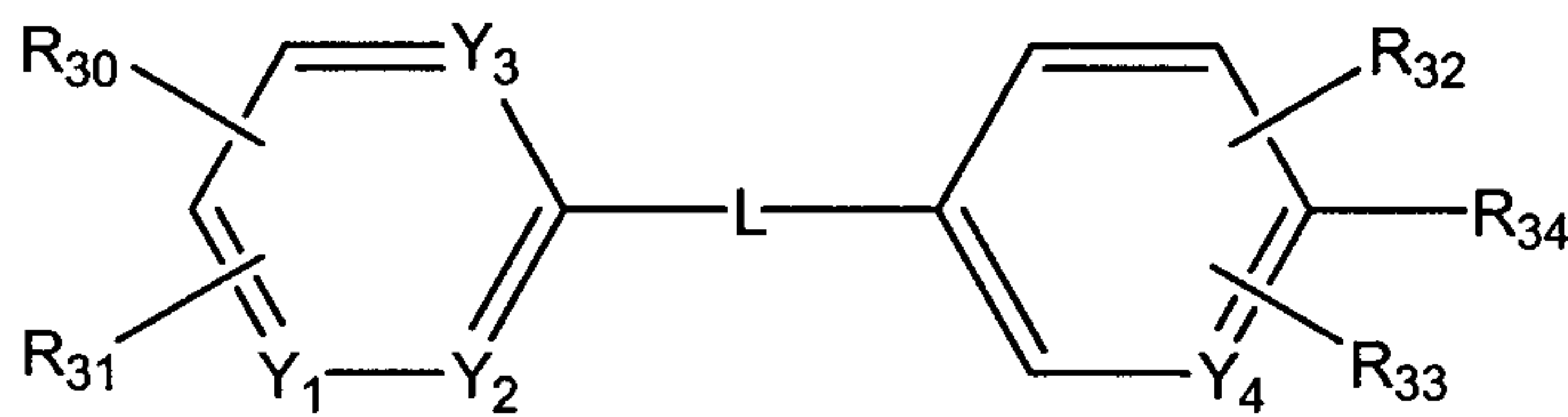


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in which R_{25} is H, --NHaryl, --NHalkaryl, or branched or straight chain radical having from 4 to 24 carbon atoms that is alkyl, alkenyl, alkoxy, aralkyl or alkaryl; R_{26} is --NH₂, --(NH(CH₂)_n)_m NH₂, --NHalkyl, or --NHaralkyl, in which n and m each have a value from 1 to 10; and R_{27} is hydrogen, alkyl, alkenyl, alkoxy, aralkyl, or alkaryl, having from 4 to 24 carbon atoms; provided that when R_{25} is hydrogen or a branched or straight chain radical having from 4 to 24 carbon atoms selected from the group consisting of alkyl, alkenyl, alkoxy, aralkyl and alkaryl, then R_{26} must be NH₂ or --(NH(CH₂)_n)_mNH₂, -CH₂-(CH₂)_n-NH₂, or -CH₂-aryl-NH₂;

20

- (g) an aromatic amine comprising two aromatic groups, linked by a group, L, represented by the following formula:



5

wherein L is selected from the group consisting of $-O-$, $-N=N-$, $-NH-$, $-CH_2NH-$, $-C(O)NR_{28}-$, $-C(O)O-$, $-SO_2-$, $-SO_2NR_{29}-$ and $-SO_2NH-$, wherein R_{28} and R_{29} independently represent a hydrogen, an alkyl, an alkenyl or an alkoxy group having from 1 to 8 carbon atoms;

10

wherein each Y_1 , Y_2 , Y_3 and Y_4 are independently N or CH provided that Y_1 and Y_2 may not both be N;

15

R_{30} and R_{31} independently represent a hydrogen, alkyl, aryl, alkaryl, aralkyl, alkoxy, hydroxyalkyl, aminoalkyl, $-OH$, $-NO_2$, $-SO_3H$, $-SO_3Na$, CO_2H or salt thereof, or $-NR_{41}R_{42}$ wherein R_{41} and R_{42} are independently hydrogen, alkyl, aryl, arylalkyl, or alkaryl;

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R_{32} and R_{33} independently represent a hydrogen, an alkyl, an alkenyl or an alkoxy group having from 1 to 8 carbon atoms, $-OH$, $-SO_3H$ or $-SO_3Na$;

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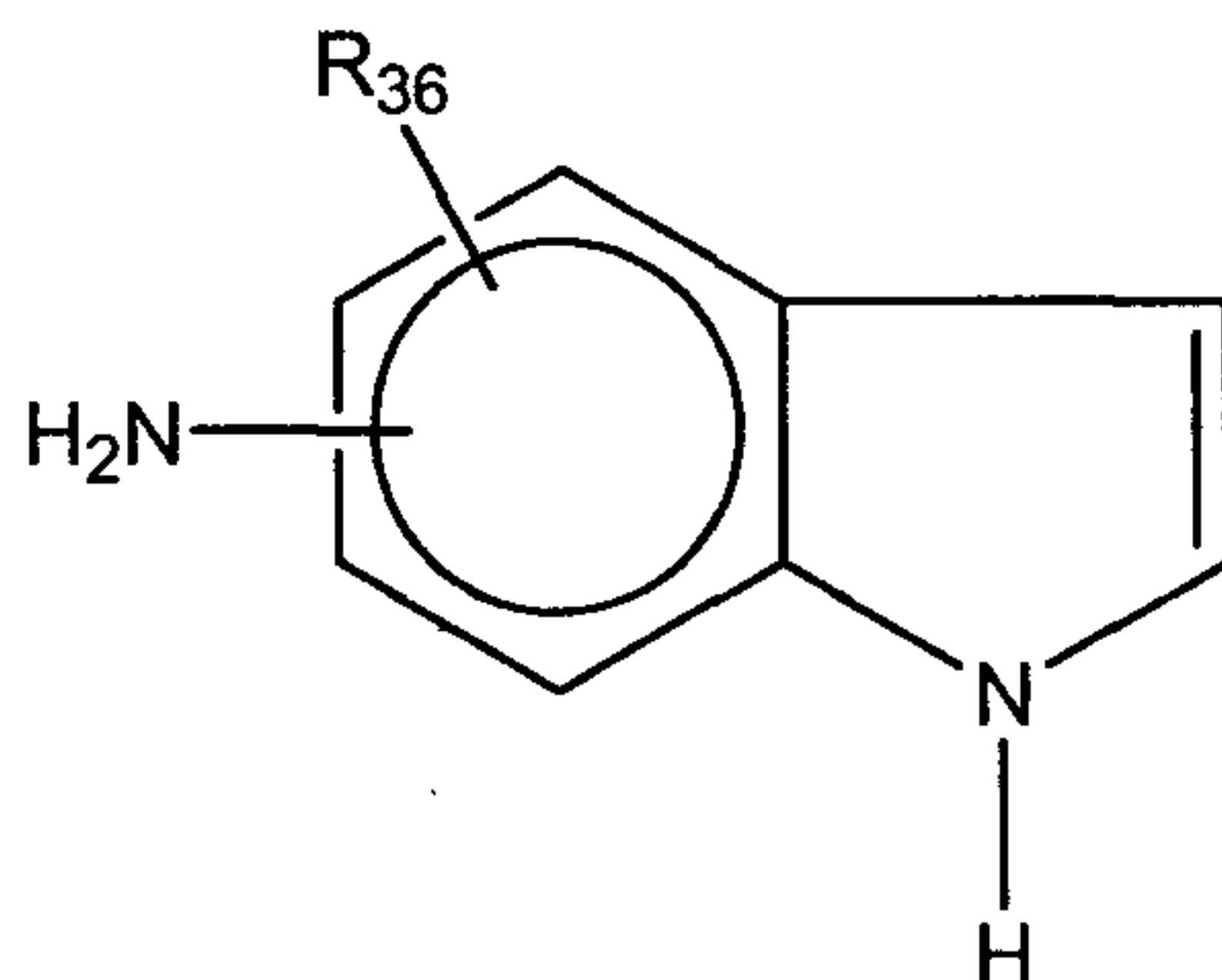
R_{34} represents $-NH_2$, $-NHR_{35}$, wherein R_{35} is an alkyl or an alkenyl group having from 1 to 8 carbon atoms, $-CH_2-(CH_2)_n-NH_2$ or $-CH_2$ -aryl- NH_2 and n is from 0 to 10;

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provided that when R_{34} is $-NHR_{35}$ wherein R_{35} is an alkyl or an alkenyl group having from 1 to 8 carbon atoms, then either L is $-NH-$ or $-CH_2NH-$; or R_{30} or R_{31} is OH or $-NR_{41}R_{42}$ wherein at least one of R_{41} or R_{42} is hydrogen; or R_{32} or R_{33} is OH ;

(h) an aminothiazole selected from the group consisting of aminothiazole, aminobenzothiazole, aminobenzothiadiazone and aminoalkylthiazole;

(i) an aminoindole represented by the formula:

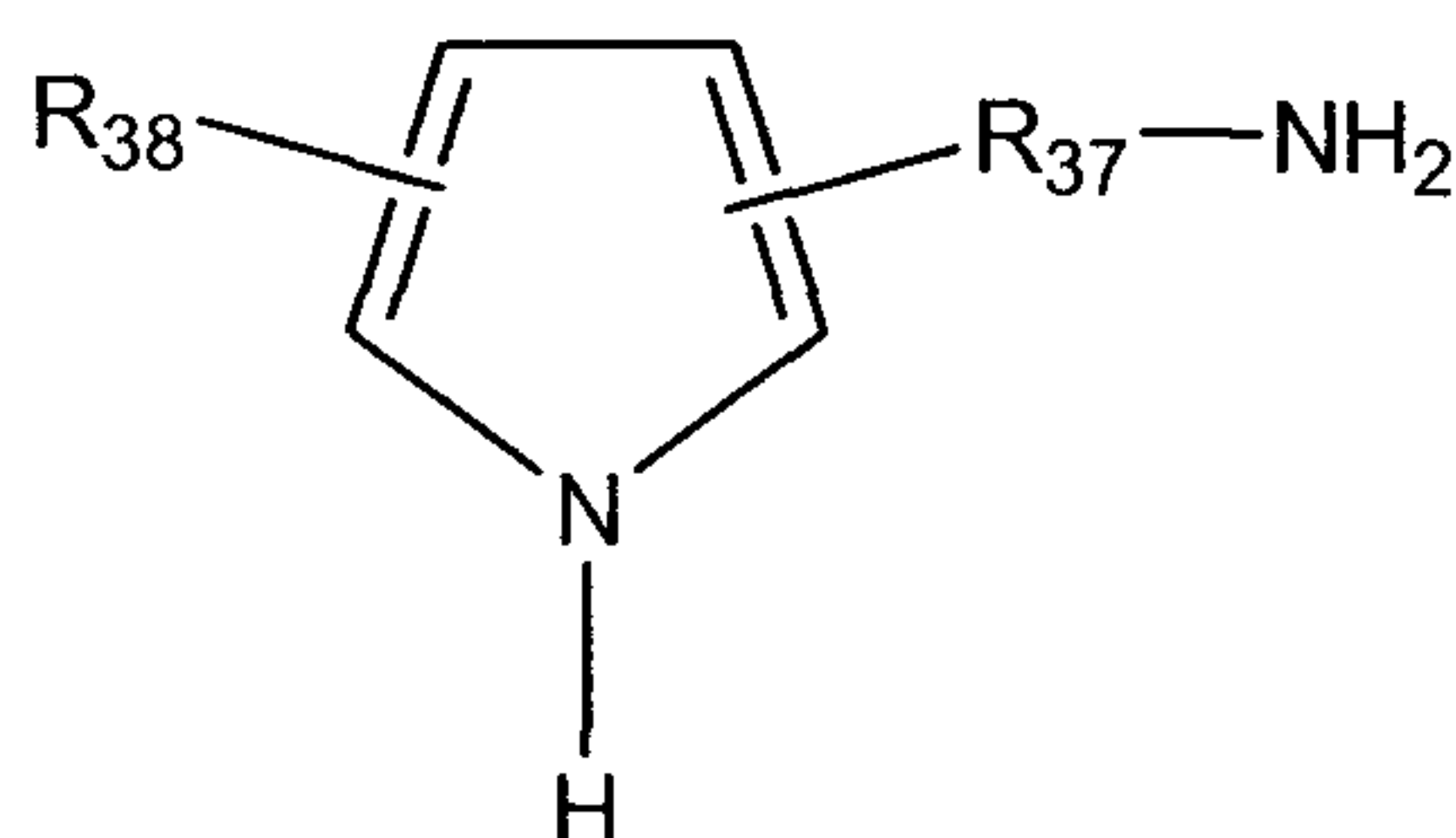


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wherein R_{36} represents a hydrogen, an alkyl or an alkenyl group having from 1 to 14 carbon atoms;

(j) an aminopyrrole represented by the formula:

10



wherein R_{37} represents a divalent alkylene group having 2 to 6 carbon atoms and R_{38} represents a hydrogen, an alkyl or an alkenyl group having from 1 to 14 carbon atoms;

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(k) a ring substituted or unsubstituted aniline;

(l) an aminoquinoline;

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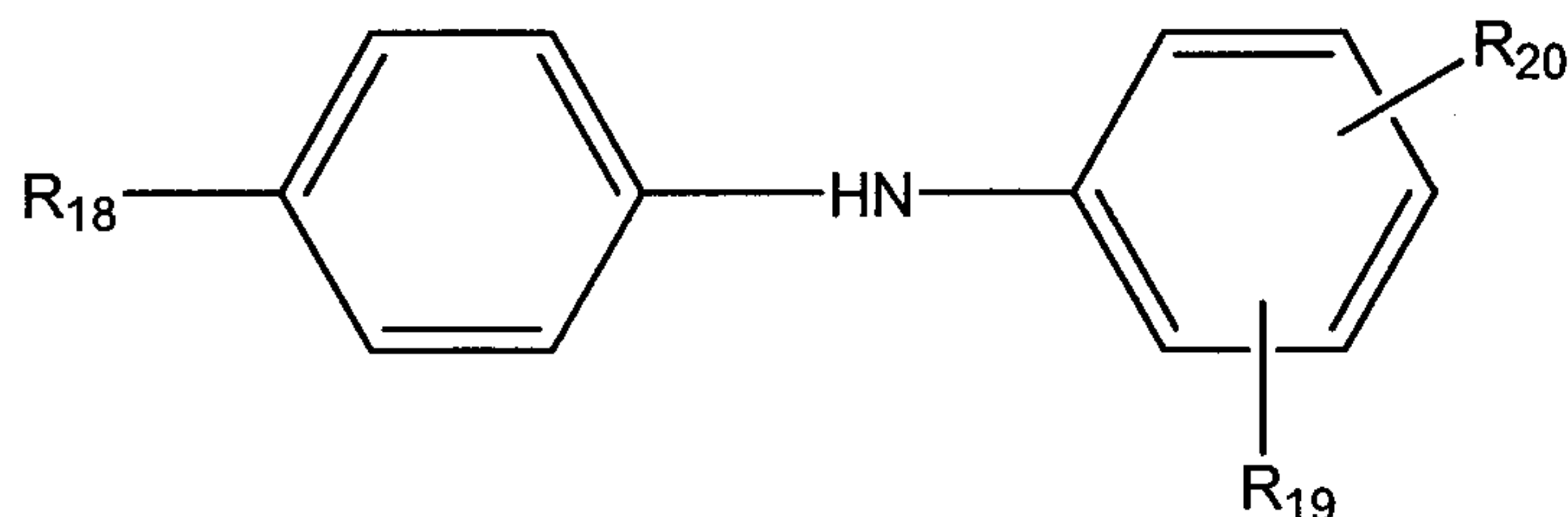
(m) an aminobenzimidazole;

(n) a N, N-dialkylphenylenediamine; and

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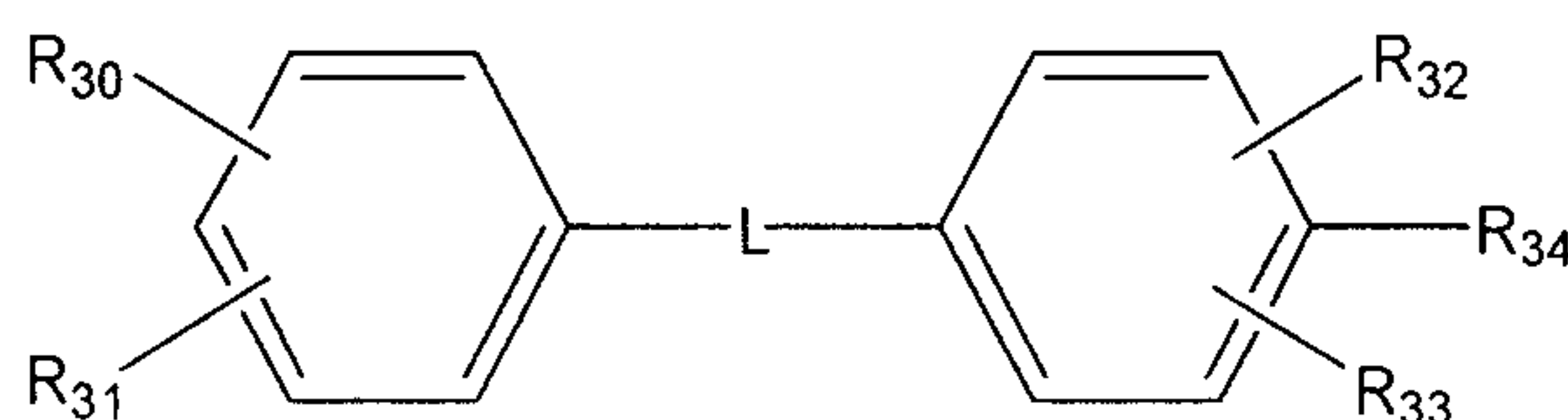
(o) a benzylamine.

4. The lubricating oil additive composition of claim 3, wherein the polyether aromatic compound is derived from an aromatic amine having the following formula



- 5 R_{18} is H, --NHaryl, -NHalkaryl, or a branched or straight chain hydrocarbonyl radical having from 4 to 24 carbon atoms selected from the group consisting of alkyl, alkenyl, alkoxyl, aralkyl and alkaryl; R_{19} is --NH₂, --(NH(CH₂)_n)_mNH₂, --NHalkyl, --NHaralkyl, --CH₂ --aryl--NH₂, in which n and m each have a value from 1 to 10; and R_{20} is hydrogen, alkyl, alkenyl, alkoxyl, aralkyl, or alkaryl, having from 4 to 24 carbon atoms.

5. The lubricating oil additive composition of Claim 3 wherein the polyether aromatic compound is derived from the following formula:



- 15 wherein L is selected from the group consisting of --O--, --N=N--, --NH--, and --CH₂NH;

- 20 R_{30} and R_{31} independently represent a hydrogen, alkyl, aryl, alkaryl, aralkyl, alkoxy, hydroxyalkyl, aminoalkyl, -OH, NO₂ or, -NR₄₁R₄₂ wherein R_{41} and R_{42} are independently hydrogen, alkyl, aryl, arylalkyl, or alkaryl;

- R_{32} and R_{33} independently represent a hydrogen, an alkyl, an alkenyl or an alkoxy group having from 1 to 8 carbon atoms, or -OH;

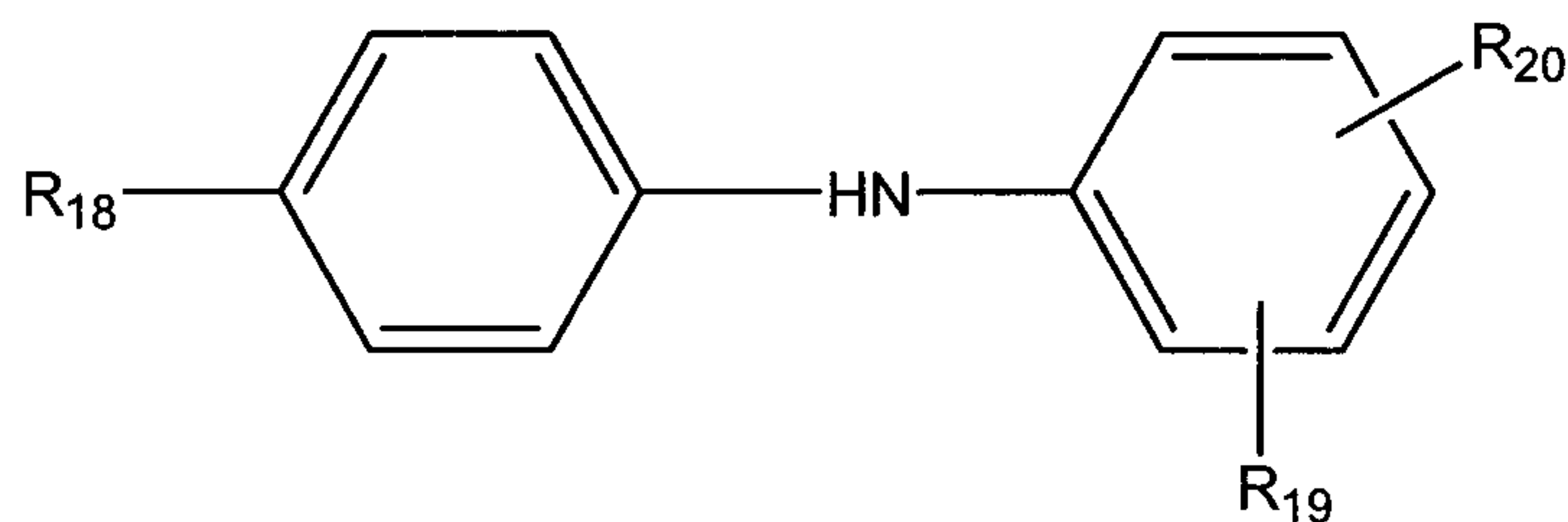
- 25 R_{34} represents --NH₂, -NHR₃₅, wherein R_{35} is an alkyl or an alkenyl group having from 1 to 8 carbon atoms, -CH₂-(CH₂)_n-NH₂ or --CH₂-aryl-NH₂ and n is from 0 to 10;

- provided that when R_{34} is $-NHR_{35}$ wherein R_{35} is an alkyl or an alkenyl group having from 1 to 8 carbon atoms, then either L is $-NH-$ or $-CH_2-NH-$; or R_{30} or R_{31} is OH or $-NR_{41}R_{42}$ wherein at least one of R_{41} or R_{42} is hydrogen; or R_{32} or R_{33} is OH.
6. The lubricating oil additive composition of Claim 4 wherein the polyether aromatic compound is derived from N-phenyl-1,4-phenylenediamine.
 7. The lubricating oil additive composition of Claim 5 wherein the polyether aromatic compound is derived from 4-(4-nitrophenylazo)aniline or 4-phenylazoaniline.
 8. The lubricating oil additive composition of claim 5, wherein the polyether aromatic compound is derived from 4-phenoxyaniline.
 9. The lubricating oil additive composition of claim 2, wherein the ether compound (1) is a polyoxyalkylene diamine wherein each alkylene unit individually contains from 2 to 5 carbon atoms.
 10. The lubricating oil additive composition of claim 9 wherein the oxyalkylene moiety is oxyethylene or oxypropylene, or mixtures thereof.
 11. The lubricating oil additive composition of claim 1 wherein the copolymer is copolymer (i).
 12. The lubricating oil additive composition of claim 1 wherein the copolymer is copolymer (ii).
 13. The lubricating oil additive composition of claim 12 wherein copolymer (ii) is polyPIBSA, obtained by the free radical catalyzed reaction of maleic anhydride and polyisobutylene.

14. The lubricating oil additive composition of claim 1 wherein the copolymer is copolymer (iii).

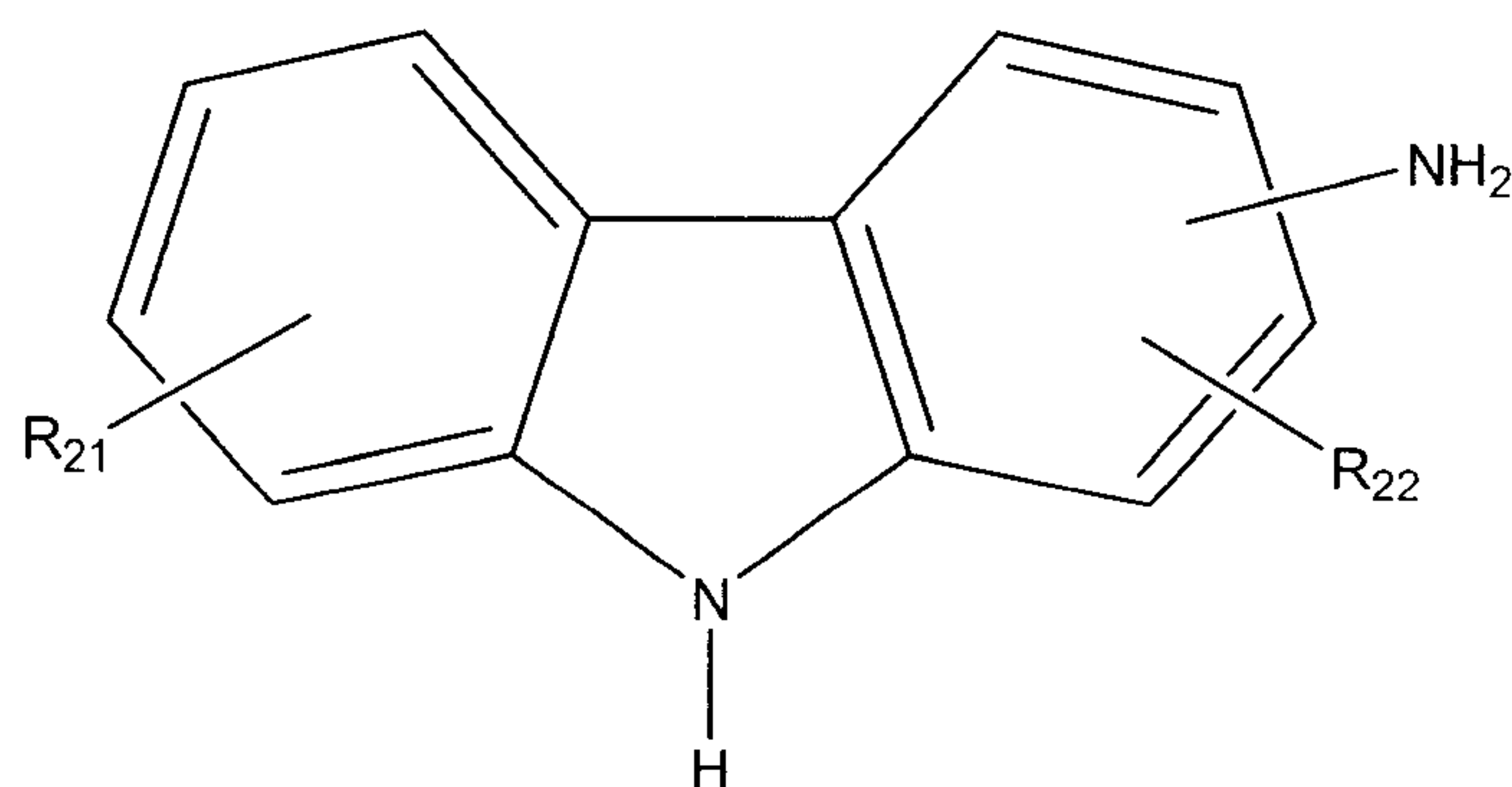
15. The lubricating oil additive composition of claim 2 wherein the aromatic compound is selected from the group consisting of:

(a) an N-arylphenylenediamine represented by the formula:



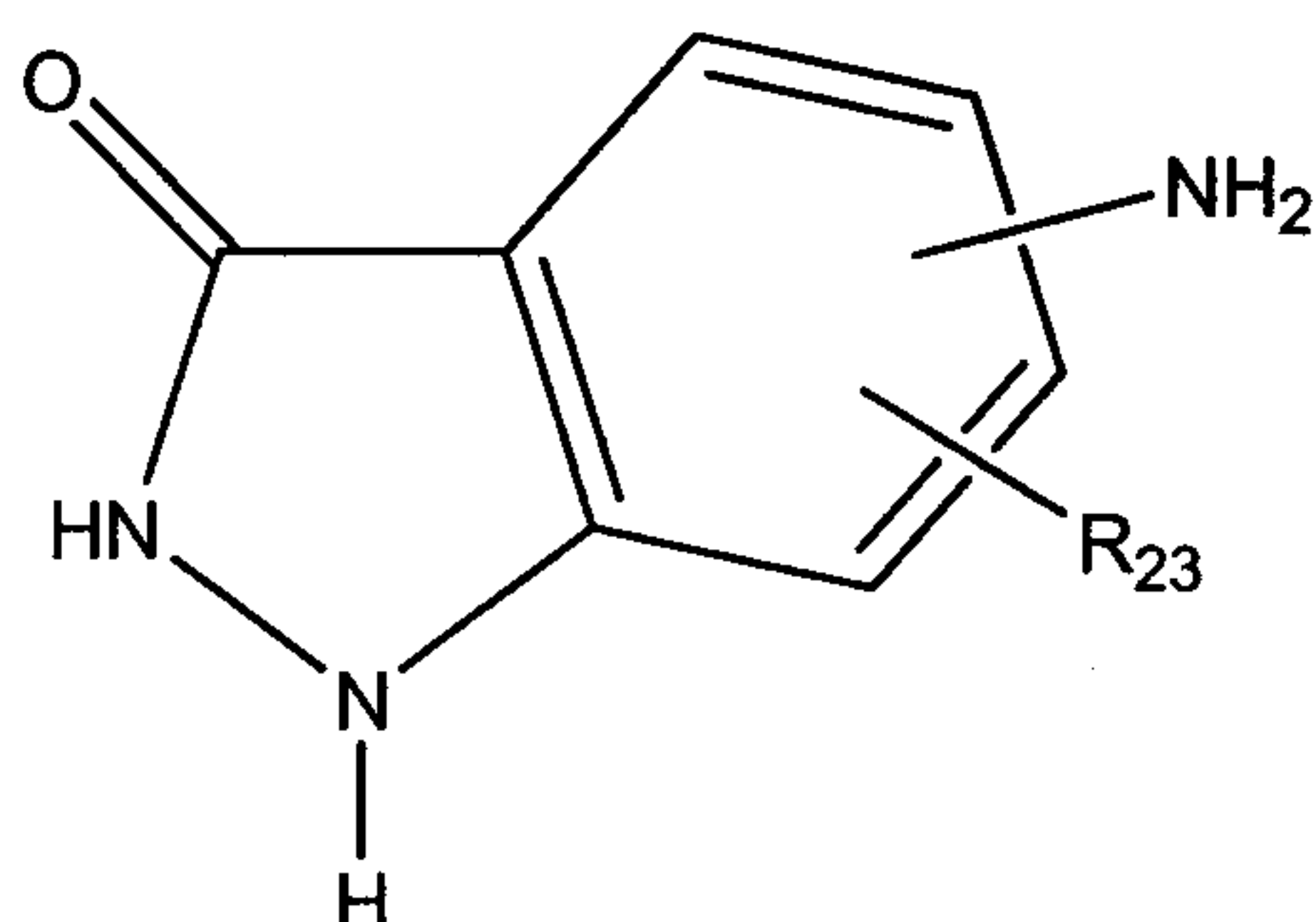
R_{18} is H, --NHaryl, --NHalkaryl, or a branched or straight chain hydrocarbyl radical having from 4 to 24 carbon atoms selected from the group consisting of alkyl, alkenyl, alkoxyl, aralkyl and alkaryl; R_{19} is --NH₂, --(NH(CH₂)_n)_mNH₂, --NHalkyl, --NHaralkyl, --CH₂--aryl--NH₂, in which n and m each have a value from 1 to 10; and R_{20} is hydrogen, alkyl, alkenyl, alkoxyl, aralkyl, or alkaryl, having from 4 to 24 carbon atoms.

(b) aminocarbazole represented by the formula:



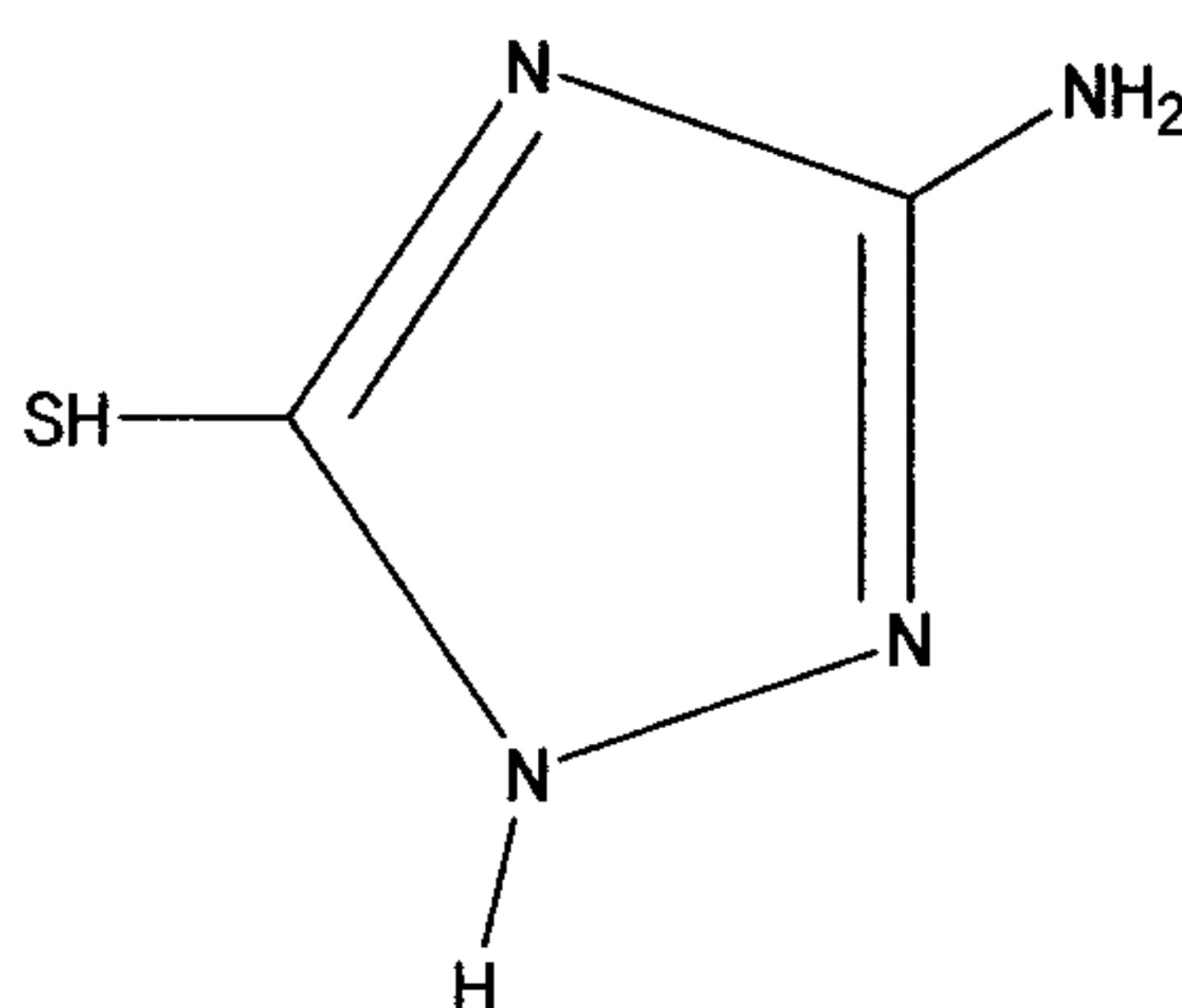
in which R_{21} and R_{22} each independently represent hydrogen or an alkyl or alkenyl radical having from 1 to 14 carbon atoms,

(c) an amino-indazolinone represented by the formula:

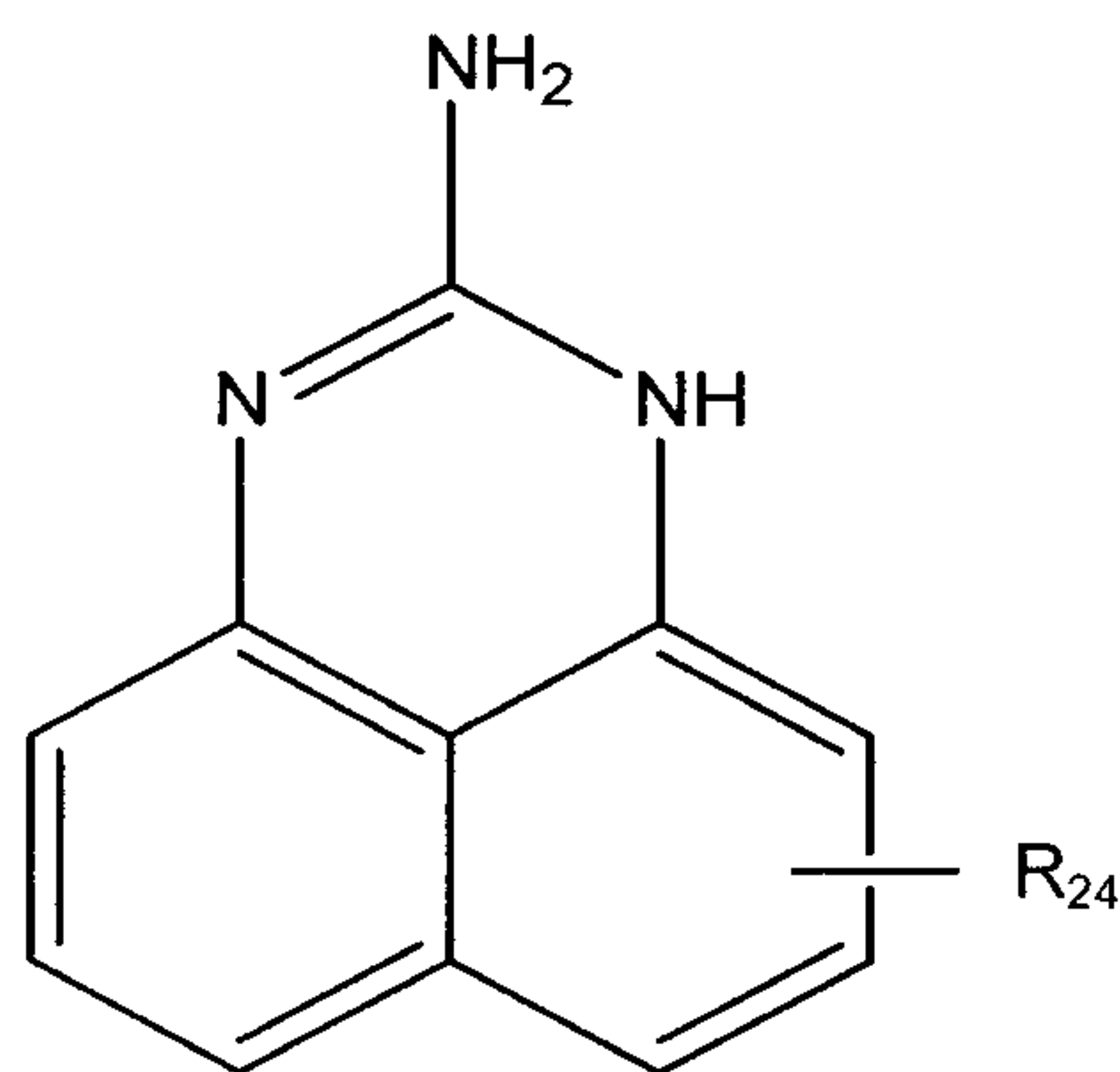


in which R_{23} is hydrogen or an alkyl radical having from 1 to 14 carbon atoms; and

- 5 (d) an aminomercaptotriazole represented by the formula:

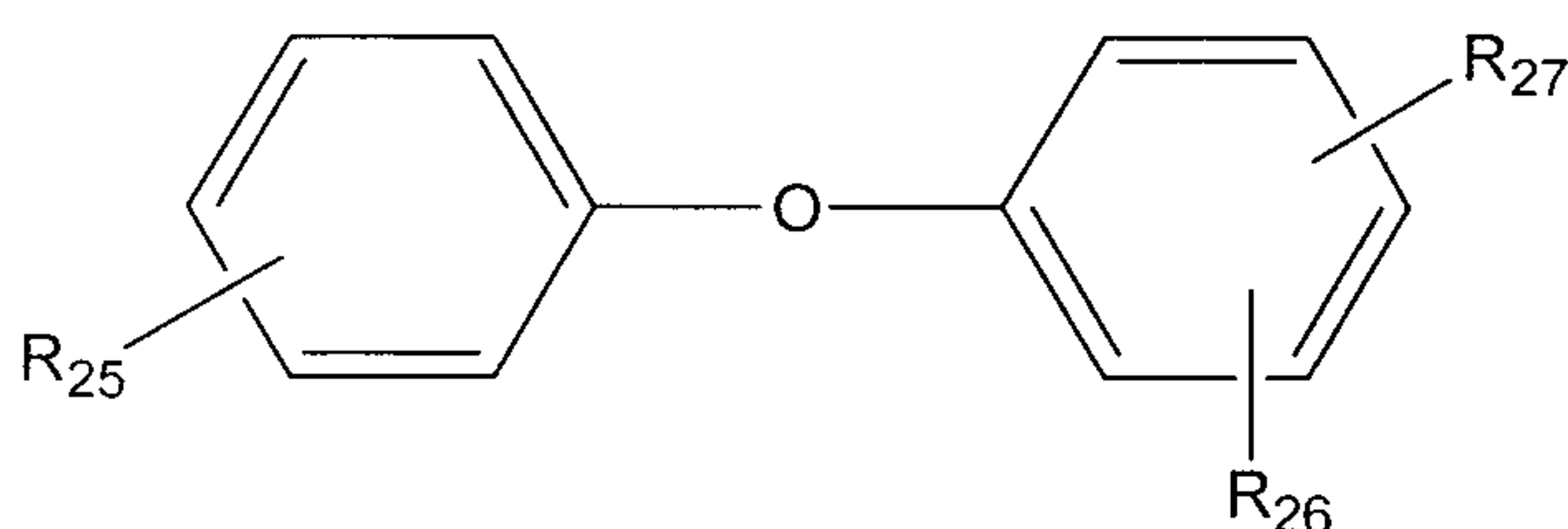


- (e) an aminoperimidine represented by the formula:



in which R_{24} represents hydrogen or an alkyl radical having from 1 to 14 carbon atoms;

- (f) an aryloxyphenyleneamine represented by the formula:

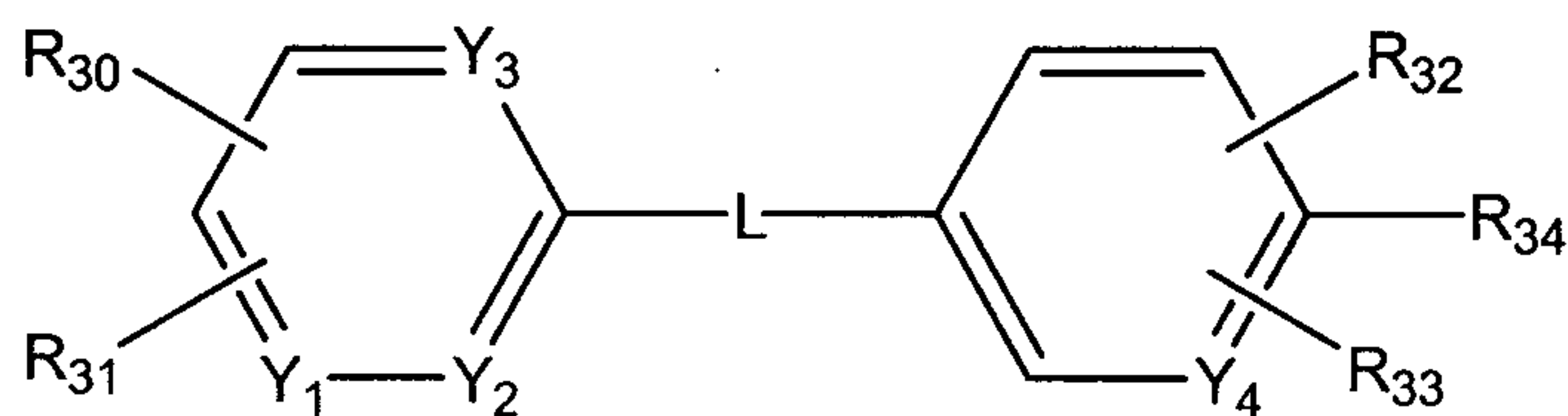


in which R_{25} is H, --NHaryl, --NHalkaryl, or branched or straight chain radical having from 4 to 24 carbon atoms that is alkyl, alkenyl,

alkoxyl, aralkyl or alkaryl; R_{26} is $--NH_2$, $--(NH(CH_2)_n)_m NH_2$, $--NHalkyl$, or $--NHaralkyl$, in which n and m each have a value from 1 to 10; and R_{27} is hydrogen, alkyl, alkenyl, alkoxyl, aralkyl, or alkaryl, having from 4 to 24 carbon atoms;

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- (g) an aromatic amine comprising two aromatic groups, linked by a group, L, represented by the following formula:



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wherein L is selected from the group consisting of $-O-$, $-N=N-$, $-NH-$, $-CH_2NH-$, $-C(O)NR_{28}-$, $-C(O)O-$, $-SO_2-$, $-SO_2NR_{29}-$ and $-SO_2NH-$, wherein R_{28} and R_{29} independently represent a hydrogen, an alkyl, an alkenyl or an alkoxy group having from 1 to 8 carbon atoms;

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wherein each Y_1 , Y_2 , Y_3 and Y_4 are independently N or CH provided that Y_1 and Y_2 may not both be N;

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R_{30} and R_{31} independently represent a hydrogen, alkyl, aryl, alkaryl, aralkyl, alkoxy, hydroxyalkyl, aminoalkyl, $-OH$, $-NO_2$, $-SO_3H$, $-SO_3Na$, CO_2H or salt thereof, or $-NR_{41}R_{42}$ wherein R_{41} and R_{42} are independently hydrogen, alkyl, aryl, arylalkyl, or alkaryl;

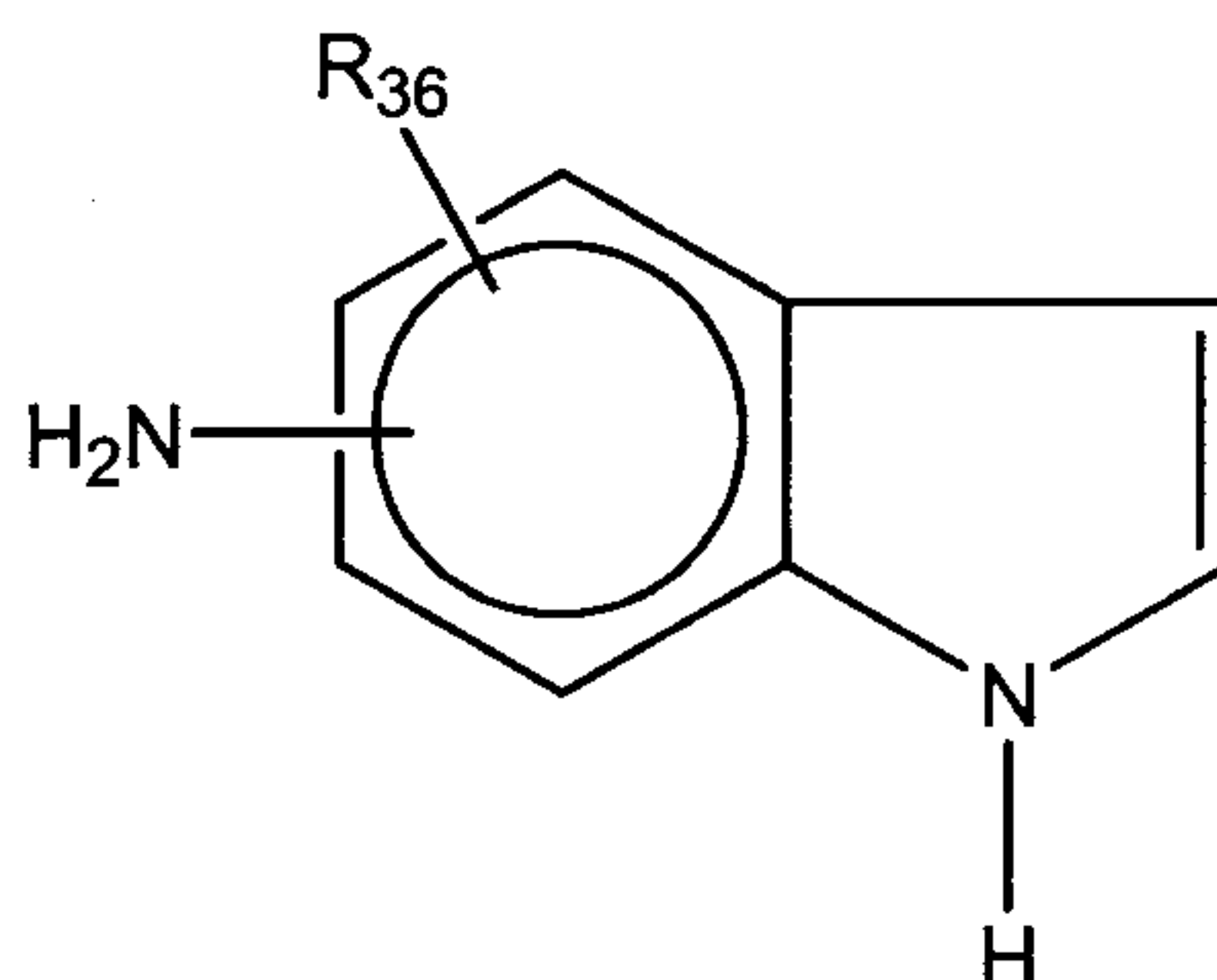
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R_{32} and R_{33} independently represent a hydrogen, an alkyl, an alkenyl or an alkoxy group having from 1 to 8 carbon atoms, $-OH$, $-SO_3H$ or $-SO_3Na$;

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- (h) an aminothiazole selected from the group consisting of aminothiazole, aminobenzothiazole, aminobenzothiadiazole and aminoalkylthiazole;

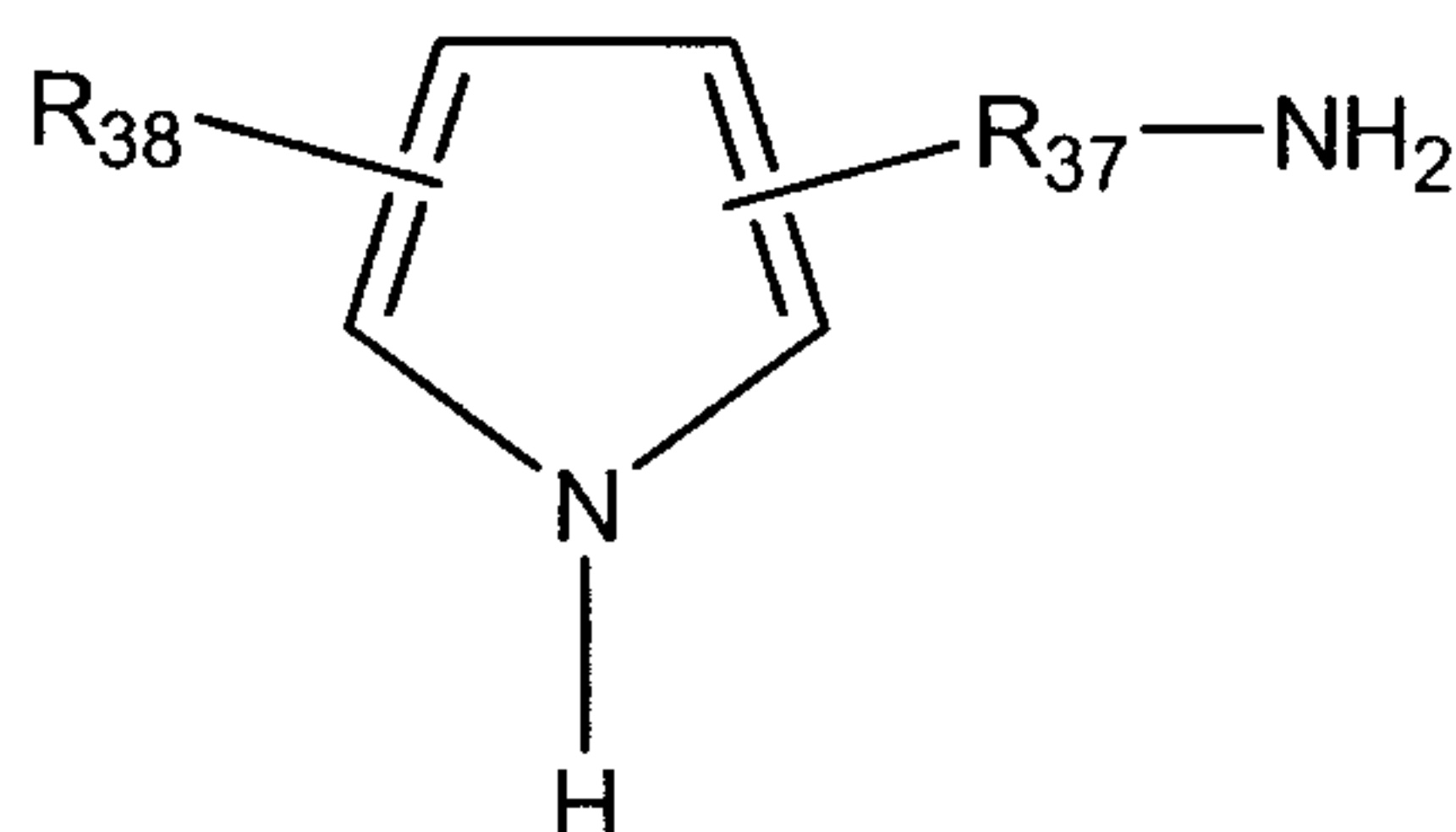
- (i) an aminoindole represented by the formula:



wherein R_{36} represents a hydrogen, an alkyl or an alkenyl group having from 1 to 14 carbon atoms;

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- (j) an aminopyrrole represented by the formula:



wherein R_{37} represents a divalent alkylene group having 2 to 6 carbon atoms and R_{38} represents a hydrogen, an alkyl or an alkenyl group having from 1 to 14 carbon atoms;

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- (k) a ring substituted or unsubstituted aniline;

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- (l) an aminoquinoline;

- (m) an aminobenzimidazole;

- (n) a N, N-dialkylphenylenediamine;

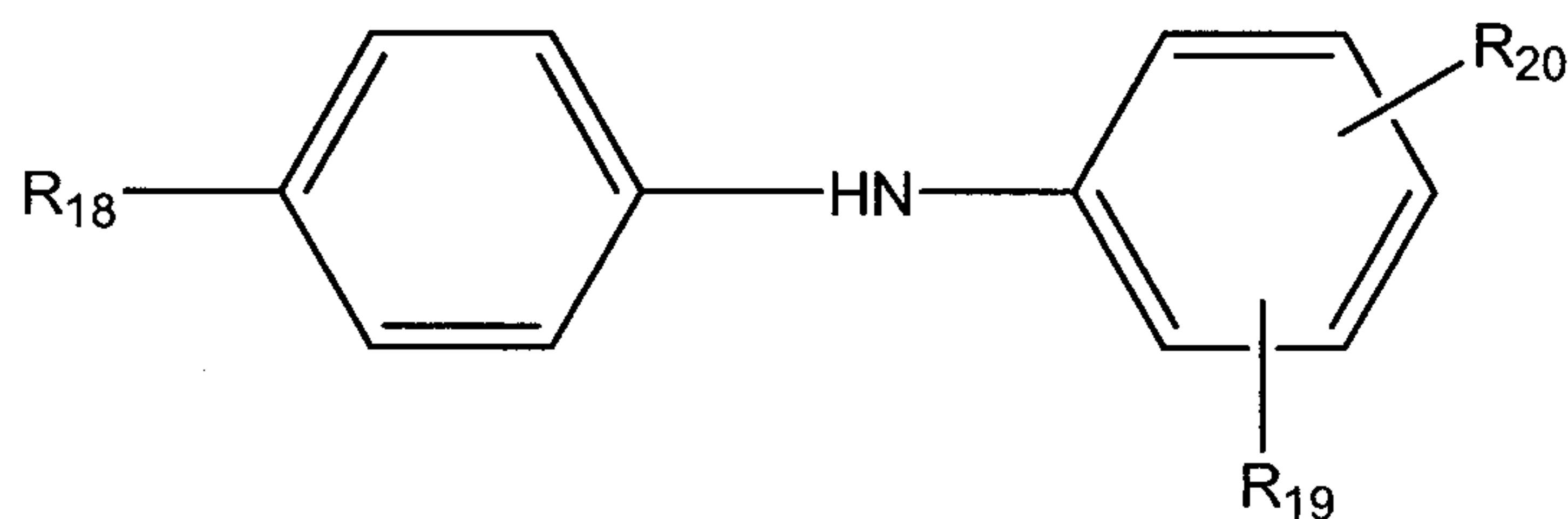
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- (o) a benzylamine; and

- (p) a benzyl alcohol.

16. The lubricating oil additive composition of claim 15 wherein the aromatic compound is N-arylphenylenediamine.
17. The lubricating oil additive composition of claim 16 wherein the N-arylphenylenediamine is N-phenylphenylenediamine.
18. The lubricating oil additive composition of claim 17 wherein the N-phenylphenylenediamine is N-phenyl-1,4-phenylenediamine.

19. The lubricating oil additive composition of claim 15, wherein the aromatic compound is an aromatic amine having the following formula



- R₁₈ is H, --NHaryl, --NHalkaryl, or a branched or straight chain hydrocarbyl radical having from 4 to 24 carbon atoms selected from the group consisting of alkyl, alkenyl, alkoxyl, aralkyl and alkaryl; R₁₉ is --NH₂, --(NH(CH₂)_n)_mNH₂, --NHalkyl, --NHaralkyl, --CH₂ --aryl--NH₂, in which n and m each have a value from 1 to 10; and R₂₀ is hydrogen, alkyl, alkenyl, alkoxyl, aralkyl, or alkaryl, having from 4 to 24 carbon atoms.

20. The lubricating oil additive composition of claim 1 wherein compound (i)(b) of copolymer (i) is polyisobutene having a number average molecular weight (M_n) of from about 112 to about 5000.
21. The lubricating oil additive composition of claim 20 wherein the number average molecular weight (M_n) is from about 500 to about 3000.
22. The lubricating oil additive composition of claim 21 wherein the number average molecular weight (M_n) is from about 1000 to about 2500.

23. The lubricating oil additive composition of claim 1 wherein (i)(a) is a dicarboxylic acid, anhydride or ester thereof.
24. The lubricating oil additive composition of claim 23 wherein (i)(a) is maleic anhydride or ester thereof.
25. The lubricating oil additive composition of claim 1 wherein the monoolefin of (i)(c) is a 1-olefin.
26. The lubricating oil additive composition of claim 2 wherein the at least one aliphatic compound (3) capable of being reacted with one monocarboxylic acid or ester thereof, or dicarboxylic acid, anhydride or ester thereof is N-aminopropylmorpholine or 1,3-dimethylaminopropylamine.
27. A lubricating oil composition comprising a major amount of an oil of lubricating viscosity and a minor amount of the lubricating oil additive composition prepared by the process which comprises reacting
- (A) at least one of the following copolymers:
- (i) a copolymer obtained by free radical copolymerization of components comprising:
- (a) at least one monoethylenically unsaturated C₃-C₂₈ monocarboxylic acid or ester thereof, or C₄-C₂₈ dicarboxylic acid, anhydride or ester thereof;
- (b) at least one 1-olefin comprising 2 to 40 carbon atoms or at least one polyolefin comprising 4 to 360 carbon atoms and having a terminal copolymerizable group in the form of a vinyl, vinylidene or alkyl vinylidene group or mixtures thereof; and

- (c) at least one monoolefin compound which is copolymerizable with the monomers of (a) and (b) and is selected from the group consisting of:
- 5 (1) an alkyl vinyl ether and an allyl alkyl ether where the alkyl group is hydroxyl, amino, dialkylamino or alkoxy substituted or is unsubstituted, and containing from 1 to 40 carbon atoms;
 - 10 (2) an alkyl amine and an N-alkylamide of a monoethylenically unsaturated mono- or dicarboxylic acid of from 3 to 10 carbon atoms where the alkyl substituent contains from 1 to 40 carbon atoms;
 - 15 (3) an N-vinylcarboxamide of carboxylic acids of from 1 to 8 carbon atoms;
 - 20 (4) an N-vinyl substituted nitrogen-containing heterocyclic compound; and
 - 25 (5) at least one 1-olefin comprising 2 to 40 carbon atoms or at least one polyolefin comprising 4 to 360 carbon atoms and having a terminal copolymerizable group in the form of a vinyl, vinylidene or alkyl vinylidene group or mixtures thereof, provided that the olefin employed is not the same as the olefin employed in (i)(b);
 - 30 (ii) a copolymer obtained by reacting compound (i)(a) and compound(i)(b) in the presence of a free radical initiator; or

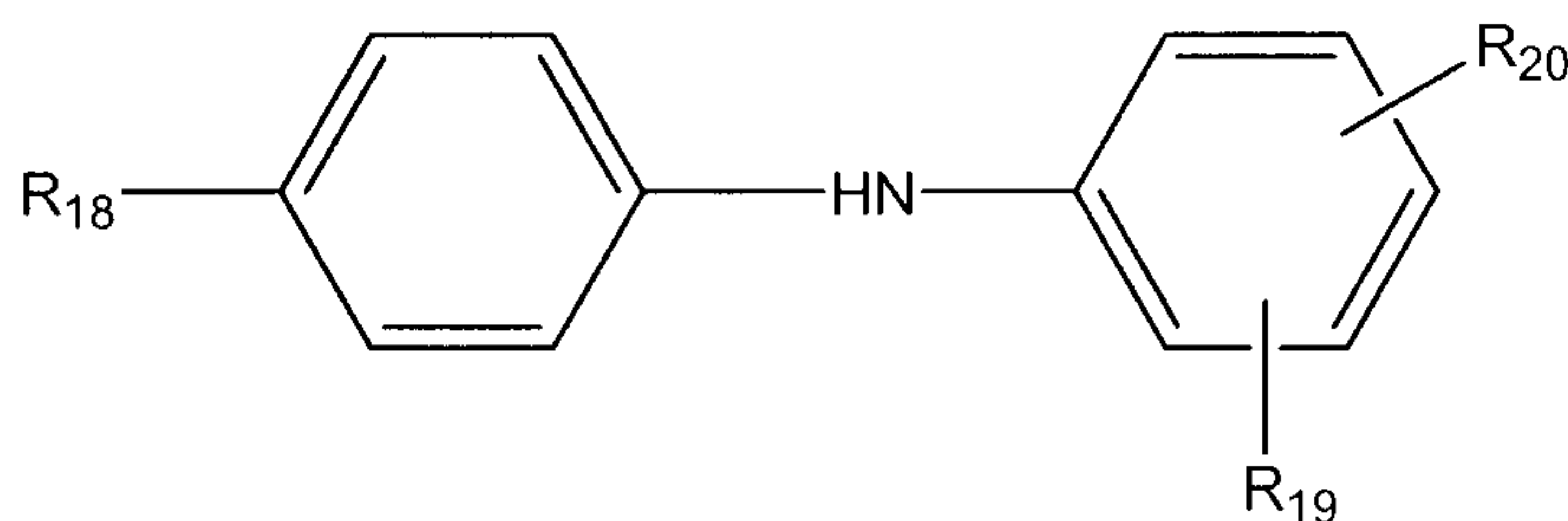
(iii) a copolymer obtained by (a) reacting compound (i)(a) with compound (i)(b) or (i)(c) in a non-free radical catalyzed reaction in the presence of copolymer (i) or copolymer (ii) or both; or by (b) contacting copolymer (i) or copolymer (ii) or both with the non-free radical catalyzed reaction product of compound (i)(a) and compound (i)(b) or (i)(c); with

(B) at least one polyether aromatic compound capable of being reacted with at least two monocarboxylic acids or esters thereof, or with at least two dicarboxylic acids, anhydrides or esters thereof, or mixtures thereof.

28. The lubricating oil composition of Claim 27, wherein copolymer (i), (ii) or (iii) is reacted with at least one polyether aromatic compound and additionally with (1) at least one polyether aliphatic compound or (2) at least one aromatic compound capable of being reacted with at least one monocarboxylic acid or ester thereof, or dicarboxylic acid, anhydride or ester thereof, or (3) at least one aliphatic compound capable of being reacted with at least one monocarboxylic acid or ester thereof, or dicarboxylic acid, anhydride or ester thereof, or mixtures of (1), (2) or (3).

29. The lubricating oil composition of Claim 27, wherein the polyether aromatic compound is derived from an aromatic amine selected from the group consisting of

(a) an N-arylphenylenediamine represented by the formula:

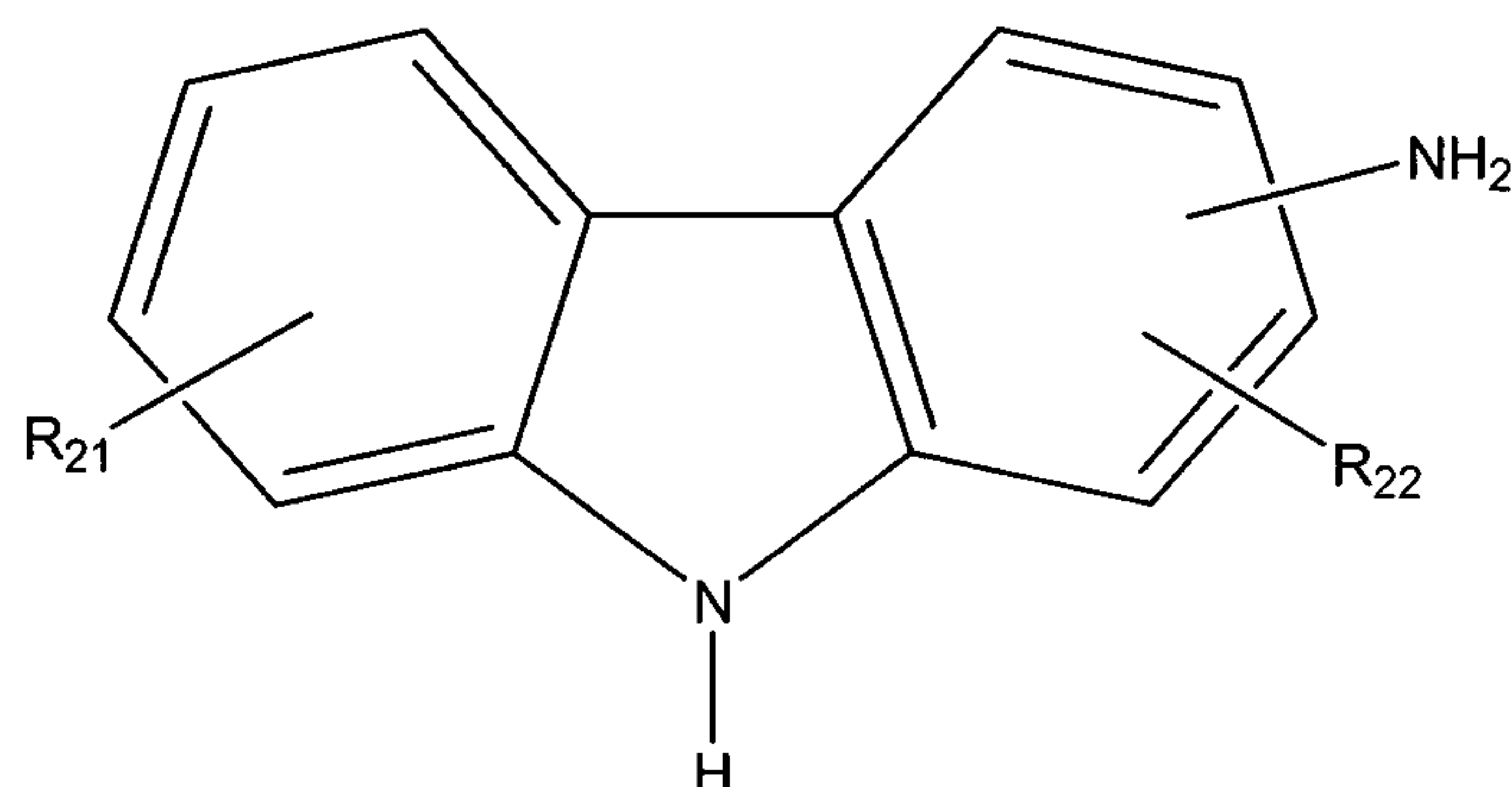


R_{18} is H, --NHaryl, -NHalkaryl, or a branched or straight chain hydrocarbyl radical having from 4 to 24 carbon atoms selected from the group consisting of alkyl, alkenyl, alkoxyl, aralkyl and alkaryl; R_{19}

is --NH₂, --(NH(CH₂)_n)_mNH₂, --NHalkyl, --NHaralkyl, --CH₂--aryl--NH₂, in which n and m each have a value from 1 to 10; and R₂₀ is hydrogen, alkyl, alkenyl, alkoxy, aralkyl, or alkaryl, having from 4 to 24 carbon atoms;

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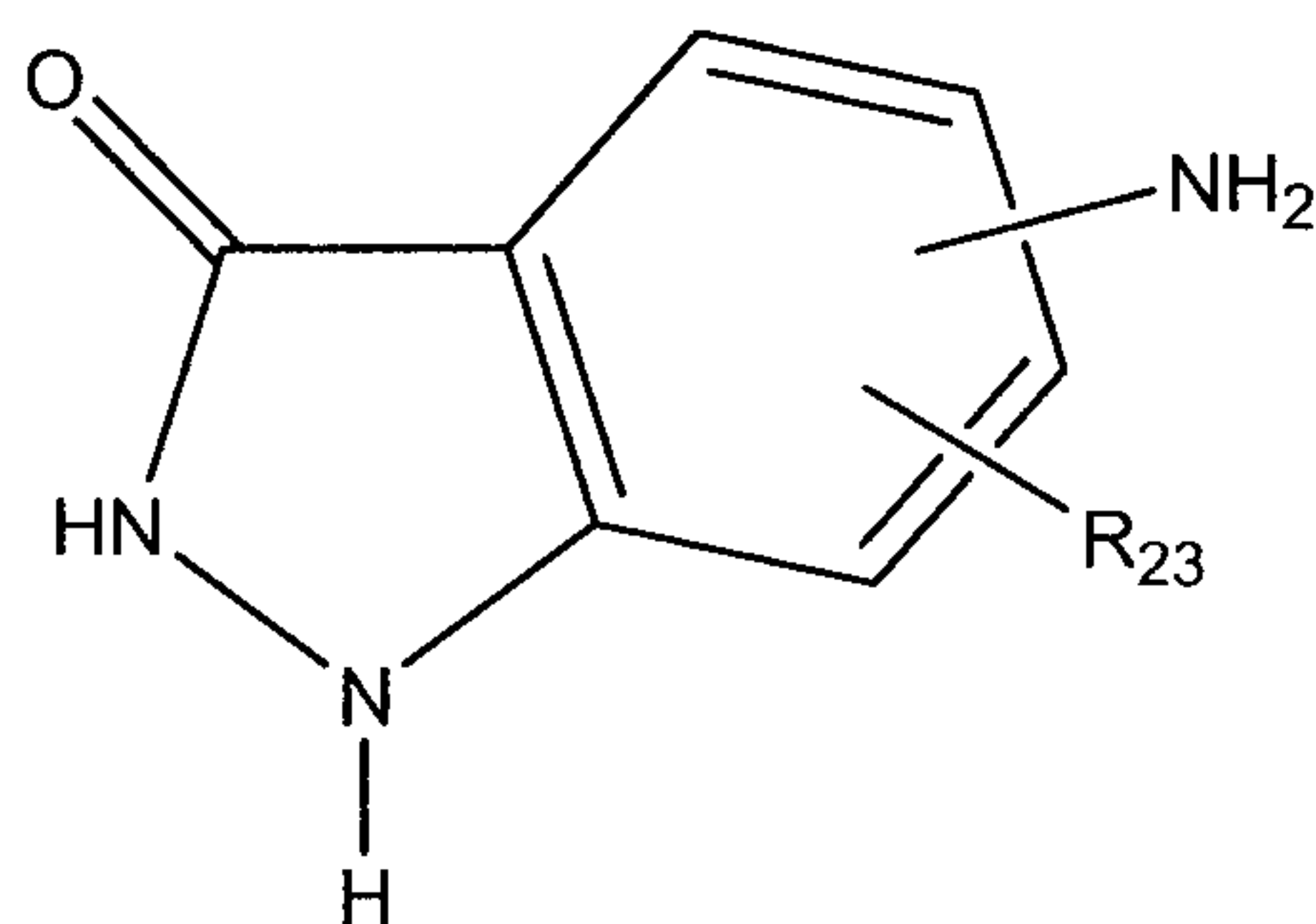
(b) aminocarbazole represented by the formula:



in which R₂₁ and R₂₂ each independently represent hydrogen or an alkyl or alkenyl radical having from 1 to 14 carbon atoms,

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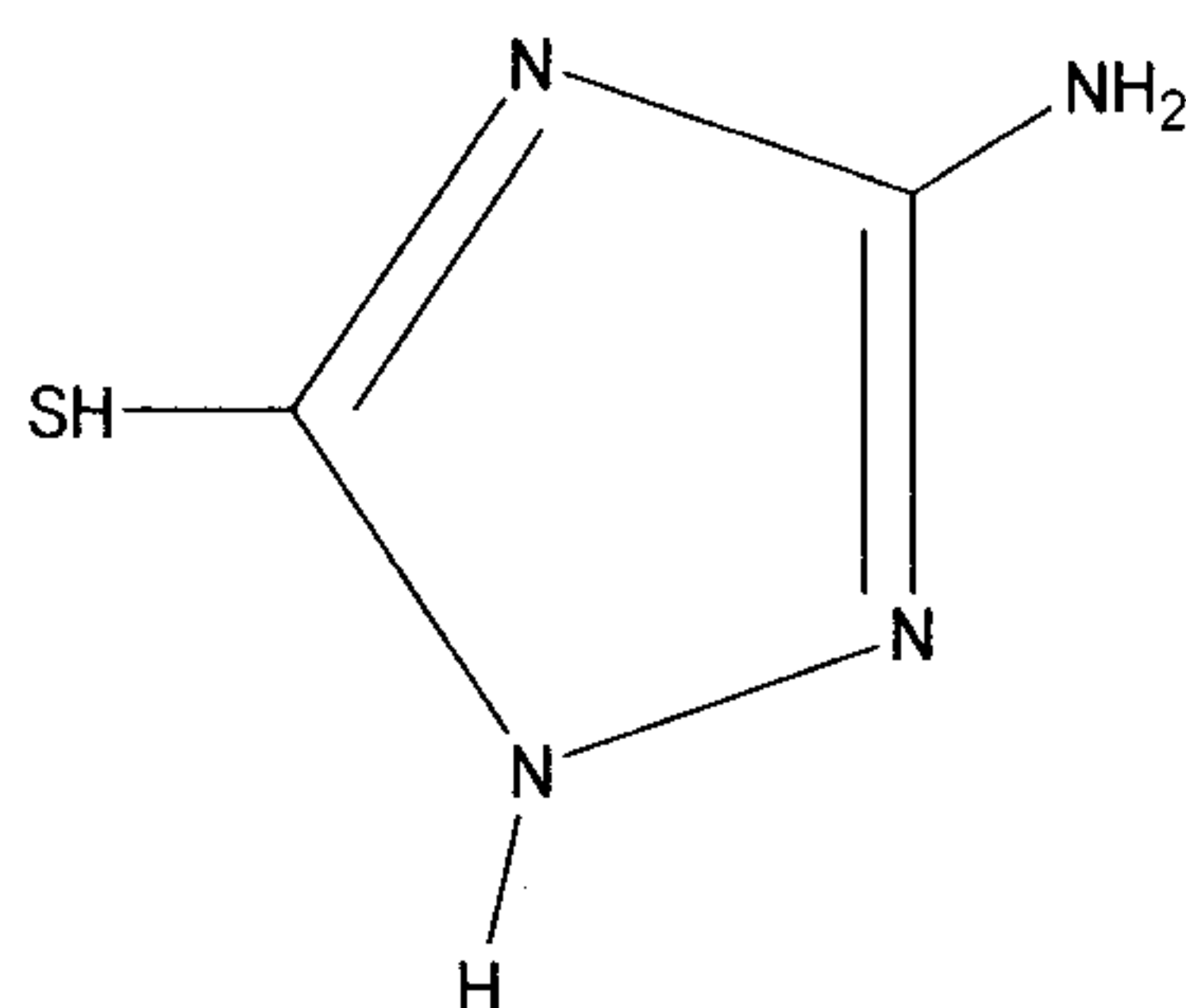
(c) an amino-indazolinone represented by the formula:



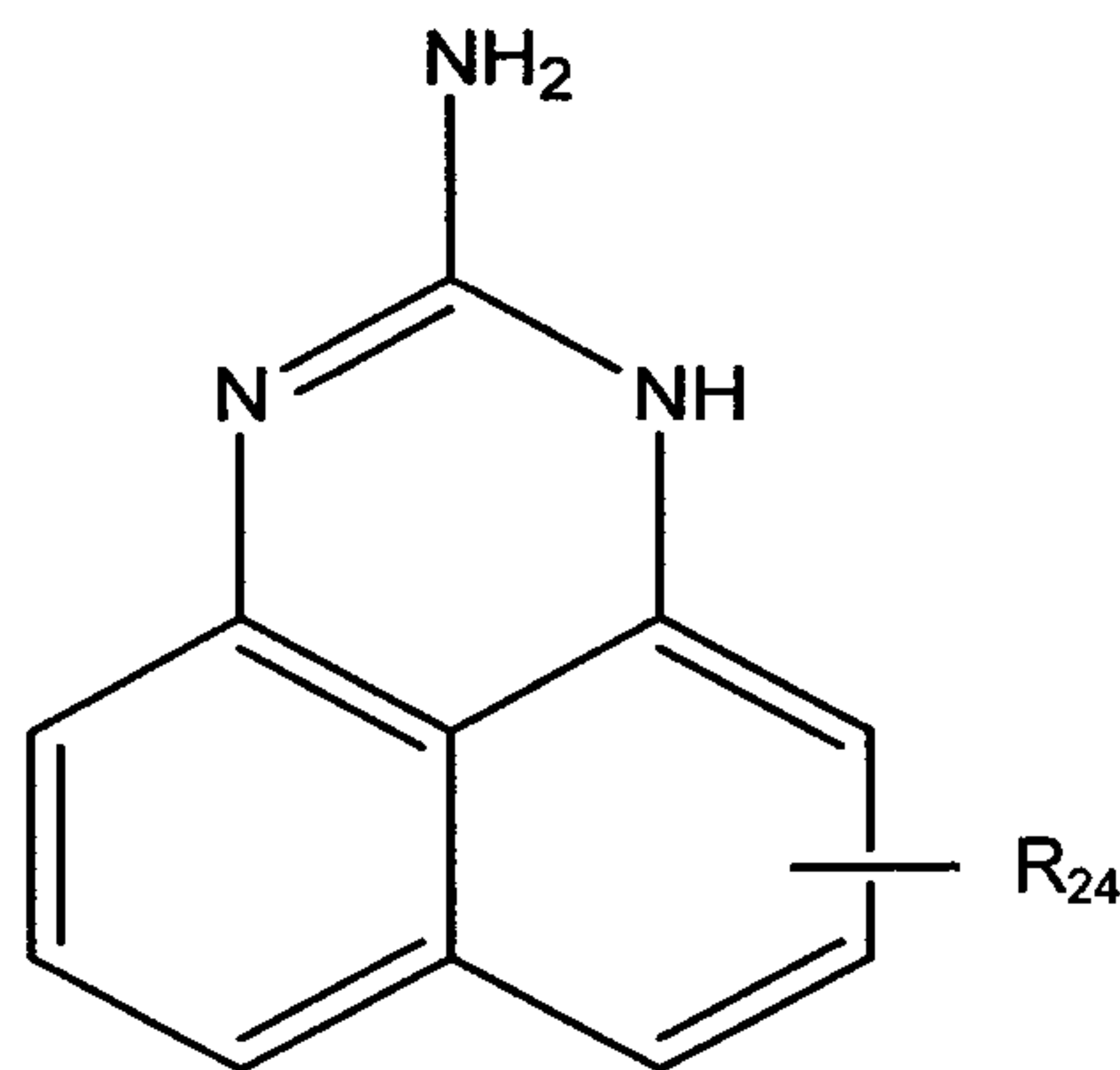
in which R₂₃ is hydrogen or an alkyl radical having from 1 to 14 carbon atoms;

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(d) an aminomercaptotriazole represented by the formula:

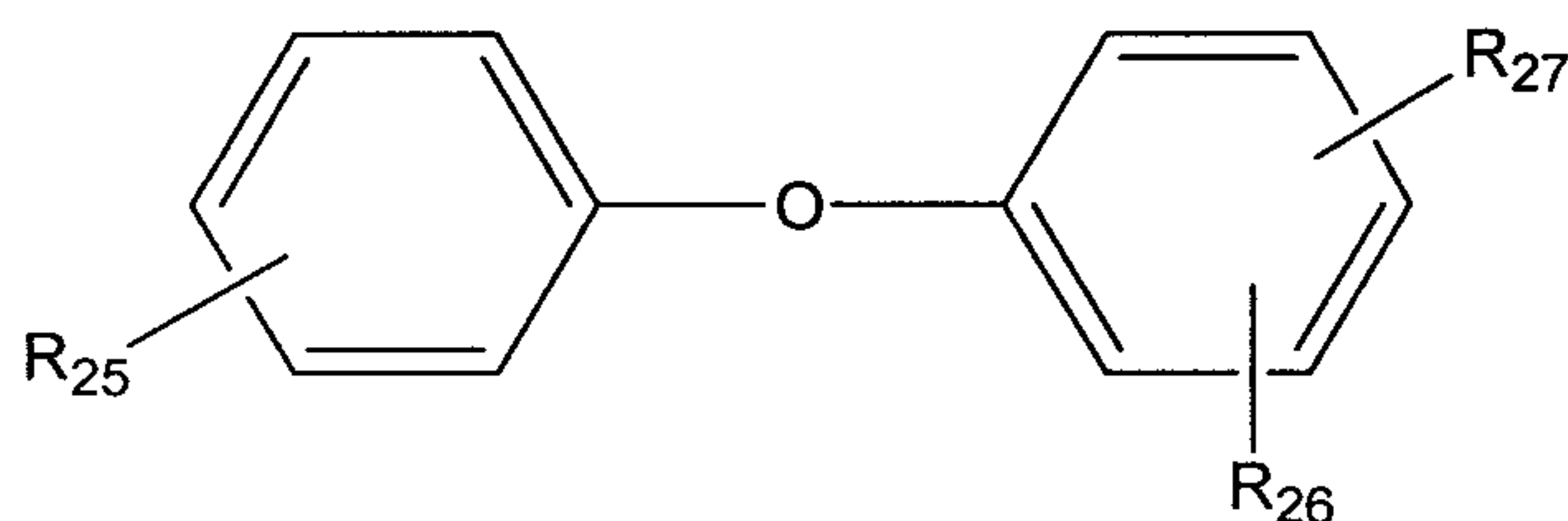


(e) an aminoperimidine represented by the formula:



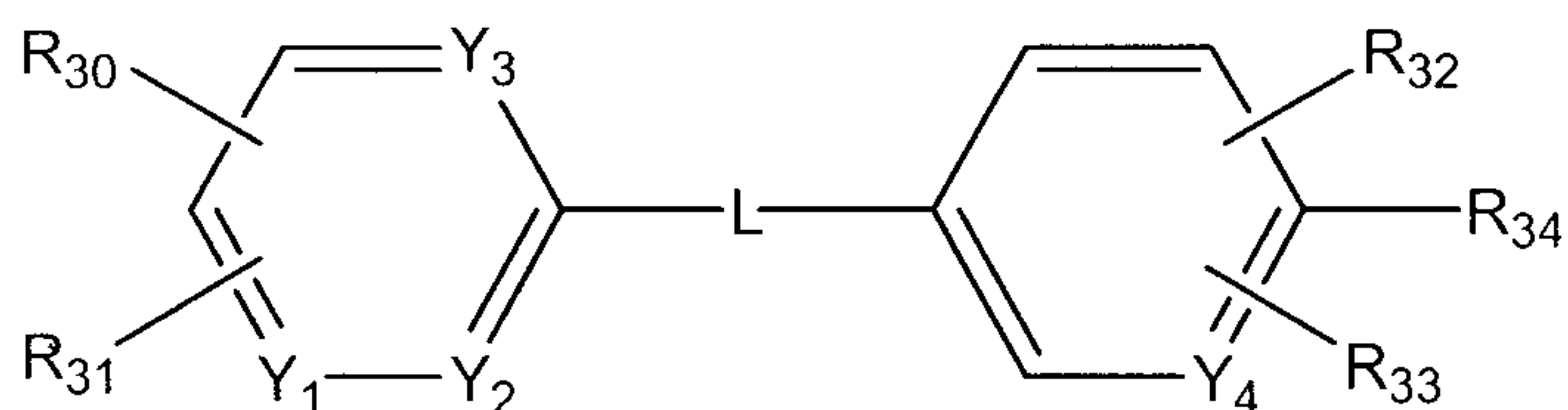
in which R_{24} represents hydrogen or an alkyl radical having from 1 to 14 carbon atoms;

- 5 (f) an aryloxyphenyleneamine represented by the formula:



in which R_{25} is H, --NHaryl, -NHalkaryl, or branched or straight chain radical having from 4 to 24 carbon atoms that is alkyl, alkenyl, alkoxy, aralkyl or alkaryl; R_{26} is -NH₂, -(NH(CH₂)_n)_m NH₂, -NHalkyl, or --NHaralkyl, in which n and m each have a value from 1 to 10; and R_{27} is hydrogen, alkyl, alkenyl, alkoxy, aralkyl, or alkaryl, having from 4 to 24 carbon atoms; provided that when R_{25} is hydrogen or a branched or straight chain radical having from 4 to 24 carbon atoms selected from the group consisting of alkyl, alkenyl, alkoxy, aralkyl and alkaryl, then R_{26} must be NH₂ or -(NH(CH₂)_n)_mNH₂, -CH₂-(CH₂)_n-NH₂, or -CH₂-aryl-NH₂;

- (g) an aromatic amine comprising two aromatic groups, linked by a group, L, represented by the following formula:



wherein L is selected from the group consisting of -O-, -N=N-, -NH-, -CH₂NH-, -C(O)NR₂₈-, -C(O)O-, -SO₂-, -SO₂NR₂₉- and -SO₂NH-,

wherein R_{28} and R_{29} independently represent a hydrogen, an alkyl, an alkenyl or an alkoxy group having from 1 to 8 carbon atoms;

wherein each Y_1 , Y_2 , Y_3 and Y_4 are independently N or CH provided that Y_1 and Y_2 may not both be N;

R_{30} and R_{31} independently represent a hydrogen, alkyl, aryl, alkaryl, aralkyl, alkoxy, hydroxyalkyl, aminoalkyl, -OH, -NO₂, -SO₃H, -SO₃Na, CO₂H or salt thereof, or -NR₄₁R₄₂ wherein R_{41} and R_{42} are independently hydrogen, alkyl, aryl, arylalkyl, or alkaryl;

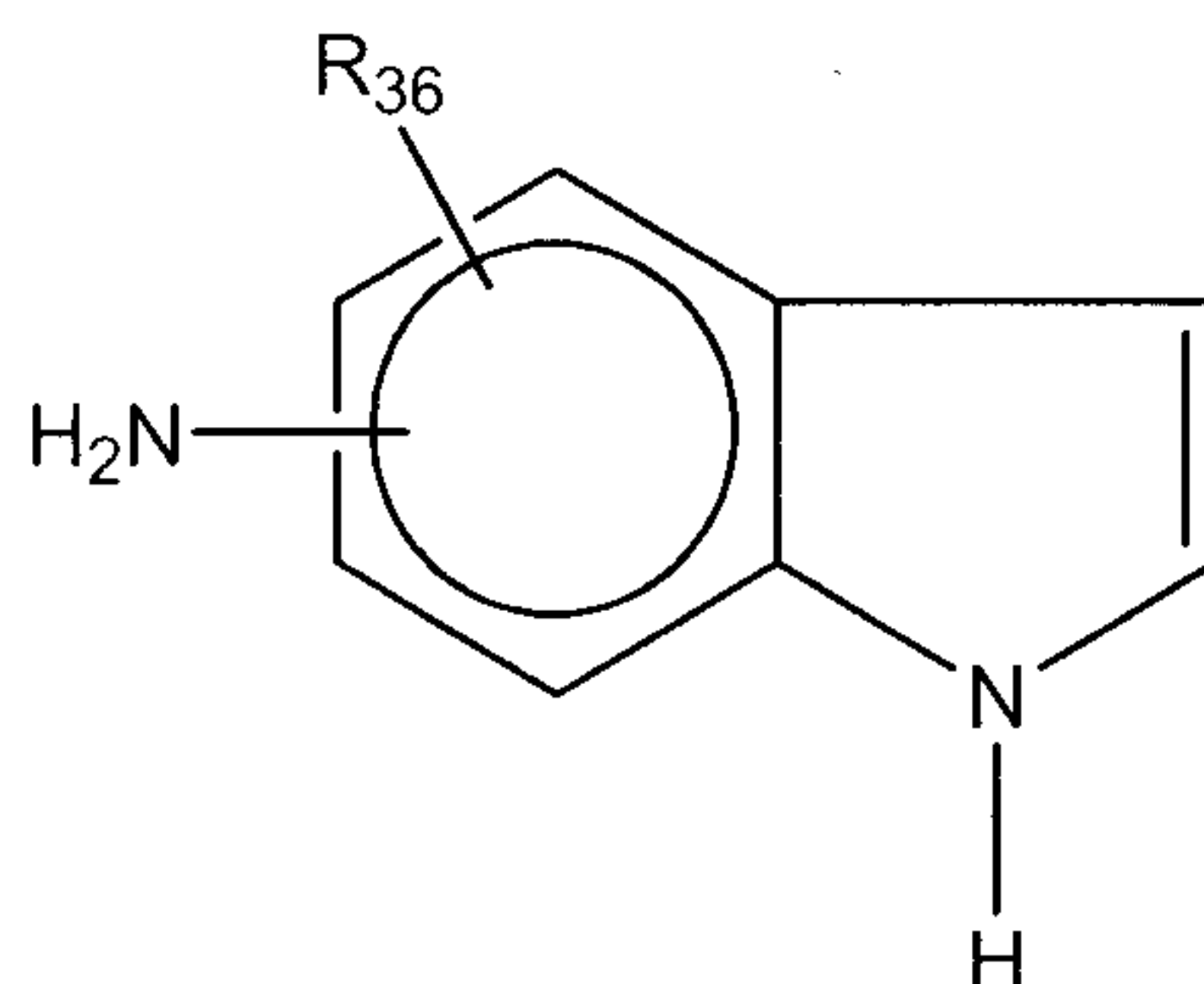
R_{32} and R_{33} independently represent a hydrogen, an alkyl, an alkenyl or an alkoxy group having from 1 to 8 carbon atoms, -OH, -SO₃H or -SO₃Na;

R_{34} represents -NH₂, -NHR₃₅, wherein R_{35} is an alkyl or an alkenyl group having from 1 to 8 carbon atoms, -CH₂-(CH₂)_n-NH₂ or -CH₂-aryl-NH₂ and n is from 0 to 10;

provided that when R_{34} is -NHR₃₅ wherein R_{35} is an alkyl or an alkenyl group having from 1 to 8 carbon atoms, then either L is -NH- or -CH₂-NH-; or R_{30} or R_{31} is OH or -NR₄₁R₄₂ wherein at least one of R_{41} or R_{42} is hydrogen; or R_{32} or R_{33} is OH;

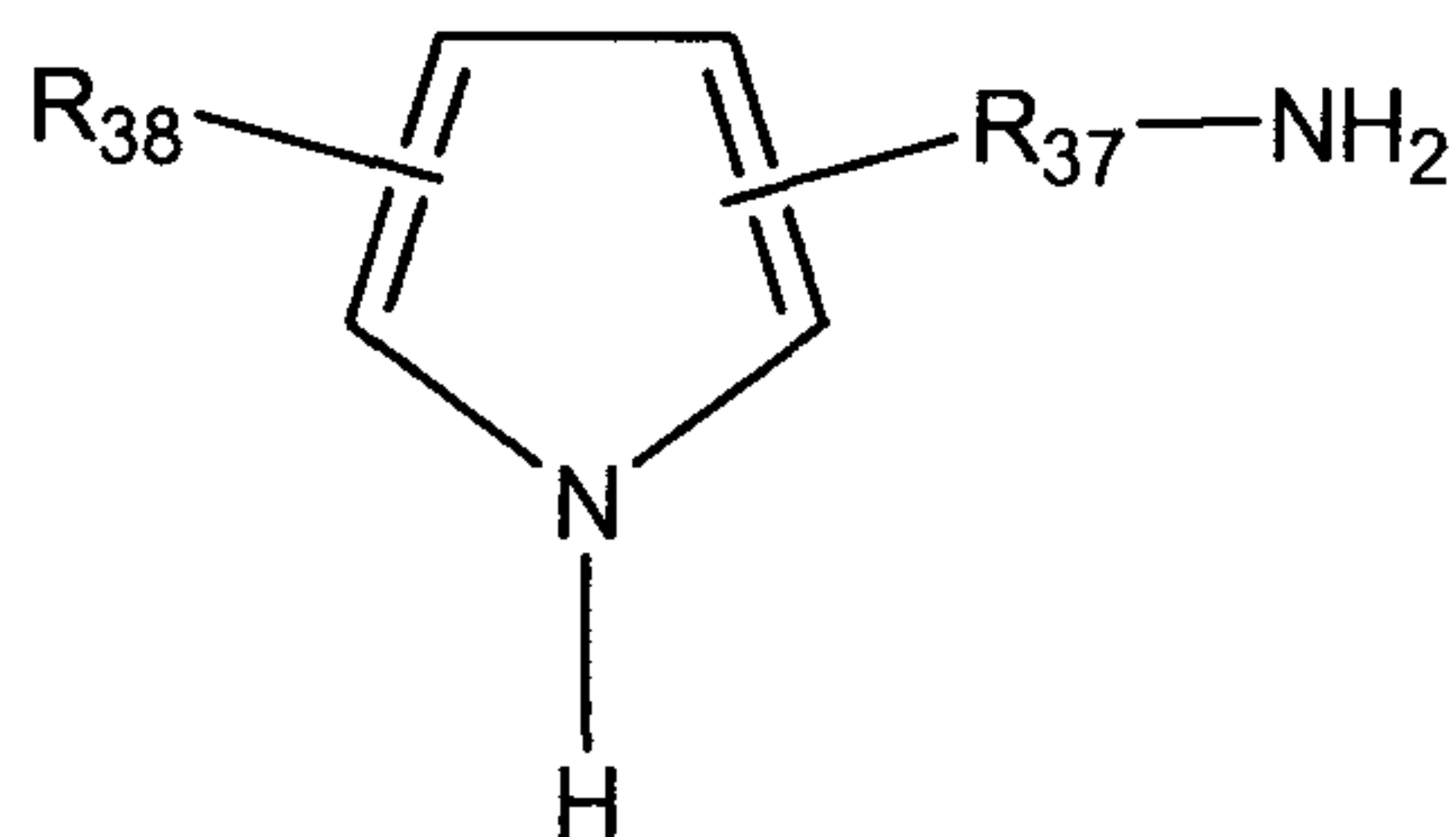
(h) an aminothiazole selected from the group consisting of aminothiazole, aminobenzothiazole, aminobenzothiadiazole and aminoalkylthiazole;

(i) an aminoindole represented by the formula:



wherein R_{36} represents a hydrogen, an alkyl or an alkenyl group having from 1 to 14 carbon atoms;

(j) an aminopyrrole represented by the formula:



wherein R_{37} represents a divalent alkylene group having 2 to 6 carbon atoms and R_{38} represents a hydrogen, an alkyl or an alkenyl group having from 1 to 14 carbon atoms;

(k) a ring substituted or unsubstituted aniline;

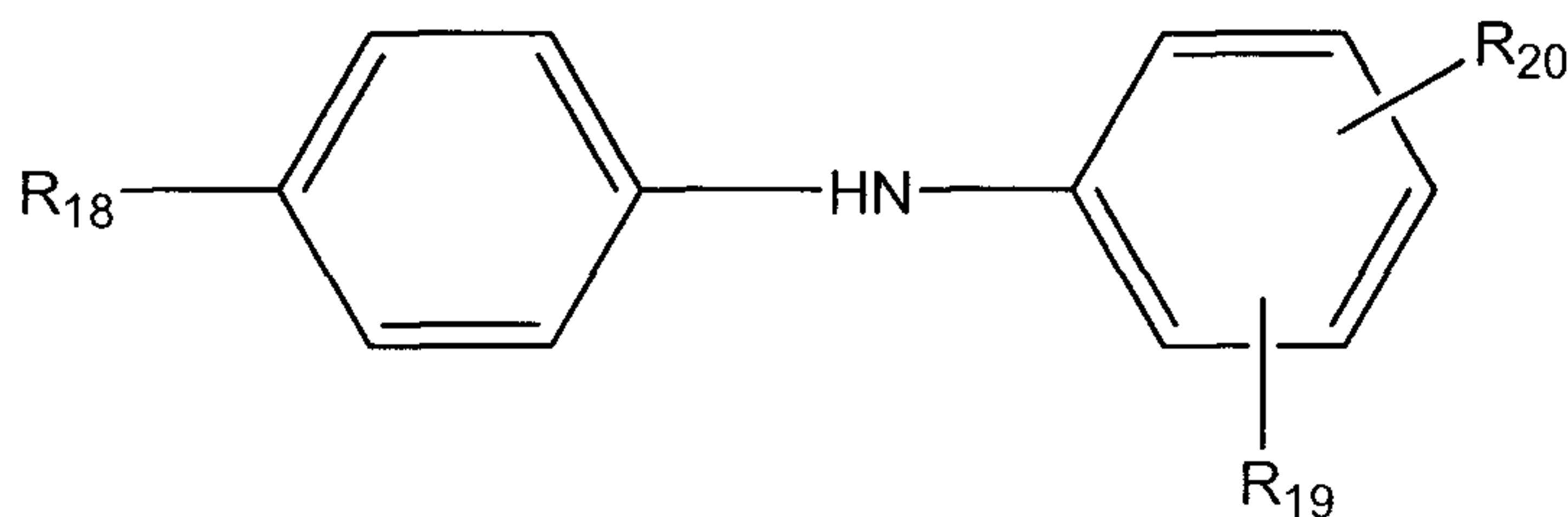
(l) an aminoquinoline;

(m) an aminobenzimidazole;

(n) a N, N-dialkylphenylenediamine; and

(o) a benzylamine.

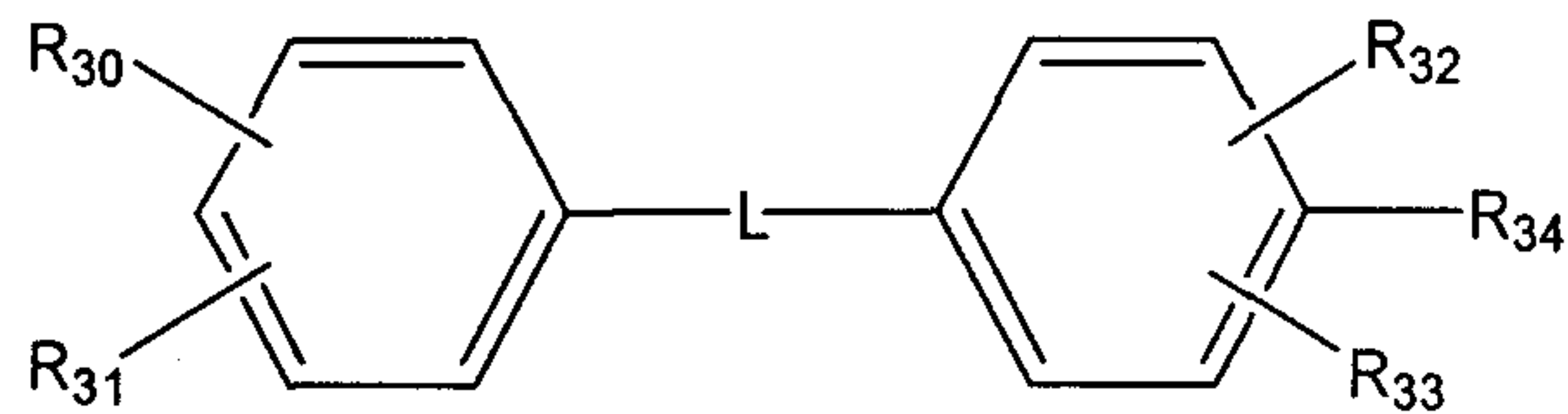
30. The lubricating oil composition of claim 29, wherein the polyether aromatic compound is derived from an aromatic amine having the following formula



R_{18} is H, --NHaryl, -NHalkaryl, or a branched or straight chain hydrocarbyl radical having from 4 to 24 carbon atoms selected from the group consisting of alkyl, alkenyl, alkoxyl, aralkyl and alkaryl; R_{19} is --NH₂, -(NH(CH₂)_n)_mNH₂, -NHalkyl, -NHaralkyl, -CH₂-aryl--NH₂, in which n and m each have a

value from 1 to 10; and R_{20} is hydrogen, alkyl, alkenyl, alkoxy, aralkyl, or alkaryl, having from 4 to 24 carbon atoms.

31. The lubricating oil composition of Claim 29 wherein the polyether aromatic compound is derived from the following formula:



wherein L is selected from the group consisting of $-O-$, $-N=N-$, $-NH-$, and $-CH_2NH-$;

- R_{30} and R_{31} independently represent a hydrogen, alkyl, aryl, alkaryl, aralkyl, alkoxy, hydroxyalkyl, aminoalkyl, $-OH$, or, $-NR_{41}R_{42}$ wherein R_{41} and R_{42} are independently hydrogen, alkyl, aryl, arylalkyl, or alkaryl;

- R_{32} and R_{33} independently represent a hydrogen, an alkyl, an alkenyl or an alkoxy group having from 1 to 8 carbon atoms, or $-OH$;

R_{34} represents $-NH_2$, $-NHR_{35}$, wherein R_{35} is an alkyl or an alkenyl group having from 1 to 8 carbon atoms, $-CH_2-(CH_2)_n-NH_2$ or $-CH_2$ -aryl- NH_2 and n is from 0 to 10;

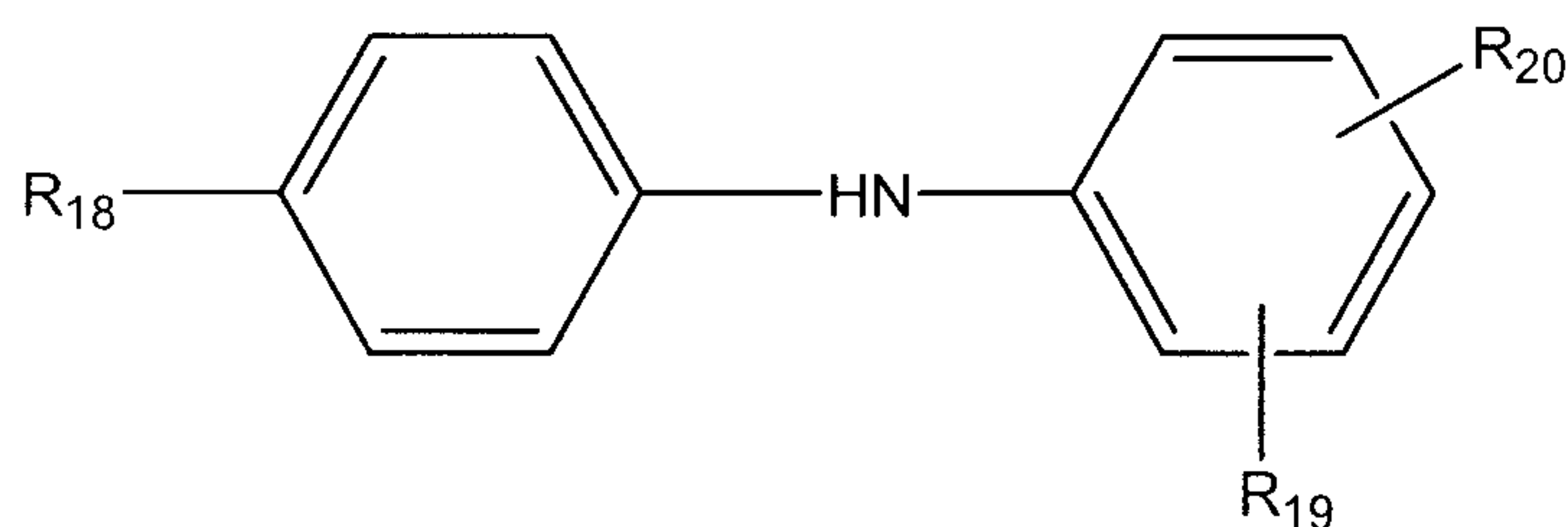
- provided that when R_{34} is $-NHR_{35}$ wherein R_{35} is an alkyl or an alkenyl group having from 1 to 8 carbon atoms, then either L is $-NH-$ or $-CH_2NH-$; or R_{30} or R_{31} is OH or $-NR_{41}R_{42}$ wherein at least one of R_{41} or R_{42} is hydrogen; or R_{32} or R_{33} is OH .

32. The lubricating oil composition of Claim 30 wherein the polyether aromatic compound is derived from N-phenyl-1,4-phenylenediamine.

33. The lubricating oil composition of Claim 29 wherein the polyether aromatic compound is derived from 4-(4-nitrophenylazo)aniline or 4-phenylazoaniline.

34. The lubricating oil composition of Claim 31, wherein the polyether aromatic compound is derived from 4-phenoxyaniline.
35. The lubricating oil composition of Claim 28, wherein the polyether aliphatic compound (1) is a polyoxyalkylene diamine wherein each alkylene unit individually contains from 2 to 5 carbon atoms.
36. The lubricating oil composition of claim 35 wherein the oxyalkylene moiety is oxyethylene or oxypropylene, or mixtures thereof.
37. The lubricating oil composition of claim 27 wherein the copolymer is copolymer (i).
38. The lubricating oil composition of claim 27 wherein the copolymer is copolymer (ii).
39. The lubricating oil composition of claim 38 wherein copolymer (ii) is polyPIBSA, obtained by the free radical catalyzed reaction of maleic anhydride and polyisobutylene.
40. The lubricating oil composition of claim 27 wherein the copolymer is copolymer (iii).
41. The lubricating oil composition of claim 28 wherein the aromatic compound is selected from the group consisting of:

(a) an N-arylphenylenediamine represented by the formula:

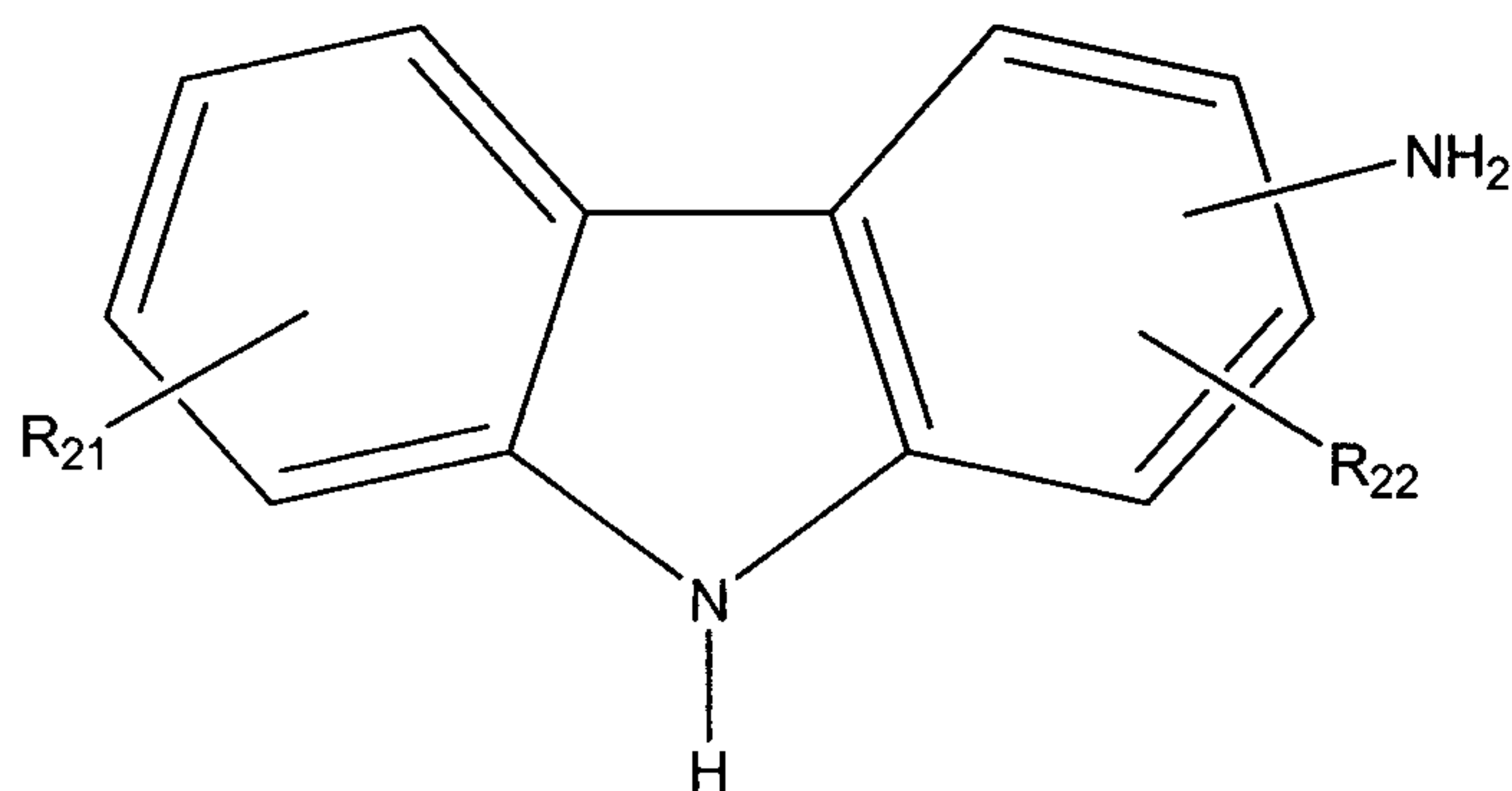


R_{18} is H, --NHaryl, --NHalkaryl, or a branched or straight chain hydrocarbyl radical having from 4 to 24 carbon atoms selected from

the group consisting of alkyl, alkenyl, alkoxy, aralkyl and alkaryl; R_{19} is $-NH_2$, $-(NH(CH_2)_n)_mNH_2$, $-NHalkyl$, $-NHaralkyl$, $-CH_2-aryl--NH_2$, in which n and m each have a value from 1 to 10; and R_{20} is hydrogen, alkyl, alkenyl, alkoxy, aralkyl, or alkaryl, having from 4 to 24 carbon atoms.

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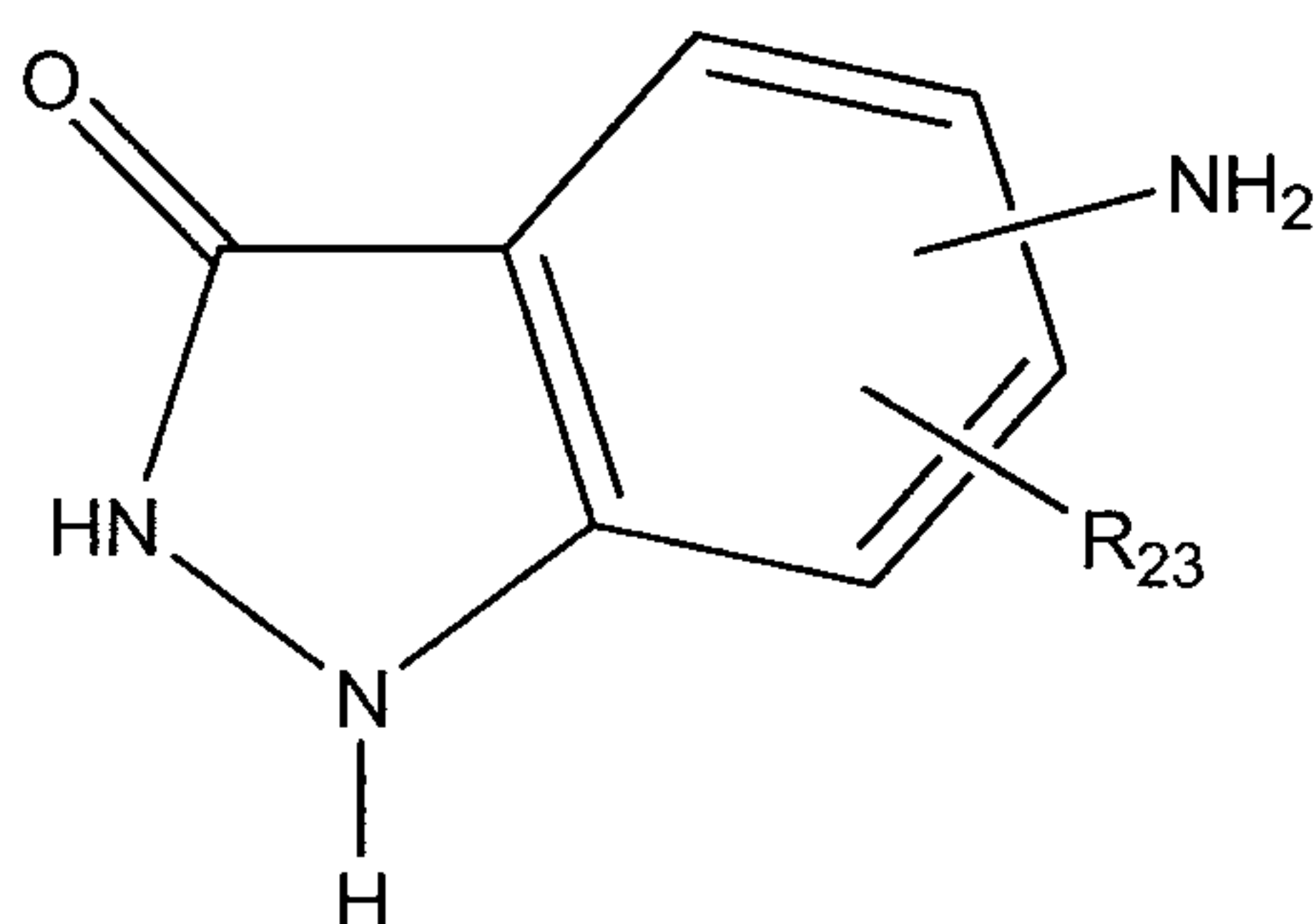
(b) aminocarbazole represented by the formula:



in which R_{21} and R_{22} each independently represent hydrogen or an alkyl or alkenyl radical having from 1 to 14 carbon atoms,

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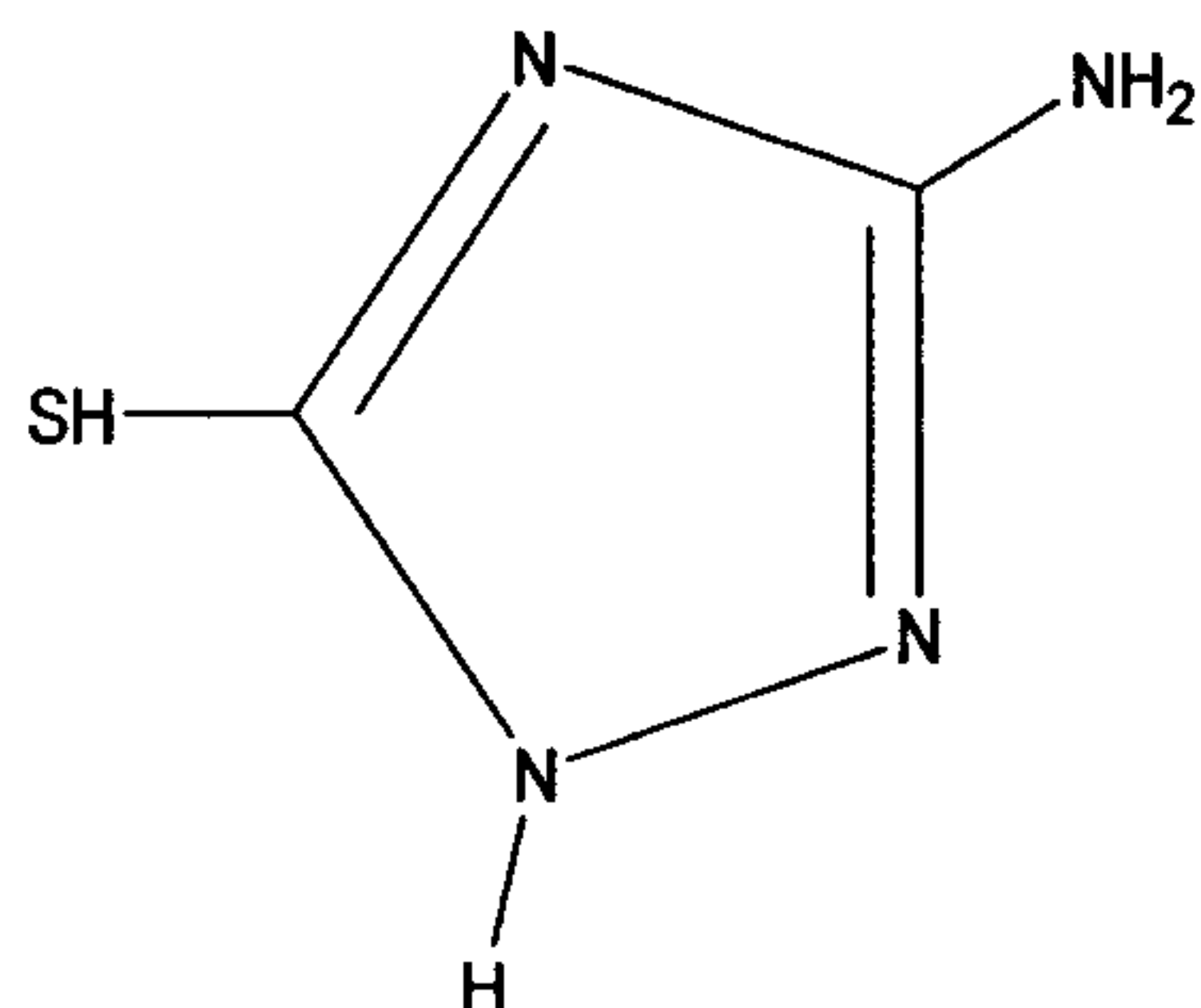
(c) an amino-indazolinone represented by the formula:



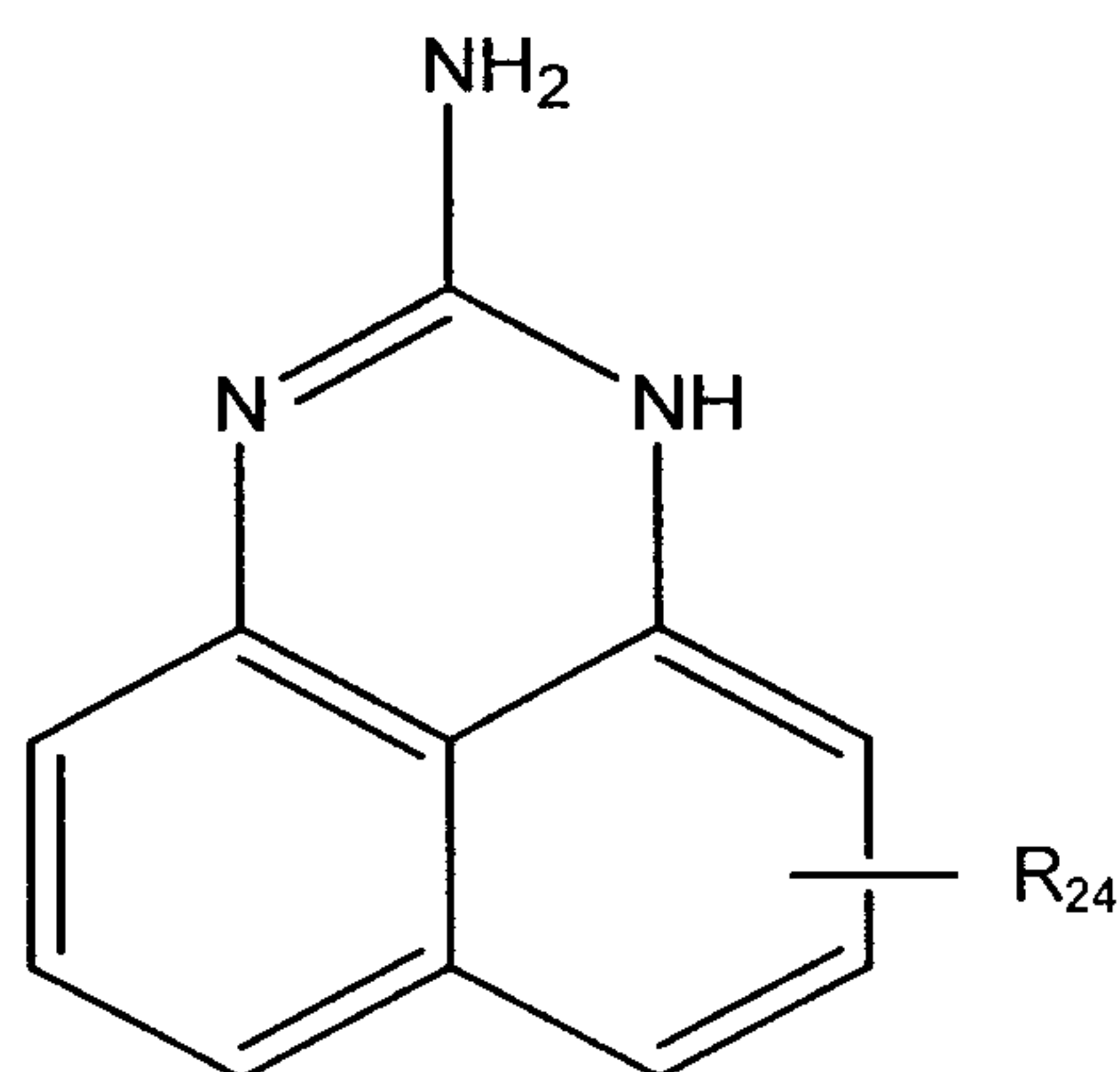
in which R_{23} is hydrogen or an alkyl radical having from 1 to 14 carbon atoms;

15

- (d) an aminomercaptotriazole represented by the formula:



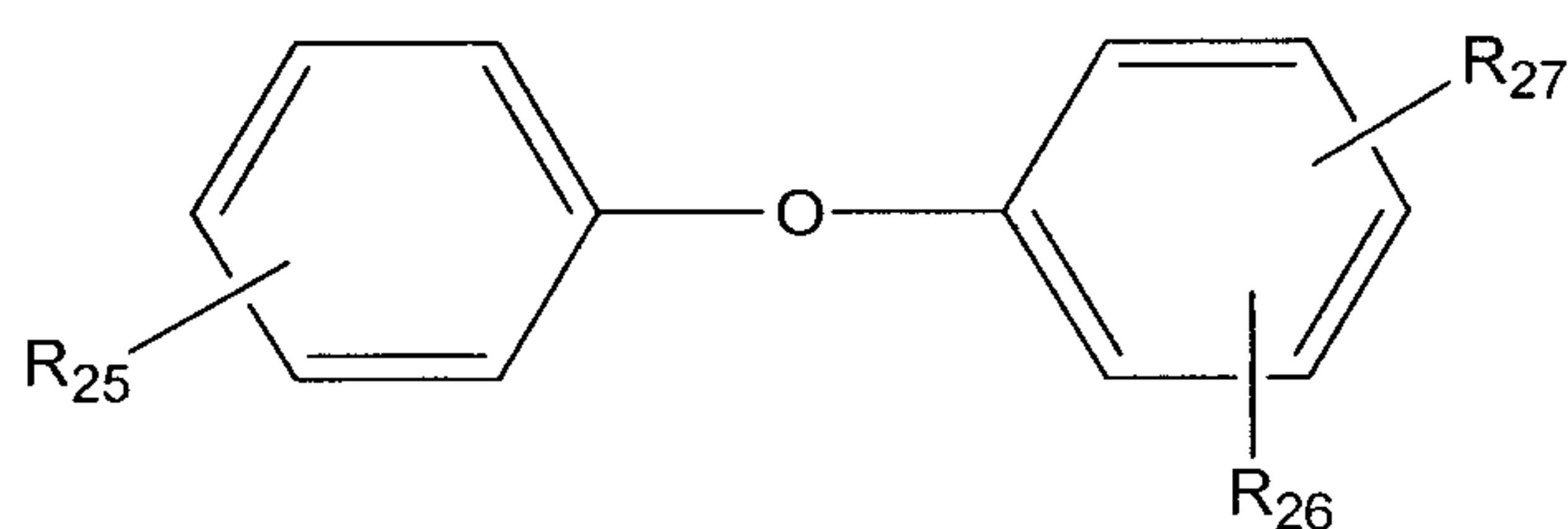
- (e) an aminoperimidine represented by the formula:



5

in which R_{24} represents hydrogen or an alkyl radical having from 1 to 14 carbon atoms;

- (f) an aryloxyphenyleneamine represented by the formula:

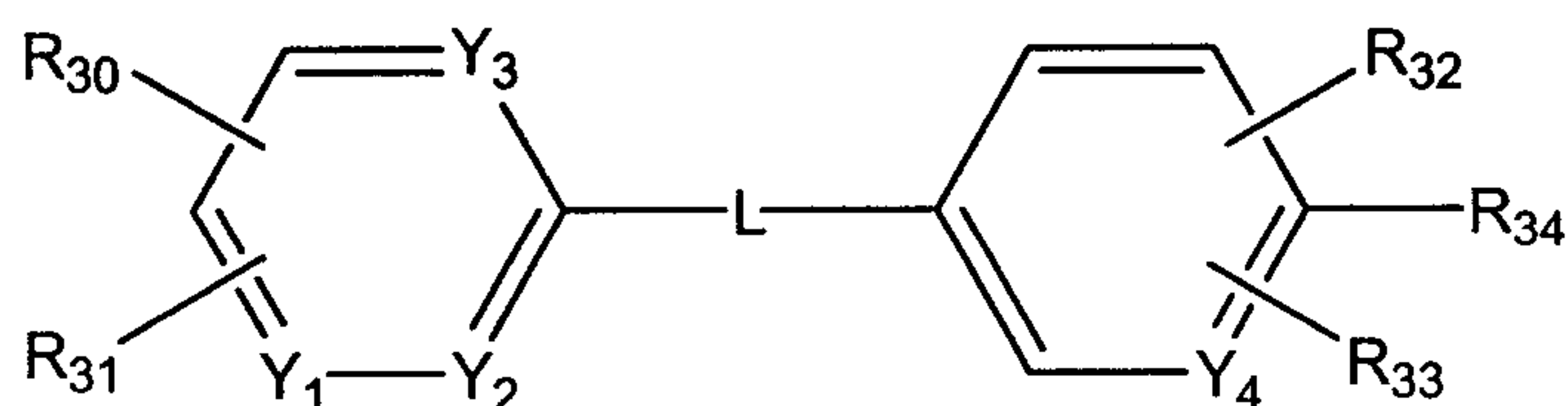


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in which R_{25} is H, --NHaryl, --NHalkaryl, or branched or straight chain radical having from 4 to 24 carbon atoms that is alkyl, alkenyl, alkoxyl, aralkyl or alkaryl; R_{26} is --NH₂, --(NH(CH₂)_n)_m NH₂, -NHalkyl, or -NHaralkyl, in which n and m each have a value from 1 to 10; and R_{27} is hydrogen, alkyl, alkenyl, alkoxyl, aralkyl, or alkaryl, having from 4 to 24 carbon atoms;

15

- (g) an aromatic amine comprising two aromatic groups, linked by a group, L, represented by the following formula:



wherein L is selected from the group consisting of -O-, -N=N-, -NH-, -CH₂NH-, -C(O)NR₂₈-, -C(O)O-, -SO₂-, -SO₂NR₂₉- and -SO₂NH-,
 wherein R₂₈ and R₂₉ independently represent a hydrogen, an alkyl, an
 5 alkenyl or an alkoxy group having from 1 to 8 carbon atoms;

wherein each Y₁, Y₂, Y₃ and Y₄ are independently N or CH provided
 that Y₁ and Y₂ may not both be N;

10 R₃₀ and R₃₁ independently represent a hydrogen, alkyl, aryl, alkaryl,
 aralkyl, alkoxy, hydroxyalkyl, aminoalkyl, -OH, -NO₂, -SO₃H, -
 SO₃Na, CO₂H or salt thereof, or -NR₄₁R₄₂ wherein R₄₁ and R₄₂ are
 independently hydrogen, alkyl, aryl, arylalkyl, or alkaryl;

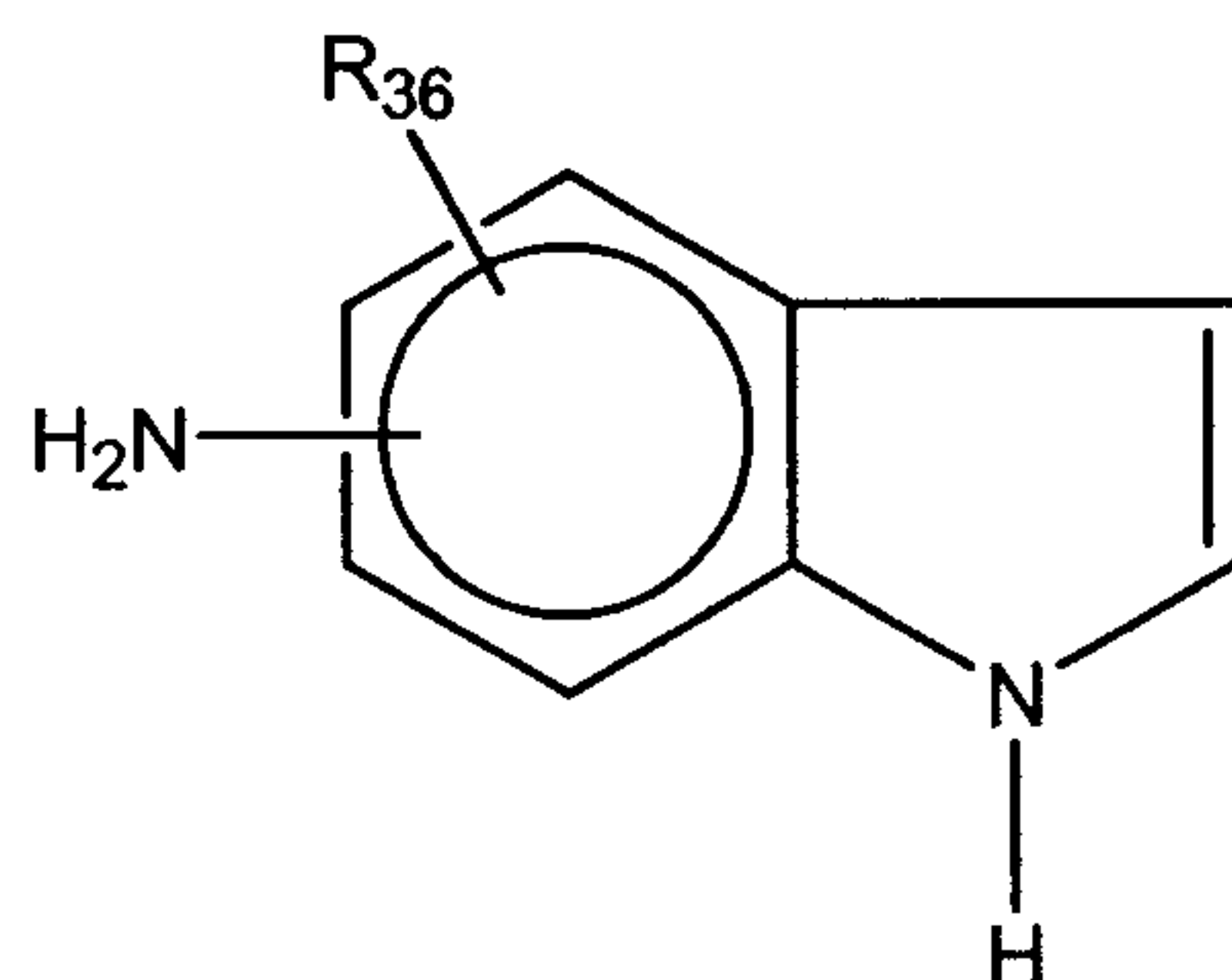
15 R₃₂ and R₃₃ independently represent a hydrogen, an alkyl, an alkenyl or
 an alkoxy group having from 1 to 8 carbon atoms, -OH, -SO₃H or -
 SO₃Na;

20 R₃₄ represents -NH₂, -NHR₃₅, wherein R₃₅ is an alkyl or an alkenyl
 group having from 1 to 8 carbon atoms, -CH₂-(CH₂)_n-NH₂ or -CH₂-
 aryl-NH₂ and n is from 0 to 10;

(h) an aminothiazole selected from the group consisting of aminothiazole,
 aminobenzothiazole, aminobenzothiadiazole and aminoalkylthiazole;

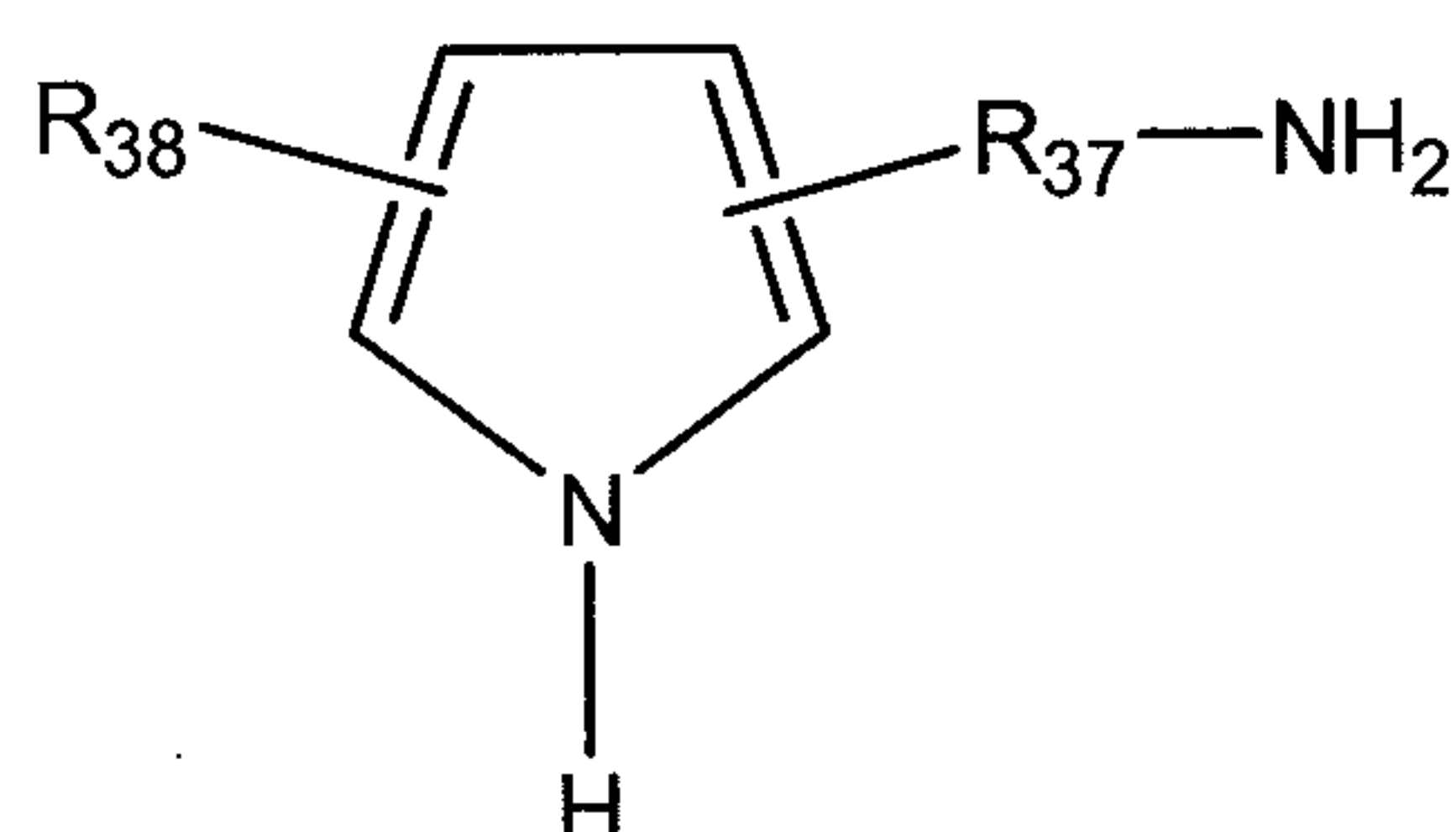
25

(i) an aminoindole represented by the formula:



wherein R_{36} represents a hydrogen, an alkyl or an alkenyl group having from 1 to 14 carbon atoms;

- 5 (j) an aminopyrrole represented by the formula:



wherein R_{37} represents a divalent alkylene group having 2 to 6 carbon atoms and R_{38} represents a hydrogen, an alkyl or an alkenyl group having from 1 to 14 carbon atoms;

10

- (k) a ring substituted or unsubstituted aniline;

- (l) an aminoquinoline;

- 15 (m) an aminobenzimidazole;

- (n) a N, N-dialkylphenylenediamine;

- (o) a benzylamine; and

20

- (p) a benzyl alcohol.

42. The lubricating oil composition of claim 41 wherein the aromatic amine is N-arylphenylenediamine.

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43. The lubricating oil composition of claim 42 wherein the N-arylphenylenediamine is N-phenylphenylenediamine.
44. The lubricating oil composition of claim 43 wherein the N-phenylphenylenediamine is N-phenyl-1,4-phenylenediamine.
45. The lubricating oil composition of claim 41 wherein the aromatic amine is phenoxyaniline, 4-(4-nitrophenylazo)aniline or 4-phenylazoaniline, 4-benzoylamine-2,5-dimethoxyaniline, N-(4-aminophenyl) acetamide or 3-nitroaniline.
46. The lubricating oil composition of claim 27 wherein compound (i)(b) of copolymer (i) is polyisobutene having a number average molecular weight (M_n) of from about 112 to about 5000.
47. The lubricating oil composition of claim 46 wherein the number average molecular weight (M_n) is from about 500 to about 3000.
48. The lubricating oil composition of claim 47 wherein the number average molecular weight (M_n) is from about 1000 to about 2500.
49. The lubricating oil composition of claim 27 wherein (i)(a) is a dicarboxylic acid, anhydride or ester thereof.
50. The lubricating oil composition of claim 49 wherein (i)(a) is maleic anhydride or ester thereof.
51. The lubricating oil composition of claim 27 wherein the monoolefin of (i)(c) is a 1-olefin.
52. The lubricating oil composition of claim 28 wherein the at least one aliphatic compound (3) capable of being reacted with one monocarboxylic acid or ester

thereof, or dicarboxylic acid, anhydride or ester thereof is N-aminopropylmorpholine or 1,3-dimethylaminopropylamine.

53. A method of making a lubricating oil additive composition which comprises
5 reacting

(A) at least one of the following copolymers:

10 (i) a copolymer obtained by free radical copolymerization of components comprising:

15 (a) at least one monoethylenically unsaturated C₃-C₂₈ monocarboxylic acid or ester thereof, or a C₄-C₂₈ dicarboxylic acid, anhydride or ester thereof;

20 (b) at least one 1-olefin comprising 2 to 40 carbon atoms or at least one polyolefin comprising 4 to 360 carbon atoms and having a terminal copolymerizable group in the form of a vinyl, vinylidene or alkyl vinylidene group or mixtures thereof; and

25 (c) at least one monoolefin compound which is copolymerizable with the monomers of (a) and (b) and is selected from the group consisting of:

30 (1) an alkyl vinyl ether and an allyl alkyl ether where the alkyl group is hydroxyl, amino, dialkylamino or alkoxy substituted or is unsubstituted, and containing from 1 to 40 carbon atoms;

(2) an alkyl amine and an N-alkylamide of a monoethylenically unsaturated mono- or

dicarboxylic acid of from 3 to 10 carbon atoms
where the alkyl substituent contains from 1 to
40 carbon atoms;

5 (3) an N-vinylcarboxamide of carboxylic acids of
from 1 to 8 carbon atoms;

(4) an N-vinyl substituted nitrogen-containing
heterocyclic compound; and

10

(5) at least one 1-olefin comprising 2 to 40 carbon
atoms or at least one polyolefin comprising 4 to
360 carbon atoms and having a terminal
copolymerizable group in the form of a vinyl,
15 vinylidene or alkyl vinylidene group or mixtures
thereof, provided that the olefin employed is not
the same as the olefin employed in (i)(b);

15

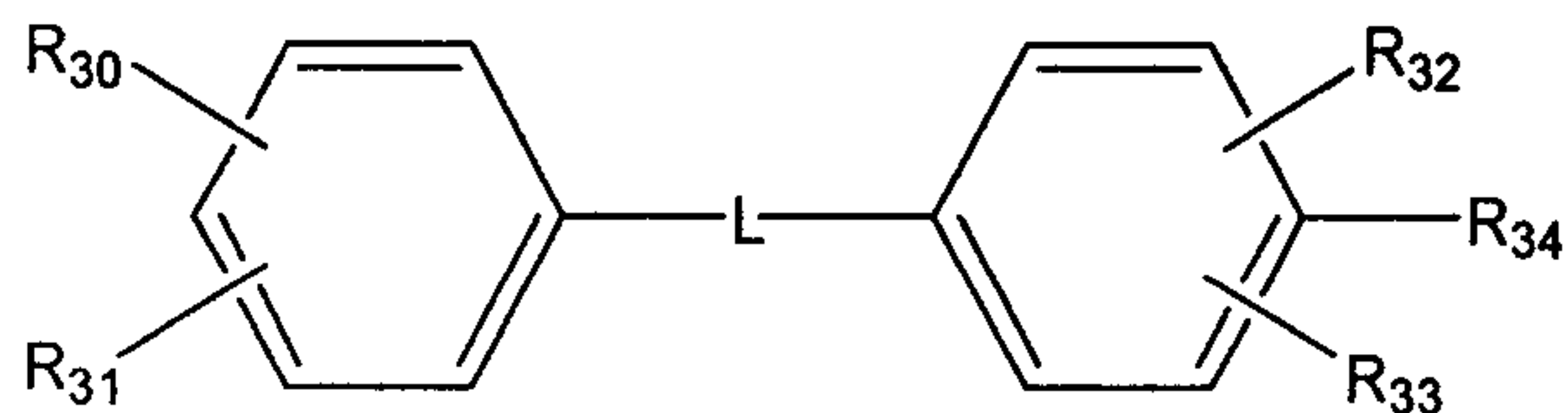
(ii) a copolymer obtained by reacting compound (i)(a) and
20 compound(i)(b) in the presence of a free radical initiator; or

(iii) a copolymer obtained by (a) reacting compound (i)(a) with
compound (i)(b) or (i)(c) in a non-free radical catalyzed
reaction in the presence of copolymer (i) or copolymer (ii) or
25 both; or by (b) contacting copolymer (i) or copolymer (ii) or
both with the non-free radical catalyzed reaction product of
compound (i)(a) and compound (i)(b) or (i)(c); with

25

(B) at least one polyether aromatic compound capable of being reacted
30 with at least two monocarboxylic acids or esters thereof, or
dicarboxylic acids, anhydrides or esters thereof.

54. The method of making the lubricating oil additive composition of claim 53, wherein copolymer (i), (ii) or (iii) is reacted with at least one polyether aromatic amine compound and additionally with (1) at least one polyether amino compound (2) at least one aromatic compound capable of being reacted with one monocarboxylic acid or ester thereof, or dicarboxylic acid, anhydride or ester thereof, (3) at least one aliphatic compound capable of being reacted with one monocarboxylic acid or ester thereof, or dicarboxylic acid, anhydride or ester thereof, or (1), (2) and (3).
55. A method of improving soot dispersancy or sludge dispersancy or both in an internal combustion engine which comprises operating the engine with the lubricating oil composition comprising a major amount of oil of lubricating viscosity and an effective amount of the lubricating oil additive composition of claim 1.
56. The lubricating oil additive composition of Claim 3 wherein the aromatic amine is 4-benzoylamine-2,5-dimethoxyaniline or N-(4-aminophenyl) acetamide
57. The lubricating oil additive composition of Claim 3 wherein the at least one polyether aromatic compound is derived from 3-nitroaniline.
58. The lubricating oil composition of Claim 29 wherein the aromatic amine is 4-benzoylamine-2,5-dimethoxyaniline or N-(4-aminophenyl) acetamide.
59. The lubricating oil composition of Claim 29 wherein the at least one polyether aromatic compound is derived from 3-nitroaniline.
60. The lubricating oil additive composition of claim 15 wherein the aromatic amine is phenoxyaniline, 4-(4-nitrophenylazo)aniline or 4-phenylazoaniline.
61. The lubricating oil additive composition of Claim 3 wherein the polyether aromatic compound is derived from the following formula:



wherein L is selected from the group consisting of $-O-$, $-N=N-$, $-NH-$, and $-CH_2NH-$;

5 R_{30} and R_{31} independently represent a hydrogen, alkyl, aryl, alkaryl, aralkyl, alkoxy, hydroxyalkyl, aminoalkyl, $-OH$, NO_2 or, $-NR_{41}R_{42}$ wherein R_{41} and R_{42} are independently hydrogen, alkyl, aryl, arylalkyl, or alkaryl;

10 R_{32} and R_{33} independently represent a hydrogen, an alkyl, an alkenyl or an alkoxy group having from 1 to 8 carbon atoms, or $-OH$;

R_{34} represents $-NH_2$, $-NHR_{35}$, wherein R_{35} is an alkyl or an alkenyl group having from 1 to 8 carbon atoms, $-CH_2-(CH_2)_n-NH_2$ or $-CH_2$ -aryl- NH_2 and n is from 0 to 10;

15 provided that when R_{34} is $-NHR_{35}$ wherein R_{35} is an alkyl or an alkenyl group having from 1 to 8 carbon atoms, then either L is $-NH-$ or $-CH_2NH-$; or R_{30} or R_{31} is OH or $-NR_{41}R_{42}$ wherein at least one of R_{41} or R_{42} is hydrogen; or R_{32} or R_{33} is OH .

20 62. The lubricating oil additive composition of Claim 15 wherein the aromatic compound is 4-benzoylamine-2,5-dimethoxyaniline or N-(4-aminophenyl) acetamide.

25 63. The lubricating oil additive composition of Claim 15 wherein the aromatic compound is 3-nitroaniline.

64. The lubricating oil additive composition of Claim 19 wherein the aromatic compound is N-phenyl-1,4-phenylenediamine.

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65. The lubricating oil additive composition of Claim 61 wherein the polyether aromatic compound is derived from 4-(4-nitrophenylazo)aniline or 4-phenylazoaniline.
- 5 66. The lubricating oil additive composition of Claim 61 wherein the polyether aromatic compound is derived from 4-phenoxyaniline.
67. The lubricating additive composition of claim 3 wherein the ring substituted or unsubstituted aniline is nitroaniline or 4-aminoacetanilide.
- 10 68. The lubricating additive composition of claim 15 wherein the ring substituted or unsubstituted aniline is nitroaniline or 4-aminoacetanilide.
- 15 69. The lubricating oil composition of claim 29 wherein the ring substituted or unsubstituted aniline is nitroaniline or 4-aminoacetanilide.
70. The lubricating oil composition of claim 41 wherein the ring substituted or unsubstituted aniline is nitroaniline or 4-aminoacetanilide.