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(54) Title: LOW PH STRUCTURED SURFACTANT COMPOSITIONS

(57) Abstract: An aqueous, low pH structured surfactant composition, contains, based on 100 parts by weight of the composition, from about 3 parts by weight to about 40 parts by weight of one or more anionic surfactants selected from anionic phosphate ester surfactants, anionic sulfonate surfactants, and anionic carboxylate surfactants, wherein the composition exhibits a pH of less than about 5, exhibits shear-thinning viscosity, and is capable of suspending water insoluble or partially water soluble components.



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LOW pH STRUCTURED SURFACTANT COMPOSITIONS

Field of the Invention

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This invention relates to surfactant compositions, more particularly to low pH structured liquid surfactant compositions.

Background of the Invention

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Structured surfactant compositions are pumpable fluid compositions that exhibit shear-thinning viscosity and have the capacity physically to suspend water insoluble or partially water soluble ingredients. Typically, the surfactant phase is present as packed spherulites, i.e., lamellar droplets, formed from an aqueous solution.

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Structured surfactant compositions are useful in personal care applications, such as shampoos, body wash, hand soap, lotions, creams, conditioners, shaving products, facial washes, neutralizing shampoos, and skin treatments, in home care applications, such as liquid detergents, laundry detergents, hard surface cleansers, dish wash liquids, toilet bowl cleaners, and in other applications, such as oil field and agrochemical applications.

20

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Structured surfactant compositions for the personal care market typically exhibit a pH in the range about 5 to 7. The surfactants used in known structured surfactant compositions are, in many cases, unsuitable for use in low pH systems, because the typical components of such compositions become unstable and ineffective at a pH of less than about 5.

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In some applications, it would be desirable to suspend water insoluble or partially water soluble ingredients in a low pH aqueous composition. For example, U.S. Patent No. 6,416,768 discloses the use of water-in-oil emulsions to incorporate active ingredients in low pH compositions. However, water-in-oil emulsions are capable of suspending only lipophilic agents and typically have limited stability over time.

What is needed is a structured surfactant composition that provides typical structured surfactant properties, that is, shear-thinning viscosity and a capacity to suspend water insoluble or partially water soluble components, at low pH.

Summary of the Invention

In a first aspect, the present invention is directed to an aqueous, low pH structured surfactant composition, comprising, based on 100 parts by weigh ("pbw") of the composition, from about 3 pbw to about 40 pbw of one or more anionic surfactants selected from anionic phosphate ester surfactants, anionic sulfonate surfactants, and anionic carboxylate surfactants, wherein the composition exhibits a pH of less than about 5, exhibits shear-thinning viscosity, and is capable of suspending water insoluble or partially water soluble components.

In a second aspect, the present invention is directed to an aqueous, low pH composition, comprising:

a continuous structured surfactant phase, said structured surfactant phase comprising water and one or more anionic surfactants selected from anionic phosphate ester surfactants, anionic sulfonate surfactants, and anionic carboxylate surfactants, and exhibiting shear-thinning viscosity, and

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one or more water insoluble or partially water soluble components suspended in the structured surfactant phase,
wherein the composition exhibits a pH of less than about 5.

5 In a third aspect, the present invention is directed to an aqueous, low pH composition, comprising at least two at least substantially distinct phases, at least one of which is a structured surfactant phase that comprises water and one or more anionic surfactants selected from anionic phosphate ester surfactants, anionic sulfonate surfactants, and anionic
10 carboxylate surfactants, and exhibits shear-thinning viscosity, wherein the composition exhibits a pH of less than about 5.

Detailed Description of Invention and Preferred Embodiments

15 As used herein in reference to viscosity, the terminology "shear-thinning" means that such viscosity decreases with an increase in shear rate. Shear-thinning may be characterized as a "non-Newtonian" behavior, in that it differs from that of a classical Newtonian fluid, for example, water, in which viscosity is not dependent on shear rate.

20 As used herein in reference to a component of an aqueous composition, the terminology "water insoluble or partially water soluble components" means that the component is present in the aqueous composition at a concentration above the solubility limit of the component
25 so that, in the case of a water insoluble component, the component remains substantially non-dissolved in the aqueous composition and, in the case of a partially water soluble component, at least a portion of such component remains undissolved in the aqueous composition.

30 As used herein, characterization of an aqueous composition as "capable of suspending", or as being "able to suspend" water insoluble or

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partially water insoluble components means that the composition substantially resists flotation of such components in the composition or sinking of such components in such composition so that such components appear to be neutrally buoyant in such composition and remain at least

5 substantially suspended in such composition under the anticipated processing, storage, and use conditions for such low pH aqueous composition.

As used herein in reference to a component of a low pH aqueous

10 composition, the terminology "chemically stable" means that the component remains at least substantially non-degraded under the anticipated processing, storage, and use conditions for such low pH aqueous composition.

As used herein, the terminology "lamellar phase" means a phase that comprises a plurality of bilayers of surfactant arranged in parallel and separated by liquid medium. A lamellar phase is detectable by, for example, small angle x-ray measurement or by evidence of birefringence under a cross-polarized microscope. Lamellar phases include both

20 spherulitic phases and the typical form of the liquid crystal G-phase, as well as mixtures thereof. "G-phases", which are sometimes referred to in the literature as L_{α} phases, are typically pumpable, non-Newtonian, anisotropic products that are cloudy looking and exhibit a characteristic "smeary" appearance on flowing. Lamellar phases, can exist in several different

25 forms, including domains of parallel sheets which constitute the bulk of the typical G-phases described above and spherulites formed from a number of concentric spheroidal shells, each of which is a bilayer of surfactant. In this specification the term "G-phase" will be reserved for compositions which are at least partly of the former type. The spherulites are typically between

30 0.1 and 50 microns in diameter and so differ fundamentally from micelles. Unlike micellar solutions, spherulitic compositions are typically anisotropic

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and non-Newtonian. When close packed, spherulites have good solid suspending properties and allow incorporation of water insoluble or partially water soluble solids, liquids and/or gases as a separate, discontinuous phase suspended in a continuous matrix of the surfactant composition.

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In one embodiment, the composition of the present invention exhibits a pH of from about 1.5 to less than about 5, more typically, from about 2 to about 4.5, even more typically from about 3 to about 4.

10

In one embodiment, the structured surfactant composition of the present invention comprises, based on 100 pbw of the composition, from about 3 to about 40 pbw, more typically from about 5 to about 30 pbw, and still more typically from about 8 to about 20 pbw, of the one or more anionic surfactants.

15

Compounds suitable as the anionic surfactant component of the present invention are anionic phosphate surfactants, such as monoalkyl phosphate surfactants and dialkyl phosphate surfactants, anionic sulfonate surfactants, such as linear alkylbenzene sulfonate surfactants, alpha olefin sulfonate surfactants, and paraffin sulfonate surfactants, and anionic carboxylate surfactants, such as alkyl ether carboxylate surfactants, as well as mixtures thereof. In one embodiment, the alkyl substituent of such monoalkyl phosphate surfactants, dialkyl phosphate surfactants, linear alkylbenzene sulfonate surfactants, and alkyl ether carboxylate surfactants is a (C₈–C₂₄)alkyl group, which may be branched or linear, and the alpha olefin substituent of such alpha olefin sulfonate surfactants is an ethylenically unsaturated (C₈–C₂₄)alkenyl group, which may be branched or linear. Anionic surfactants that are suitable as the anionic surfactant component of the composition of the present invention include, for example, lauryl phosphate, cetyl phosphate, tridecyl phosphate, behenyl phosphate, laureth-2 phosphate, ceteth-3 phosphate, trideceth-4

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phosphate, trideceth-6 phosphate, beheneth-4 phosphate, dilauryl phosphate, dicetyl phosphate, ditridecyl phosphate, dibehenyl phosphate, dilaureth-2 phosphate, dipareth-3 phosphate, diceteth-4 phosphate, ditrideceth-4 phosphate, ditrideceth-6 phosphate, dibeheneth-6 phosphate, 5 tridecyl benzene sulfonate, dodecyl benzene sulfonate, laureth-3 carboxylate, trideceth-7 carboxylate, ceteth-4 carboxylate, beheneth-5 carboxylate, or mixtures thereof wherein the anionic surfactant may be included in the formulation in the acid (non-neutralized form) or as the neutralized salt.

10

When neutralized, the cation of any anionic surfactant is typically sodium but may alternatively be potassium, lithium, calcium, magnesium, ammonium, (C₁-C₆)alkyl ammonium, or (C₁-C₆)alkanol ammonium, such as isopropylammonium, monoethanolammonium, diethanolammonium, and 15 triethanolammonium. Ammonium and ethanolammonium salts are generally more soluble than the sodium salts. Mixtures of the above cations may be used.

In one embodiment, the anionic surfactant comprises non- 20 neutralized acids of one or more phosphate esters, such as, for example, Dermalcare MAP L-210 (laureth-2 phosphate) and Rhodifac RS-410 (trideceth-4 phosphate). Such surfactants, when dispersed in water, will readily form a lamellar phase at a low pH, without requiring a structurant. The propensity to form a lamellar phase makes such surfactants 25 particularly useful in formulating low pH structured liquid formulations.

In one embodiment, the structured surfactant composition of the present invention optionally comprises at least an effective amount of one or more structuring agents. Suitable structuring agents which can have 30 chemical stability at low pH include cationic surfactants, such as amine salts, quaternary ammonium compounds, and amine oxides, nonionic

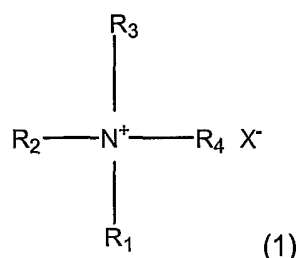
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surfactants, such as fatty alcohols, ethoxylated alcohols, and fatty acids, and electrolytes. An effective amount of such structuring agent is one that can aid in the formation of a shear-thinning phase capable of suspending water insoluble or partially water soluble components.

5

Suitable cationic surfactants are known compounds. Any cationic surfactant that is acceptable for use in the intended end use application and is chemically stable at the required formulation pH is suitable as a structurant component of the composition of the present invention, including, for example, cationic surfactants according to formula (1) below:

10



wherein:

R₁, R₂, R₃ and R₄, are independently hydrogen, an organic group, provided that at least one of R₁, R₂, R₃ and R₄ is not hydrogen, and

15

X⁻ is an anion.

If one to three of the R groups are hydrogen, the compound may be referred to as an amine salt. Some examples of cationic amines include polyethoxylated (2) oleyl/stearyl amine, ethoxylated tallow amine, cocoalkylamine, oleylamine, and tallow alkyl amine.

20

For quaternary ammonium compounds (generally referred to as quats) R₁, R₂, R₃, and R₄ may be the same or different organic group, but may not be hydrogen. In one embodiment, R₁, R₂, R₃, and R₄ are each (C₈-C₂₄) branched or linear which may comprise additional functionality such as, for example, fatty acids or derivatives thereof, including esters of fatty acids and fatty acids with alkoxylated groups, alkyl amido groups, aromatic

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rings, heterocyclic rings, phosphate groups, epoxy groups, and hydroxyl groups. The nitrogen atom may also be part of a heterocyclic or aromatic ring system, e.g., cetethyl morpholinium ethosulfate or steapyrium chloride.

- 5 Suitable anions include, for example, chloride, bromide, methosulfate, ethosulfate, lactate, saccharinate, acetate or phosphate.

- Examples of quaternary ammonium compounds of the monoalkyl amine derivative type include: cetyl trimethyl ammonium bromide (also
10 known as CETAB or cetrimonium bromide), cetyl trimethyl ammonium chloride (also known as cetrimonium chloride), myristyl trimethyl ammonium bromide (also known as myrtrimonium bromide or Quaternium-13), stearyl dimethyl benzyl ammonium chloride (also known as
15 stearalkonium chloride), oleyl dimethyl benzyl ammonium chloride, (also known as olealkonium chloride), lauryl/myristyl trimethyl ammonium methosulfate (also known as cocotrimonium methosulfate), cetyl-dimethyl-(2)hydroxyethyl ammonium dihydrogen phosphate (also known as hydroxyethyl cetyldimonium phosphate), bassuamidopropylkonium chloride, cocotrimonium chloride, distearyldimonium chloride, wheat germ-
20 amidopropalkonium chloride, stearyl octyldimonium methosulfate, isostearaminopropal-konium chloride, dihydroxypropyl PEG-5 linoleaminium chloride, PEG-2 stearamonium chloride, Quaternium 18, Quaternium 80, Quaternium 82, Quaternium 84, behentrimonium chloride, dicetyl dimonium chloride, behentrimonium methosulfate, tallow trimonium
25 chloride and behenamidopropyl ethyl dimonium ethosulfate.

- Quaternary ammonium compound of the dialkyl amine derivative type distearyldimonium chloride, dicetyl dimonium chloride, stearyl octyldimonium methosulfate, dihydrogenated palmoylethyl
30 hydroxyethylmonium methosulfate, dipalmitoylethyl hydroxyethylmonium

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methosulfate, dioleoylethyl hydroxyethylmonium methosulfate, hydroxypropyl bisstearyldimonium chloride and mixtures thereof.

- Quaternary ammonium compounds of the imidazoline derivative
- 5 type include, for example, isostearyl benzylimidonium chloride, cocoyl benzyl hydroxyethyl imidazolinium chloride, cocoyl hydroxyethylimidazolinium PG-chloride phosphate, Quaternium 32, and stearyl hydroxyethylimidonium chloride, and mixtures thereof.
- 10 Suitable cationic surfactants include, for example, amine salts such as polyethoxylated (2) oleyl/stearyl amine, *ethoxylated tallow amine*, cocoalkylamine, oleylamine, and tallow alkyl amine or quaternary ammonium compounds such as cetyl trimethyl ammonium bromide (also known as CETAB or cetrimonium bromide), cetyl trimethyl ammonium
- 15 chloride (also known as cetrimonium chloride), myristyl trimethyl ammonium bromide (also known as myrtrimonium bromide or Quaternium-13), stearyl dimethyl benzyl ammonium chloride (also known as stearalkonium chloride), oleyl dimethyl benzyl ammonium chloride, (also known as olealkonium chloride), lauryl/myristyl trimethyl ammonium
- 20 methosulfate (also known as cocotrimonium methosulfate), cetyl-dimethyl-(2)hydroxyethyl ammonium dihydrogen phosphate (also known as hydroxyethyl cetyldimonium phosphate), bassuamidopropylkonium chloride, cocotrimonium chloride, distearyldimonium chloride, wheat germ-amidopropalkonium chloride, stearyl octyldimonium methosulfate,
- 25 isostearaminopropyl-konium chloride, dihydroxypropyl PEG-5 linoleaminium chloride, PEG-2 stearamonium chloride, Quaternium 18, Quaternium 80, Quaternium 82, Quaternium 84, behentrimonium chloride, dicetyl dimonium chloride, *behentrimonium methosulfate*, *tallow trimonium* chloride and behenamidopropyl ethyl dimonium ethosulfate,
- 30 distearyldimonium chloride, dicetyl dimonium chloride, stearyl octyldimonium methosulfate, dihydrogenated palmoylethyl

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hydroxyethylmonium methosulfate, dipalmitoylethyl hydroxyethylmonium methosulfate, dioleylethyl hydroxyethylmonium methosulfate, hydroxypropyl bisstearyldimonium chloride, isostearyl benzylimidonium chloride, cocoyl benzyl hydroxyethyl imidazolinium chloride, cocoyl

5 hydroxyethylimidazolinium PG-chloride phosphate, Quaternium 32, and stearyl hydroxyethylimidonium chloride, and mixtures thereof.

Additionally, amine oxides may be used as structuring agents due to their cationic nature at low pH. Specific examples of suitable alkyl amine

10 oxides may include, for example, lauramine oxide, cocamine oxide, cocamidopropylamine oxide, and lauramidopropylamine oxide.

Nonionic surfactants are known. Any nonionic surfactant that is acceptable for use in the intended end use application and is chemically

15 stable at the required formulation pH is suitable as a structurant component of the composition of the present invention.

Suitable fatty alcohols include, for example, (C₁₀-C₂₂) saturated or unsaturated branched or straight chain alcohols, such as for example,

20 decyl alcohol, lauryl alcohol, tridecyl alcohol, myristyl alcohol, cetyl alcohol, stearyl alcohol, oleyl alcohol, linoleyl alcohol and linolenyl alcohol.

Suitable ethoxylated alcohols include alkoxylated, typically ethoxylated, derivatives of (C₁₀-C₂₂) saturated or unsaturated branched or

25 straight chain alcohols, which may include, on average, from 1 to 22 alkoxyl units per molecule of ethoxylated alcohol, for example, laureth-1 laureth-2 laureth-4, laureth-5, laureth-7, laureth-9, trideceth-1, trideceth-2, trideceth-3, (C₁₁-C₁₅)pareth-3, (C₁₂-C₁₃)pareth-5, and (C₁₄-C₁₅)pareth-9.

30 Suitable fatty acids include (C₁₀-C₂₂) saturated or unsaturated acids, such as, for example, lauric acid, oleic acid, stearic acid, isostearic acid,

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myristic acid, cetearic acid, isostearic acid, linoleic acid, linolenic acid, ricinoleic acid, elaidic acid, arichidonic acid, myristoleic acid, palmitoleic acid, or the neutralized versions thereof.

- 5 Electrolytes suitable as a structurant component of the composition of the present invention include salts of multivalent anions, such as potassium pyrophosphate, potassium tripolyphosphate, and sodium or potassium citrate, salts of multivalent cations, including alkaline earth metal salts such as calcium chloride and calcium bromide, as well as zinc
- 10 halides, barium chloride and calcium nitrate, salts of monovalent cations with monovalent anions, including alkali metal or ammonium halides, such as potassium chloride, sodium chloride, potassium iodide, sodium bromide, and ammonium bromide, alkali metal or ammonium nitrates, and
- 15 polyelectrolytes, such as uncapped polyacrylates, polymaleates, or polycarboxylates, lignin sulphonates or naphthalene sulphonate formaldehyde copolymers.

- Typically, the greater the amount of anionic surfactant present in relation to its solubility, the lesser the amount of structurant required in
- 20 order to form a structure capable of supporting solid materials and/or to cause flocculation of the structured surfactant. The structurant is incorporated in an amount sufficient to, in combination with the one or more anionic surfactants, promote the formation of structured surfactant composition that exhibits shear-thinning viscosity, and is capable of
- 25 suspending water insoluble or partially water soluble components and may be added separately or may be included in one of the other raw materials added to the formulation.

- In one embodiment, the structured surfactant composition of the
- 30 present invention comprises, based on 100 pbw of the structured surfactant composition, up to about 40 pbw, more typically from about 0.5 to about 25

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pbw and still more typically from about 1 to about 10 pbw of one or more structurants.

In another embodiment, the structured surfactant composition of the
5 present invention does not require a structurant to form the lamellar phase.

In one embodiment, the structured surfactant composition of the present invention comprises less than an effective amount of structuring agent. In another embodiment, the structured surfactant composition of the
10 present invention does not comprise a structurant.

The composition of the present invention may optionally further comprise, in addition to the anionic surfactant and any cationic surfactant, nonionic surfactant and/or electrolyte used as a structuring agent, one or
15 more cationic surfactants, one or more non-ionic surfactants, one or more electrolytes, one or more amphoteric surfactants, one or more zwitterionic surfactants, or a mixture thereof. Such optional cationic surfactant, nonionic surfactant and/or electrolyte may each independently be present in an amount in excess of the minimum amount effective to act as a
20 structurant.

The cationic surfactants, nonionic surfactant, and electrolytes discussed above are also suitable as the respective optional additional cationic surfactant, nonionic surfactant and electrolyte.
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Suitable Zwitterionic surfactants are known compounds. Any Zwitterionic surfactant that is acceptable for use in the intended end use application and is chemically stable at the required formulation pH is suitable as the optional Zwitterionic surfactant component of the composition of the
30 present invention, including, for example, those which can be broadly described as derivatives of aliphatic quaternary ammonium, phosphonium,

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and sulfonium compounds in which the aliphatic radicals can be straight chain or branched and wherein one of the aliphatic substituents contains from about 8 to about 24 carbon atoms and one contains an anionic water-solubilizing group such as carboxyl, sulfonate, sulfate, phosphate or phosphonate. Specific examples of suitable Zwitterionic surfactants include alkyl betaines, such as cocodimethyl carboxymethyl betaine, lauryl dimethyl carboxymethyl betaine, lauryl dimethyl alpha-carboxy-ethyl betaine, cetyl dimethyl carboxymethyl betaine, lauryl bis-(2-hydroxy-ethyl)carboxy methyl betaine, stearyl bis-(2-hydroxy-propyl)carboxymethyl betaine, oleyl dimethyl gamma-carboxypropyl betaine, and lauryl bis-(2-hydroxypropyl)alpha-carboxyethyl betaine, amidopropyl betaines, and alkyl sultaines, such as cocodimethyl sulfopropyl betaine, stearyldimethyl sulfopropyl betaine, lauryl dimethyl sulfoethyl betaine, lauryl bis-(2-hydroxy-ethyl)sulfopropyl betaine and alkylamidopropylhydroxy sultaines.

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Suitable amphoteric surfactants are known compounds. Any Amphoteric surfactant that is acceptable for use in the intended end use application and is chemically stable at the required formulation pH is suitable as the optional amphoteric surfactant component of the composition of the present invention, including, for example, those which can be broadly described as compounds in which the aliphatic radicals can be straight chain or branched and wherein one of the aliphatic substituents contains from about 8 to about 24 carbon atoms and one contains an anionic water-solubilizing group such as carboxyl, sulfonate, phosphate or phosphonate. Specific examples of suitable amphoteric surfactants include alkyl propionates, such as cocoampho propionates, lauroampho propionates, tridecylampho propionate, oleylampho propionates, caprylampho propionates, behenylampho propionates, dipropionates such as cocoampho dipropionates, lauroampho dipropionates, tridecylampho dipropionate, oleylampho dipropionates, caprylampho dipropionates, behenylampho dipropionates, and amphoteric sulfonates such as

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cocoampho hydroxypropyl sulfonates, lauroampho hydroxypropyl sulfonates, tridecylampho hydroxypropyl sulfonates, oleylampho hydroxypropyl sulfonates, caprylampho hydroxypropyl sulfonates, behenylampho hydroxypropyl sulfonates.

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In one embodiment, the composition of the present invention comprises, based on 100 pbw of the composition and inclusive of any surfactant used as a structuring agent, a total amount of from about 0.1 to about 20 pbw, more typically from about 0.5 to about 15 pbw, and still more typically from about 1 to about 10 pbw, of one or more cationic surfactants, nonionic surfactants, amphoteric surfactants, and/or zwitterionic surfactants.

In one embodiment, the structured surfactant composition is made by combining and mixing a surfactant and water and optionally, adjusting the pH and then adding any optional structurant. Mixing may be applied as required to form a homogeneous solution.

In one embodiment, the structured surfactant is subjected to a high shear mixing in known mixing equipment, such as, for example, a high shear mixer or a homogenizer.

Shear-thinning viscosity is measured by known viscometric methods, such as for example, using a rotational viscometer, such as a Brookfield viscometer. In one embodiment, the composition of the present invention exhibits shear-thinning behavior when subjected to viscosity measurement using a Brookfield rotational viscometer, equipped with an appropriate spindle, at a rotation speed of from about 0.1 revolutions per minute ("rpm") to about 60 rpm.

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The composition of the present invention is capable of suspending water-insoluble particles or partially water soluble components, such as vegetable oils, mineral oils, silicone oils, solid particles, abrasives, and similar articles. The composition provides a means to include otherwise
5 difficult to incorporate components in surfactant mixtures resulting in cosmetic preparations with multi-functional benefits including, in some cases, cleansing, moisturizing, improved skin feel, exfoliation/abrasion, novel appearance, or a combination of these benefits.

10 The ability of a composition to suspend water insoluble or partially water insoluble components is typically evaluated by mixing the composition with sufficient vigor to entrap air bubbles in the composition and then visually observing whether the air bubbles remain entrapped in the composition for a defined period of time, such as for example, 12 to 24
15 hours, under defined environmental conditions, such as for example, room temperature. In one embodiment, the composition of the present invention is capable of suspending air bubbles for at least 1 week, and more typically for at least 3 months. A composition that is capable of suspending air bubbles under the for at least 12 hours at room temperature is deemed to
20 be generally capable of suspending water insoluble or partially water soluble components in the composition under generally anticipated processing, storage, and use conditions for such composition. For components other than air, the result of the air suspension test should be confirmed by conducting an analogous suspension test using the
25 component of interest. For unusually rigorous processing, storage and/or use conditions, more rigorous testing may be appropriate.

In one embodiment, the ability to suspend water insoluble or partially water insoluble components is evaluated under more rigorous conditions,
30 that is, the mixed samples are visually evaluated after subjecting the samples to one or more freeze/thaw cycles, wherein each freeze/thaw

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cycle consists of 12 hours at -10°C and 12 hours at 25°C. In one embodiment, composition of the present invention remains capable of suspending air bubbles after one freeze/thaw cycle, more typically after 3 freeze/thaw cycles.

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In one embodiment, the composition of the present invention further comprises one or more water insoluble or partially water soluble components. Such components may be in the form of a solid, a liquid, or a gas and may comprise one or more materials selected from water insoluble or partially water soluble chemically stable benefit agents, such as, for example, in the case of a personal care application, emollients, conditioners, moisturizers, vitamins, vitamin derivatives, anti-UV agents, anti-bacterial agents, anti-fungal agents, tanning accelerators, anti-aging agents, anti-wrinkle agents, antiperspirants, deodorants, essential oils, fragrances, air, or abrasives, and water insoluble or partially water soluble chemically stable appearance modifying additives such as, for example, colored or reflective particles or beads.

In another embodiment, the composition of the present invention comprises a structured surfactant component according to the present invention (that is, a component that comprises water and one or more anionic surfactants selected from anionic phosphate ester surfactants, anionic sulfonate surfactants, and anionic carboxylate surfactants) that forms a first phase (which may itself comprise a plurality of phases, including aqueous phases, lamellar surfactant phases, and spherulitic phases, as discussed above) and the composition further comprises one or more additional phases that are at least substantially distinct from such first phase. As used herein in reference to the phases of a multiphase embodiments of the present invention, the terminology "substantially distinct" means that the phases each exhibit substantially homogeneous properties within a given phase and that the phases differ with respect to at

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least one characteristic or property, such as for example, visual characteristics, such as color, clarity, pearlescence, or physical/chemical properties, such as viscosity, lubricity, and/or benefit agent content.

5 In one embodiment, the structured surfactant component forms a first phase that exhibits shear-thinning viscosity and is capable of suspending water insoluble or partially water soluble components.

10 In one embodiment, the structured surfactant component forms a first phase that exhibits shear-thinning viscosity and is capable of suspending water insoluble or partially water soluble components and the composition comprises at least one additional phase that is at least substantially distinct from such first phase and that does not exhibit shear-thinning viscosity and/or is not capable of suspending water insoluble or
15 partially water soluble components.

20 In one embodiment, the structured surfactant component forms a first phase that exhibits shear-thinning viscosity and is capable of suspending water insoluble or partially water soluble components and the composition comprises at least one additional phase, such as an additional structured surfactant component according to the present invention, that is at least substantially distinct from such first phase and that exhibits shear-thinning viscosity and is capable of suspending water insoluble or partially
25 water soluble components.

30 In one embodiment, the structured surfactant component forms a first phase and the composition comprises at least one additional phase that is at least substantially distinct from such first phase, wherein each of the phases is a continuous phase and the phases are disposed adjacent to each other.

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In one embodiment, the structured surfactant component forms a first phase and the composition comprises at least one additional phase that is at least substantially distinct from such first phase, wherein one of such phases is a continuous phase, the other phase is a discontinuous phase, and the discontinuous phase is disposed adjacent to or is dispersed within the continuous phase.

In one embodiment, the structured surfactant component forms a first phase and the composition comprises at least one additional phase that that is at least substantially visually distinct from such first phase such as for example, wherein at least one additional phase is an opaque water insoluble component that is suspended in the first phase.

In one embodiment, the composition of the present invention comprises two distinct phases, wherein each of the phases is a continuous phase and the phases are disposed adjacent to each other.

In one embodiment, the composition of the present invention comprises two distinct phases, wherein one phase is a continuous phase the other phase is a discontinuous phase and the discontinuous phase is disposed adjacent to the continuous phase or is dispersed within the continuous phase.

In one embodiment, the composition of the present invention comprises two distinct phases, wherein each phase is a continuous phase and the two phases are disposed in a mutually interpenetrating network.

In one embodiment, the composition of the present invention comprises two or more visually distinct phases, such as for example, two or more visually distinct phases which exhibit an appearance of alternating visually distinct stripes.

The composition of the present invention is useful in, for example, personal care applications, such as shampoos, body washes, hand soap, lotions, creams, conditioners, shaving products, facial washes, neutralizing
5 shampoos, and skin treatments, and in home care applications, such as liquid detergents, laundry detergents, hard surface cleansers, dish wash liquids, toilet bowl cleaners, as well as other applications, such as oil field and agrochemical applications.

10 In one embodiment, the composition of the present invention is a personal care composition.

In one embodiment, the structured surfactant composition of the present invention is useful as a personal care composition.

15

In one embodiment, the personal care composition of the present invention comprises a structured surfactant composition according to the present invention and an aqueous carrier.

20 In one embodiment, the personal care composition of the present invention further comprises one or more chemically stable benefit agents, such as emollients, moisturizers, conditioners, skin conditioners, hair conditioners, vitamins or their derivatives, antioxidants, free-radical scavengers, abrasives, dyes, hair coloring agents, bleaching agents, hair
25 bleaching agents, anti-UV agents, UV absorbers, antimicrobial agents, antibacterial agents, antifungal agents, melanin regulators, tanning accelerators, depigmenting agents, skin-coloring agents, liporegulators, weight-reduction agents, anti-acne agents, antiseborrhoeic agents, anti-ageing agents, anti-wrinkle agents, keratolytic agents, anti-inflammatory
30 agents, refreshing agents, cicatrizing agents, vascular-protection agents, antiperspirants, deodorants, immunomodulators, nourishing agents,

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agents for combating hair loss, reducing agents for permanent-waving, essential oils and fragrances.

In one embodiment, the personal care composition of the present invention further comprises one or more chemically stable benefit agents selected from acids, such as, ascorbic acid, salicylic acid, alpha-hydroxy acids, beta-hydroxy acids, alpha-keto acids optionally in lactone form, kojic acid, caffeic acid, phytic acid, quinic acid, benzene-1,4-bis(3-methylidenecamphorsulfonic acid, glycolic acid, lactic acid, mandelic acid, malic acid, tartaric acid, citric acid, hydroxybutyric acid, gluconic acid, ascorbic acid, salicylic acid, gentisic acid, homogentisic acid, and pyruvic acid, zinc pyrithion, Vitamin B, Vitamin E Acetate, silicone fluids, organosilicon materials, such as, silicone gums, polyorganosiloxane fluids, and crosslinked polyorganosiloxane resins, hydrocarbon conditioning agents, such as petrolatum, mineral oils, and gelled mineral oils, thickening and/or benefit polymers, such as succinoglycan (Rheozan from Rhodia), methyl cellulose products such as carboxymethyl cellulose gum (Aqualon CMC-7HOF from Aqualon), modified starches such as sodium hydroxypropyl starch phosphate (Pure-Gel 980 and Pure-Gel 998 from Grain Processing Corporation), potato starch modified (Structure-Solanace from National Starch), acrylates copolymers such as Acrylates/Aminoacrylates/C10-30 Alkyl PEG-20 Itaconate Copolymer (Structure-Plus from National Starch), cationic polymers (Rheovis CSP, Rheovis CDE, Rheovis CDP from Ciba), Polyacrylimidomethylpropane Sulfonate / Polyquaternium-4 (Plexagel ASC from ISP), hydrophobically modified nonionic polyols (Acusol 880, Acusol 882 from Rohm & Haas).

In one embodiment, the personal care composition of the present invention further comprises up to about 40 pbw, more typically from about 0.1 to about 40 pbw, even more typically from about 0.3 to about 20 pbw,

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and still more typically from about 0.5 to 10 pbw, of one or more chemically stable benefit agents.

The personal care composition of the present invention may,
5 optionally, further comprise other ingredients, such as, for example, preservatives, such as benzyl alcohol, methyl paraben, propyl paraben and imidazolidinyl urea, viscosity adjusting agents, electrolytes, such as sodium chloride, and sodium sulfate, pH adjusting agents such as citric acid, succinic acid, phosphoric acid, sodium hydroxide, potassium
10 hydroxide, and sodium carbonate, perfumes, colorants, and sequestering agents, such as disodium ethylene diamine tetra-acetate.

In general, personal care composition of the present invention may optionally comprise, based on 100 pbw of the personal care composition
15 and independently for each such ingredient, up to about 10 pbw, preferably from 0.5 pbw to about 5.0 pbw, of such other ingredients, depending on the desired properties of the personal care composition.

EXAMPLES 1-3

20

The compositions of Examples 1-3 were made by mixing the relative amounts of the ingredients listed in TABLE I, and allowing them to sit overnight at ambient lab temperature. Typically, the monoalkyl phosphate a ("MAP") component was first dissolved in water, followed by the pH
25 adjustment, where applicable. All amounts are indicated by the pbw per 100 pbw of the composition. The mixed compositions were visually observed to contain entrapped air bubbles.

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TABLE I

Ingredient	Ex. 1	Ex. 2	Ex. 3
Laureth-1 Phosphate (Dermalcare MAP L-210, Rhodia)	24.9	24.7	24.5
50% NaOH	0.5	1.0	2
water	74.6	74.3	73.5

The compositions of Examples 1-3 were each evaluated as being capable of suspending air, based on the visual observation that the samples contained entrapped air bubbles after sitting overnight. The compositions of Examples 1-3 were each subjected to one freeze/thaw cycle (12 hours at -10°C and 12 hours at 25°C). and evaluated as having retained the capacity to suspend air following the freeze/thaw cycle, based on the visual observation that samples contained entrapped air bubbles after having been subjected to the freeze thaw cycle.

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EXAMPLES 4-7

The compositions of Examples 4-7 were made by mixing the relative amounts of the ingredients listed in TABLE II, and allowing them to sit overnight at ambient lab temperature. Typically, the MAP ester was dissolved in water, followed by the pH adjustment, where applicable. All amounts are indicated by the pbw per 100 pbw of the composition.

10 TABLE II

Ingredient	Ex. 4	Ex. 5	Ex. 6	Ex. 7
Laureth-1 Phosphate (Dermalcare MAP L-210, Rhodia)	16.7	16.4	24.9	8.3
Isostearic Acid	1.3	1.3		
Cetrimonium Bromide (Rhodaquat M242B/99, Rhodia)	0.9	0.9	0.5	0.17
Laureth-2 (Genapol 26-L-2)	7.1	8.7		
Succinoglycan (Rheozan, Rhodia)				1.33
50% NaOH	1.8	1.8		
water	72.2	70.9	74.6	90.2

The compositions of Examples 4-7 were evaluated for the ability to suspend air using the procedure described above in reference to the compositions of Examples 1-3 and were each found to be capable of suspending air and to retain the capacity to suspend air following the freeze/thaw cycle.

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EXAMPLES 8-10

The compositions of Examples 8-10 were made by mixing the relative amounts of the ingredients listed in TABLE III, and allowing them to sit overnight at ambient lab temperature. Typically, the MAP ester was dissolved in water, followed by the pH adjustment, other surfactant additions, and salt addition, where applicable. All amounts are indicated by the pbw per 100 pbw of the composition.

10 TABLE III

Ingredient	Ex. 8	Ex. 9	Ex. 10
Trideceth-4 Phosphate (Rhodifac RS-410, Rhodia)	12.2	12.6	12.4
Trideceth-7 Carboxylic Acid (Nikkol ECT-7, Nikko)			3.8
Lauryl Betaine (Mirataine BB/FLA, Rhodia)	4.9	5.0	5.0
Laureth-2 (Genapol 26-L-2)	4.6		
Isostearic Acid		1.9	
Sodium Chloride	3.6	3.7	2.8
50% NaOH	1.3	1.3	1.3
water	73.4	75.5	74.8

The compositions of Examples 8-10 were evaluated for the ability to suspend air using the procedure described above in reference to the compositions of Examples 1-3 and were each found to be capable of suspending air and to retain the capacity to suspend air following the freeze/thaw cycle.

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EXAMPLES 11-12

The composition of Examples 11-12 were made by mixing the relative amounts of the ingredients listed in TABLE IV, and allowing them to sit overnight at ambient lab temperature. Typically, the MAP ester was dissolved in water, followed by the pH adjustment, where applicable. All amounts are indicated by the pbw per 100 pbw of the composition.

TABLE IV

Ingredient	Ex. 11	Ex. 12
Trideceth-4 Phosphate (Rhodifac RS-410, Rhodia)	22.9	16.0
Dodecyl Benzene Sulfonic Acid (Rhodacal SSA/A, Rhodia)	1.6	1.1
50% NaOH	0.5	0.3
water	75.0	82.5

10

The compositions of Examples 11-12 were evaluated for the ability to suspend air using the procedure described above in reference to the compositions of Examples 1-3 and were each found to be capable of suspending air and to retain the capacity to suspend air following the freeze/thaw cycle.

15

EXAMPLES 13-15

The composition of Examples 13-15 were made by mixing the relative amounts of the ingredients listed in TABLE V, and allowing them to sit overnight at ambient lab temperature. Typically, the MAP ester was dissolved in water, followed by the pH adjustment, nonionic surfactant and sodium chloride, where applicable. All amounts are indicated by the pbw per 100 pbw of the composition.

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TABLE V

Ingredient	Ex. 13	Ex. 14	Ex. 15
Laureth-2 Phosphate (Dermalcare MAP L-210, Rhodia)	9.1	11.3	9.1
Trideceth-4 Phosphate (Rhodifac RS-410, Rhodia)	4.7		4.7
Laureth-2 (Genapol 26-L-2)	6.0	13.0	6.0
Sodium Chloride	0.6		0.4
10% NaOH	7.3	9.1	7.3
water	72.4	66.6	72.6

- The compositions of Examples 13-15 were evaluated for the ability
- 5 to suspend air using the procedure described above in reference to the compositions of Examples 1-3 and were each found to be capable of suspending air. and to retain the capacity to suspend air following the freeze/thaw cycle.

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Claims:

1. An aqueous, low pH structured surfactant composition, comprising,
based on 100 parts by weight of the composition, from about 3 parts by
5 weight to about 40 parts by weight of one or more anionic surfactants
selected from anionic phosphate ester surfactants, anionic sulfonate
surfactants, and anionic carboxylate surfactants, wherein the composition
exhibits a pH of less than about 5, exhibits shear-thinning viscosity, and is
capable of suspending water insoluble or partially water soluble
10 components.
2. The composition of claim 1, wherein the anionic surfactant is
selected from monoalkyl phosphate surfactants, a dialkyl phosphate
surfactants, linear alkylbenzene sulfonate surfactants, alpha-olefin
15 sulfonate surfactants, paraffin sulfonate surfactants, alkyl ether carboxylate
surfactants, and mixtures thereof.
3. The composition of claim 1, wherein at least a portion of the
composition is in the lamellar form.
20
4. The composition of claim 1, further comprising a structuring agent
selected from cationic surfactants, nonionic surfactants, electrolytes and
mixtures thereof.
- 25 5. The composition of claim 1, further comprising a structuring agent
selected from amine salts, quaternary ammonium compounds, amine
oxides, fatty alcohols, ethoxylated alcohols, fatty acids, electrolytes, and
mixtures thereof

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6. The composition of claim 1, wherein the composition comprises, based on 100 parts by weight of the composition, from about 0.5 to about 25 p parts by weight structuring agent.
- 5 7. The composition of claim 1, further comprising a surfactant selected from nonionic surfactants, amphoteric surfactants, zwitterionic surfactants, cationic surfactants, and mixtures thereof.
8. A personal care composition, comprising the structured surfactant
10 composition of claim 1.
9. The personal care composition of claim 8, wherein the personal care composition is selected from shampoos, body washes, hand soaps, lotions, creams, conditioners, shaving products, facial washes, and skin treatments
15
10. The personal care composition of claim 8, further comprising one or more water insoluble or partially water soluble components suspended in the composition.
- 20 11. The personal care composition of claim 8, further comprising one or more of benefit agents.
12. The personal care composition of claim 11, wherein the one or more benefit agents are selected from emollients, moisturizers, conditioners, skin
25 conditioners, hair conditioners, vitamins or their derivatives, antioxidants, free-radical scavengers, abrasives, dyes, hair coloring agents, bleaching agents, hair bleaching agents, anti-UV agents, UV absorbers, antimicrobial agents, antibacterial agents, antifungal agents, melanin regulators, tanning accelerators, depigmenting agents, skin-coloring agents, liporegulators,
30 weight-reduction agents, anti-acne agents, antiseborrhoeic agents, anti-ageing agents, anti-wrinkle agents, keratolytic agents, anti-inflammatory

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agents, refreshing agents, cicatrizing agents, vascular-protection agents, antiperspirants, deodorants, immunomodulators, nourishing agents, agents for combating hair loss, reducing agents for permanent-waving, essential oils and fragrances, and mixtures thereof

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13. The personal care composition of claim 8, wherein the composition comprises, based on 100 parts by weight of the personal care composition, from about 0.1 to about 40 parts by weight benefit agent.

10 14. The composition of claim 8, wherein the composition comprises two or more visually distinct phases.

15. The composition of claim 8, wherein the two or more phases are visible as stripes.

15

16. An aqueous, low pH composition, comprising:

a continuous structured surfactant phase, said structured surfactant phase comprising water and one or more anionic surfactants selected from anionic phosphate ester surfactants, anionic sulfonate surfactants, and
20 anionic carboxylate surfactants, and exhibiting shear-thinning viscosity, and one or more water insoluble or partially water soluble components suspended in the structured surfactant phase,

wherein the composition exhibits a pH of less than about 5.

25 17. An aqueous, low pH composition, comprising at least two at least substantially distinct phases, wherein at least one of such phases is a structured surfactant phase that comprises water and one or more anionic surfactants selected from anionic phosphate ester surfactants, anionic sulfonate surfactants, and anionic carboxylate surfactants, and exhibits
30 shear-thinning viscosity and wherein the composition exhibits a pH of less than about 5.