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(54) Title: LUBRICANT COMPOSITIONS CONTAINING CONTROLLED RELEASE ADDITIVES

(57) Abstract: A lubricating oil including a lubricating oil base stock as a major component, and one or more lubricating oil additives having at least one protected active group, as a minor component. The one or more lubricating oil additives having at least one protected active group are converted into one or more lubricating oil additives having at least one unprotected active group in the lubricating oil in-service in an engine or other mechanical component. Compositions including one or more lubricating oil additives having at least one protected active group. A method for improving solubility of one or more lubricating oil additives in a lubricating oil. A method for improving oxidative stability of a lubricating oil and extending performance life of one or more lubricating oil additives. A method for improving friction control in an engine or other mechanical component lubricated with a lubricating oil.



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LUBRICANT COMPOSITIONS CONTAINING CONTROLLED RELEASE ADDITIVES**FIELD**

[0001] This disclosure relates to lubricant compositions containing controlled release additives. This disclosure also relates to a method for controlled release of one or more lubricating oil additives into a lubricating oil. This disclosure further relates to compositions comprising one or more lubricating oil additives having at least one protected active group. This disclosure yet further relates to a method for improving solubility of one or more lubricating oil additives in a lubricating oil. This disclosure also relates to a method for improving oxidative stability of a lubricating oil and extending performance life of one or more lubricating oil additives. This disclosure further relates to a method for improving friction control in an engine or other mechanical component lubricated with a lubricating oil.

BACKGROUND

[0002] The performance of a lubricant degrades over time, which defines its specified oil drain interval. The degradation rate of a lubricant is dependent up the rate at which the activity of the additives contained in the lubricant degrades over time. Conventional ways in approaching this challenge is by developing or identifying additives that are more robust or more oxidatively stable so that they can persist longer in the lubricant environment, however this can often come at the cost of additive performance. Alternatively, lubricants formulations contain higher treat rates of the additives with the hopes of extending the performance of that additive to a longer lifetime. But this is often difficult as lubricant formulations are a delicate balance of additives and overtreating one additive can have significant negative impacts on the performance of another.

[0003] Time release additives for engine oils are known. These additives are typically incorporated into thermoplastic polymers which slowly dissolve into the engine oil. See, for example, U.S. Patent No. 4,075,098. Time release additives have also been incorporated into polymers which are oil-permeable at elevated engine temperatures. See, for example, U.S. Patent No. 4,066,559.

[0004] Replenishment of additives in a lubricant, by using a controlled release gel or other means to add additional additive to the lubricant, can improve the performance of the lubricant and the device using the lubricant. Use of controlled release gels, as described in U.S. Patent No. 6,843,916, can replenish a lubricant with fresh additives over time. Such gels are formed by incorporating additive components which are compatible with the functional fluid to which the additive is to be delivered into a gel matrix. These gel matrixes often result from the interaction of a basic component and an acidic component, forming the gel.

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[0005] There is a need for extending the life of current lubricant additives without compromising on additive performance and without increasing the initial treat rate of active additive. In addition, there is a need for improving the solubility of additives in lubricants, thereby reducing the need for co-base stocks (e.g., alkylated naphthalene such as AN5 or polar esters) or providing a mechanism to stabilize less soluble additives in lubricant formulations.

SUMMARY

[0006] This disclosure relates to lubricant compositions containing controlled release additives. This disclosure also relates to a method for controlled release of one or more lubricating oil additives into a lubricating oil. This disclosure further relates to compositions comprising one or more lubricating oil additives having at least one protected active group. This disclosure yet further relates to a method for improving solubility of one or more lubricating oil additives in a lubricating oil. This disclosure also relates to a method for improving oxidative stability of a lubricating oil and extending performance life of one or more lubricating oil additives. This disclosure further relates to a method for improving friction control in an engine or other mechanical component lubricated with a lubricating oil.

[0007] This disclosure also relates in part to a lubricating oil comprising a lubricating oil base stock as a major component; and one or more lubricating oil additives having at least one protected active group, as a minor component. The one or more lubricating oil additives having at least one protected active group are inactive with respect to their innate performance function. The one or more lubricating oil additives having at least one protected active group are converted into one or more lubricating oil additives having at least one unprotected active group in the lubricating oil in-service in an engine or other mechanical component.

[0008] This disclosure further relates in part to a method for controlled release of one or more lubricating oil additives into a lubricating oil. The method comprises using as the lubricating oil a formulated oil, the formulated oil having a composition comprising a lubricating oil base stock as a major component; and one or more lubricating oil additives having at least one protected active group, as a minor component. The one or more lubricating oil additives having at least one protected active group are inactive with respect to their innate performance function. The method further comprises converting the one or more lubricating oil additives having at least one protected active group into one or more lubricating oil additives having at least one unprotected active group in the lubricating oil in-service in an engine or other mechanical component.

[0009] This disclosure yet further relates in part to a method for extending performance life of one or more lubricating oil additives. The method comprises using as the lubricating oil a formulated oil, the formulated oil having a composition comprising a lubricating oil base stock as

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a major component; and one or more lubricating oil additives having at least one protected active group, as a minor component. The one or more lubricating oil additives having at least one protected active group are inactive with respect to their innate performance function. The method further comprises converting the one or more lubricating oil additives having at least one protected active group into one or more lubricating oil additives having at least one unprotected active group in the lubricating oil in-service in an engine or other mechanical component. This method allows the slow delivery of at least one unprotected active group in the lubrication oil in-service in an engine or other mechanical component, reducing the rate of additive consumption and extending the performance life of the additive.

[0010] This disclosure yet further relates in part to a method for improving oxidative stability of a lubricating oil. The method comprises using as the lubricating oil a formulated oil, the formulated oil having a composition comprising a lubricating oil base stock as a major component; and one or more lubricating oil additives having at least one protected active group, as a minor component. The one or more lubricating oil additives having at least one protected active group are inactive with respect to their innate performance function. The method further comprises converting the one or more lubricating oil additives having at least one protected active group into one or more lubricating oil additives having at least one unprotected active group in the lubricating oil in-service in an engine or other mechanical component.

[0011] This disclosure also relates in part to a method for improving oxidative stability of a lubricating oil additive. The method comprises using as a lubricating oil a formulated oil, the formulated oil having a composition comprising a lubricating oil base stock as a major component; and one or more lubricating oil additives having at least one protected active group, as a minor component. The lubricating oil additives having at least one protected active group are inactive with respect to their innate performance function and exhibit improved oxidative stability, such that they have longer in-service retention times than their active additive counterparts in a lubricating oil. The method further comprises converting the one or more lubricating oil additives having at least one protected active group into one or more lubricating oil additives having at least one unprotected active group in the lubricating oil in-service in an engine or other mechanical component.

[0012] This disclosure further relates in part to an antioxidant composition comprising di-*tert*-butyl (methylenebis(2,6-di-*tert*-butyl-4,1-phenylene)) bis(carbonate) derived from a hindered bisphenol, *tert*-butyl carbonate of 3,5-di-*tert*-butyl-4-hydroxyphenylpropionic alkyl ester derived from a hindered monophenol, or *tert*-butyl diaryl carbamate derived from a substituted (or unsubstituted) diarylamine.

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[0013] This disclosure yet further relates in part to a friction modifier composition comprising an alkyl tert-butyl-1,2-diyl dicarbonate, or glycerol alkyl ester bis(carbonate).

[0014] This disclosure also relates in part to a dispersant composition comprising a Mannich dispersant having a *tert*-butyl carbonate group.

[0015] This disclosure further relates in part to a lubricating oil comprising a lubricating oil base stock as a major component; and one or more lubricating oil additives having at least one cyclic carbonate active group, as a minor component.

[0016] This disclosure yet further relates in part to a friction modifier composition comprising 4-hexadecyl-1,3-dioxolan-2-one.

[0017] This disclosure also relates in part to a method for improving friction control in an engine or other mechanical component lubricated with a lubricating oil by using as the lubricating oil a formulated oil. The formulated oil has a composition comprising a lubricating oil base stock as a major component, and one or more lubricating oil additives having at least one cyclic carbonate active group, as a minor component.

[0018] This disclosure further relates in part to a lubricating oil comprising a lubricating oil base stock as a major component; and a mixture of (i) one or more lubricating oil additives having at least one cyclic carbonate active group, and (ii) one or more amine-containing lubricating oil additives, as a minor component.

[0019] This disclosure yet further relates in part to a method for improving friction control in an engine or other mechanical component lubricated with a lubricating oil by using as the lubricating oil a formulated oil. The formulated oil has a composition comprising a lubricating oil base stock as a major component, and a mixture of (i) one or more lubricating oil additives having at least one cyclic carbonate active group, and (ii) one or more amine-containing lubricating oil additives, as a minor component. Friction control is improved as compared to friction control achieved using a lubricating oil containing other than a mixture of (i) one or more lubricating oil additives having at least one cyclic carbonate active group, and (ii) one or more amine-containing lubricating oil additives.

[0020] It has been surprisingly found that a lubricating oil having one or more lubricating oil additives having at least one protected active group, exhibits extended oxidative protection and improved lubricant life. It has also been surprisingly found that one or more lubricating oil additives having at least one protected active group included in a lubricating oil, exhibit extended oxidative protection and improved lubricant additive life. In particular, it has been surprisingly found that the lubricating oil additive protected active groups extend the performance of the lubricating oil additives through a chemical activation that occurs over the life of the lubricating

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oil, thereby decreasing the rate of lubricating oil performance degradation, and extending the lubricating oil drain interval. The lubricating oil additives having at least one protected active group are inactive with respect to their innate performance function and exhibit improved oxidative stability, such that they have longer in-service retention times than their active additive counterparts in a lubricating oil. Under the appropriate conditions, these lubricating oil additives having at least one protected active group become activated, delivering fresh active lubricant additives to the lubricant formulation over time, thus maintaining the lubricant performance over a longer period of time. Other advantages afforded by the lubricating oil additives having at least one protected active group include improved additive solubility and storage stability.

[0021] Other objects and advantages of the present disclosure will become apparent from the detailed description that follows.

DETAILED DESCRIPTION

Definitions

[0022] All numerical values within the specification and the claims herein are modified by “about” or “approximately” the indicated value, and take into account experimental error and variations that would be expected by a person having ordinary skill in the art.

[0023] “Other mechanical component” within the specification and the claims herein includes, but is not limited to, a power train, a driveline, a transmission, a gear, a gear train, a gear set, a compressor, a pump, a hydraulic system, a bearing, a bushing, a turbine, a piston, a piston ring, a cylinder liner, a cylinder, a cam, a tappet, a lifter, a gear, a valve, or a bearing including a journal, a roller, a tapered, a needle, or a ball bearing.

[0024] “Over time” within the specification and the claims herein means a typical service life for a lubricant, or 6,000 miles for an engine oil, or alternatively 100 service hours for an engine oil.

[0025] “Extending performance life” or “extended performance life” of one or more lubricating oil additive within the specification and the claims herein means an increase in the expected performance life of the one or more lubricating oil additives by 50%, or preferably by 100%, or more preferably by 200%, or even more preferably by 300%.

[0026] “Unprotected active groups” or “active groups” within the specification and the claims herein means the part of a lubricating oil additive which is known to contribute to the primary performance function of the particular lubricating oil additive. Active groups or unprotected active groups include, for example, an –OH group for friction modifier additives or antioxidant additives. Another example is a –NH group for antioxidant additives or dispersant additives.

[0027] “Protected active groups” within the specification and the claims herein means the

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chemical protection of an active group or unprotected active group of a lubricating oil additive, whereby protection of the active group or unprotected active group results in the lubricating oil additive being inactive to its primary performance function.

[0028] “Conversion of protected to unprotected active groups” within the specification and the claims herein means the conversion of a protected active group to an active group or unprotected active group of a lubricating oil additive by chemical deprotection of the protected active group, whereby the resulting lubricating oil additive is made active with respect to its primary performance function.

Exemplary Embodiments

[0029] This disclosure provides a lubricating oil comprising a lubricating oil base stock as a major component; and one or more lubricating oil additives having at least one protected active group, as a minor component. The one or more lubricating oil additives having at least one protected active group are inactive with respect to their innate performance function. The one or more lubricating oil additives having at least one protected active group are converted into one or more lubricating oil additives having at least one unprotected active group in the lubricating oil in-service in an engine or other mechanical component.

[0030] In an embodiment, the one or more lubricating oil additives having at least one protected active group are converted into one or more lubricating oil additives having at least one unprotected active group in the lubricating oil over time, thereby extending performance life of the one or more lubricating oil additives.

[0031] In another embodiment, the one or more lubricating oil additives having at least one protected active group exhibit improved solubility in the lubricating oil, as compared to solubility achieved using a lubricating oil containing the same one or more lubricating oil additives having at least one active group that is not protected.

[0032] In still another embodiment, the one or more lubricating oil additives having at least one protected active group exhibit improved oxidative stability in the lubricating oil, as compared to oxidative stability achieved using a lubricating oil containing the same one or more lubricating oil additives having at least one active group that is not protected.

[0033] The one or more lubricating oil additives having at least one protected active group are converted to one or more lubricating oil additives having at least one unprotected active group in the lubricating oil in-service in the engine or other mechanical component at a temperature greater than or equal to 110°C, or by reaction with free acids that catalyze the release of an unprotected active group at a temperature greater than or equal to ambient temperature.

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[0034] Illustrative unprotected active groups include, for example, an –OH group, a –NH group, and the like.

[0035] Illustrative protected active groups include, for example, a carbonate, a carbamate, an acetal, an ester, an amide, a urea, an alkoxy silane, an alkyl silane, a phosphite, a phosphonate, a phosphate, a sulfonamide, a sulfonate, a sulfate, and the like.

[0036] Protection methods for the one or more lubricating oil additives having at least one protected active group can include, for example, chemical protection. Illustrative chemical protection includes, for example, converting an unprotected –OH group or –NH group to a protected carbonate, carbamate, acetal, ester, amide, urea, alkoxy silane, alkyl silane, phosphite, phosphonate, phosphate, sulfonamide, sulfonate, or sulfate group.

[0037] Deprotection methods for converting one or more lubricating oil additives having at least one protected active group to one or more lubricating oil additives having at least one unprotected active group include chemical deprotection.

[0038] Illustrative chemical deprotection methods include, for example, converting a protected carbonate, carbamate, acetal, ester, amide, urea, alkoxy silane, alkyl silane, phosphite, phosphonate, phosphate, sulfonamide, sulfonate, or sulfate group to an unprotected –OH group or –NH group.

[0039] Preferred lubricating oil additives having at least one protected active group include a protected phenolic antioxidant, a protected aminic antioxidant, a protected alkane diol friction modifier, a protected ester diol friction modifier, or a protected Mannich dispersant.

[0040] Illustrative lubricating oil additives having at least one protected active group comprise a protected phenolic antioxidant comprising di-*tert*-butyl (methylenebis(2,6-di-*tert*-butyl-4,1-phenylene)) bis(carbonate) derived from a hindered bisphenol, *tert*-butyl carbonate of 3,5-di-*tert*-butyl-4-hydroxyphenylpropionic alkyl ester derived from a hindered monophenol, a protected aminic antioxidant comprising *tert*-butyl diaryl carbamate derived from a substituted (or unsubstituted) diarylamine, a protected alkane diol friction modifier comprising *tert*-butyl octadecane-1,3-diyl dicarbonate, a protected ester diol friction modifier comprising glycerol monostearate bis(carbonate), a protected Mannich dispersant comprising a Mannich dispersant having a *tert*-butyl carbonate group, and the like.

[0041] The lubricating oils of this disclosure can further include one or more lubricating oil additives having at least one unprotected active group. The performance function of the lubricating oil additives having at least one unprotected active group can be the same or different from the lubricating oil additives having at least one protected active group. Illustrative of such lubricating oil additives having at least one unprotected active group include, for example, an unprotected viscosity improver, an unprotected antioxidant, an unprotected detergent, an unprotected

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dispersant, an unprotected pour point depressant, an unprotected corrosion inhibitor, an unprotected friction modifier, an unprotected antiwear agent, an unprotected extreme pressure additive, an unprotected metal deactivator, an unprotected seal compatibility additive, an unprotected anti-foam agent, an unprotected inhibitor, an unprotected anti-rust additive, and the like.

[0042] In the lubricating oils of this disclosure, the lubricating oil base stock can be present in an amount from 70 weight percent to 95 weight percent, and the one or more lubricating oil additives can be present in an amount from 0.1 weight percent to 10 weight percent or greater, based on the total weight of the lubricating oil.

[0043] The lubricating oils of this disclosure can be used in automotive, marine, aviation, industrial engine and machine component applications, and the like.

[0044] As described herein, this disclosure provides a method for controlled release of one or more lubricating oil additives into a lubricating oil. The method comprises using as the lubricating oil a formulated oil, the formulated oil having a composition comprising a lubricating oil base stock as a major component; and one or more lubricating oil additives having at least one protected active group, as a minor component. The one or more lubricating oil additives having at least one protected active group are inactive with respect to their innate performance function. The method further comprises converting the one or more lubricating oil additives having at least one protected active group into one or more lubricating oil additives having at least one unprotected active group in the lubricating oil in-service in an engine or other mechanical component.

[0045] As also described herein, this disclosure provides an antioxidant composition comprising di-*tert*-butyl (methylenebis(2,6-di-*tert*-butyl-4,1-phenylene)) bis(carbonate) derived from a hindered bisphenol, *tert*-butyl carbonate of 3,5-di-*tert*-butyl-4-hydroxyphenylpropionic alkyl ester derived from a hindered monophenol, or *tert*-butyl diaryl carbamate derived from a substituted or unsubstituted diarylamine.

[0046] As further described herein, this disclosure provides a friction modifier composition comprising *tert*-butyl octadecane-1,3-diyl dicarbonate, or glycerol monostearate bis(carbonate).

[0047] As yet further described herein, this disclosure provides a dispersant composition comprising a Mannich dispersant having a *tert*-butyl carbonate group.

[0048] As also described herein, this disclosure provides a lubricating oil comprising a lubricating oil base stock as a major component; and one or more lubricating oil additives having at least one cyclic carbonate active group, as a minor component.

[0049] As yet further described herein, this disclosure provides a friction modifier composition comprising 4-hexadecyl-1,3-dioxolan-2-one.

[0050] As also described herein, this disclosure provides a method for improving friction control in an engine or other mechanical component lubricated with a lubricating oil by using as the lubricating oil a formulated oil. The formulated oil has a composition comprising a lubricating oil base stock as a major component, and one or more lubricating oil additives having at least one cyclic carbonate active group, as a minor component.

[0051] In yet another embodiment, friction control in an engine is improved as compared to friction control in an engine using a lubricating oil containing a minor component other than the lubricating oil additive having at least one cyclic carbonate active group.

[0052] As further described herein, this disclosure provides a lubricating oil comprising a lubricating oil base stock as a major component; and a mixture of (i) one or more lubricating oil additives having at least one cyclic carbonate active group, and (ii) one or more amine-containing lubricating oil additives, as a minor component.

[0053] As also described herein, this disclosure provides a method for improving friction control in an engine or other mechanical component lubricated with a lubricating oil by using as the lubricating oil a formulated oil. The formulated oil has a composition comprising a lubricating oil base stock as a major component, and a mixture of (i) one or more lubricating oil additives having at least one cyclic carbonate active group, and (ii) one or more amine-containing lubricating oil additives, as a minor component.

[0054] In another embodiment, friction control in an engine is improved as compared to friction control in an engine using a lubricating oil containing other than a mixture of (i) one or more lubricating oil additives having at least one cyclic carbonate active group, and (ii) one or more amine-containing lubricating oil additives.

[0055] In still another embodiment, this disclosure provides a method for improving oxidative stability of a lubricating oil and extending performance life of one or more lubricating oil additives. The method comprises using as the lubricating oil a formulated oil, the formulated oil having a composition comprising a lubricating oil base stock as a major component, and one or more lubricating oil additives having at least one protected active group, as a minor component. The one or more lubricating oil additives having at least one protected active group are inactive with respect to their innate performance function. The method further comprises converting the one or more lubricating oil additives having at least one protected active group into one or more lubricating oil additives having at least one unprotected active group in the lubricating oil in-service in an engine or other mechanical component.

[0056] In the above method for improving oxidative stability of a lubricating oil and extending performance life of one or more lubricating oil additives, oxidative stability is improved and

additive performance life is extended as compared to oxidative stability and additive performance life achieved using a lubricating oil containing the same one or more lubricating oil additives having at least one active group that is not protected.

[0057] In yet another embodiment, this disclosure relates in part to a method for improving oxidative stability of a lubricating oil additive. The method comprises using as a lubricating oil a formulated oil, the formulated oil having a composition comprising a lubricating oil base stock as a major component; and one or more lubricating oil additives having at least one protected active group, as a minor component. The lubricating oil additives having at least one protected active group are inactive with respect to their innate performance function and exhibit improved oxidative stability, such that they have longer in-service retention times than their active additive counterparts in a lubricating oil. The method further comprises converting the one or more lubricating oil additives having at least one protected active group into one or more lubricating oil additives having at least one unprotected active group in the lubricating oil in-service in an engine or other mechanical component.

[0058] In the above method for improving oxidative stability of a lubricating oil additive, the one or more lubricating oil additives having at least one protected active group exhibit improved oxidative stability in the lubricating oil, as compared to oxidative stability achieved using a lubricating oil containing the same one or more lubricating oil additives having at least one active group that is not protected.

Lubricating Oil Base Stocks

[0059] A wide range of lubricating base oils is known in the art. Lubricating base oils that are useful in the present disclosure are both natural oils, and synthetic oils, and unconventional oils (or mixtures thereof) can be used unrefined, refined, or rerefined (the latter is also known as reclaimed or reprocessed oil). Unrefined oils are those obtained directly from a natural or synthetic source and used without added purification. These include shale oil obtained directly from retorting operations, petroleum oil obtained directly from primary distillation, and ester oil obtained directly from an esterification process. Refined oils are similar to the oils discussed for unrefined oils except refined oils are subjected to one or more purification steps to improve at least one lubricating oil property. One skilled in the art is familiar with many purification processes. These processes include solvent extraction, secondary distillation, acid extraction, base extraction, filtration, and percolation. Re-refined oils are obtained by processes analogous to refined oils but using an oil that has been previously used as a feed stock.

[0060] Groups I, II, III, IV and V are broad base oil stock categories developed and defined by the American Petroleum Institute (API Publication 1509; www.API.org) to create guidelines for

lubricant base oils. Group I base stocks have a viscosity index of between 80 and 120 and contain greater than 0.03% sulfur and/or less than 90% saturates. Group II base stocks have a viscosity index of between 80 and 120, and contain less than or equal to 0.03% sulfur and greater than or equal to 90% saturates. Group III stocks have a viscosity index greater than 120 and contain less than or equal to 0.03 % sulfur and greater than 90% saturates. Group IV includes polyalphaolefins (PAO). Group V base stock includes base stocks not included in Groups I-IV. The table below summarizes properties of each of these five groups.

	Base Oil Properties		
	Saturates	Sulfur	Viscosity Index
Group I	<90 and/or	>0.03% and	≥80 and <120
Group II	≥90 and	≤0.03% and	≥80 and <120
Group III	≥90 and	≤0.03% and	≥120
Group IV	Includes polyalphaolefins (PAO) and GTL products		
Group V	All other base oil stocks not included in Groups I, II, III or IV		

[0061] Natural oils include animal oils, vegetable oils (castor oil and lard oil, for example), and mineral oils. Animal and vegetable oils possessing favorable thermal oxidative stability can be used. Of the natural oils, mineral oils are preferred. Mineral oils vary widely as to their crude source, for example, as to whether they are paraffinic, naphthenic, or mixed paraffinic-naphthenic. Oils derived from coal or shale are also useful. Natural oils vary also as to the method used for their production and purification, for example, their distillation range and whether they are straight run or cracked, hydrotreated, or solvent extracted.

[0062] Group II and/or Group III hydroprocessed or hydrocracked base stocks, including synthetic oils such as polyalphaolefins, alkyl aromatics and synthetic esters are also well known base stock oils.

[0063] Synthetic oils include hydrocarbon oil. Hydrocarbon oils include oils such as polymerized and interpolymerized olefins (polybutylenes, polypropylenes, propylene isobutylene copolymers, ethylene-olefin copolymers, and ethylene-alphaolefin copolymers, for example). Polyalphaolefin (PAO) oil base stocks are commonly used synthetic hydrocarbon oil. By way of example, PAOs derived from C₈, C₁₀, C₁₂, C₁₄ olefins or mixtures thereof may be utilized. See U.S. Patent Nos. 4,956,122; 4,827,064; and 4,827,073.

[0064] The number average molecular weights of the PAOs, which are known materials and generally available on a major commercial scale from suppliers such as ExxonMobil Chemical Company, Chevron Phillips Chemical Company, BP, and others, typically vary from 250 to 3,000,

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although PAO's may be made in viscosities up to 100 cSt (100°C). The PAOs are typically comprised of relatively low molecular weight hydrogenated polymers or oligomers of alphaolefins which include, but are not limited to, C₂ to C₃₂ alphaolefins with the C₈ to C₁₆ alphaolefins, such as 1-octene, 1-decene, 1-dodecene and the like, being preferred. The preferred polyalphaolefins are poly-1-octene, poly-1-decene and poly-1-dodecene and mixtures thereof and mixed olefin-derived polyolefins. However, the dimers of higher olefins in the range of C₁₄ to C₁₈ may be used to provide low viscosity base stocks of acceptably low volatility. Depending on the viscosity grade and the starting oligomer, the PAOs may be predominantly trimers and tetramers of the starting olefins, with minor amounts of the higher oligomers, having a viscosity range of 1.5 to 12 cSt.

[0065] The PAO fluids may be conveniently made by the polymerization of an alphaolefin in the presence of a polymerization catalyst such as the Friedel-Crafts catalysts including, for example, aluminum trichloride, boron trifluoride or complexes of boron trifluoride with water, alcohols such as ethanol, propanol or butanol, carboxylic acids or esters such as ethyl acetate or ethyl propionate. For example, the methods disclosed by U.S. Patent Nos. 4,149,178 or 3,382,291 may be conveniently used herein. Other descriptions of PAO synthesis are found in the following U.S. Patent Nos. 3,742,082; 3,769,363; 3,876,720; 4,239,930; 4,367,352; 4,413,156; 4,434,408; 4,910,355; 4,956,122; and 5,068,487. The dimers of the C₁₄ to C₁₈ olefins are described in U.S. Patent No. 4,218,330.

[0066] The hydrocarbyl aromatics can be used as base oil or base oil component and can be any hydrocarbyl molecule that contains at least 5% of its weight derived from an aromatic moiety such as a benzenoid moiety or naphthenoid moiety, or their derivatives. These hydrocarbyl aromatics include alkyl benzenes, alkyl naphthalenes, alkyl diphenyl oxides, alkyl naphthols, alkyl diphenyl sulfides, alkylated bisphenol A, alkylated thiodiphenol, and the like. The aromatic can be mono-alkylated, dialkylated, polyalkylated, and the like. The aromatic can be mono- or poly-functionalized. The hydrocarbyl groups can also be comprised of mixtures of alkyl groups, alkenyl groups, alkynyl, cycloalkyl groups, cycloalkenyl groups and other related hydrocarbyl groups. The hydrocarbyl groups can range from C₆ up to C₆₀ with a range of C₈ to C₂₀ often being preferred. A mixture of hydrocarbyl groups is often preferred, and up to three such substituents may be present. The hydrocarbyl group can optionally contain sulfur, oxygen, and/or nitrogen containing substituents. The aromatic group can also be derived from natural (petroleum) sources, provided at least 5% of the molecule is comprised of an above-type aromatic moiety. Viscosities at 100°C of approximately 3 cSt to 50 cSt are preferred, with viscosities of approximately 3.4 cSt to 20 cSt often being more preferred for the hydrocarbyl aromatic component. In one embodiment, an alkyl naphthalene where the alkyl group is primarily comprised of 1-hexadecene is used. Other alkylates

of aromatics can be advantageously used. Naphthalene or methyl naphthalene, for example, can be alkylated with olefins such as octene, decene, dodecene, tetradecene or higher, mixtures of similar olefins, and the like. Useful concentrations of hydrocarbyl aromatic in a lubricant oil composition can be 2% to 25%, preferably 4% to 20%, and more preferably 4% to 15%, depending on the application.

[0067] Esters comprise a useful base stock. Additive solvency and seal compatibility characteristics may be secured by the use of esters such as the esters of dibasic acids with monoalkanols and the polyol esters of monocarboxylic acids. Esters of the former type include, for example, the esters of dicarboxylic acids such as phthalic acid, succinic acid, alkyl succinic acid, alkenyl succinic acid, maleic acid, azelaic acid, suberic acid, sebacic acid, fumaric acid, adipic acid, linoleic acid dimer, malonic acid, alkyl malonic acid, alkenyl malonic acid, etc., with a variety of alcohols such as butyl alcohol, hexyl alcohol, dodecyl alcohol, 2-ethylhexyl alcohol, etc. Specific examples of these types of esters include dibutyl adipate, di(2-ethylhexyl) sebacate, di-n-hexyl fumarate, dioctyl sebacate, diisooctyl azelate, diisodecyl azelate, dioctyl phthalate, didecyl phthalate, dicicosyl sebacate, etc.

[0068] Particularly useful synthetic esters are those which are obtained by reacting one or more polyhydric alcohols, preferably the hindered polyols (such as the neopentyl polyols, e.g., neopentyl glycol, trimethylol ethane, 2-methyl-2-propyl-1,3-propanediol, trimethylol propane, pentaerythritol and dipentaerythritol) with alkanoic acids containing at least 4 carbon atoms, preferably C₅ to C₃₀ acids such as saturated straight chain fatty acids including caprylic acid, capric acid, lauric acid, myristic acid, palmitic acid, stearic acid, arachic acid, and behenic acid, or the corresponding branched chain fatty acids or unsaturated fatty acids such as oleic acid, or mixtures of any of these materials.

[0069] Suitable synthetic ester components include the esters of trimethylol propane, trimethylol butane, trimethylol ethane, pentaerythritol and/or dipentaerythritol with one or more monocarboxylic acids containing from 5 to 10 carbon atoms. These esters are widely available commercially, for example, the Mobil P-41 and P-51 esters of ExxonMobil Chemical Company).

[0070] Other useful fluids of lubricating viscosity include non-conventional or unconventional base stocks that have been processed, preferably catalytically, or synthesized to provide high performance lubrication characteristics.

[0071] Non-conventional or unconventional base stocks/base oils include one or more of a mixture of base stock(s) derived from one or more Gas-to-Liquids (GTL) materials, as well as isomerate/isodewaxate base stock(s) derived from natural wax or waxy feeds, mineral and or non-mineral oil waxy feed stocks such as slack waxes, natural waxes, and waxy stocks such as gas oils,

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waxy fuels hydrocracker bottoms, waxy raffinate, hydrocrackate, thermal crackates, or other mineral, mineral oil, or even non-petroleum oil derived waxy materials such as waxy materials received from coal liquefaction or shale oil, and mixtures of such base stocks.

[0072] GTL materials are materials that are derived via one or more synthesis, combination, transformation, rearrangement, and/or degradation/deconstructive processes from gaseous carbon-containing compounds, hydrogen-containing compounds and/or elements as feed stocks such as hydrogen, carbon dioxide, carbon monoxide, water, methane, ethane, ethylene, acetylene, propane, propylene, propyne, butane, butylenes, and butynes. GTL base stocks and/or base oils are GTL materials of lubricating viscosity that are generally derived from hydrocarbons; for example, waxy synthesized hydrocarbons, that are themselves derived from simpler gaseous carbon-containing compounds, hydrogen-containing compounds and/or elements as feed stocks. GTL base stock(s) and/or base oil(s) include oils boiling in the lube oil boiling range (1) separated/fractionated from synthesized GTL materials such as, for example, by distillation and subsequently subjected to a final wax processing step which involves either or both of a catalytic dewaxing process, or a solvent dewaxing process, to produce lube oils of reduced/low pour point; (2) synthesized wax isomerates, comprising, for example, hydrodewaxed or hydroisomerized cat and/or solvent dewaxed synthesized wax or waxy hydrocarbons; (3) hydrodewaxed or hydroisomerized cat and/or solvent dewaxed Fischer-Tropsch (F-T) material (i.e., hydrocarbons, waxy hydrocarbons, waxes and possible analogous oxygenates); preferably hydrodewaxed or hydroisomerized/followed by cat and/or solvent dewaxing dewaxed F-T waxy hydrocarbons, or hydrodewaxed or hydroisomerized/followed by cat (or solvent) dewaxing dewaxed, F-T waxes, or mixtures thereof.

[0073] GTL base stock(s) and/or base oil(s) derived from GTL materials, especially, hydrodewaxed or hydroisomerized/followed by cat and/or solvent dewaxed wax or waxy feed, preferably F-T material derived base stock(s) and/or base oil(s), are characterized typically as having kinematic viscosities at 100°C of from 2 mm²/s to 50 mm²/s (ASTM D445). They are further characterized typically as having pour points of -5°C to -40°C or lower (ASTM D97). They are also characterized typically as having viscosity indices of 80 to 140 or greater (ASTM D2270).

[0074] In addition, the GTL base stock(s) and/or base oil(s) are typically highly paraffinic (>90% saturates), and may contain mixtures of monocycloparaffins and multicycloparaffins in combination with non-cyclic isoparaffins. The ratio of the naphthenic (i.e., cycloparaffin) content in such combinations varies with the catalyst and temperature used. Further, GTL base stock(s) and/or base oil(s) typically have very low sulfur and nitrogen content, generally containing less than 10 ppm, and more typically less than 5 ppm of each of these elements. The sulfur and nitrogen content of GTL base stock(s) and/or base oil(s) obtained from F-T material, especially F-T wax, is

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essentially nil. In addition, the absence of phosphorous and aromatics make this material especially suitable for the formulation of low SAP products.

[0075] The term GTL base stock and/or base oil and/or wax isomerate base stock and/or base oil is to be understood as embracing individual fractions of such materials of wide viscosity range as recovered in the production process, mixtures of two or more of such fractions, as well as mixtures of one or two or more low viscosity fractions with one, two or more higher viscosity fractions to produce a blend wherein the blend exhibits a target kinematic viscosity.

[0076] The GTL material, from which the GTL base stock(s) and/or base oil(s) is/are derived is preferably an F-T material (i.e., hydrocarbons, waxy hydrocarbons, wax).

[0077] In addition, the GTL base stock(s) and/or base oil(s) are typically highly paraffinic (>90% saturates), and may contain mixtures of monocycloparaffins and multicycloparaffins in combination with non-cyclic isoparaffins. The ratio of the naphthenic (i.e., cycloparaffin) content in such combinations varies with the catalyst and temperature used. Further, GTL base stock(s) and/or base oil(s) and hydrodewaxed, or hydroisomerized/cat (and/or solvent) dewaxed base stock(s) and/or base oil(s) typically have very low sulfur and nitrogen content, generally containing less than 10 ppm, and more typically less than 5 ppm of each of these elements. The sulfur and nitrogen content of GTL base stock(s) and/or base oil(s) obtained from F-T material, especially F-T wax, is essentially nil. In addition, the absence of phosphorous and aromatics make this material especially suitable for the formulation of low sulfur, sulfated ash, and phosphorus (low SAP) products.

[0078] Base oils for use in the formulated lubricating oils useful in the present disclosure are any of the variety of oils corresponding to API Group I, Group II, Group III, Group IV, and Group V oils and mixtures thereof, preferably API Group II, Group III, Group IV, and Group V oils and mixtures thereof, more preferably the Group III to Group V base oils due to their exceptional volatility, stability, viscometric and cleanliness features. Minor quantities of Group I stock, such as the amount used to dilute additives for blending into formulated lube oil products, can be tolerated but should be kept to a minimum, i.e. amounts only associated with their use as diluents/carrier oil for additives used on an "as-received" basis. Even in regard to the Group II stocks, it is preferred that the Group II stock be in the higher quality range associated with that stock, i.e. a Group II stock having a viscosity index in the range $100 < VI < 120$.

[0079] The base oil constitutes the major component of the engine oil lubricant composition of the present disclosure and typically is present in an amount ranging from 50 to 99 weight percent, preferably from 70 to 95 weight percent, and more preferably from 85 to 95 weight percent, based on the total weight of the composition. The base oil may be selected from any of the synthetic or

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natural oils typically used as crankcase lubricating oils for spark-ignited and compression-ignited engines. The base oil conveniently has a kinematic viscosity, according to ASTM standards, of 2.5 cSt to 12 cSt (or mm² /s) at 100°C and preferably of 2.5 cSt to 9 cSt (or mm²/s) at 100°C. Mixtures of synthetic and natural base oils may be used if desired.

Lubricating Oil Additives Having at Least One Protected Active Group

[0080] This disclosure provides one or more lubricating oil additives having at least one protected active group. The one or more lubricating oil additives having at least one protected active group are inactive with respect to their innate performance function. The one or more lubricating oil additives having at least one protected active group are converted into one or more lubricating oil additives having at least one unprotected active group in the lubricating oil in-service in an engine or other mechanical component.

[0081] The one or more lubricating oil additives having at least one protected active group are converted to one or more lubricating oil additives having at least one unprotected active group in the lubricating oil in-service in the engine or other mechanical component at a temperature greater than or equal to 110°C, or by reaction with free acids that catalyze the release of a unprotected active group at a temperature greater than or equal to ambient temperature.

[0082] Illustrative unprotected active groups include, for example, an –OH group, a –NH group, and the like.

[0083] Illustrative protected active groups include, for example, a carbonate, a carbamate, an acetal, an ester, an amide, a urea, an alkoxysilane, an alkylsilane, a phosphite, a phosphonate, a phosphate, a sulfonamide, a sulfonate, a sulfate, and the like.

[0084] Protection methods for the one or more lubricating oil additives having at least one protected active group can include, for example, chemical protection. Illustrative chemical protection includes, for example, converting an unprotected –OH group or –NH group to a protected carbonate, carbamate, acetal, ester, amide, urea, alkoxysilane, alkylsilane, phosphite, phosphonate, phosphate, sulfonamide, sulfonate, or sulfate group.

[0085] Deprotection methods for converting one or more lubricating oil additives having at least one protected active group to one or more lubricating oil additives having at least one unprotected active group include chemical deprotection.

[0086] Illustrative chemical deprotection methods include, for example, converting a protected carbonate, carbamate, acetal, ester, amide, urea, alkoxysilane, alkylsilane, phosphite, phosphonate, phosphate, sulfonamide, sulfonate, or sulfate group to an unprotected –OH group or –NH group.

[0087] Preferred lubricating oil additives having at least one protected active group include a protected phenolic antioxidant, a protected aminic antioxidant, a protected alkane diol friction modifier, a protected ester diol friction modifier, or a protected Mannich dispersant.

[0088] Illustrative lubricating oil additives having at least one protected active group comprise a protected phenolic antioxidant comprising di-*tert*-butyl (methylenebis(2,6-di-*tert*-butyl-4,1-phenylene)) bis(carbonate) derived from a hindered bisphenol such as, but not limited to, Ethanox™ 4702, or *tert*-butyl carbonate of 3,5-di-*tert*-butyl-4-hydroxyphenylpropionic alkyl ester derived from a hindered monophenol such as Irganox™ L135 or Irganox™ 1076, a protected aminic antioxidant comprising *tert*-butyl diaryl carbamate derived from a substituted (or unsubstituted) diarylamine such as, but not limited to, Irganox™ L57 or Irganox™ L06, a protected alkane diol friction modifier comprising *tert*-butyl octadecane-1,3-diyl dicarbonate or Vikinol™ 18 bis(carbonate), a protected ester diol friction modifier comprising glycerol monostearate bis(carbonate), a protected Mannich dispersant comprising a Mannich dispersant having a *tert*-butyl carbonate group, and the like.

[0089] The lubricating oils of this disclosure can further include one or more lubricating oil additives having at least one unprotected active group. Illustrative of such lubricating oil additives having at least one unprotected active group include, for example, an unprotected viscosity improver, an unprotected antioxidant, an unprotected detergent, an unprotected dispersant, an unprotected pour point depressant, an unprotected corrosion inhibitor, an unprotected friction modifier, an unprotected antiwear agent, an unprotected extreme pressure additive, an unprotected metal deactivator, an unprotected seal compatibility additive, an unprotected anti-foam agent, an unprotected inhibitor, an unprotected anti-rust additive, and the like.

[0090] In the lubricating oils of this disclosure, the one or more lubricating oil additives can be present in an amount from about 0.1 weight percent to about 10 weight percent or greater, preferably from about 0.25 weight percent to about 8 weight percent, more preferably from about 0.5 weight percent to about 5 weight percent, more preferably from about 0.75 weight percent to about 3 weight percent, and more preferably from about 1 weight percent to about 2 weight percent, based on the total weight of the lubricating oil.

Other Additives

[0091] The formulated lubricating oil useful in the present disclosure may additionally contain one or more of the other commonly used lubricating oil performance additives including but not limited to dispersants, detergents, corrosion inhibitors, rust inhibitors, metal deactivators, other anti-wear agents and/or extreme pressure additives, anti-seizure agents, wax modifiers, viscosity index improvers, viscosity modifiers, fluid-loss additives, seal compatibility agents, friction

modifiers, lubricity agents, anti-staining agents, chromophoric agents, defoamants, demulsifiers, emulsifiers, densifiers, wetting agents, gelling agents, tackiness agents, colorants, and others. For a review of many commonly used additives, see Klamann in *Lubricants and Related Products*, Verlag Chemie, Deerfield Beach, FL; ISBN 0-89573-177-0. Reference is also made to "Lubricant Additives" by M. W. Ranney, published by Noyes Data Corporation of Parkridge, NJ (1973).

[0092] The types and quantities of performance additives used in combination with the instant disclosure in lubricant compositions are not limited by the examples shown herein as illustrations.

Friction Modifiers

[0093] A friction modifier is any material or materials that can alter the coefficient of friction of a surface lubricated by any lubricant or fluid containing such material(s). Friction modifiers, also known as friction reducers, or lubricity agents or oiliness agents, and other such agents that change the ability of base oils, formulated lubricant compositions, or functional fluids, to modify the coefficient of friction of a lubricated surface may be effectively used in combination with the base oils or lubricant compositions of the present disclosure if desired. Friction modifiers that lower the coefficient of friction are particularly advantageous in combination with the base oils and lube compositions of this disclosure. Friction modifiers may include metal-containing compounds or materials as well as ashless compounds or materials, or mixtures thereof. Metal-containing friction modifiers may include metal salts or metal ligand complexes where the metals may include alkali, alkaline earth, or transition group metals. Such metal-containing friction modifiers may also have low-ash characteristics. Transition metals may include Mo, Sb, Sn, Fe, Cu, Zn, and others. Ligands may include hydrocarbyl derivative of alcohols, polyols, glycerols, partial ester glycerols, thiols, carboxylates, carbamates, thiocarbamates, dithiocarbamates, phosphates, thiophosphates, dithiophosphates, amides, imides, amines, thiazoles, thiadiazoles, dithiazoles, diazoles, triazoles, and other polar molecular functional groups containing effective amounts of O, N, S, or P, individually or in combination. In particular, Mo-containing compounds can be particularly effective such as for example Mo-dithiocarbamates, Mo(DTC), Mo-dithiophosphates, Mo(DTP), Mo-amines, Mo (Am), Mo-alcoholates, Mo-alcohol-amides, etc. See U.S. Patent Nos. 5,824,627, 6,232,276, 6,153,564, 6,143,701, 6,110,878, 5,837,657, 6,010,987, 5,906,968, 6,734,150, 6,730,638, 6,689,725, 6,569,820; WO 99/66013; WO 99/47629; and WO 98/26030.

[0094] Ashless friction modifiers may also include lubricant materials that contain effective amounts of polar groups, for example, hydroxyl-containing hydrocarbyl base oils, glycerides, partial glycerides, glyceride derivatives, and the like. Polar groups in friction modifiers may include hydrocarbyl groups containing effective amounts of O, N, S, or P, individually or in

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combination. Other friction modifiers that may be particularly effective include, for example, salts (both ash-containing and ashless derivatives) of fatty acids, fatty alcohols, fatty amides, fatty esters, hydroxyl-containing carboxylates, and comparable synthetic long-chain hydrocarbyl acids, alcohols, amides, esters, hydroxy carboxylates, and the like. In some instances fatty organic acids, fatty amines, and sulfurized fatty acids may be used as suitable friction modifiers.

[0095] Useful concentrations of friction modifiers may range from 0.01 weight percent to 10-15 weight percent or more, often with a preferred range of 0.1 weight percent to 5 weight percent. Concentrations of molybdenum-containing materials are often described in terms of Mo metal concentration. Advantageous concentrations of Mo may range from 10 ppm to 3000 ppm or more, and often with a preferred range of 20-2000 ppm, and in some instances a more preferred range of 30-1000 ppm. Friction modifiers of all types may be used alone or in mixtures with the materials of this disclosure. Often mixtures of two or more friction modifiers, or mixtures of friction modifier(s) with alternate surface active material(s), are also desirable.

Antioxidants

[0096] Antioxidants retard the oxidative degradation of base oils during service. Such degradation may result in deposits on metal surfaces, the presence of sludge, or a viscosity increase in the lubricant. One skilled in the art knows a wide variety of oxidation inhibitors that are useful in lubricating oil compositions. See, Klamann in *Lubricants and Related Products*, op cite, and U.S. Patent Nos. 4,798,684 and 5,084,197, for example.

[0097] Useful antioxidants include hindered phenols. These phenolic antioxidants may be ashless (metal-free) phenolic compounds or neutral or basic metal salts of certain phenolic compounds. Typical phenolic antioxidant compounds are the hindered phenolics which are the ones which contain a sterically hindered hydroxyl group, and these include those derivatives of dihydroxy aryl compounds in which the hydroxyl groups are in the o- or p-position to each other. Typical phenolic antioxidants include the hindered phenols substituted with C₆+ alkyl groups and the alkylene coupled derivatives of these hindered phenols. Examples of phenolic materials of this type 2-*t*-butyl-4-heptyl phenol; 2-*t*-butyl-4-octyl phenol; 2-*t*-butyl-4-dodecyl phenol; 2,6-di-*t*-butyl-4-heptyl phenol; 2,6-di-*t*-butyl-4-dodecyl phenol; 2-methyl-6-*t*-butyl-4-heptyl phenol; and 2-methyl-6-*t*-butyl-4-dodecyl phenol. Other useful hindered mono-phenolic antioxidants may include for example hindered 2,6-di-alkyl-phenolic propionic ester derivatives. Bis-phenolic antioxidants may also be advantageously used in combination with the instant disclosure. Examples of ortho-coupled phenols include: 2,2'-bis(4-heptyl-6-*t*-butyl phenol); 2,2'-bis(4-octyl-6-*t*-butyl-phenol); and 2,2'-bis(4-dodecyl-6-*t*-butyl-phenol). Para-coupled bisphenols include for example 4,4'-bis(2,6-di-*t*-butyl phenol) and 4,4'-methylene-bis(2,6-di-*t*-butyl phenol).

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[0098] Non-phenolic oxidation inhibitors which may be used include aromatic amine antioxidants and these may be used either as such or in combination with phenolics. Typical examples of non-phenolic antioxidants include: alkylated and non-alkylated aromatic amines such as aromatic monoamines of the formula $R^8R^9R^{10}N$ where R^8 is an aliphatic, aromatic or substituted aromatic group, R^9 is an aromatic or a substituted aromatic group, and R^{10} is H, alkyl, aryl or $R^{11}S(O)_xR^{12}$ where R^{11} is an alkylene, alkenylene, or aralkylene group, R^{12} is a higher alkyl group, or an alkenyl, aryl, or alkaryl group, and x is 0, 1 or 2. The aliphatic group R^8 may contain from 1 to 20 carbon atoms, and preferably contains from 6 to 12 carbon atoms. The aliphatic group is a saturated aliphatic group. Preferably, both R^8 and R^9 are aromatic or substituted aromatic groups, and the aromatic group may be a fused ring aromatic group such as naphthyl. Aromatic groups R^8 and R^9 may be joined together with other groups such as S.

[0099] Typical aromatic amines antioxidants have alkyl substituent groups of at least 6 carbon atoms. Examples of aliphatic groups include hexyl, heptyl, octyl, nonyl, and decyl. Generally, the aliphatic groups will not contain more than 14 carbon atoms. The general types of amine antioxidants useful in the present compositions include diphenylamines, phenyl naphthylamines, phenothiazines, imidodibenzyls and diphenyl phenylene diamines. Mixtures of two or more aromatic amines are also useful. Polymeric amine antioxidants can also be used. Particular examples of aromatic amine antioxidants useful in the present disclosure include: *p,p'*-dioctyldiphenylamine; *t*-octylphenyl- α -naphthylamine; phenyl- α -naphthylamine; and *p*-octylphenyl- α -naphthylamine.

[00100] Sulfurized alkyl phenols and alkali or alkaline earth metal salts thereof also are useful antioxidants.

[00101] Preferred antioxidants include hindered phenols, arylamines. These antioxidants may be used individually by type or in combination with one another. Such additives may be used in an amount of 0.01 to 5 weight percent, preferably 0.01 to 2.5 weight percent, more preferably 0.01 to 1.5 weight percent.

Dispersants

[00102] During engine operation, oil-insoluble oxidation byproducts are produced. Dispersants help keep these byproducts in solution, thus diminishing their deposition on metal surfaces. Dispersants used in the formulation of the lubricating oil may be ashless or ash-forming in nature. Preferably, the dispersant is ashless. So-called ashless dispersants are organic materials that form substantially no ash upon combustion. For example, non-metal-containing or borated metal-free dispersants are considered ashless. In contrast, metal-containing detergents discussed above form ash upon combustion.

[00103] Suitable dispersants typically contain a polar group attached to a relatively high molecular weight hydrocarbon chain. The polar group typically contains at least one element of nitrogen, oxygen, or phosphorus. Typical hydrocarbon chains contain 50 to 400 carbon atoms.

[00104] Chemically, many dispersants may be characterized as phenates, sulfonates, sulfurized phenates, salicylates, naphthenates, stearates, carbamates, thiocarbamates, phosphorus derivatives. A particularly useful class of dispersants are the alkenylsuccinic derivatives, typically produced by the reaction of a long chain hydrocarbyl substituted succinic compound, usually a hydrocarbyl substituted succinic anhydride, with a polyhydroxy or polyamino compound. The long chain hydrocarbyl group constituting the oleophilic portion of the molecule which confers solubility in the oil, is normally a polyisobutylene group. Many examples of this type of dispersant are well known commercially and in the literature. Exemplary U.S. patents describing such dispersants are U.S. Patent Nos. 3,172,892; 3,215,707; 3,219,666; 3,316,177; 3,341,542; 3,444,170; 3,454,607; 3,541,012; 3,630,904; 3,632,511; 3,787,374 and 4,234,435. Other types of dispersant are described in U.S. Patent Nos. 3,036,003; 3,200,107; 3,254,025; 3,275,554; 3,438,757; 3,454,555; 3,565,804; 3,413,347; 3,697,574; 3,725,277; 3,725,480; 3,726,882; 4,454,059; 3,329,658; 3,449,250; 3,519,565; 3,666,730; 3,687,849; 3,702,300; 4,100,082; 5,705,458. A further description of dispersants may be found, for example, in European Patent Application No. 471 071, to which reference is made for this purpose.

[00105] Hydrocarbyl-substituted succinic acid and hydrocarbyl-substituted succinic anhydride derivatives are useful dispersants. In particular, succinimide, succinate esters, or succinate ester amides prepared by the reaction of a hydrocarbon-substituted succinic acid compound preferably having at least 50 carbon atoms in the hydrocarbon substituent, with at least one equivalent of an alkylene amine are particularly useful.

[00106] Succinimides are formed by the condensation reaction between hydrocarbyl substituted succinic anhydrides and amines. Molar ratios can vary depending on the polyamine. For example, the molar ratio of hydrocarbyl substituted succinic anhydride to TEPA can vary from 1:1 to 5:1. Representative examples are shown in U.S. Patent Nos. 3,087,936; 3,172,892; 3,219,666; 3,272,746; 3,322,670; and 3,652,616, 3,948,800; and Canada Patent No. 1,094,044.

[00107] Succinate esters are formed by the condensation reaction between hydrocarbyl substituted succinic anhydrides and alcohols or polyols. Molar ratios can vary depending on the alcohol or polyol used. For example, the condensation product of a hydrocarbyl substituted succinic anhydride and pentaerythritol is a useful dispersant.

[00108] Succinate ester amides are formed by condensation reaction between hydrocarbyl substituted succinic anhydrides and alkanol amines. For example, suitable alkanol amines include

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ethoxylated polyalkylpolyamines, propoxylated polyalkylpolyamines and polyalkenylpolyamines such as polyethylene polyamines. One example is propoxylated hexamethylenediamine. Representative examples are shown in U.S. Patent No. 4,426,305.

[00109] The molecular weight of the hydrocarbyl substituted succinic anhydrides used in the preceding paragraphs will typically range between 800 and 2,500. The above products can be post-reacted with various reagents such as sulfur, oxygen, formaldehyde, carboxylic acids such as oleic acid. The above products can also be post reacted with boron compounds such as boric acid, borate esters or highly borated dispersants, to form borated dispersants generally having from 0.1 to 5 moles of boron per mole of dispersant reaction product.

[00110] Mannich base dispersants are made from the reaction of alkylphenols, formaldehyde, and amines. See U.S. Patent No. 4,767,551, which is incorporated herein by reference. Process aids and catalysts, such as oleic acid and sulfonic acids, can also be part of the reaction mixture. Molecular weights of the alkylphenols range from 800 to 2,500. Representative examples are shown in U.S. Patent Nos. 3,697,574; 3,703,536; 3,704,308; 3,751,365; 3,756,953; 3,798,165; and 3,803,039.

[00111] Typical high molecular weight aliphatic acid modified Mannich condensation products useful in this disclosure can be prepared from high molecular weight alkyl-substituted hydroxyaromatics or HNR₂ group-containing reactants.

[00112] Hydrocarbyl substituted amine ashless dispersant additives are well known to one skilled in the art; see, for example, U.S. Patent Nos. 3,275,554; 3,438,757; 3,565,804; 3,755,433, 3,822,209, and 5,084,197.

[00113] Preferred dispersants include borated and non-borated succinimides, including those derivatives from mono-succinimides, bis-succinimides, and/or mixtures of mono- and bis-succinimides, wherein the hydrocarbyl succinimide is derived from a hydrocarbylene group such as polyisobutylene having a Mn of from 500 to 5000 or a mixture of such hydrocarbylene groups. Other preferred dispersants include succinic acid-esters and amides, alkylphenol-polyamine-coupled Mannich adducts, their capped derivatives, and other related components. A preferred dispersant is polyisobutylene succinimide polyamine (PIBSA-PAM). Such additives may be used in an amount of 0.1 to 20 weight percent, preferably 0.5 to 8 weight percent.

Detergents

[00114] A typical detergent is an anionic material that contains a long chain hydrophobic portion of the molecule and a smaller anionic or oleophobic hydrophilic portion of the molecule. The anionic portion of the detergent is typically derived from an organic acid such as a sulfur acid,

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carboxylic acid, phosphorous acid, phenol, or mixtures thereof. The counterion is typically an alkaline earth or alkali metal.

[00115] Salts that contain a substantially stoichiometric amount of the metal are described as neutral salts and have a total base number (TBN, as measured by ASTM D2896) of from 0 to 80. Many compositions are overbased, containing large amounts of a metal base that is achieved by reacting an excess of a metal compound (a metal carbonate, hydroxide or oxide, for example) with an acidic gas (such as carbon dioxide). Useful detergents can be neutral, mildly overbased, or highly overbased.

[00116] It is desirable for at least some detergent to be overbased. Overbased detergents help neutralize acidic impurities produced by the combustion process and become entrapped in the oil. Typically, the overbased material has a ratio of metallic ion to anionic portion of the detergent of 1.05:1 to 50:1 on an equivalent basis. More preferably, the ratio is from 4:1 to 25:1. The resulting detergent is an overbased detergent that will typically have a TBN of 150 or higher, often 250 to 450 or more. Preferably, the overbasing cation is sodium, calcium, or magnesium. A mixture of detergents of differing TBN can be used in the present disclosure.

[00117] Preferred detergents include the alkali or alkaline earth metal salts of sulfonates, phenates, carboxylates, phosphates, and salicylates, e.g., a mixture of magnesium sulfonate and calcium salicylate.

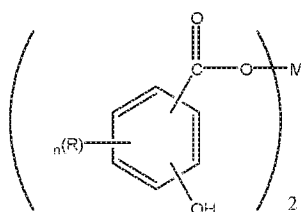
[00118] Sulfonates may be prepared from sulfonic acids that are typically obtained by sulfonation of alkyl substituted aromatic hydrocarbons. Hydrocarbon examples include those obtained by alkylating benzene, toluene, xylene, naphthalene, biphenyl and their halogenated derivatives (chlorobenzene, chlorotoluene, and chloronaphthalene, for example). The alkylating agents typically have 3 to 70 carbon atoms. The alkaryl sulfonates typically contain 9 to 80 carbon or more carbon atoms, more typically from 16 to 60 carbon atoms.

[00119] Alkaline earth phenates are another useful class of detergent. These detergents can be made by reacting alkaline earth metal hydroxide or oxide (CaO , Ca(OH)_2 , BaO , Ba(OH)_2 , MgO , Mg(OH)_2 , for example) with an alkyl phenol or sulfurized alkylphenol. Useful alkyl groups include straight chain or branched C_1 - C_{30} alkyl groups, preferably, C_4 - C_{20} . Examples of suitable phenols include isobutylphenol, 2-ethylhexylphenol, nonylphenol, dodecyl phenol, and the like. It should be noted that starting alkylphenols may contain more than one alkyl substituent that are each independently straight chain or branched. When a non-sulfurized alkylphenol is used, the sulfurized product may be obtained by methods well known in the art. These methods include heating a mixture of alkylphenol and sulfurizing agent (including elemental sulfur, sulfur halides

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such as sulfur dichloride, and the like) and then reacting the sulfurized phenol with an alkaline earth metal base.

[00120] Metal salts of carboxylic acids are also useful as detergents. These carboxylic acid detergents may be prepared by reacting a basic metal compound with at least one carboxylic acid and removing free water from the reaction product. These compounds may be overbased to produce the desired TBN level. Detergents made from salicylic acid are one preferred class of detergents derived from carboxylic acids. Useful salicylates include long chain alkyl salicylates. One useful family of compositions is of the formula



where R is an alkyl group having 1 to 30 carbon atoms, n is an integer from 1 to 4, and M is an alkaline earth metal. Preferred R groups are alkyl chains of at least C₁₁, preferably C₁₃ or greater. R may be optionally substituted with substituents that do not interfere with the detergent's function. M is preferably, calcium, magnesium, or barium. More preferably, M is calcium.

[00121] Hydrocarbyl-substituted salicylic acids may be prepared from phenols by the Kolbe reaction (see U.S. Patent No. 3,595,791). The metal salts of the hydrocarbyl-substituted salicylic acids may be prepared by double decomposition of a metal salt in a polar solvent such as water or alcohol.

[00122] Alkaline earth metal phosphates are also used as detergents and are known in the art.

[00123] Detergents may be simple detergents or what is known as hybrid or complex detergents. The latter detergents can provide the properties of two detergents without the need to blend separate materials. See U.S. Patent No. 6,034,039.

[00124] Preferred detergents include calcium phenates, calcium sulfonates, calcium salicylates, magnesium phenates, magnesium sulfonates, magnesium salicylates and other related components (including borated detergents) in any combination. A preferred detergent includes magnesium sulfonate and calcium salicylate.

[00125] The detergent concentration in the lubricating oils of this disclosure can range from 1.0 to 6.0 weight percent, preferably 2.0 to 5.0 weight percent, and more preferably from 2.0 weight percent to 4.0 weight percent, based on the total weight of the lubricating oil.

Anti-Wear Additives

[00126] A metal alkylthiophosphate and more particularly a metal dialkyl dithio phosphate in which the metal constituent is zinc, or zinc dialkyl dithio phosphate (ZDDP) is a component of the lubricating oils of this disclosure. ZDDP can be primary, secondary or mixtures thereof. ZDDP compounds generally are of the formula $\text{Zn}[\text{SP}(\text{S})(\text{OR}^1)(\text{OR}^2)]_2$ where R^1 and R^2 are C_1 - C_{18} alkyl groups, preferably C_2 - C_{12} alkyl groups. These alkyl groups may be straight chain or branched.

[00127] Preferable zinc dithiophosphates which are commercially available include secondary zinc dithiophosphates such as those available from for example, The Lubrizol Corporation under the trade designations "LZ 677A", "LZ 1095" and "LZ 1371", from for example Chevron Oronite under the trade designation "OLOA 262" and from for example Afton Chemical under the trade designation "HITEC 7169".

[00128] The ZDDP is typically used in amounts of from 0.4 weight percent to 1.2 weight percent, preferably from 0.5 weight percent to 1.0 weight percent, and more preferably from 0.6 weight percent to 0.8 weight percent, based on the total weight of the lubricating oil, although more or less can often be used advantageously. Preferably, the ZDDP is a secondary ZDDP and present in an amount of from 0.6 to 1.0 weight percent of the total weight of the lubricating oil.

[00129] ZDDP is one of the most successful anti-wear additives ever used in lubricants. This additive is fairly cost effective and provides exceptionally durable anti-wear tribofilms on ferrous surfaces under extreme lubrication conditions. ZDDP forms protective films on ferrous surfaces within a very short period of time. This additive forms pad-like polymeric tribofilms at the rubbing contact and thus prevents wear. It is believed that ZDDP undergoes thermal decomposition at the tribological contact followed by the reactions with reactive iron surfaces or iron oxides that forms glassy phosphate films. These films contain minimal iron meaning that the formation of tribofilm requires minimal loss of iron from the rubbed surfaces. The chain lengths of the phosphate decreases with the depth of the tribofilm and the layers near the surface were mostly dominated by iron sulphides and iron oxides.

[00130] Using an optical interferometry technique, it has been demonstrated that the formation of ZDDP tribofilm takes several tens of minutes. The friction coefficients during the film formation period initially increases and then gradually decreases and finally reaches to steady state. The increase of friction is a result of initial wear (adhesive/abrasive wear) that generates enough nascent iron to react with the thermally decomposed ZDDP. As soon as the ZDDP tribofilm starts to dominate the contact between two interacting surfaces, friction starts to decrease. Since the film formation of ZDDP is primarily influenced by the initial wear, the nature of wear influences the uniformity as well as growth rate of ZDDP tribofilm to a great extent.

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[00131] Uniform anti-wear tribofilms are desirable over the non-uniform patchy tribofilms. This is because the uniform tribofilm can resist the applied load more uniformly and thereby generates distributed stresses within the tribofilm. In contrast, in the case of non-uniform tribofilms, the applied load is mainly taken by the high spots resulting in more concentrated stresses and thereby causing more failure of tribofilms. This disclosure reveals that NGP materials enable the formation of uniform ZDDP tribofilms by controlling the initial wear process.

Pour Point Depressants (PPDs)

[00132] Conventional pour point depressants (also known as lube oil flow improvers) may be added to the compositions of the present disclosure if desired. These pour point depressant may be added to lubricating compositions of the present disclosure to lower the minimum temperature at which the fluid will flow or can be poured. Examples of suitable pour point depressants include polymethacrylates, polyacrylates, polyarylamides, condensation products of haloparaffin waxes and aromatic compounds, vinyl carboxylate polymers, and terpolymers of dialkylfumarates, vinyl esters of fatty acids and allyl vinyl ethers. U.S. Patent Nos. 1,815,022; 2,015,748; 2,191,498; 2,387,501; 2,655,479; 2,666,746; 2,721,877; 2,721,878; and 3,250,715 describe useful pour point depressants and/or the preparation thereof. Such additives may be used in an amount of 0.01 to 5 weight percent, preferably 0.01 to 1.5 weight percent.

Seal Compatibility Agents

[00133] Seal compatibility agents help to swell elastomeric seals by causing a chemical reaction in the fluid or physical change in the elastomer. Suitable seal compatibility agents for lubricating oils include organic phosphates, aromatic esters, aromatic hydrocarbons, esters (butylbenzyl phthalate, for example), and polybutenyl succinic anhydride. Such additives may be used in an amount of 0.01 to 3 weight percent, preferably 0.01 to 2 weight percent.

Antifoam Agents

[00134] Anti-foam agents may advantageously be added to lubricant compositions. These agents retard the formation of stable foams. Silicones and organic polymers are typical anti-foam agents. For example, polysiloxanes, such as silicon oil or polydimethyl siloxane, provide antifoam properties. Anti-foam agents are commercially available and may be used in conventional minor amounts along with other additives such as demulsifiers; usually the amount of these additives combined is less than 1 weight percent and often less than 0.1 weight percent.

Viscosity Index Improvers

[00135] Viscosity index improvers (also known as VI improvers, viscosity modifiers, and viscosity improvers) can be included in the lubricant compositions of this disclosure. Preferably, the method of this disclosure obtains improvements in fuel economy without sacrificing durability

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by a reduction of high-temperature high-shear (HTHS) viscosity to a level lower than 2.6 cP through reduction or removal of viscosity index improvers or modifiers.

[00136] Viscosity index improvers provide lubricants with high and low temperature operability. These additives impart shear stability at elevated temperatures and acceptable viscosity at low temperatures.

[00137] Suitable viscosity index improvers include high molecular weight hydrocarbons, polyesters and viscosity index improver dispersants that function as both a viscosity index improver and a dispersant. Typical molecular weights of these polymers are between 10,000 and 1,500,000, more typically 20,000 and 1,200,000, and even more typically between 50,000 and 1,000,000.

[00138] Examples of suitable viscosity index improvers are linear or star-shaped polymers and copolymers of methacrylate, butadiene, olefins, or alkylated styrenes. Polyisobutylene is a commonly used viscosity index improver. Another suitable viscosity index improver is polymethacrylate (copolymers of various chain length alkyl methacrylates, for example), some formulations of which also serve as pour point depressants. Other suitable viscosity index improvers include copolymers of ethylene and propylene, hydrogenated block copolymers of styrene and isoprene, and polyacrylates (copolymers of various chain length acrylates, for example). Specific examples include styrene-isoprene or styrene-butadiene based polymers of 50,000 to 200,000 molecular weight.

[00139] Olefin copolymers, are commercially available from Chevron Oronite Company LLC under the trade designation "PARATONE®" (such as "PARATONE® 8921" and "PARATONE® 8941"); from Afton Chemical Corporation under the trade designation "HiTEC®" (such as "HiTEC® 5850B"); and from The Lubrizol Corporation under the trade designation "Lubrizol® 7067C". Polyisoprene polymers are commercially available from Infineum International Limited, e.g. under the trade designation "SV200"; diene-styrene copolymers are commercially available from Infineum International Limited, e.g. under the trade designation "SV 260".

[00140] In an embodiment of this disclosure, the viscosity index improvers may be used in an amount of less than 2.0 weight percent, preferably less than 1.0 weight percent, and more preferably less than 0.5 weight percent, based on the total weight of the formulated oil or lubricating engine oil.

[00141] In another embodiment of this disclosure, the viscosity index improvers may be used in an amount of from 0.0 to 2.0 weight percent, preferably 0.1 to 1.0 weight percent, and more preferably 0.2 to 0.5 weight percent, based on the total weight of the formulated oil or lubricating engine oil.

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[00142] When lubricating oil compositions contain one or more of the additives discussed above, the additive(s) are blended into the composition in an amount sufficient for it to perform its intended function. Typical amounts of such additives useful in the present disclosure are shown in Table A below.

[00143] It is noted that many of the additives are shipped from the additive manufacturer as a concentrate, containing one or more additives together, with a certain amount of base oil diluents. Accordingly, the weight amounts in the table below, as well as other amounts mentioned in this specification, are directed to the amount of active ingredient (that is the non-diluent portion of the ingredient). The weight percent (wt%) indicated below is based on the total weight of the lubricating oil composition.

TABLE 1
Typical Amounts of Other Lubricating Oil Components

Compound	Approximate wt% (Useful)	Approximate wt% (Preferred)
Dispersant	0.1-20	0.1-8
Detergent	1.0-6.0	2.0-4.0
Friction Modifier	0.01-5	0.01-1.5
Antioxidant	0.1-5	0.1-1.5
Pour Point Depressant (PPD)	0.0-5	0.01-1.5
Anti-foam Agent	0.001-3	0.001-0.15
Viscosity Index Improver (solid polymer basis)	0.0-2	0.0-1

[00144] The foregoing additives are all commercially available materials. These additives may be added independently but are usually precombined in packages which can be obtained from suppliers of lubricant oil additives. Additive packages with a variety of ingredients, proportions and characteristics are available and selection of the appropriate package will take the requisite use of the ultimate composition into account.

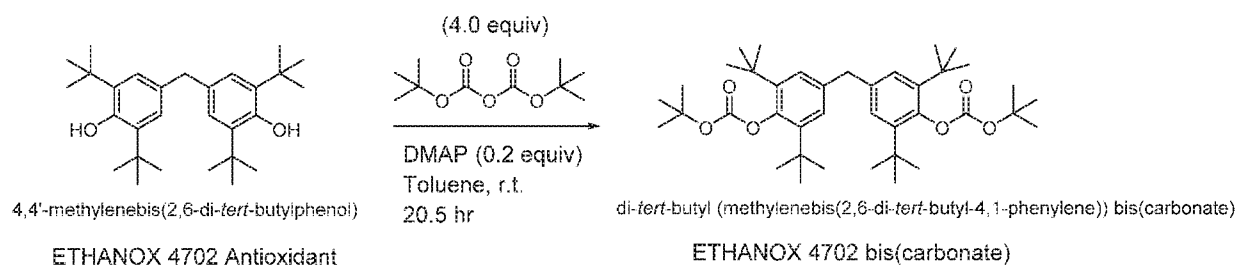
[00145] The following non-limiting examples are provided to illustrate the disclosure.

EXAMPLES

Example 1

Protection of hydroxyl groups in 4,4'-methylenebis(2,6-di-*tert*-butylphenol) with two *tert*-butyl carbonate groups

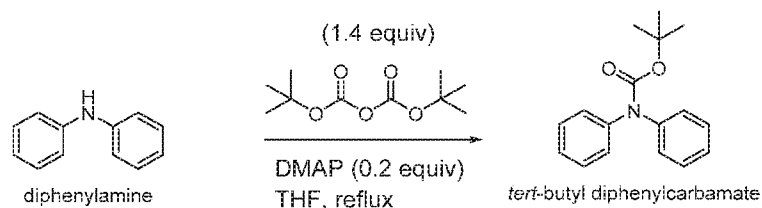
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[00146] To a solution of 4,4'-methylenebis(2,6-di-*tert*-butylphenol) (2.00 g, 4.71 mmol) and di-*tert*-butyl carbonate (4.157g, 19.05 mmol) in toluene (47 ml) was added 4-(dimethylamino)pyridine (0.1151 g, 0.9420 mmol) at room temperature. The resulting mixture was stirred at room temperature for 20 hours. The reaction was quenched by adding water and stirring at room temperature. The mixture was diluted with ethyl acetate and the organic phase was separated. The organic extract was then washed successively with 1N HCl, water, dilute aqueous sodium bicarbonate, water, brine, and then dried with anhydrous magnesium sulfate, filtered and concentrated on a rotary evaporator to afford a viscous yellow liquid as product. This crude product was further dried under high vacuum to afford a yellow crystalline solid. ¹H NMR (CDCl₃) indicated the desired bis(*tert*-butyl carbonate) product.

Example 2

Protection of amine group in diphenylamine antioxidant with a *tert*-butyl carbamate group

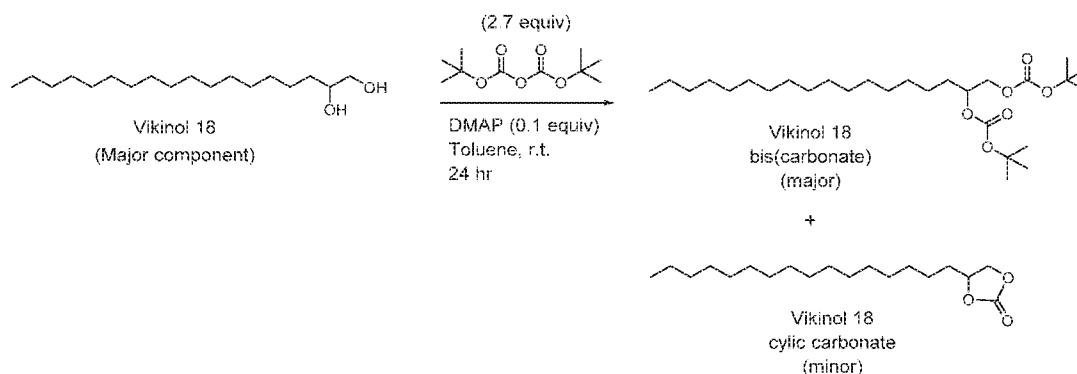


[00147] To a solution of diphenylamine (4.00 g, 23.64 mmol) and di-*tert*-butyl carbonate (7.223, 33.10 mmol) in tetrahydrofuran (25 ml) was added 4-(dimethylamino)pyridine (0.5776 g, 4.7274 mmol) at room temperature. The resulting mixture was heated at reflux for 4 hours and then at room temperature for 22 hours. The reaction was quenched by adding water and stirring at room temperature. The mixture was diluted with ethyl acetate and the organic phase was separated. The organic extract was then washed successively with 1N HCl, water, dilute aqueous sodium bicarbonate, water, brine, and then dried with anhydrous magnesium sulfate, filtered and concentrated on a rotary evaporator to afford a crude product.

Example 3

Protection of hydroxyl groups in octadecane-1,2-diol with carbonate groups

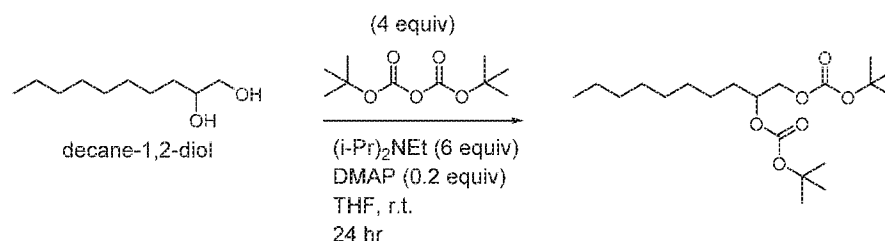
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[00148] To a mixture of Vikinol™ 18 (10.00 g, ~34.9 mmol) and di-*tert*-butyl dicarbonate (20.568 g, 94.24 mmol) in toluene (170 ml) was added dropwise a solution of 4-(dimethylamino)pyridine (0.4230 g, 3.491 mmol) in toluene (50 ml) over 35 minutes at room temperature. The resulting mixture was stirred at room temperature for 24 hours. The reaction was quenched by adding water and stirring at room temperature. The mixture was diluted with ethyl acetate and the organic phase was separated. The organic extract was then washed successively with 1N HCl, water, dilute aqueous sodium bicarbonate, brine, and then dried with anhydrous magnesium sulfate, filtered and concentrated on a rotary evaporator to afford a waxy solid (13.74 g) as product. ¹H NMR (CDCl₃) indicated the product was a mixture of the corresponding bis(*tert*-butyl carbonate) (major product) and cyclic carbonate (minor product) of Vikinol™ 18 in approximately 4:1 ratio.

Example 4

Protection of hydroxyl groups in decane-1,2-diol with carbonate groups



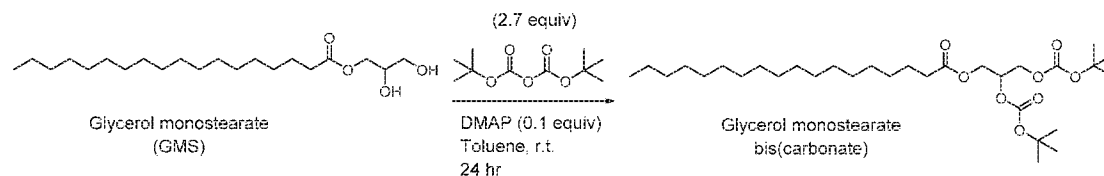
[00149] To a solution of decane-1,2-diol (2.50 g, 14.345 mmol) in THF (25 ml) at room temperature was added successively *N,N*-diisopropylethylamine (11.12 g, 86.04 mmol, 6.0 equiv), 4-(dimethylamino)pyridine (0.3505 g, 2.869 mmol, 0.20 equiv) and di-*tert*-butyl carbonate (12.52 g, 57.37 mmol, 4.0 equiv.). The resulting mixture was stirred at room temperature for 24 hours. The reaction was quenched by adding water and stirring at room temperature. The mixture was diluted with EtOAc (50 ml) and washed with NaOH (50 ml, 1 M aqueous solution), water and brine, and then dried (MgSO₄), filtered, and concentrated on a rotary evaporator to afford a

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colorless liquid (4.58 g) as crude product. After chromatographic separation on silica gel using a mixture of hexanes and ethyl acetate as eluent, a colorless viscous liquid was obtained (3.48 g). ^1H NMR (CDCl_3) indicated the product to be the corresponding bis(*tert*-butyl carbonate).

Example 5

Protection of hydroxyl groups in glycerol monostearate (GMS) ester with carbonate groups



[00150] To a mixture of glycerol monostearate (20.00 g, ~55.78 mmol) and di-*tert*-butyl dicarbonate (32.869 g, 150.60 mmol) in toluene (185 ml) was added dropwise a solution of 4-(dimethylamino)pyridine (0.6759 g, 5.578 mmol) in toluene (40 ml) over 2.5 hours at room temperature. The resulting mixture was stirred at room temperature for 24 hours. The reaction was quenched by adding water and stirring at room temperature. The mixture was diluted with ethyl acetate and the organic phase was separated. The organic extract was then washed successively with 0.5N HCl, water, dilute aqueous sodium bicarbonate, brine, and then dried with anhydrous magnesium sulfate, filtered and concentrated on a rotary evaporator to afford a clear, light yellow liquid (30.63 g, 98%) as product. ^1H NMR (CDCl_3) indicated the product was the corresponding bis(*tert*-butyl carbonate) of glycerol monostearate.

Example 6

[00151] The protection of a representative alkane-1,2-diol such as VikinolTM 18 (available as an experimental product from Arkema) with di-*tert*-butyl dicarbonate can lead to a mixture of the corresponding bis(*tert*-butyl carbonate) (major) and cyclic carbonate (minor) in approximately 4:1 ratio, as illustrated in Example 3. This carbonate protected diol mixture was added at 1 wt% level to a formulated reference engine oil (called "Reference oil" in Table 2 below). This reference oil contains base oils, dispersants, detergents, antioxidants, antifoaming agents, but no antiwear agents, friction modifiers or viscosity modifiers. Similarly, neat (i.e., unprotected) VikinolTM 18 was added at 1 wt% level to the same reference oil for comparison. The release and friction-reducing performance of each of these additized test oils samples was measured by the High Frequency Reciprocating Rig (HFRR) under boundary conditions. The reference oil was also subjected to the same test conditions to establish the coefficient of friction (COF) in the absence of friction modifiers.

[00152] As used herein, the HFRR test configuration was an oscillating ball-on-disk, with ball and disk hardware immersed in oil. The device used was a High Frequency Reciprocating Rig

(HFRR) manufactured by PCS Instruments, London, UK. The HFRR conditions were a load of 400 g (translates to a 1GPa Herzian contact), a reciprocating frequency of 60 Hz, and a stroke length of 1.0 mm. Unless otherwise stated, the tests were run for a total of 4 hours under isothermal conditions. The temperature for each individual HFRR test is specified below. The ball and disk hardware were purchased from PCS Instruments, London, UK. The ball was a 52100 steel with a typical hardness of 800Hv. The disk was a 52100 steel with a typical hardness of 200Hv. Friction was measured with a load cell, and film thickness between the rubbing surfaces of the ball and disk were measured electrically.

[00153] Table 2 details the coefficient of friction as measured by 4 hours HFRR tests taken at the start of the test and end of the test for (i) 1 wt% carbonate protected Vikinol™ 18, (ii) 1 wt% neat Vikinol™ 18, and (iii) reference engine oil without any antiwear agent, friction modifier, or viscosity modifier measured at different temperatures.

TABLE 2

	HFRR Test Temperature	Coefficient of Friction at Start of Test	Coefficient of Friction at End of Test
1 wt% carbonate protected Vikinol™ 18	110°C	0.110	0.078
	150 °C	0.114	0.063
	180 °C	0.065	0.053
1 wt% Neat Vikinol™ 18	150 °C	0.048	0.048
	180 °C	0.040	0.046
Reference Oil	110 °C	0.109	0.105
	150 °C	0.126	0.120
	180 °C	0.133	0.108

[00154] Table 2 clearly shows that for each test temperature the 1 wt% carbonate protected Vikinol™ 18 additive system starts with high friction at the start of the test, which gradually decreases over time down to the same level (COF ~0.5 to 0.6) as afforded by the 1 wt% neat Vikinol 18, and effectively reducing the friction of the reference oil. This demonstrates that the carbonate protected Vikinol™ 18 additive system is less active of a friction modifier than unprotected neat Vikinol™ 18. This also demonstrates successful thermal conversion of carbonate

protected Vikinol™ 18 additive system into the active unprotected Vikinol™ 18 additive system during the HFRR test.

Example 7

[00155] In this example, the protection methodology was applied to another class of conventional organic friction modifiers, namely the glycerol esters. Representative examples of the organic friction modifiers based on glycerol ester include but not limited to glycerol mono-oleate (GMO), glycerol monostearate. It is understood that these esters are usually a mixture of the mono-, di- and tri-esters. The glycerol ester employed in Example 5 is a commercially available glycerol monostearate of high purity (i.e., high diol content). It was unexpectedly found that the bis(carbonate) was the sole product when glycerol monostearate was employed as the starting material. This is in sharp contrast to the result obtained for the Vikinol™ 18, a typical alkane-1,2-diol (Example 3). The release and friction-reducing performance of 1 wt% bis(carbonate) protected glycerol monostearate in the same formulated oil (reference oil) are shown in Table 3 below. It is evident that the release was effective at the temperature of the tests (either 180°C or 150°C or lower) and the friction-reducing effect was significant when compared to the reference oil at these two test temperatures.

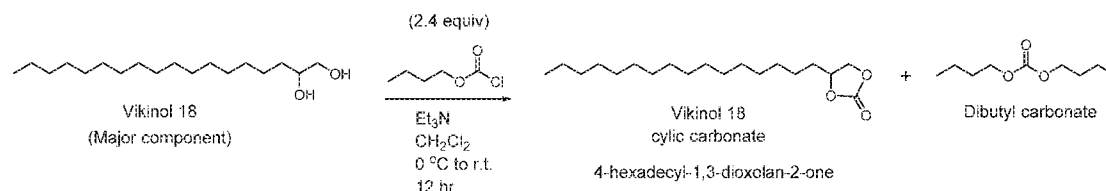
[00156] Table 3 details the coefficient of friction as measured by 4 hours HFRR tests taken at the start of the test and end of the test for (i) 1 wt% carbonate protected glycerol monostearate, (ii) 1 wt% glycerol monostearate, and (iii) reference engine oil without any antiwear agent, friction modifier, or viscosity modifier measured at different temperatures.

TABLE 3

	HFRR Test Temperature	Coefficient of Friction at Start of Test	Coefficient of Friction at End of Test
1 wt% Carbonate Protected Glycerol Monostearate	150°C	0.106	0.052
	180 °C	0.077	0.043
1 wt% Neat Glycerol Monostearate	150 °C	0.060	0.053
	180 °C	0.061	0.034

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Reference Oil	150 °C	0.126	0.120
	180 °C	0.133	0.108

Example 8Protection of hydroxyl groups in octadecane-1,2-diol with cyclic carbonate group

[00157] To a mixture of Vikinol™ 18 (15.00 g, ~52.4 mmol) and triethylamine (15.364 g, 151.83 mmol) in methylene chloride (180 ml) was added dropwise a solution of butyl chloroformate (17.162 g, 125.66 mmol) in methylene chloride (20 ml) over 30 minutes at 0°C. The resulting mixture was stirred at 0°C and allowed to warm to room temperature and stirred for 12 hours (overnight). The reaction was quenched by adding water and the organic phase was separated. The organic extract was washed successively with 1N HCl, water, dilute aqueous sodium carbonate, water, brine, and then dried with anhydrous magnesium sulfate, filtered and concentrated on a rotary evaporator to afford a waxy solid (15.0 g). This crude product was further dried under high vacuum to afford a waxy solid (14.87g). ¹H NMR (CDCl₃) indicated the product was a mixture of the corresponding cyclic carbonate (major product) and dibutyl carbonate (minor product) in approximately 3.1:1 ratio.

Example 9

[00158] Alkyl cyclic carbonates (i.e., alkyl 1,3-dioxolan-2-one) can be obtained from the reaction of alkane-1,2-diol with carbon dioxide under catalyzed conditions, phosgene, triphosgene, urea, or dialkyl carbonate. It can also be prepared from the reaction of alkyl epoxide with carbon dioxide under catalysis.

[00159] The protection of a representative alkane-1,2-diol such as Vikinol™ 18 (available as an experimental product from Arkema) with butyl chloroformate can lead to a mixture of the corresponding cyclic carbonate (major) and symmetrical dibutyl carbonate (minor) in approximately 3.1:1 ratio, as illustrated in Example 8. With regard to reaction conditions for preparing the cyclic carbonate, if the dibutyl chloroformate is used in stoichiometric ratio with respect to the diol moiety, the amount of symmetrical dibutyl carbonate will be reduced. Nevertheless, this cyclic carbonate protected Vikinol™ 18 and symmetrical carbonate mixture was added at 1 wt% level to a formulated reference engine oil (called "Reference oil" in Table 4). This

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reference oil contains base oils, dispersants, detergents, antioxidants, antifoaming agents, but no antiwear agents, friction modifiers or viscosity modifiers. Similarly, neat (i.e., unprotected) Vikinol™ 18 was added at 1 wt% level to the same reference oil for comparison. The release and friction-reducing performance of each of these additized test oil samples was measured by HFRR under conditions as described above. The reference oil was also subjected to the same test conditions to establish the coefficient of friction (COF) in the absence of friction modifiers.

[00160] Table 4 details the coefficient of friction, as measured by the HFRR test at 100°C, averaged over 2 hours demonstrating the friction reducing performance of 1 wt% cyclic carbonate protected Vikinol™ 18 in a Group IV base oil (PAO) and a formulated reference oil. Table 4 also demonstrates the further reduction in friction achievable by combining the cyclic carbonate with amine-containing additives such as the PIBSA-PAM dispersant.

TABLE 4

	Average HFRR Coefficient of Friction	
	Without Cyclic Carbonate	With 1 wt% Cyclic Carbonate
PAO	0.215	0.091
Formulated Engine Oil	0.111	0.074
PAO + 3.25 wt% PIBSA-PAM + 1.3 wt% B-PIBSA-PAM	0.118	0.061

[00161] Table 4 demonstrates the friction reducing capability of the cyclic carbonate system. 1 wt% of the cyclic carbonate reduces friction by over 50% in a Group IV polyalphaolefin (PAO) base oil, and by over 30% in a formulated reference oil. Where the formulated reference oil is comprised of 8.87 wt% detergent inhibitor (DI) package in 5 wt% of alkylated naphthalene Group V base oil with a balance of Group III+/IV base oil. The friction reducing performance of the cyclic carbonate system can be further enhanced in the presence of an amine-containing compound such as the polyisobutylene-succinic acid-polyamine (PIBSA-PAM) and its borated derivative (B-PIBSA-PAM). Table 4 shows the performance of these individual additives in a Group IV PAO base oil, demonstrating higher friction than the cyclic carbonate system, but still providing some

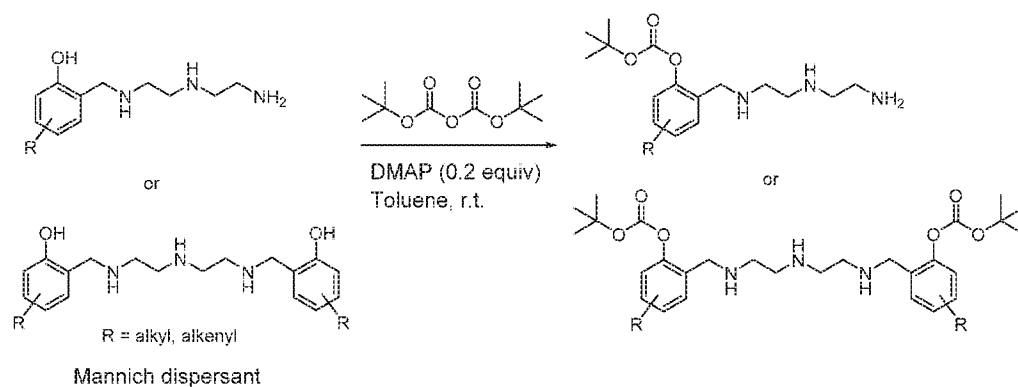
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frictional benefit to the base oil. Yet when combined with 1 wt% of the cyclic carbonate system, a further 30% reduction in friction is achieved over the PAO + 1 wt% cyclic carbonate system.

[00162] Low molecular weight or small alkyl cyclic carbonates (e.g., ethylene carbonate, propylene carbonate) are important industrial chemicals that find uses as solvents or as monomers for polymerization. These highly polar cyclic carbonate compounds are thermally stable and have high boiling points. For example, the boiling points for ethylene carbonate and propylene carbonate are 243°C and 240°C, respectively. It has been unexpectedly found that the cyclic carbonate derivative of Vikinol™ 18, when used in a typical engine oil formulation, provides a significant friction reduction at a range of test temperatures by the HFRR test. The lowest temperature employed in the HFRR test was 60 °C, which is not a limitation of the present disclosure. The high thermal stability of these systems can lead to extended friction performance in engine oil formulations.

Example 10

Protection of hydroxyl group in Mannich dispersant with a tert-butyl carbonate group



[00163] A hydroxyl group in a Mannich dispersant is protected with a tert-butyl carbonate group as depicted in the above reaction scheme.

[00164] All patents and patent applications, test procedures (such as ASTM methods, UL methods, and the like), and other documents cited herein are fully incorporated by reference to the extent such disclosure is not inconsistent with this disclosure and for all jurisdictions in which such incorporation is permitted.

[00165] When numerical lower limits and numerical upper limits are listed herein, ranges from any lower limit to any upper limit are contemplated. While the illustrative embodiments of the disclosure have been described with particularity, it will be understood that various other modifications will be apparent to and can be readily made by those skilled in the art without departing from the spirit and scope of the disclosure. Accordingly, it is not intended that the scope

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of the claims appended hereto be limited to the examples and descriptions set forth herein but rather that the claims be construed as encompassing all the features of patentable novelty which reside in the present disclosure, including all features which would be treated as equivalents thereof by those skilled in the art to which the disclosure pertains.

[00166] The present disclosure has been described above with reference to numerous embodiments and specific examples. Many variations will suggest themselves to those skilled in this art in light of the above detailed description. All such obvious variations are within the full intended scope of the appended claims.

CLAIMS:

1. A lubricating oil comprising a lubricating oil base stock as a major component; and one or more lubricating oil additives having at least one protected active group, as a minor component; wherein the one or more lubricating oil additives having at least one protected active group are inactive with respect to their innate performance function; and wherein the one or more lubricating oil additives having at least one protected active group are converted into one or more lubricating oil additives having at least one unprotected active group in the lubricating oil in-service in an engine or other mechanical component.
2. The lubricating oil of claim 1 wherein the one or more lubricating oil additives having at least one protected active group are converted to one or more lubricating oil additives having at least one unprotected active group in the lubricating oil in-service in the engine or other mechanical component at a temperature greater than or equal to 110°C, or by reaction with free acids that catalyze the release of an unprotected active group at a temperature greater than or equal to ambient temperature.
3. The lubricating oil of claims 1 and 2 wherein the one or more lubricating oil additives having at least one protected active group comprise a protected phenolic antioxidant, a protected aminic antioxidant, a protected alkane diol friction modifier, a protected ester diol friction modifier, or a protected Mannich dispersant.
4. The lubricating oil of claims 1-3 wherein the one or more lubricating oil additives having at least one protected active group comprise a protected phenolic antioxidant comprising di-*tert*-butyl (methylenebis(2,6-di-*tert*-butyl-4,1-phenylene)) bis(carbonate) derived from a hindered bisphenol or *tert*-butyl carbonate of 3,5-di-*tert*-butyl-4-hydroxyphenylpropionic alkyl ester derived from a hindered monophenol, a protected aminic antioxidant comprising *tert*-butyl diaryl carbamate derived from a substituted or unsubstituted diarylamine, a protected alkane diol friction modifier with a chain length of C8-C24 comprising *tert*-butyl octadecane-1,3-diyl dicarbonate, a protected ester diol friction modifier with a chain length of C8-C24 comprising glycerol monostearate bis(carbonate), or a protected Mannich dispersant comprising a Mannich dispersant having a *tert*-butyl carbonate group.
5. The lubricating oil of claims 1-4 wherein the at least one unprotected active group comprises an -OH group or a -NH group, and wherein the at least one protected active group is selected from the group consisting of a carbonate, a carbamate, an acetal, an ester, an amide, a urea, an alkoxy silane, an alkyl silane, a phosphite, a phosphonate, a phosphate, a sulfonamide, a sulfonate, and a sulfate.

6. The lubricating oil of claims 1-5 further comprising one or more lubricating oil additives having at least one unprotected active group; wherein the one or more lubricating oil additives having at least one unprotected active group are selected from the group consisting of an unprotected viscosity improver, an unprotected antioxidant, an unprotected detergent, an unprotected dispersant, an unprotected pour point depressant, an unprotected corrosion inhibitor, an unprotected friction modifier, an unprotected metal deactivator, an unprotected seal compatibility additive, an unprotected anti-foam agent, an unprotected inhibitor, and an unprotected anti-rust additive.

7. The lubricating oil of claims 1-6 wherein protection for the one or more lubricating oil additives having at least one protected active group comprises chemical protection; wherein the chemical protection comprises converting an unprotected $-OH$ group or $-NH$ group to a protected carbonate, carbamate, acetal, ester, amide, urea, alkoxysilane, alkylsilane, phosphite, phosphonate, phosphate, sulfonamide, sulfonate, or sulfate group.

8. The lubricating oil of claims 1-7 wherein deprotection for the one or more lubricating oil additives having at least one unprotected active group comprises chemical deprotection; wherein chemical deprotection comprises converting a protected carbonate, carbamate, acetal, ester, amide, urea, alkoxysilane, alkylsilane, phosphite, phosphonate, phosphate, sulfonamide, sulfonate, or sulfate group to an unprotected $-OH$ group or $-NH$ group.

9. A method for controlled release of one or more lubricating oil additives into a lubricating oil, said method comprising:

using as the lubricating oil a formulated oil, said formulated oil having a composition comprising a lubricating oil base stock as a major component; and one or more lubricating oil additives having at least one protected active group, as a minor component; wherein the one or more lubricating oil additives having at least one protected active group are inactive with respect to their innate performance function; and

converting the one or more lubricating oil additives having at least one protected active group into one or more lubricating oil additives having at least one unprotected active group in the lubricating oil in-service in an engine or other mechanical component.

10. An antioxidant composition comprising di-*tert*-butyl (methylenebis(2,6-di-*tert*-butyl-4,1-phenylene)) bis(carbonate) derived from a hindered bisphenol, *tert*-butyl carbonate of 3,5-di-*tert*-butyl-4-hydroxyphenylpropionic alkyl ester derived from a hindered monophenol, or *tert*-butyl diaryl carbamate derived from a substituted or unsubstituted diarylamine; or a friction modifier composition comprising *tert*-butyl octadecane-1,3-diyl dicarbonate), or glycerol monostearate bis(carbonate); or a dispersant composition comprising a Mannich dispersant having

a *tert*-butyl carbonate group; or a friction modifier composition comprising 4-hexadecyl-1,3-dioxolan-2-one.

11. A lubricating oil comprising a lubricating oil base stock as a major component; and one or more lubricating oil additives having at least one cyclic carbonate active group, as a minor component.

12. A method for improving friction control in an engine or other mechanical component lubricated with a lubricating oil by using as the lubricating oil a formulated oil, said formulated oil having a composition comprising a lubricating oil base stock as a major component; and one or more lubricating oil additives having at least one cyclic carbonate active group, as a minor component.

13. A lubricating oil comprising a lubricating oil base stock as a major component; and a mixture of (i) one or more lubricating oil additives having at least one cyclic carbonate active group, and (ii) one or more amine-containing lubricating oil additives, as a minor component.

14. A method for improving friction control in an engine or other mechanical component lubricated with a lubricating oil by using as the lubricating oil a formulated oil, said formulated oil having a composition comprising a lubricating oil base stock as a major component; and a mixture of (i) one or more lubricating oil additives having at least one cyclic carbonate active group, and (ii) one or more amine-containing lubricating oil additives, as a minor component; wherein friction control is improved as compared to friction control achieved using a lubricating oil containing other than a mixture of (i) one or more lubricating oil additives having at least one cyclic carbonate active group, and (ii) one or more amine-containing lubricating oil additives.

15. A method for improving oxidative stability of a lubricating oil and extending performance life of one or more lubricating oil additives, or for improving oxidative stability of one or more lubricating oil additives and extending performance life of said one or more lubricating oil additives, said method comprising:

using as the lubricating oil a formulated oil, said formulated oil having a composition comprising a lubricating oil base stock as a major component; and one or more lubricating oil additives having at least one protected active group, as a minor component; wherein the one or more lubricating oil additives having at least one protected active group are inactive with respect to their innate performance function; and

converting the one or more lubricating oil additives having at least one protected active group into one or more lubricating oil additives having at least one unprotected active group in the lubricating oil in-service in an engine or other mechanical component.

INTERNATIONAL SEARCH REPORT

International application No

PCT/US2017/016796

A. CLASSIFICATION OF SUBJECT MATTER
 INV. C10M169/04 C10M129/84 C10M133/18
 ADD.

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

C10M C10N

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EPO-Internal, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

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X	----- RAVI VARALA ET AL: "Molecular Iodine-Catalyzed Facile Procedure for N-Boc Protection of Amines", THE JOURNAL OF ORGANIC CHEMISTRY, vol. 71, no. 21, 1 October 2006 (2006-10-01), pages 8283-8286, XP055356118, ISSN: 0022-3263, DOI: 10.1021/jo0612473 example 10; table 3	10
X	----- US 2010/294499 A1 (LEWIS DAVID C [US] ET AL) 25 November 2010 (2010-11-25) 1,2-octadecylcarbonate; page 2 ----- -/-	10



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents :

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"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

31 March 2017

Date of mailing of the international search report

12/04/2017

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C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

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Information on patent family members

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