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(54) Titre : GUAR, AGENT ANTI-DERIVE LORS DE LA PULVERISATION
(54) Title: GUAR AS DRIFT CONTROL AGENT

(57) Abrégé/Abstract:

Aerial spray or discharge drift is controlled in aqueous compositions via the use of selected non-visco-elastic amounts of guar, one or more derivatives of guar or combinations thereof.



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ABSTRACT

Aerial spray or discharge drift is controlled in aqueous compositions via the use of selected non-visco-elastic amounts of guar, one or more derivatives of guar or
5 combinations thereof.

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GUAR AS A DRIFT CONTROL AGENTBACKGROUND OF THE INVENTIONField of the Invention

This invention relates to the control of droplet-size distributions in aqueous aerial sprays or discharges and, more particularly, relates to the minimization of spray drift.

Description of the Prior Art

Mist, or the fine particles end of the droplet-size spectra (typically those less than 150 microns in diameter) in industrial aqueous spray or discharge processes, such as those associated with aerial firefighting and dust control, gas scrubbers, crude oil spill treatments and various bioactive ingredient application processes, particularly those associated with agriculture, often reduce the effectiveness of these processes.

When the sprays are to be directed toward a specific target, the aerial spray or discharge delivery systems are typically mounted on airplanes, tractors, ground rigs or railcars. However, as a result of spray drift, much of the material in a spray can be rendered ineffective because of the inability of the small diameter spray particles to reach and impact upon the intended target. It is well known that spray droplet-size is a major factor affecting drift. While small droplets provide better coverage of a

target, they are more susceptible to drift than larger droplets. Spray drift represents a loss of chemical from intended targets and thus implies the dangers inherent in air and water pollution. Since off-target chemicals are
5 wasted product and with agricultural sprays, in particular, can represent a hazard to surrounding crops, water supplies and livestock, spray drift is an economical and environmental concern.

Research efforts to reduce spray drift have typically
10 dealt with improved equipment design, e.g., nozzle design to optimize spray patterns, or application techniques such as spray pressures, heights, formulations, etc. The most promising improvements in the application technology area have been in the reduction of fine spray droplets in the
15 droplet spectrum during atomization via the use of spray modifiers known as drift control agents. Effective drift control agents must possess a great number of characteristics for they must be able to increase the small droplet size; be insensitive to the high shear process
20 conditions realized in the spray system pumps, nozzles, etc.; not detract from the biological effects of the spray bioactives; be compatible with other spray adjuvants, i.e., non-bioactive material added to the spray mixture to improve chemical or physical characteristics; not separate
25 upon standing; be easy to use; be environmentally friendly; and be cost efficient.

Drift control agents are usually high molecular weight polymers which, when added to aqueous systems, tend to

increase the viscosity of the system and thus prevent the water from being broken up into a fine mist when aeri-ally sprayed or discharged.

5 These high molecular weight polymers tend to be unstable in that they often degrade upon aging and are very shear sensitive: both of which conditions, upon occurrence, cause a decrease in solution viscosity with a concomitant decrease in drift control activity.

10 Typical polymers currently utilized as drift control agents are the visco-elastic polyacrylamides, the polyethylene oxides, and the poly (vinyl pyrrolidones), with the polyacrylamides being the agriculture industry spray tank additive, drift reduction standard. However, current polyacrylamide drift control spray formulations
15 have a very limited effective time of positive drift reduction for a number of reasons. At the outset, the synthetic polyacrylamide polymer drift control agents are usually distributed in a kerosene carrier, which limits the dispersibility and additionally presents a volatile organic
20 component problem for the end user. The polymers themselves are essentially non-biodegradable. Furthermore, specific organic inverting surfactants must be used with these polymers to enable them to be properly hydrated and dispersed in water. Some of these polymers have also
25 demonstrated a sensitivity to water quality. Of course, all of the above necessitates the use of plastic (or glass) containers; a decided disadvantage. Finally, and perhaps most importantly, these high molecular weight

synthetic polyacrylamide polymers are extremely sensitive to shear stresses. Shear stressing is caused by high pressure gradients which may be imposed on a liquid by flow controllers, turbine metering systems, pumps and, in
5 general, pressure differentials exceeding about 40 psi such as is commonly associated with aerial spray nozzles and discharge systems. Unfortunately, shear stressing damages shear-sensitive visco-elastic polymers such as the polyacrylamides by a phenomenon known as physical shear
10 degradation. This degradation of the polymer realizes a significant decrease in solution viscosity which results in a lessening of the droplet-size distribution control effects. In summary, the polyacrylamide drift-reducing products have several major characteristics that
15 are not conducive to ease of use or reliable efficiency: slow hydration, water quality sensitivity and, most importantly, shear sensitivity.

SUMMARY OF THE INVENTION

It has now been discovered that guar and derivatives
20 of guar can be utilized in an aqueous spray medium as excellent drift control agents with essentially none of the above-identified disadvantages associated with the polyacrylamide agents. When used in amounts such that, if used in water alone, the guar-water combinations would
25 exhibit Newtonian liquid behavior, guar and its derivatives effectively reduce the number of droplets below about 150 microns, i.e. the droplets most responsible for drift problems; exhibit rapid dispersion and hydration in water;

and are ion insensitive, i.e. not dependent on water quality.

In addition to being biodegradable, the initial guar materials are dry and, thus are not subject to separation
5 upon storage, nor are they freeze sensitive. No volatile organic compound carriers are needed nor is there a need for surfactants to affect rapid hydration in water.

The guar compositions of this invention not only possess the highly desirable characteristics of efficient
10 drift control agents, but also maintain these properties under prolonged high shear commercial spray conditions, i.e., the guar compositions of this invention are highly resistant to shear scission and degradation of the drift reduction effect for which these adjuvants are intended.

15 DETAILED DESCRIPTION OF THE INVENTION

The essence of this invention lies in the discovery that very small amounts of guar (0.075 to less than 0.2% weight per unit volume (w/v)), one or more non-cationic derivatized guars (0.075 to 0.275% w/v), or one or more
20 cationic guars (0.05 to 0.1% w/v), or combinations thereof, in aqueous spray or discharge compositions at final dilution (the final spray composition) functions as an extremely effective drift reduction control agent and, serendipitously, in these low concentration ranges,
25 exhibits Newtonian behavior, i.e., is not shear sensitive. These concentration ranges are far below that previously disclosed (typically in excess of 0.6% w/v) for the utilization in aqueous compositions of the other art

recognized characteristics of guar and its derivatives, such as their ability to act as a lubricant, a binder, a thickener or a suspension agent.

Guar gum is the refined endosperm of the legume seed
5 of Cyamopsis tetragonolobus (L.) Taub., a plant which physically resembles the soy plant. The gum is a pure food vegetable colloid recognized by the agricultural, chemical and food formulation industry for many years as having excellent thickening, film-forming and stabilizing
10 properties.

Guar is often used in foods as a thickener and a binder of free water. In salad dressings, guar raises the viscosity of the emulsion and decreases the separation rate. Because guar functions to bind free water, it is
15 used to stabilize foods such as ice cream by inhibiting the formation of ice crystals. Guar is also utilized to stabilize certain delicate, non-food emulsions such as 1:1 mixtures of water and mineral oil.

Guar has been shown to be useful as a lubricant not
20 only by facilitating smooth extrusions at low pressures, but the additions of small amounts of guar have resulted in the reduction of frictional pressure drops in process water lines by up to 50%, thus increasing pump life and capacities and decreasing power requirements.

25 Functionally, guar is a cold water swelling, nonionic polysaccharide which develops and maintains its properties over a wide pH range. The guar polysaccharide is a complex carbohydrate polymer composed of essentially a straight

chain of mannose units with single-membered galactose branches; chemically classified as a polygalactomannan.

Guar solutions are simply prepared by rapidly sifting dry gum into a vigorously agitated tank of water and
5 permitting the gum to hydrate. Higher water temperatures can shorten the hydration time so long as the heating is not so prolonged or excessive as to degrade the polymer.

At concentrations used in this invention, solutions of guar have a zero yield value, i.e., they begin to flow at
10 the slightest shear.

The nature of guar allows almost constant viscosity for a given solution concentration over the pH range of 3-10. Above pH 11, a lower viscosity results from the decreased ability of the gum to hydrate. The optimum
15 hydration range occurs between pH 5 and 8. This unusual compatibility of guar over the 3-10 pH range is attributed to the nonionic nature of the molecule.

Etherification and esterification reactions are made on the guar hydroxyl functionalities. The C₆ hydroxyl
20 position is the most reactive position for etherification, for example, with propylene oxide, but the secondary hydroxyls are also probable sites.

Principle etherification reactions are carboxymethylation via monochloroacetic acid,
25 hydroxyalkylation via ethylene oxide or propylene oxide, and quaternization with various quaternary amine compounds containing reactive epoxide or chloride sites. Anionic and cationic sites modify the way the guar molecule interacts

with inorganic salts, hydrated cellulosic and mineral surfaces, and organic particulates.

In general, the hydroxyalkyl ethers of polygalactomannans are prepared by reacting the
5 polygalactomannans with alkylene oxides under basic conditions. In U. S. Patent Nos. 3,723,408 and 3,723,409, guar flour is reacted with alkylene oxides in the presence of water and sodium hydroxide. The reaction product is then neutralized with acid, washed with an alcohol-water
10 mixture, and is then dried and ground. In U. S. Patent No. 3,483,121, the polygalactomannans and the alkylene oxides are reacted under basic conditions with small amounts of water and larger amounts of water miscible or water immiscible organic solvents.

15 Specific hydroxyalkylating agents include ethylene oxide, propylene oxide-1,2; butylene oxide-1,2; hexylene oxide-1,2; ethylene chlorohydrin; propylene chlorohydrin; and epichlorohydrin.

Hydroxypropylation increases the gum's solubility,
20 resulting in a product which hydrates rapidly, regardless of water temperature. Hydroxyalkyl derivatives are more tolerant of the water-miscible solvents and thus can swell in and develop viscosity in aqueous solutions containing low molecular weight organic solvents such as methanol,
25 ethanol, etc. Both hydroxyalkyl and carboxymethyl derivatives typically form clearer solutions than standard guar gum and also hydroxyalkyl derivatives resist thermal degradation better than standard guar. Hydroxypropyl guar

is particularly useful as a flow modifier and friction reducing agent which does not flocculate solids.

Carboxyalkyl ethers and mixed carboxyhydroxyalkyl ethers of polygalactomannans are described in U.S. Patent Nos. 3,740,388 and 3,723,409, respectively. These derivatives are made by reacting the polygalactomannan with the derivatizing agents (halofatty acid and alkylene oxide) in a water-alcohol mixture followed by washing with water-alcohol mixtures.

10 Specific carboxyalkylating agents include chloroacetic acid, chloropropionic acid, and acrylic acid.

Carboxymethylation introduces an anionic function to the polymer chain and further increases the solubility of guar. Carboxymethyl hydroxypropyl guar is exceptional in
15 its ability to suspend undissolved solids.

Other derivatives of polygalactomannans are described in such patents as U. S. Patent No. 2,461,502 (cyanoethyl ethers), U. S. Patent No. 4,094,795 (dialkylacrylamide ethers) and U. S. Patent No. 3,498,912 (quaternary ammonium
20 alkyl ethers). In the described processes, the reactions are conducted in water-organic solvent mixtures and the reaction products are washed with solvents of water solvent mixtures. Specific quaternary ammonium alkylating
25 agents are such agents as 2,3-epoxypropyl trimethylammonium chloride, 3-chloro-2-hydroxypropyl trimethylammonium chloride and the like.

Other agents that can react with the hydroxyl groups of the polygalactomannans to form ether groups are, for

example, alkylating agents which include methyl chloride, methyl bromide, ethyl chloride, ethyl iodide and isopropyl chloride; aminoalkylating agents; such as aminoethyl chloride, aminopropyl bromide, and N,N-dimethyl-aminopropyl chloride; ethylenically unsaturated group containing agents which react through Michael addition with hydroxyl groups such as acrylamide, methacrylamide, acrylonitrile, methacrylonitrile, acrylic acid, sodium acrylate and, in fact, any of the polymerizable monomers which contain one ethylenically unsaturated polymerizable group.

The term "derivatized guar" is meant to include any of the above described derivatized guar products.

Guar, derived from a nitrogen-fixing, renewable resource, is a versatile, environmentally friendly, highly biodegradable polymer. Derivatized guar is slightly less sensitive to biological degradation, as the molecules are less suitable as food for common organisms.

The aqueous spray compositions of this invention are those containing water as the major component, i.e., greater than 50% by weight. Industrial aqueous spray compositions will, of course, contain in addition to the guar and guar derivatives of this invention, at least one chemically reactive compound. In the agricultural art, the compound is usually a bioactive pesticide. Other adjuvants in a guar aqueous spray composition may include minor amounts of, for example, buffering agents, defoaming agents, surfactants, wetting agents, sticking agents, tank cleaners, and other additives well known in the art.

The term "aerial spraying or discharging" means the spray or discharge process that occurs with commercial delivery systems typically mounted on airplanes, tractors, ground rigs or railcars and is not meant to include processes wherein drift is not a problem, e.g. totally enclosed systems such as spray dryers or low pressure, low shear, hand-held consumer application processes such as those associated with watering cans.

To provide effective spray drift reduction control of aqueous compositions, the effects realized by the drift control agent must be predictable and constant, i.e., the effects should not change with time or shear conditions.

Investigations of droplet spectra in air from industrial spray nozzles, especially those produced by most agricultural nozzles, have increasingly relied on laser-based devices. The spray cloud studies of this invention utilized the laser-based PDPA-100 system from Aerometrics Inc. for assessing the droplet spectra temporally. The drop-size ranges of the PDPA (about a 35 fold range) were sufficient to cover the droplet spectra produced by the equipment and processing conditions used in our study, i.e., flat fan agricultural-type nozzles atomizing conventional agricultiv formulations at normal pressures. The methodology conformed to GLP standards.

Generally, compounds were added to thirty (30) liters of water at 26° C, then recycled and atomized through a Teejet XR8003VS nozzle at forty (40) psi. The first atomization measurement was taken after about two minutes

of recycling, subsequent measurements occurred at 3-4
minute intervals. A single X-axis traverse of the spray
cloud was taken. Time to traverse was adjusted so that at
least 10,000 drops were counted; in most cases, it was
5 closer to 20,000.

The spray spectra droplet diameters measured were from
a maximum size of about 800 microns to a minimum size of
about 20 microns.

It is generally agreed that the spray droplet sizes
10 most susceptible to drift are those below about 150
microns. The preferred range of droplet size diameters for
commercial aerial sprays lies from about 200 microns to
about 500 microns.

A number of formulations were atomized both with and
15 without drift control adjuvants. Water was used as a
standard in our tests because many formulations,
particularly those containing wettable powders, atomize
similarly to water if adjuvants are not present.

Droplet frequency distribution data from nozzles,
20 specifically agricultural nozzles, tend to take the form of
an approximate skewed log-normal distribution. The two
most commonly used terms to describe such distributions are
the Volume Median Diameter ($D_{v0.5}$) and the Number Median
Diameter (NMD), the diameters below which 50% of the total
25 volume and number of drops of liquid sprayed is in drops of
smaller diameter, respectively.

V% and N% depicts the proportion of the volume of the
spray cloud/number of drops contained within (above/below)

given size ranges.

10% Point (10% Pnt) and 90% Point (90% Pnt) means that drop size below which 10% (or 90% respectively) of the volume of the measured drops lie.

5 Drift of aerial sprays, especially those sprays associated with the agricultural industry, are major contributors to the wasteful nature of commercial spray applications and impacts upon public health concerns and environmental costs. Since the application equipment
10 associated with such sprays is unlikely to significantly improve near term, the spray modifiers of the instant invention are especially valuable in obviating the above concerns and can potentially extend the life span of both new and existing active chemicals, especially the bioactive
15 pesticides of the crop protection industry.

The following examples are given to illustrate the invention and should not be construed as limiting its scope. Unless otherwise indicated, all parts and percentages are by weight of final product volume.

20

EXAMPLE I

The following are the results realized in a hydration rate/mixing series of studies comparing an industry standard polyacrylamide drift control agent with two derivatized guar, i.e., a hydroxy propyl guar and a
25 carboxymethyl hydroxy propyl guar.

The polymers were added to a forty five (45) liter spray tank containing thirty (30) liters of tap water. The guar derivative powders were added by tapping them onto the

surface of the water where the recycling liquid was returned from the pump. The polyacrylamide was added from a twenty (20) milliliter syringe into the same area. Both were stirred briefly by hand with a stirring rod.

5 The mixtures were atomized as soon as mixing was complete (after approximately two minutes), i.e., when most solid material had disappeared. The initiation of the atomization was considered time zero. The liquid was recycled with no pressure restriction, i.e., the material
10 recycled freely through the pump, except when spraying, to simulate field tank mixing.

 Droplet spectra data were measured for a single ninety (90) second traverse of the long axis of the spray cloud at each hydration/mixing interval. The intervals used were 5,
15 30, and 60 minutes. All guar mixtures were added to give 0.1% weight per unit volume and the polyacrylamide added to give 0.0625% volume per unit volume to achieve comparable viscosities. The liquid temperature was 25° C +/- 2° C. Data in all the Examples are reported in microns (μm).

TABLE I
HYDRATION/MIXING STUDY

<u>NALCOTROL II (i)</u>					
5	<u>HYDRATION TIME (MIN.)</u>	<u>10% Pnt</u>	<u>NMD</u>	<u>%V<100 $\mu\text{m}^{(iv)}$</u>	<u>%V<150</u>
	<u>μm</u>				
	5	211.3	53.7	1.85	42
	30	202.4	48.5	2.00	56
	60	175.4	47.9	2.75	73
<u>JAGUAR 8000 (ii)</u>					
10	<u>HYDRATION TIME (MIN.)</u>	<u>10% Pnt</u>	<u>NMD</u>	<u>%V<100 μm</u>	<u>%V<150</u>
	<u>μm</u>				
	5	203.3	43.8	2.36	53
	30	214.3	44.0	1.89	46
15	60	194.4	43.8	2.41	56
<u>JAGUAR 8600 (iii)</u>					
	<u>HYDRATION TIME (MIN.)</u>	<u>10% Pnt</u>	<u>NMD</u>	<u>%v<100 μm</u>	<u>%V<150</u>
	<u>μm</u>				
	5	201.8	41.9	2.41	52
20	30	198.9	41.2	2.49	53
	60	190.0	41.8	2.70	62

(i) NALCOTROL II is the trade name of Nalco Chemical Co. for its high molecular weight nonionic polyacrylamide.

25 (ii) JAGUAR 8000 is the trade name of Rhone-Poulenc Inc. for its 0.4 ms hydroxy propyl guar.

(iii) JAGUAR 8600 is the trade name of Rhone-Poulenc Inc. for its carboxymethyl hydroxy propyl guar.

30 (iv) Water typically has 6-7% by volume of droplets with diameter less than 100 μm when measured similarly.

The above results show that derivatized guar in water at 0.1% concentration are extremely effective at reducing the number of particles below 150 μm diameter and the spray volumes associated therewith. The initial effects are comparable to a polyacrylamide agricultural industry standard, however, the effectiveness of the derivatized guar does not deteriorate with time as is

quite noticeable with the polyacrylamide. Although the polyacrylamide at five minutes had reduced the volume of liquid with drop size diameters below 150 μm to 4.72%, fifty-five (55) minutes later its effectiveness had deteriorated significantly, i.e., to the point where the volume below 150 μm had risen to 7.03%.

EXAMPLE II

The following are results realized during a study to examine the effect of high shear, such as that experienced in the field, upon the drift control agents of this invention using a polyacrylamide and water as the two controls.

The polymers were added to the spray tank as was done for the hydration/mixing studies of Example I. The mixtures were allowed to recycle freely (no pressure restriction) for two minutes prior to initial atomization (time zero) and then recycled with continuous pressure restriction to simulate field tank recycling while spraying was underway.

Droplet size spectra data were obtained along a single (90 second) traverse of the long axis of the spray cloud. The nozzle was then returned to the starting point (60 seconds); lines cleared of any formulation (15 seconds); and a new traverse started. This gives more or less a three minute interval between measurements, and essentially continuous shear stress. The process was repeated until the entire thirty (30) liters had been atomized, or less than 1 liter remained in the spray tank.

Measurements recorded at approximately 3, 12, 24 and 35 minutes are shown below. The piston pump used for the experiments has a throughput of approximately 6.7 L/min. with no pressure restriction; 4.6 L/min. when spraying at 40 psi and 6 L/min. when restricted but not spraying.

TABLE II

<u>NALCOTROL II</u>							
	<u>RECYCLING TIME (MIN.)</u>	<u>10% Pnt</u>	<u>90% Pnt</u>	<u>D_{v0.5}</u>	<u>NMD</u>	<u>%V<100</u>	<u>%V<150</u>
10	WATER (CONTROL)	119.8	418.3	250.3	54.7	6.69	16.64
	2.97	204.6	746.4	428.0	50.5	1.96	4.76
	11.77	169.2	617.9	368.2	48.3	3.14	7.70
15	23.57	135.8	519.4	293.5	53.8	4.81	12.71
	35.26	127.2	454.5	278.8	58.8	5.54	14.62
<u>JAGUAR 8000</u>							
	<u>RECYCLING TIME (MIN.)</u>	<u>10% Pnt</u>	<u>90% Pnt</u>	<u>D_{v0.5}</u>	<u>NMD</u>	<u>%V<100</u>	<u>%V<150</u>
	2.90	176.8	713.4	381.4	38.8	3.19	7.22
25	11.60	199.0	719.8	400.8	40.9	2.25	5.47
	23.38	192.7	689.9	386.3	40.3	2.51	6.09
	35.35	189.5	800.6	409.9	39.3	2.61	5.98
30	5.98						
<u>JAGUAR 8600</u>							
	<u>RECYCLING TIME (MIN.)</u>	<u>10% Pnt</u>	<u>90% Pnt</u>	<u>D_{v0.5}</u>	<u>NMD</u>	<u>%V<100</u>	<u>%V<150</u>
	2.83	212.8	787.1	424.0	39.7	2.05	4.71
35	11.38	209.9	752.4	417.2	38.6	2.17	4.99
	23.07	209.7	792.4	425.3	38.8	2.23	5.05
40	34.72	177.1	698.4	375.6	39.3	2.83	6.93

As can be seen from the above data, the polyacrylamide drift control agent shears quite

significantly over time. The Volume Median Diameter ($D_{v0.5}$),
i.e., the drop size below which 50% of the volume is
contained in drops smaller, is initially fairly high for
the polyacrylamide (428 μm), but drops off rapidly to below
5 280 μm , whereas the hydroxy propyl guar begins high and
actually increases slightly with time from about 381 to
about 410 μm . The carboxymethyl hydroxy propyl guar
started high and stayed fairly constant at 424 μm (with a
slight decrease to 376 at 35 minutes). Most importantly,
10 the data shows that, as opposed to the polyacrylamide drift
control agent, after approximately 35 minutes of recycling,
the percent by volume of the spray composition contained in
droplet sizes prone to drift, i.e., the <100 μm and <150 μm
sizes, of the derivatized guar is not significantly
15 different from what it was at three minutes. The
polyacrylamide suffered a significant reduction in
effectiveness during the same period of time.

EXAMPLE III

The following are results achieved during
20 comparative high shear studies of a hydroxy propyl guar
with other guar, i.e., a 1.2ms hydroxy propyl guar; guar
and a hydroxy propyl trimonium chloride guar.

The test conditions and procedures were identical
to that used in the high shear recycle studies of Example
25 II.

TABLE III

<u>JAGUAR 8000</u>							
	<u>TIME (MIN.)</u>	<u>10% Pnt</u>	<u>90% Pnt</u>	<u>VMD</u>	<u>NMD</u>	<u>%V<100</u>	<u>%V<150</u>
5	Water	119.4	392.8	250.1	40.3	6.90	16.10
	Control						
	3.67	237.1	785.9	475.4	38.5	1.59	3.53
	13.85	230.0	812.0	430.6	40.0	1.60	3.65
	24.08	230.0	778.4	430.3	38.6	1.65	3.71
	37.73	224.6	813.2	432.6	36.8	1.85	4.28
10	<u>JAGUAR 8012 (i)</u>						
	<u>TIME (MIN.)</u>	<u>10% Pnt</u>	<u>90% Pnt</u>	<u>VMD</u>	<u>NMD</u>	<u>%V<100</u>	<u>%V<150</u>
	Water	125.5	388.5	260.5	42.7	6.17	14.29
	Control						
	5.03	183.6	608.2	370.1	45.7	2.59	6.36
15	15.43	187.8	638.7	373.9	43.7	2.53	6.10
	25.75	186.1	706.3	369.6	48.2	2.48	6.16
	39.42	177.3	602.3	361.8	42.7	2.84	6.83
	<u>JAGUAR 2610 (ii)</u>						
	<u>TIME (MIN.)</u>	<u>10% Pnt</u>	<u>90% Pnt</u>	<u>VMD</u>	<u>NMD</u>	<u>%V<100</u>	<u>%V<150</u>
20	Water	126.3	392.4	256.6	40.7	6.18	14.46
	Control						
	3.43	194.6	700.4	383.6	36.5	2.56	5.58
	13.82	192.2	625.5	381.4	37.7	2.63	5.96
	24.13	191.7	656.3	380.4	37.0	2.62	5.91
25	38.00	181.4	687.1	374.2	35.9	3.02	6.65
	<u>JAGUAR C-13S (iii)</u>						
	<u>TIME (MIN.)</u>	<u>10% Pnt</u>	<u>90% Pnt</u>	<u>VMD</u>	<u>NMD</u>	<u>%V<100</u>	<u>%V<150</u>
	Water	123.2	401.4	259.5	42.3	6.38	14.99
	Control						
30	3.52	187.5	624.0	371.0	35.7	2.75	6.28
	13.83	182.4	604.5	362.4	36.0	3.00	6.59
	24.17	183.8	667.3	369.6	36.0	2.92	6.52
	38.02	187.8	670.2	373.0	38.1	2.89	6.37
35	(i)	JAGUAR 8012 is the trade name for 1.2ms substituted hydroxy propyl guar sold by Rhone-Poulenc Inc.					
	(ii)	JAGUAR 2610 is the trade name for non-derivatized guar sold by Rhone-Poulenc Inc.					
	(iii)	JAGUAR C-13S is the trade name for hydroxy propyl trimonium chloride guar sold by Rhone-Poulenc Inc.					
40		The above data confirms the effectiveness and					

essentially constant control of the drift droplets, i.e., those below 150 μm realized by guar and derivatized guars during extended high shear recycling conditions.

EXAMPLE IV

5 A study was conducted in a wind tunnel at the Long Ashton Research Station in Bristol, England to evaluate the effect of pump shear on the downwind movement, i.e. the drift of a spray mixture containing 0.1% w/v JAGUAR 8000 in water and a spray mixture containing 0.0625% v/v Nalcotrol
10 II in water, both compared with water above.

The wind tunnel is 4 meters wide, 4 meters high and 12 meters long, with an effective reach of 8 meters, housing a Mardrive track sprayer capable of handling a 5 nozzle boom (50 cm nozzle spacing) at boom speeds up to 20 km per
15 hour. A 3 meters diameter, horizontally mounted, axial fan pulls air through the wind tunnel at velocities up to 8 meters per second. Airflow is approximately laminar for the center 3 meters width. Temperature and relative humidity are not controllable. The floor of the tunnel was
20 covered with trays of stubble to act as an artificial crop.

To create the stubble, winter wheat was sown in 60 X 40 cm trays and grown outside. Shortly before heading, the wheat was sprayed off with paraquat and cut to a height of approximately 28 cm above soil level. For the edges of the
25 wind tunnel, lower grade stubble was used (24 cm high) as guard rows.

The polymers were added to tap water and were applied through a static TeeJet XR8003VS nozzle at 40 psi mounted

45 cm above "crop" height. Half of each mixture was sprayed using a pressure can, i.e., no shear, and the other half was subjected to 10 minutes of recycling through a small piston pump before spraying. A fluorescent tracer (Fluorescein) was added to the spray solutions at 0.05% w/v.

The drift was measured at a single position 5 meters downwind from the boom and nozzles at five heights, (0: crop height, 10, 28, 45, and 55 cm above crop height). Two wind velocities were used: nominally 2 and 4 meters per second. All applications were replicated three times.

Deposits on the drift collectors (string as supplied by WRK Inc. Manhattan Ks (66502) were extracted in 0.05M NaOH containing 0.05% Triton X100. Fluorescence was determined, within 1 hour of collection, using a Perkin-Elmer fluorescence spectrophotometer LS-2B (flow cell and peristaltic pump). Quantities of fluorescent material were determined from standard calibration curves derived from fresh standards.

The amount of drift for each treatment and at each height is expressed in terms of $\mu\text{g/g}$ of tracer applied. Hence, the data can be related to "active ingredient" applied, irrespective of the volume applied. A summary of the data is presented in Table IV below.

TABLE IV

Tracer Drift ($\mu\text{g/g}$ of tracer applied)

Nominal Wind Speed 2 Meters/Second

5	Centimeters Above	55	45	28	10	0
	Crop Height					
	Water	0.296	0.779	2.350	3.874	
	4.211					
	Nalcotrol II Pressure Can	0.091	0.220	0.678	1.103	
	1.152					
10	Nalcotrol II Sheared	0.160	0.396	1.250	2.073	
	2.289					
	JAGUAR 8000 Pressure Can	0.091	0.206	0.770	1.365	
	1.555					
	JAGUAR Sheared	0.080	0.206	0.749	1.372	
15	1.522					

Nominal Wind Speed 4 Meters/Second

20	Centimeters Above	55	45	28	10	0
	Crop Height					
	Water	0.370	2.029	16.899	44.227	
	54.440					
	Nalcotrol II Pressure Can	0.157	0.882	8.181	18.685	
	21.404					
	Nalcotrol II Sheared	0.147	0.818	13.471	37.125	
	47.656					
25	JAGUAR 8000 Pressure Can	0.109	0.494	7.181	19.975	
	22.410					
	JAGUAR Sheared	0.076	0.493	7.286	21.025	
	23.576					

At "crop height" and nominal wind speed of 2 meters/second, JAGUAR 8000, both sheared and unsheared, reduced drift by about 64%, whereas sheared Nalcotrol II reduced drift by only about 45%.

At nominal wind speed of 4 meters/second, there was essentially no difference between the mixtures containing the sheared and unsheared JAGUAR 8000 and the unsheared Nalcotrol II; a reduction effect of about 60%. However, the sheared Nalcotrol II polyacrylamide drifted

nearly as much as water alone.

Thus, this simulated field study data show that a derivatized guar, both sheared and unsheared, can reduce drift as effectively as an unsheared polyacrylamide drift control standard. Furthermore, both sheared and unsheared derivatized guar can reduce drift significantly compared to a sheared polyacrylamide drift control standard.

EXAMPLE V

Aqueous compositions containing sixteen (16) additional commercial drift reduction products were tested under the procedures set forth in Example II. As JAGUAR 8000 and Nalcotrol II yielded viscosities of 2.4 cP at our test concentrations, the required concentration of each test material was identified to yield approximately the same viscosity. The products included both cold and hot water soluble polymers.

All viscosity measurements in the Examples were made using the Contraves Low Shear 40 Viscometer (LS40). Temperature was controlled at 25.0° C using a circulating water bath. The LS40 uses Couette geometry (cup and bob) and the fixture designated DIN 412 was used for the measurements. The materials selected and their respective concentrations and viscosities are set forth in Table Va.

TABLE Va

	Trade Name	Description	Supplier	Conc.	Test	
					Viscosity(cP)	
5	JAGUAR 8000	HP guar	RPI	0.10	2.4	
	Nalcotrol II	polyacrylamide	Nalco	0.0625	2.4	
	SeaSpen PF	carrageenan	FMC	0.05	2.4	
	Viscarin GP 209	carrageenan	FMC	0.05	5.1	
	Viscarin SD 389	carrageenan	FMC	0.075	3.2	
	Klucel M	HP cellulose	Aqualon	0.10	2.2	
10	Cellulose Gum L	Na CM cellulose	Aqualon	0.10	3.4	
	Cellulose Gum 250MR	HE cellulose	Aqualon	0.17	2.5	
	Pemulen TR-1	Acrylic copolymer	Goodrich	0.125	2.1	
	Gum Arabic, Tech.	-	AEP Colloids	3.10	2.3	
15	Locust Bean Gum	-	Meer	0.20	2.3	
	Tragacanth Gum	-	Meer	0.10	1.9	
	Polyox 301	poly(ethylene oxide)	U. Carbide	0.12	2.4	
	Polyox Coagulant	poly(ethylene oxide)	U. Carbide	0.07	2.5	
	K9A50	gellan gum	Kelco	0.07	2.1	
20	K1A96	whelan gum	Kelco	0.025	2.6	
	K1A112	rhamsan gum	Kelco	0.012	2.2	
	Luviskol K90	poly(vinyl pyrrolidone)	BASF	0.70	2.7	

Table Vb reflects the drift-prone particle size distributions and the change in this distribution as a function of recycle shear time.

TABLE Vb

	PRODUCT	% Volume at Start		% Volume at End		% Change	
		<100 μ m	<150 μ m	<100 μ m	<150 μ m	<100 μ m	<150 μ m
30	water	5.8	13.9	5.5	12.8	-5.2	-85
	JAGUAR 8000 - HP guar	1.8	3.8	2.2	4.8	-22.2	-263
	Nalcotrol II - polyacrylamide	2.0	4.7	3.8	10.8	-90.0	-1298
35	SeaSpen PF - carrageenan	4.3	9.9	4.4	10.7	-2.5	-81
	Viscarin GP 209 - carrageenan	3.8	8.9	3.7	8.9	+2.6	0
	Viscarin SD 389 - carrageenan	3.7	8.3	4.7	11.1	-27.0	-346
	Klucel M - HP Cellulose	3.3	8.1	3.5	8.5	-6.1	-49
	Cellulose Gum 7M - Na CMC	4.7	10.6	4.6	11.0	+2.1	-38
40	Cellulose Gum 250MR - HEC	2.9	6.4	3.4	8.0	-17.2	250
	Pemulen TR-1 - Acrylic copol.	4.4	10.8	4.9	12.2	-11.4	-130
	Gum Arabic, Tech.	5.1	12.4	5.7	13.4	-11.8	-81
	Locust Bean Gum	4.0	9.8	4.1	9.9	-2.5	-10
	Tragacanth Gum	4.6	10.2	4.1	9.7	+21.7	+49
45	Polyox 301 - PEO	0.1	0.2	2.1	4.7	-2000	-2250
	Polyox Coagulant - PEO	0.1	0.3	3.8	9.0	-3700	-2900
	K9A50 - gellan gum	4.1	10.0	4.4	10.4	-7.3	-40
	K1A96 - whelan gum	3.5	8.6	4.7	11.3	-30.6	-314
	K1A112 - rhamsan gum	2.2	6.7	4.1	9.9	-86.4	-340
50	Luviskol K90 - PVP	4.1	9.4	4.5	10.0	-9.8	-64

* (+) change is favorable; volume decreased with time.
 (-) is unfavorable; volume increased with time.

Based on water behavior; +/-8.5% (or greater) may not be significant.

None of the compounds tested provided as much drift

protection as JAGUAR 8000 when judged by the percent of spray volume in droplets less than 100 or 500 microns. Only Polyox 301 and Polyox Coagulant (both polyethylene oxides) provided more initial drift protection, but these
5 compounds atomized poorly and sheared extremely rapidly. As an aside, the "301" and "Coagulant" products did not atomize well until sheared and so initial droplet counts for them were below 1,000.

JAGUAR 8000 resisted shear degradations very well,
10 essentially maintaining its droplet size spectrum over the approximately 40 minutes of the test.

EXAMPLE VI

Tests were run to establish the upper concentration that could be utilized with guar and its derivatives to
15 ensure the Newtonian properties necessary to keep the drift reduction effects constant under the shearing conditions likely to be encountered in commercial spray applications. By Newtonian behavior, we mean that there be less than a 20% loss in viscosity at 100 sec.^{-1} shear relative to the
20 average viscosity between 0.1 and 1.0 sec.^{-1} shear. If greater than a 20% loss occurs, the composition will be assumed to be non-Newtonian, i.e., visco-elastic.

The viscosity profiles of a non-derivatized guar and two derivatized guar were examined.

25 The adjuvant was added to test water (tap water or otherwise specified hardness) at room temperature ($20 - 25^\circ \text{C}$). With high-speed mixing, the drift reduction adjuvant was thoroughly mixed and hydrated. This is nominally

accomplished within 45 seconds.

The solution was de-aerated (to remove foam or entrained air) by pulling a vacuum over its surface or by centrifugation.

5 The viscosity was measured.

A. The average viscosity between 0.1 and 1.0 reciprocal seconds (sec^{-1}) of shear was determined.

10 B. The viscosity at 100 reciprocal seconds (sec^{-1}) of shear was measured.

The following table summarizes the results of the viscosity tests.

TABLE VI

Rheological Data Summary

15	<u>Guar/Guar Derivative</u>	<u>Ave. Visc. (cP)</u> <u>(0.1 - 1.0 sec^{-1})</u>	<u>Visc. (cP)</u> <u>@ 100 sec^{-1}</u>	<u>Δ %</u>
	JAGUAR 8000			
	0.25%	35.39	19.25	-45.6
	0.20%	18.49	12.38	-33.0
20	0.15%	9.03	7.39	-18.2
	0.125%	8.01	6.48	-19.2
	0.100%	4.89	4.40	-10.0
	0.075%	3.36	3.11	- 7.7
	JAGUAR 8012			
25	0.25%	11.14	9.50	-14.8
	0.20%	6.98	6.56	- 6.1
	0.15%	4.21	4.31	+ 2.3
	JAGUAR 2610			
	0.20%	12.81	10.26	-19.9
30	0.15%	6.63	6.15	- 7.2
	0.10%	3.10	3.37	+ 8.8
	JAGUAR C-13S			
	0.15%	24.23	14.09	-41.9
	0.10%	9.90	7.48	-24.5
35	0.05%	3.17	3.19	+ 0.5

In view of the above, the upper concentration of guar

and its derivatives in aqueous compositions has been determined to be that which establishes a viscosity of about 7.5 cP or less at 100 sec⁻¹. Depending on the nature of the guar or its derivative, the concentration range required to achieve this viscosity will vary. For guar, 5 the concentration range is 0.075 to less than 0.2% weight per unit volume, preferably from 0.075 to 0.18% w/v. For non-cationic derivatized guar, the concentration range is 0.075 to 0.275% w/v, preferably 0.1 to 0.125% w/v. For 10 cationic guar, the concentration range is from 0.05 to 0.1% w/v. For blends of the above, the concentration range is from 0.05 to 0.275% w/v with the proviso that i) the cationic guar concentration not exceed 0.1% w/v; and ii) the non-derivatized guar concentration be less than 0.2% 15 w/v.

While the embodiments of the invention chosen herein for purposes of disclosure are considered to be preferred, it is to be understood that this invention is intended to cover all changes and modifications in the disclosed 20 embodiments which fall within the spirit and scope of the invention.

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CLAIMS:

1. A spray drift reducing composition comprising at final dilution:

(a) greater than 50% by weight of water; and

5 (b) from 0.075 to less than 0.2% weight per unit volume of a sole drift control agent consisting essentially of guar.

2. The spray drift reducing composition of claim 1 wherein the drift control agent is from 0.075% to 0.18% weight per unit volume.

10 3. A spray drift reducing composition comprising at final dilution:

(a) greater than 50% by weight of water; and

(b) from 0.075 to 0.275% weight per unit volume of a sole drift control agent consisting essentially of non-cationic
15 derivatized guars.

4. The spray drift reducing composition of claim 3 wherein the drift control agent is from 0.1% to 0.125% weight per unit volume.

5. A spray drift reducing composition comprising at
20 final dilution:

(a) greater than 50% by weight of water; and

(b) from 0.075 to 0.275% weight per unit volume of a sole drift control agent consisting essentially of hydroxy propyl guar.

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6. The spray drift reducing composition of claim 5 wherein the drift control agent is from 0.1% to 0.125% weight per unit volume.

7. A spray drift reducing composition comprising at
5 final dilution:

(a) greater than 50% by weight of water; and

(b) from 0.075 to 0.275% weight per unit volume of a sole drift control agent consisting essentially of carboxymethyl hydroxy propyl guar.

10 8. The spray drift reducing composition of claim 7 wherein the drift control agent is from 0.1% to 0.125% weight per unit volume.

9. A spray drift reducing composition comprising at final dilution:

15 (a) greater than 50% by weight of water; and

(b) from 0.05 to 0.1% weight per unit volume of a sole drift control agent consisting essentially of cationic guar.

10. A spray drift reducing composition comprising at final dilution:

20 (a) greater than 50% by weight of water; and

(b) from 0.05 to 0.275% weight per unit volume of a sole drift control agent selected from the group consisting of guar, one or more derivatized guars, and combinations thereof with the proviso that:

25 (i) the cationic guar concentration not exceed 0.1% weight per unit volume; and

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(ii) the non-derivatized guar concentration not exceed 0.2% weight per unit volume.

11. The spray drift reducing composition of any one of claims 1 to 10 which additionally contains a bioactively
5 effective amount of a bioactive.

12. The spray drift reducing composition of claim 11 wherein said bioactive is a pesticide.

13. A method for reducing the drift during aerial spraying or discharge of an aqueous composition containing
10 greater than 50% by weight of water and essentially no drift control agents comprising the steps of:

admixing with said composition prior to said spraying or discharge from 0.075 to less than 0.20% weight per unit volume at final dilution of a sole drift control
15 agent consisting essentially of guar; and

aerial spraying or discharging the admixture.

14. The method of claim 13 wherein the drift control agent is from 0.075 to 0.18% weight per unit volume.

15. A method for reducing the drift during aerial
20 spraying or discharge of an aqueous composition containing greater than 50% by weight of water and essentially no drift control agents comprising the steps of:

admixing with said composition prior to said spraying or discharge from 0.075 to 0.275% weight per unit
25 volume at final dilution of a sole drift control agent consisting essentially of non-cationic guar; and

aerial spraying or discharging the admixture.

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16. The method of claim 15 wherein the drift control agent is from 0.1 to 0.125% weight per unit volume.

17. A method for reducing the drift during aerial spraying or discharge of an aqueous composition containing
5 greater than 50% by weight of water and essentially no drift control agents comprising the steps of:

admixing with said composition prior to said spraying or discharge from 0.075 to 0.275% weight per unit volume at final dilution of a sole drift control agent
10 consisting essentially of hydroxy propyl guar; and

aerial spraying or discharging the admixture.

18. The method of claim 17 wherein the drift control agent is from 0.1 to 0.125% weight per unit volume.

19. A method for reducing the drift during aerial
15 spraying or discharge of an aqueous composition containing greater than 50% by weight of water and essentially no drift control agents comprising the steps of:

admixing with said composition prior to said spraying or discharge from 0.075 to 0.275% weight per unit
20 volume at final dilution of a sole drift control agent consisting essentially of carboxymethyl hydroxy propyl guar; and

aerial spraying or discharging the admixture.

20. The method of claim 19 wherein the drift control
25 agent is from 0.1 to 0.125% weight per unit volume.

21. A method for reducing the drift during aerial spraying or discharge of an aqueous composition containing

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greater than 50% by weight of water and essentially no drift control agents comprising the steps of:

admixing with said composition prior to said spraying or discharge from 0.05 to 0.1% weight per unit
5 volume at final dilution of a sole drift control agent consisting essentially of cationic guar; and

aerial spraying or discharging the admixture.

22. A method for reducing the drift during aerial spraying or discharge of an aqueous composition containing
10 greater than 50% by weight of water and essentially no drift control agents comprising the steps of:

admixing with said composition prior to said spraying or discharge from 0.05 to 0.275% weight per unit
volume at final dilution of a sole drift control agent
15 selected from the group consisting of guar, one or more derivatized guars, and combinations thereof with the proviso that:

(i) the cationic guar concentration not exceed 0.1% weight per unit volume; and

20 (ii) the non-derivatized guar concentration not exceed 0.2% weight per unit volume.

23. The method of any one of claims 13 to 22 wherein said aqueous composition contains a bioactively effective amount of a bioactive.

25 24. The method of claim 23 wherein said bioactive is a pesticide.