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(54) **Title:** LIQUID-LIQUID EXTRACTION COMPOSITION USEFUL IN PROCESSING WATER-SOLUBLE SURFACTANTS

(57) **Abstract:** Compositions useful in liquid-liquid extraction processes for improving the taste of water-soluble surfactants, said composition comprising: from about 5% to about 60%, by weight of the composition, of water soluble surfactant; from about 10% to about 90%, by weight of the composition, of water; from about 10% to about 90%, by weight of the composition, of extraction solvent; at least 0.01%, by weight of the composition, of undesirable non-polar materials; wherein the extraction solvent is selected from solvents having individual Hansen solubility parameters of a dispersion force component (?D) ranging from about 15 to about 17 (MPa)^{0.5}, a polar component (δ_P) ranging from 0 to about 9 (MPa)^{0.5} and a hydrogen bonding component (δ_H) ranging from 0 to about 11 (MPa)^{0.5}.

Purification of surfactant materials through steam-stripping, vacuum-stripping, and/or carbon filtration processes is also generally known to beneficially remove impurities to increase efficacy, minimize undesirable side reactions, and the like. However, these purification processes have been found to be insufficient to remedy the unpleasant tastes and/or odors associated with commercially available water-soluble surfactant materials.

Liquid / liquid extractions (LLE) are generally known in the art as useful for separating components of a mixture, wherein the constituents have differing polarities which can be separated when mixed within two immiscible solvents that form a liquid bilayer after mixing. For example, LLEs are useful for purifying or cleaning samples which contain impurities of significantly differing polarity than the majority or desirable component(s) of the sample. This can be achieved by mixing a sample with a solvent that is immiscible with the primary liquid in which the sample is dissolved.

LLE has been utilized in chemical processing to reduce or eliminate undesirable by-products or contaminants. For instance, PCT Patent Application WO 2008005550 to Hoke, et al (Procter & Gamble) discloses a water washing procedure to remove polar sulfur impurities from peppermint oils to avoid malodor formation when formulated in dentifrice containing stannous ions. In U.S. Patent No. 4,352,829 to Noyes, et al (Procter & Gamble) an ethyl acetate extraction of caffeine from coffee was shown to be an effective decaffeination process.

However, there is still an interest in finding ways to improve the overall taste and/or odor of water-soluble surfactants such as those used in an oral care composition that are efficacious, cost-effective, and desirable to consumers.

SUMMARY OF THE INVENTION

It has now surprisingly been found that liquid-liquid extraction processes utilizing solvents such as ethyl acetate may be useful to significantly reduce the occurrence of non-polar materials found in water-soluble surfactant raw materials and thereby improve the surfactant's odor and/or taste profile.

Without being limited by theory, it is now believed that water-soluble surfactants previously generally thought to have bad taste and/or odor profiles stemming from the pure material itself are in fact surprisingly acceptable in terms of taste and odor. It has been surprisingly found that non-polar materials commonly present in commercially available water-soluble surfactant compositions such as residual alcohols, alcohol ethoxylates, aldehydes, ethers, ketones, alkylamines, and esters, may be linked to the majority of the negative taste and odor profiles previously associated with the surfactants themselves. Since some of these materials are

often used in flavors and perfumes, it was further surprising that a new process for more efficiently extracting these materials from the underlying surfactant would produce such results. For example, dodecanol and dodecanal are commonly taught to be safe and useful for inclusion in flavors and perfumes, yet it has been surprisingly found that if included in water-soluble surfactant compositions at significantly higher levels, these materials present an unpleasant taste such as bitter, soapy and the like.

Further without being limited by theory, liquid-liquid extraction using the appropriate solvent is more effective than previously known techniques to purify such surfactants, allowing for the incorporation of such surfactants into oral care products with minimal negative taste and/or odor attributes.

The present invention is therefore directed to compositions useful in such liquid-liquid extraction processes for improving the taste of water-soluble surfactants, said composition comprising: from about 5% to about 60%, by weight of the composition, of water soluble surfactant; from about 10% to about 90%, by weight of the composition, of water; from about 10% to about 90%, by weight of the composition, of extraction solvent; and at least 0.01%, by weight of the composition, of at least one undesirable non-polar material; wherein the extraction solvent is selected from solvents having individual Hansen solubility parameters of a dispersion force component (δ_D) ranging from about 15 to about 17 (MPa)^{0.5}, a polar component (δ_P) ranging from 0 to about 9 (MPa)^{0.5} and a hydrogen bonding component (δ_H) ranging from 0 to about 11 (MPa)^{0.5}.

In another embodiment, the present invention relates to a composition useful in liquid-liquid extraction processes for improving the taste of water-soluble surfactants, said composition consisting essentially of: from about 30% to about 60% of a water soluble surfactant; from about 20% to about 80% water; from about 20% to about 80% of ethyl acetate; from about 0.01% to about 20%, by weight of the composition, of undesirable non-polar materials.

In another embodiment, the present invention relates to compositions as set forth above wherein the composition comprises an aqueous phase and a solvent phase.

In another embodiment, the present invention relates to compositions as set forth above wherein the aqueous phase comprises the water soluble surfactant and water.

In another embodiment, the present invention relates to compositions as set forth above wherein the solvent phase comprises the extraction solvent and at least one undesirable non-polar material.

In another embodiment, the present invention relates to compositions as set forth above wherein the water-soluble surfactant is at least about 20% soluble in water.

In another embodiment, the present invention relates to compositions as set forth above wherein the water-soluble surfactant is selected from anionic surfactants, zwitterionic surfactants and mixtures thereof and is at least about 30% soluble in water.

5 In another embodiment, the present invention relates to compositions as set forth above wherein the water soluble surfactant is selected from alkyl phosphate surfactants, alkyl phosphate ethoxylated surfactants, lauryl sulfate surfactants, betaine surfactants, amine oxide surfactants, and mixtures thereof.

10 In another embodiment, the present invention relates to compositions as set forth above wherein the water-soluble surfactant is selected from cocoamidopropyl betaines, lauryl betaines capryl/capramidobetaines, sodium lauryl sulfates, mono alkyl phosphates, alkyl ethoxylated phosphates, amine oxides, and mixtures thereof.

In another embodiment, the present invention relates to compositions as set forth above wherein the water soluble surfactant is a mono alkyl phosphate surfactant.

15 In another embodiment, the present invention relates to compositions as set forth above wherein the extraction solvent has individual Hansen solubility parameters of a dispersion force component (δ_D) ranging from about 13 to about 19 (MPa)^{0.5}, a polar component (δ_P) ranging from about 2 to about 9 (MPa)^{0.5} and a hydrogen bonding component (δ_H) ranging from about 2 to about 11 (MPa)^{0.5}.

20 In another embodiment, the present invention relates to compositions as set forth above wherein the extraction solvent is selected from ethyl acetate, water-saturated ethyl acetate, ethyl propionate, ethyl butyrate, ethyl pentanoate, ethyl caproate, ethyl caprylate, ethyl pelargonate methyl acetate, methyl propionate, methyl butyrate, short chain esters and mixtures thereof.

In another embodiment, the present invention relates to compositions as set forth above wherein the extraction solvent is ethyl acetate.

25 In another embodiment, the present invention relates to compositions as set forth above wherein the extraction solvent is selected from food grade ethyl esters.

In another embodiment, the present invention relates to compositions as set forth above wherein the ratio of extraction solvent to water soluble surfactant in the extraction mixture is from about 1:10 to about 10:1.

30 In another embodiment, the present invention relates to compositions as set forth above wherein the ratio of extraction solvent to water soluble surfactant in the extraction mixture is from about 1:2 to about 2:1.

In another embodiment, the present invention relates to compositions as set forth above wherein the composition further comprises a phase separation enhancer selected from salt, pH modifiers, and mixtures thereof.

In another embodiment, the present invention relates to use of the compositions set forth
5 above in a liquid-liquid extraction process.

DETAILED DESCRIPTION OF THE INVENTION

The present invention relates to compositions which may be used in processes for improving the taste of water-soluble surfactants using liquid-liquid solvent extraction. Such
10 compositions include:

- a. from about 5% to about 60%, by weight of the composition, of water soluble surfactant;
 - b. from about 10% to about 90%, by weight of the composition, of water;
 - c. from about 10% to about 90%, by weight of the composition, of extraction
15 solvent;
 - d. at least 0.01%, by weight of the composition, of undesirable non-polar materials;
- wherein the extraction solvent is selected from solvents having individual Hansen solubility parameters of a dispersion force component (δ_D) ranging from about 15 to about 17 (MPa)^{0.5}, a polar component (δ_P) ranging from 0 to about 9 (MPa)^{0.5} and a hydrogen bonding component
20 (δ_H) ranging from 0 to about 11 (MPa)^{0.5}.

These elements will be discussed in more detail below.

Water Soluble Surfactant

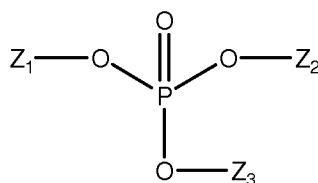
The compositions of the present invention contain from about 5% to about 60%, by
25 weight of the composition of a water-soluble surfactant. In one embodiment, the compositions of the present invention contain from about 10% to about 50%, alternatively from about 20% to about 30%, by weight of the composition, of a water-soluble surfactant.

As used herein “water-soluble surfactant” refers to those surfactants that are at least partially soluble in water, when measured at room temperature (25°C). In one embodiment, the
30 water-soluble surfactant is at least 10% soluble in water, alternatively is at least 20% soluble in water, and still alternatively is at least 30% soluble in water, alternatively at least 40% soluble in water.

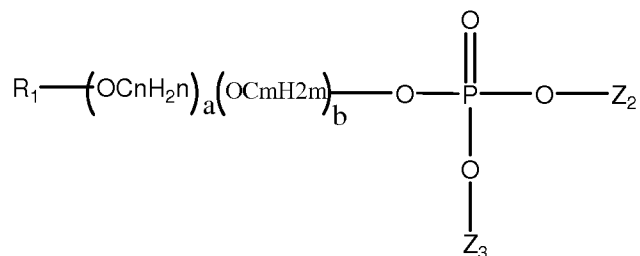
Examples of water-soluble surfactants that may be purified by the processes herein include cocoamidopropyl betaines, lauryl betaines, capryl/capramidobetaines, sodium lauryl

sulfates, mono alkyl phosphates, alkyl ethoxylated phosphates, amine oxides, and mixtures thereof.

Water-soluble surfactants useful herein may, in some embodiments be selected from anionic surfactants such as alkyl phosphates. These surface active organophosphate agents have a strong affinity for enamel surface and have sufficient surface binding propensity to desorb pellicle proteins and remain affixed to enamel surfaces. Suitable examples of organophosphate compounds include mono-, di- or triesters represented by the general structure below wherein Z1, Z2, or Z3 may be identical or different, at least one being an organic moiety, in one embodiment selected from linear or branched, alkyl or alkenyl group of from 1 to 22 carbon atoms, optionally substituted by one or more phosphate groups; alkoxyalkyl or alkenyl, (poly)saccharide, polyol or polyether group.



Some other agents include alkyl or alkenyl phosphate esters represented by the following structure:



wherein R1 represents a linear or branched, alkyl or alkenyl group of from 6 to 22 carbon atoms, optionally substituted by one or more phosphate groups; n and m, are individually and separately, 2 to 4, and a and b, individually and separately, are 0 to 20; Z2 and Z3 may be identical or different, each represents hydrogen, alkali metal, ammonium, protonated alkyl amine or protonated functional alkyl amine such as an alkanolamine, or a R1---(OCnH2n)a(OCmH2m)b--- group. Examples of suitable agents include alkyl and alkyl (poly)alkoxy phosphates such as lauryl phosphate; PPG5 cetareth-10 phosphate; Laureth-1 phosphate; Laureth-3 phosphate; Laureth-9 phosphate; Trilaureth-4 phosphate; C12-18 PEG 9 phosphate; Sodium dilaureth-10 phosphate. In one embodiment, the alkyl phosphate is polymeric. Examples of polymeric alkyl phosphates include those containing repeating alkoxy groups as the polymeric portion, in particular 3 or more ethoxy, propoxy isopropoxy or butoxy groups.

Zwitterionic or amphoteric surfactants useful in the present invention include derivatives of aliphatic quaternary ammonium, phosphonium, and sulfonium compounds, in which the aliphatic radicals can be straight chain or branched, and wherein one of the aliphatic substituents contains from about 8 to 18 carbon atoms and one contains an anionic water-solubilizing group, e.g., carboxy, sulfonate, sulfate, phosphate or phosphonate. Suitable amphoteric surfactants include betaine surfactants such as disclosed in U.S. Pat. No. 5,180,577 to Polefka et al. Typical alkyl dimethyl betaines include decyl betaine or 2-(N-decyl-N,N-dimethylammonio) acetate, coco betaine or 2-(N-coco-N, N-dimethyl ammonio) acetate, myristyl betaine, palmityl betaine, lauryl betaine, cetyl betaine, stearyl betaine, etc. The amidobetaines are exemplified by cocoamidoethyl betaine, cocamidopropyl betaine (CAPB), and lauramidopropyl betaine. The unwanted tastes often associated with these surfactants are soapy, bitter, chemical, and/or artificial.

Additional suitable polymeric organophosphate agents include dextran phosphate, polyglucoside phosphate, alkyl polyglucoside phosphate, polyglyceryl phosphate, alkyl polyglyceryl phosphate, polyether phosphates and alkoxyated polyol phosphates. Some specific examples are PEG phosphate, PPG phosphate, alkyl PPG phosphate, PEG/PPG phosphate, alkyl PEG/PPG phosphate, PEG/PPG/PEG phosphate, dipropylene glycol phosphate, PEG glyceryl phosphate, PBG (polybutylene glycol) phosphate, PEG cyclodextrin phosphate, PEG sorbitan phosphate, PEG alkyl sorbitan phosphate, and PEG methyl glucoside phosphate. Suitable non-polymeric phosphates include alkyl mono glyceride phosphate, alkyl sorbitan phosphate, alkyl methyl glucoside phosphate, alkyl sucrose phosphates. The unwanted tastes often associated with these surfactants are soapy, chemical, and/or artificial.

Water-soluble amphoteric surfactants useful herein further include amine oxide surfactants. Amine oxides are the result of oxidation of tertiary amines, typically C12-C18 alkyl dimethyl, N-oxides. For example, amine oxide surfactants useful herein may include lauryl dimethyl amine oxide; lauryl dihydroxyethyl amine oxide; cocamidopropyl amine oxide; Lauramidopropylamine oxide; cetyl dimethyl amine oxide; 3-Lauramidopropyl-N,N-dimethylamine oxide.

Water-soluble cationic surfactants useful in the present invention include derivatives of quaternary ammonium compounds having one long alkyl chain containing from about 8 to 18 carbon atoms such as lauryl trimethylammonium chloride; cetyl pyridinium chloride; cetyl trimethylammonium bromide; coconut alkyltrimethylammonium nitrite; cetyl pyridinium fluoride; etc. Preferred compounds are the quaternary ammonium halides having detergent

properties described in U.S. Patent 3,535,421 to Briner et al. Certain cationic surfactants can also act as germicides in the oral care compositions disclosed herein.

In another embodiment, the water-soluble surfactant is selected from anionic surfactants, zwitterionic surfactants, amphoteric surfactants, cationic surfactants, nonionic surfactants and mixtures thereof. In one embodiment, the water-soluble surfactant is selected from alkyl phosphate surfactants, alkyl phosphate ethoxylated surfactants, lauryl sulfate surfactants, betaine surfactants, betaine ethoxylated surfactants, amine oxide surfactants and mixtures thereof. In another embodiment, the water-soluble surfactant is selected from alkyl phosphate surfactants, alkyl phosphate ethoxylated surfactants, and mixtures thereof. In one embodiment, the water-soluble surfactant is a mono alkyl phosphate surfactant.

In one embodiment, the surfactant is selected from cocoamidopropyl betaines, alkyl ethoxylated phosphates, mono alkyl phosphates, and mixtures thereof.

Water

The compositions of the present invention contain from about 10% to about 90%, by weight of the composition, of water. In one embodiment, the composition contains from about 30% to about 90%, by weight of the composition, of water. In one embodiment, the compositions of the present invention contain from about 50% to about 90%, alternatively from about 50% to about 70%, by weight of the composition, of water.

Extraction Solvent

The compositions herein contain from about 10% to about 90%, by weight of the composition, of extraction solvent. In one embodiment, the composition contains from about 20% to about 80% of the extraction solvent, alternatively from about 30% to about 70%, by weight of the composition, of the extraction solvent.

As used herein, "extraction solvent" refers to any liquid or supercritical fluid that can be used to solubilize undesirable non-polar materials that are contained within a water-soluble surfactant composition. Organic solvents with acceptable safety profiles that will form a liquid bilayer with aqueous surfactants could be used either alone or in combination with other solvents such as ethyl acetate, ethanol, propylene glycol, PEGs, other ethers or esters, or other solvents, etc. to achieve a similar result. One example of a useful supercritical fluid is carbon dioxide.

Extraction solvents useful herein include those having individual Hansen solubility parameters of a dispersion force component (δ_D) ranging from about 15 to about 17 (MPa)^{0.5}, a

polar component (δ_P) ranging from 0 to about 9 (MPa)^{0.5} and a hydrogen bonding component (δ_H) ranging from 0 to about 11 (MPa)^{0.5}.

In one embodiment, the solvent has individual Hansen solubility parameters of a dispersion force component (δ_D) ranging from about 13 to about 19 (MPa)^{0.5}, a polar component
5 (δ_P) ranging from about 2 to about 9 (MPa)^{0.5} and a hydrogen bonding component (δ_H) ranging from about 2 to about 11 (MPa)^{0.5}. In one embodiment, the polar component ranges from about 4 to about 6, in another embodiment, the hydrogen bonding component ranges from about 6 to about 9.

In addition to Hansen solubility parameters, the solvent will form distinct layers when
10 combined with water and the water-soluble surfactant. In order to quickly determine whether a solvent will meet this criteria, the following visual separation test may be used: using a 30ml glass vial, add 10mL of the proposed extraction solvent, 10mL of a 30% aqueous solution of the water-soluble surfactant composition, cap the vial, shake vigorously for 30 seconds, allow to rest for 30 minutes, visually inspect for visible precipitation and two distinct aqueous layers. If there
15 is no visible precipitation and at least two distinct layers are formed, the solvent passes the visual separation test and may be used as an extraction solvent according to the processes set forth herein.

In one embodiment, the extraction solvents useful herein have a logP value of greater than 0.5.

20 Extraction solvents useful herein include ethyl acetate, water-saturated ethyl acetate, ethyl propionate, ethyl butyrate, ethyl pentanoate, ethyl caproate, ethyl caprylate, ethyl pelargonate methyl acetate, methyl propionate, methyl butyrate, short chain esters and mixtures thereof. In one embodiment, the extraction solvent is selected from food grade ethyl esters.

In one embodiment, the extraction solvent is substantially free of (i.e. comprises no
25 reasonably measurable quantity of) ethyl lactate, alternatively contains less than 0.0001% of ethyl lactate.

Other extraction solvents useful herein include ketones such as methyl ethyl ketone, ethers such as di-n-propyl ether, lactones, acetals, and mixtures thereof.

Other extraction solvents useful herein include those selected from hexane, cyclohexane,
30 heptane, chloroform, toluene, methylene chloride, methyl nonafluoroether, ethyl nonafluoroether, carbon tetrachloride, and mixtures thereof. HFE 7100, HFE 7200, and HFE 7500 are tradenames of commercially available hydrofluoroethers available from TCI AMERICA, 9211 N. Harborside Street, Portland, OR 97203, U.S.A.

Mixtures of extraction solvents may also be used.

In one embodiment, the extraction mixture is substantially free of (i.e. comprises no reasonably measurable quantity of) THF.

In one embodiment, the extraction mixture comprises mono alkyl phosphate and is
5 substantially free of (i.e. comprises no reasonably measurable quantity of) 1-octanol and phenoxy ethanol.

Extraction solvents useful herein also include supercritical fluids such as carbon dioxide. As used herein, "supercritical carbon dioxide" is carbon dioxide that is at a temperature and a pressure greater than $T_r=1$ and $P_r=1$. T_r is T/T_c where T is the present temperature of the
10 supercritical carbon dioxide and T_c is the critical temperature. P_r is P/P_c where P is the present pressure of the supercritical carbon dioxide and P_c is the critical pressure. T_c , the critical temperature for carbon dioxide (CO₂), is 31.1 degrees Celsius (deg. C.), or 304.1 degrees Kelvin (K), and P_c is 73 atmospheres (atm) or about 1073 pounds per square inch (PSI).

In more general terms, supercritical carbon dioxide refers to carbon dioxide that is in a
15 fluid state while also being at or above both its critical temperature and pressure. Carbon dioxide usually behaves as a gas in air at standard temperature and pressure (STP) or as a solid called dry ice when frozen. If the temperature and pressure are both increased from standard temperature and pressure to be at or above the critical point for carbon dioxide, it can adopt properties midway between a gas and a liquid. More specifically, it behaves as a supercritical fluid above its
20 critical temperature (31.1 deg. C.) and critical pressure (73 atm), expanding to fill its container like a gas but with a density like that of a liquid. The supercritical fluid region of the phase diagram is defined as a temperature above the critical temperature (31.1 deg. C.) to a pressure above the critical pressure (73.8 bar or 1070 PSI).

When using a supercritical fluid as the extraction solvent, it is possible to choose a
25 "batch-type" system or choose a "continuous-type" system. The batch systems can be used in parallel or in series, operated on a cyclic basis (at prescribed residence times), be sequentially loaded, processed, and unloaded, and yield a sufficient bulk removal efficiency. The "continuous-type" systems generally refer to a number of batch vessels, operated sequentially, with the supercritical carbon dioxide gas flow and the sequential loading, processing, and unloading of the
30 feed and product solids can be envisioned as counter current flow of the solids movement from feed to product with respect to the flow of the supercritical carbon dioxide. The directional loading, processing, and unloading is opposite to the flow of the supercritical carbon dioxide. This type of "continuous", counter current operation is generally referred to as continuous, counter current, sequencing-batch operation. Therefore, when there are one or two batch stages,

in series or parallel, the term "batch" tends to be used, and when there are three or more stages, if they operate in parallel flow to the supercritical carbon dioxide, the term "batch" is also used. However, when they operate in counter current flow of the material to be extracted to the supercritical carbon dioxide, we call them counter current "sequencing-batch" simulating counter
5 current flows of material feed and desired product to the flow direction of the supercritical carbon dioxide. It should be understood that "continuous" can also define a process in which the feed and solvent are fed continuously through a fixed system and the products are continuously removed.

When the supercritical fluid is selected as the extraction solvent, the separation of the
10 aqueous phase from the solvent phase may occur by releasing the temperature and pressure placed upon the supercritical fluid, allowing the fluid to return to a gaseous state.

The solvents selected for the solubilization method of this invention are based upon solubility parameters and cohesion properties explained by Charles Hansen in "Hansen Solubility Parameters: A User's Handbook" by Charles M. Hansen, CRC Press (2007) and in "The CRC
15 Handbook and Solubility Parameters and Cohesion Parameters," Edited by Allan F. M. Barton (1999). Each material is defined by three points in 3D space and these three points are known as the Hansen Solubility Parameters (HSP) which may be defined as follows.

Solubility parameters are theoretically calculated numerical constants which are a useful tool in predicting the ability of a solvent material to dissolve a particular solute. When the
20 solubility parameters of a solvent falls within the solubility parameter range of a solute, i.e., the material to be dissolved, solubilization of the solute is likely to occur. There are three Hansen empirically- and theoretically-derived solubility parameters, a dispersion-force component (δ_D), a polar or dipole interaction component (δ_P) and a hydrogen-bonding component (δ_H). Each of the three parameters (i.e., dispersion, polar and hydrogen bonding) represents a different
25 characteristic of solvency, or solvent capability. In combination, the three parameters are a measure of the overall strength and selectivity of a solvent. The Total Hansen solubility parameter, which is the square root of the sum of the squares of the three parameters mentioned previously, provides a more general description of the solvency of the solvents. Individual and total Solubility Parameter units are given in $\text{MPa}^{0.5}$ or $(\text{J/cc})^{0.5}$.

30 These three parameters can be treated as co-ordinates for a point in three dimensions also known as the Hansen space. The nearer two molecules are in this three dimensional space, the more likely they are to dissolve into each other. To determine if the parameters of two molecules (usually a solvent and a polymer) are within range a value called interaction radius (R_0) is given to the substance being dissolved. This value determines the radius of the sphere in Hansen space

and its center is the three Hansen parameters. To calculate the distance (Ra) between Hansen parameters in Hansen space the following formula is used.

$$(Ra)^2 = 4(\delta_{d2} - \delta_{d1})^2 + (\delta_{p2} - \delta_{p1})^2 + (\delta_{h2} - \delta_{h1})^2$$

The Hansen solubility parameters can be calculated by “Molecular Modeling Pro” software, version 5.1.9 (ChemSW, Fairfield CA, www.chemsw.com) or Hansen Solubility from Dynacomp Software. The solubility parameters of solvents useful herein are shown in Table 1, below.

Table 1

Component	Dispersion (δ_D)	Polarity (δ_P)	Hydrogen Bonding (δ_H)	Ra (With Ethyl Acetate)	Ra (With Dodecanol)
ethyl acetate	15.8	5.3	7.2	0	4.5
Carbon Dioxide	15.7	6.3	5.7	1.8	5.7
hexane	14.9	0	0	9.1	10.0
heptanes	15.3	0	0	9	10.2
benzene	18.4	0	2	9.1	11.8
diethyl ether	14.5	2.9	5.1	4.1	4.3
di-n-propyl ether	15.5	2.3	4.5	4.1	5.7
methylene chloride	18.2	6.3	6.1	5	9.4
carbon tetrachloride	17.8	0	0.6	9.4	12.0
propylene Carbonate	20	18	4.1	15.5	19.6
propylene glycol methyl ether acetate	15.6	5.6	9.8	2.6	3.9
1,1,1- trichloroethane	16.8	4.3	2	5.7	9.2
methyl nonafluorobutyl ether*	13.74	3.59	4.14	5.4	5.2
ethyl nonafluorobutyl ether*	14.31	4.36	3.98	4.5	5.5

* Methyl and Ethyl Nonafluorobutyl Ethers are commercially available from TCI AMERICA,

9211 N. Harborgate Street, Portland, OR 97203, U.S.A.

Undesirable Non-Polar Material

The compositions of the present invention contain at least 0.01% of undesirable non-polar materials. In one embodiment the composition contains from about 0.01% to about 20%, by weight of the composition, of undesirable non-polar materials. In one embodiment, the

composition contains from about 0.01% to about 10%, alternatively from about 0.01% to about 7%, alternatively from about 0.1% to about 5%, of undesirable non-polar materials, all by weight of the composition.

As used herein "undesirable non-polar materials" refers generally to any non-polar materials that are found in the water-soluble surfactant composition in need of treatment. In one embodiment, the undesirable non-polar materials are selected from residual alcohols, alcohol ethoxylates, aldehydes, ethers, ketones, alkylamines, amides, and esters.

In one embodiment, the undesirable non-polar materials may be off-tasting components selected from impurities, unreacted starting materials, by-products and/or contaminants. Such undesirable non-polar materials may be described by consumers as soapy, bitter, metallic, earthy or dirty, and astringent. Soapy is typically characterized by the presence of dodecanal or dodecanol. Bitter taste may occur in the presence of alkyl amines or alcohols.

In one embodiment, the water-soluble surfactant is cocoamidopropyl betaine and the composition contains at least 0.001%, by weight of the composition, alternatively from 0.005% to 20%, by weight of the composition of amine and amide materials.

In one embodiment, the water-soluble surfactant is cocoamidopropyl betaine and the composition contains at least 20% cocoamidopropyl betaine surfactant and contains at least 0.001%, alternatively from 0.005% to 20%, by weight of the composition, of amine and amide materials.

In one embodiment, the composition contains at least 0.001%, alternatively at least 0.005%, by weight of the composition, of total alcohols.

Useful in liquid-liquid extraction processes

As used herein, liquid-liquid extraction, also known as solvent extraction and partitioning, refers to a standard method to separate compounds based upon their relative solubilities in two different immiscible liquids, here, water and a solvent. It is an extraction of a substance from one liquid phase into another liquid phase. The "liquid-liquid" phrase refers to the two different immiscible liquids that are mixed as part of the extraction procedure. As used herein, immiscible refers to the ability of the two liquids to form at least two layers when mixed together. The layers may be formed after mixing the two liquids and allowing them to sit at rest for a variable period of time, or in some instances, the mixture of the two liquids may be centrifuged and/or cooled below room temperature in order to assist the separation.

Typically in liquid-liquid extraction, one of the phases will be aqueous, and the other a non-polar lipophilic organic solvent such as ether, MTBE, dichloromethane, chloroform, or ethyl

acetate. Most organic solvents float on top of an aqueous phase, though important exceptions are most halogenated solvents.

Equipment typically used in a laboratory setting for liquid-liquid extraction includes a separatory funnel. In a small scale plant or lab, batch-wise liquid-liquid extraction methods may
5 be used, such as by mixing the two liquids and then introducing them into a large scale separatory funnel. In larger scale plant production, a multistage continuous counter current extractor may be used to quickly and easily run multiple extractions in sequence. In one embodiment, the process includes the use of a machine selected from centrifugal contactors, thin
10 layer extractors, spray columns, pulsed columns, and mixer-settlers, and combinations thereof, in the extraction process.

In many instances, a separatory funnel has the shape of a cone surmounted by a hemisphere. It has a stopper at the top and stopcock (tap), at the bottom. Separating funnels used
15 in laboratories are typically made from borosilicate glass and their stopcocks are made from glass or PTFE. Typical sizes are between 50 mL and 3 L. In industrial chemistry they can be much bigger and for much larger volumes, centrifuges are used.

To use a separatory funnel, the extraction mixture is introduced into the separatory funnel through the top with the stopcock at the bottom closed. The funnel is then closed and shaken
20 gently by inverting the funnel multiple times. The funnel is then inverted and the tap carefully opened to release excess vapor pressure. The separating funnel is set aside to allow for the complete separation of the phases. The top and the bottom tap are then opened and the two phases are individually released by gravitation and separately captured.

Water-Soluble Surfactant

The compositions disclosed herein contain a water-soluble surfactant and one more
25 undesirable non-polar materials. Water-soluble surfactants in aqueous solutions containing undesirable non-polar materials that may be useful herein include those commercially available from suppliers such as Rhodia (located in Spartanburg, South Carolina, USA), Stepan (located in Metamoros, Mexico and Winder, Georgia, USA), Croda (located in Edison, New Jersey, USA) and Clariant (located in Charlotte, North Carolina, USA).

30 Many commonly used water-soluble surfactant raw materials are produced by commercial suppliers as aqueous solutions at fairly high concentrations. These surfactants are good candidates for odor, color, and/or taste improvement by liquid-liquid extraction and may be used in the compositions set forth herein.

Water-soluble alkyl phosphate surfactant compositions that may be used in the compositions set forth herein include commercially available compositions shown in Table 1:

Table 1

Supplier	Trade-name	Alkyl	Chain	Concentration (in aqueous solution)	Salt	EO #	Average MW
Croda	230K	Mono	Laureth	40%	Potassium	0	266.317
Rhodia	L204K	Mono	Laureth	20%	Potassium	0	266.317
Rhodia	L213/S	Mono	Laureth	30%	Sodium	1	310.3712
Clariant	340D	Di	Laureth	40%	none	4	442.5305
Rhodia	L130	Mono	Laureth	100%	none	3	398.4774
Rhodia	L190	Mono	Laureth	100%	none	9	662.7968

5 Aqueous Phase

As used herein, "aqueous phase" refers to the portion of the composition herein containing water, water-soluble surfactant, and other water-soluble materials.

Solvent Phase

As used herein, "solvent phase" refers to the portion of the composition herein containing the extraction solvent, the undesirable non-polar materials, and other water-insoluble materials.

Generally, the solvent phase and the aqueous phase will be immiscible.

EXAMPLES

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EXAMPLE I

Composition Containing MAP L213/S Surfactant

A composition according to the present invention was made by combining MAP L213/S mono alkyl phosphate surfactant supplied by Rhodia, and containing undesirable non-polar materials and water, with ethyl acetate (supplied by Honeywell Burdick & Jackson, Muskegon, MI, USA) as the extraction solvent.

To form the composition, 100 grams of MAP L213/S were placed into a clean 250 mL separatory funnel and 100 mL of ethyl acetate was added to the separatory funnel, which was stoppered, and shaken vigorously for 1 minute, forming a composition according to the present invention. By allowing the contents of the separatory funnel to rest for 1 hour, the composition settled into two layers, an aqueous phase and a solvent phase.

Such composition may be used in a liquid-liquid extraction process to improve the taste of the mono alkyl phosphate surfactant.

EXAMPLE II

Composition Containing Cocoamidopropyl Betaine Surfactant

5 A composition according to the present invention was made by combining cocoamidopropyl betaine surfactant, supplied by Stepan, Mexico SA DE CV (Matamoros, MX), and containing undesirable non-polar materials and water, with ethyl acetate (supplied by Honeywell Burdick & Jackson, Muskegon, MI, USA) as the extraction solvent.

10 To form the composition, 20 grams of cocoamidopropyl betaine surfactant were placed into a clean 250 mL separatory funnel and 20 mL of ethyl acetate was added to the separatory funnel, which was stoppered, and shaken vigorously for 1 minute, forming a composition according to the present invention. By allowing the contents of the separatory funnel to rest for 1 hour, the composition settled into two layers, an aqueous phase and a solvent phase.

15 Such composition may be used in a liquid-liquid extraction process to improve the taste of the cocoamidopropyl betaine surfactant.

EXAMPLE III

Composition Containing Lauryl Betaine Surfactant

20 A composition according to the present invention was made by combining lauryl betaine surfactant, supplied by Mason Chemical Company (Arlington Heights, IL, USA), and containing undesirable non-polar materials and water, with ethyl acetate (supplied by Honeywell Burdick & Jackson, Muskegon, MI, USA) as the extraction solvent.

25 To form the composition, 100 grams of lauryl betaine surfactant were placed into a clean 250 mL separatory funnel and 100 mL of ethyl acetate was added to the separatory funnel, which was stoppered, and shaken vigorously for 1 minute, forming a composition according to the present invention. By allowing the contents of the separatory funnel to rest for 1 hour, the composition settled into two layers, an aqueous phase and a solvent phase.

Such composition may be used in a liquid-liquid extraction process to improve the taste of the lauryl betaine surfactant.

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EXAMPLE IV

Composition Containing Sodium Lauryl Sulfate Surfactant

A composition according to the present invention was made by combining sodium lauryl sulfate surfactant, supplied by Stepan (Winder, GA, USA), and containing undesirable non-polar materials and water, with ethyl acetate (supplied by Honeywell Burdick & Jackson, Muskegon, MI, USA) as the extraction solvent.

35

To form the composition, 100 grams of sodium lauryl sulfate surfactant were placed into a clean 250 mL separatory funnel and 100 mL of ethyl acetate was added to the separatory funnel, which was stoppered, and shaken vigorously for 1 minute, forming a composition according to the present invention. By allowing the contents of the separatory funnel to rest for 1
5 hour, the composition settled into two layers, an aqueous phase and a solvent phase.

Such composition may be used in a liquid-liquid extraction process to improve the taste of the sodium lauryl sulfate surfactant.

The dimensions and values disclosed herein are not to be understood as being strictly limited to the exact numerical values recited. Instead, unless otherwise specified, each such
10 dimension is intended to mean both the recited value and a functionally equivalent range surrounding that value. For example, a dimension disclosed as "20 g" is intended to mean "about 20 g." All percentages, ratios and proportions herein are on a weight basis unless otherwise indicated. Except as otherwise noted, all amounts including quantities, percentages, portions, and proportions, are not intended to indicate significant digits.

It should be understood that every maximum numerical limitation given throughout this
15 specification includes every lower numerical limitation, as if such lower numerical limitations were expressly written herein. Every minimum numerical limitation given throughout this specification will include every higher numerical limitation, as if such higher numerical limitations were expressly written herein. Every numerical range given throughout this
20 specification will include every narrower numerical range that falls within such broader numerical range, as if such narrower numerical ranges were all expressly written herein.

Except as otherwise noted, the articles "a", "an", and "the" mean "one or more".

As used herein, "comprising" means that other steps and other ingredients which do not affect the end result can be added. This term encompasses the terms "consisting of" and
25 "consisting essentially of". The compositions and methods/processes of the present invention can comprise, consist of, and consist essentially of the essential elements and limitations of the invention described herein, as well as any of the additional or optional ingredients, components, steps, or limitations described herein.

Every document cited herein, including any cross referenced or related patent or
30 application, is hereby incorporated herein by reference in its entirety unless expressly excluded or otherwise limited. The citation of any document is not an admission that it is prior art with respect to any invention disclosed or claimed herein or that it alone, or in any combination with any other reference or references, teaches, suggests or discloses any such invention. Further, to the extent that any meaning or definition of a term in this document conflicts with any meaning

or definition of the same term in a document incorporated by reference, the meaning or definition assigned to that term in this document shall govern.

While particular embodiments of the present invention have been illustrated and described, it would be obvious to those skilled in the art that various other changes and
5 modifications can be made without departing from the spirit and scope of the invention. It is therefore intended to cover in the appended claims all such changes and modifications that are within the scope of this invention.

CLAIMS

What is claimed is:

1. A composition useful in liquid-liquid extraction processes for improving the taste of water-soluble surfactants, said composition comprising:

- a. from 5% to 60%, by weight of the composition, of water soluble surfactant;
- b. from 10% to 90%, by weight of the composition, of water;
- c. from 10% to 90%, by weight of the composition, of extraction solvent;
- d. at least 0.01%, by weight of the composition, of undesirable non-polar materials;

wherein the extraction solvent is selected from solvents having individual Hansen solubility parameters of a dispersion force component (δ_D) ranging from 15 to 17 (MPa)^{0.5}, a polar component (δ_P) ranging from 0 to 9 (MPa)^{0.5} and a hydrogen bonding component (δ_H) ranging from 0 to 11 (MPa)^{0.5}.

2. A composition according to Claim 1 wherein the composition comprises an aqueous phase and a solvent phase.

3. A composition according to Claim 2 wherein the aqueous phase comprises the water soluble surfactant and water.

4. A composition according to Claim 2 or Claim 3 wherein the solvent phase comprises the extraction solvent and at least one undesirable non-polar material.

5. A composition according to any one of the preceding claims wherein the water-soluble surfactant is selected from anionic surfactants, zwitterionic surfactants, amphoteric surfactants and mixtures thereof and is at least 30% soluble in water.

6. A composition according to Claim 1 or Claim 5 wherein the water soluble surfactant is selected from alkyl phosphate surfactants, alkyl phosphate ethoxylated surfactants, lauryl sulfate surfactants, betaine surfactants, betaine ethoxylated surfactants, amine oxide surfactants, and mixtures thereof and is preferably selected from cocoamidopropyl betaines, alkyl ethoxylated phosphates, mono alkyl phosphates and mixtures thereof.

7. A composition according to any one of the preceding claims wherein the extraction solvent is selected from ethyl acetate, water-saturated ethyl acetate, ethyl propionate, ethyl butyrate, ethyl

pentanoate, ethyl caproate, ethyl caprylate, ethyl pelargonate methyl acetate, methyl propionate, methyl butyrate, short chain esters, supercritical carbon dioxide, and mixtures thereof.

8. A composition according to any one of the preceding claims wherein the composition further comprises a phase separation enhancer selected from salt, pH modifiers, and mixtures thereof.

9. A composition according to Claim 1, said composition consisting essentially of:

- a. from 30% to 60% of a water soluble surfactant;
- b. from 20% to 80% water;
- c. from 20% to 80% of ethyl acetate;
- d. from 0.01% to 20%, by weight of the composition, of undesirable non-polar materials.

10. Use of a composition according to Claim 1 in a liquid-liquid extraction process.