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(54) Title: HYDROCARBON-TERMINATED POLYETHER-POLYAMIDE BLOCK COPOLYMERS AND USES THEREOF

(57) Abstract: A block copolymer of the formula hydrocarbon-polyether-polyamide-polyether-hydrocarbon is described. The copolymer may be prepared by reacting together reactants that include dimer acid, diamine, and a polyether having both hydrocarbon termination and termination selected from one of amine, hydroxyl and carboxyl. The copolymer may be combined with a solvent to form a gel, where the gel may be transparent and may be incorporated into household and consumer products including antiperspirants.



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HYDROCARBON-TERMINATED POLYETHER-POLYAMIDE BLOCK COPOLYMERS AND USES THEREOF

BACKGROUND OF THE INVENTION

Field of the Invention

5 This invention generally relates to organic resins, more particularly to resins having an internal structure comprised of polyamide and polyether, and terminal structure comprised of hydrocarbon. The invention also relates to the preparation of these resins, and their use as, for example, gelling agents for organic solvents.

Description of the Related Art

10 In many commercially important compositions, the consistency of the product is critical to its commercial success. One example is personal care products, which generally contain one or more active ingredients within a carrier formulation. While the active ingredient(s) determine the ultimate performance properties of the product, the carrier formulation is equally critical to the commercial success of the
15 product in that it largely determines the consistency of the product. The rheology of the carrier (also referred to as the "base") largely determines the flow properties of the product, and the flow properties largely determine the manner in which the consumer will apply or use the product.

 For example, aluminum chlorohydrate, aluminum-zirconium
20 tetrachlorohydrate, aluminum-zirconium polychlorohydrate complexed with glycine, and aluminum-zirconium complexed with any of trichlorohydrate, octachlorohydrate, and sesquichlorohydrate are metal salts that are commonly used as active ingredients in deodorant and antiperspirant products. Consumers have shown a preference for applying deodorant from a stick form. Thus, the carrier in a stick-form deodorant must
25 be a relatively hard substance, and waxy fatty alcohol such as stearyl alcohol has often been used as the carrier in these products. As another example, the active ingredient in a lipstick is the colorant. A lipstick should not be as hard as a stick deodorant, but of course must maintain its shape when undisturbed at room temperature. A blend of wax and oil is known to provide a consistency that is well suited as a carrier for a lipstick.
30 As a final example, shampoo desirably has a viscosity greater than water, and when the active ingredient(s) in a shampoo does not have a sufficiently high viscosity, a somewhat viscous carrier material is desirably included in the shampoo formulation.

From the above examples, it is seen that formulators of personal care products depend upon the availability of materials having various rheological properties, in order to formulate a successful personal care product. Materials which have a gel-like character, in that they maintain their shape when undisturbed but flow upon being rubbed, are often desired for personal care products.

Transparent (*i.e.*, clear) carriers are desired by formulators who develop a personal care product wherein colorant is an active ingredient, because a transparent carrier (as opposed to an opaque carrier) will minimally, if at all, interfere with the appearance of the colorant. In recent years, consumers have demonstrated an increasing preference for transparent and colorless personal care products such as deodorants and shampoos. There is thus an increasing demand for transparent materials that can provide the rheological properties needed for various personal care products, and particularly which can impart gel-like character to a formulation.

Polyamide resin prepared from polymerized fatty acid and diamine is reported to function as a gellant in formulations developed for personal care products. For example, U.S. Patent No. 3,148,125 is directed to a clear lipstick carrier composition formed from polyamide resin compounded with a lower aliphatic alcohol and a so-called "polyamide solvent." Likewise, U.S. Patent No. 5,500,209 is directed to forming a gel or stick deodorant, where the composition contains polyamide gelling agent and a solvent system including monohydric or polyhydric alcohols. Thus, the prior art recognizes to blend certain polyamides with alcohols, to thereby form a gel.

Polar solvents, *e.g.*, ether- and hydroxyl-containing materials which are liquid at or slightly above room temperature, are desirably included in personal care formulations because they are often benign, allow dilution with at least some water, dissolve a wide range of active and inactive formulation ingredients and are relatively inexpensive. Polar solvents are also available in a wide variety of viscosities and grades. However, these solvents typically do not have the rheological properties that are desired in a carrier, *e.g.*, they do not naturally exhibit gel-like character. Furthermore, gellants for this type of solvent are uncommon and often unavailable.

Accordingly, there is a need in the art for materials that can be combined with solvents, and particularly polar solvents, to afford a transparent material that has gel-like character. The present invention provides this and related advantages as described herein.

BRIEF SUMMARY OF THE INVENTION

In one aspect, the present invention provides a block copolymer of the formula: hydrocarbon-polyether-polyamide-polyether-hydrocarbon. The present invention also provides compositions that include this block copolymer, where such compositions may also include one or more of a diacid, diamine or hydrocarbon-terminated polyether.

In various aspects: the polyamide block includes blocks of the formula $\left(R^3 - \overset{\text{O}}{\parallel} \text{CNH} - R^4 - \text{HNC} \overset{\text{O}}{\parallel} \right)$, where R^3 is a hydrocarbon diradical, preferably dimer acid-derived, *e.g.*, wherein the R^3 group includes a diradical that results when two carboxylic acid groups are removed from dimer acid; R^4 is selected from a hydrocarbon and a polyether diradical; the polyether block includes blocks of the formula $\left(R^2 - \text{O} \right)$, where R^2 is a hydrocarbon; C_{1-22} hydrocarbon radicals are located at either end of the copolymer, where the hydrocarbon radical may optionally be selected from alkyl, aralkyl, aryl, and alkaryl radicals.

In other aspects, the copolymer has the formula $R^1 \left(\text{O} - R^2 \right)_x \overset{\text{O}}{\parallel} \text{ZC} \left(R^3 - \overset{\text{O}}{\parallel} \text{CNH} - R^4 - \text{HNC} \overset{\text{O}}{\parallel} \right)_y R^3 - \overset{\text{O}}{\parallel} \text{CZ} \left(R^2 - \text{O} \right)_z R^1$ wherein, independently at each occurrence, R^1 is selected from C_{1-22} hydrocarbon radicals; R^2 is selected from C_{2-6} hydrocarbon diradicals; R^3 is selected from C_{2-52} hydrocarbon diradicals, where at least 50% of the R^3 diradicals have at least 34 carbons; R^4 is selected from C_{2-36} hydrocarbon diradicals and $C_4 - C_{100}$ polyether diradicals; Z is selected from O and NH; x is an integer from 2 to 100; y is an integer from 1 to 10; Z is NH; R^2 is a C_2 hydrocarbon diradical; and at least 80% of the R^3 diradicals have at least 34 carbon atoms.

In various aspects, the present invention provides a composition that includes a copolymer as described above, that meets one or more of the following criteria: an acid number of less than 25; an amine number of less than 5; a softening point of 50-150°C; a weight average molecular weight of 2,000 to 20,000; a melting point above 50°C and a viscosity at 160°C of less than 5,000 cps.

In another aspect, the present invention provides a process of preparing a block copolymer where the process includes reacting together reactants that include dimer acid, diamine, and a polyether having both hydrocarbon termination and termination selected from one of amine, hydroxyl and carboxyl. The polyether may

have the formula $R^1-(O-R^2)_x-W$ where R^1 is selected from C_1-C_{22} hydrocarbyl, R^2 is selected from C_2-C_6 hydrocarbyl, x is an integer presenting the number of repeating ether units, and W is selected from amine, hydroxyl and carboxyl. The present invention also includes a copolymer and composition prepared by this process.

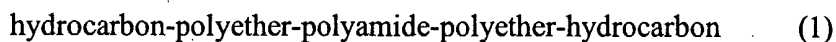
5 In another aspect, the present invention provides a gelled composition that includes a hydrocarbon-terminated block copolymer as described above, and a polar organic solvent, the solvent having hydroxyl and/or ether functionality. In a related aspect, the present invention provides a method for preparing a gel, where the method includes combining a hydrocarbon-terminated block copolymer as described
10 above, at elevated temperature with a liquid having hydroxyl and/or ether functionality to provide a mixture, and allowing the mixture to cool to room temperature to form the gel.

In a further aspect, the present invention provides a microemulsion that includes a hydrocarbon-terminated block copolymer as described above, a polar organic
15 solvent, and water.

These and related aspects of the present invention are described more fully herein.

DETAILED DESCRIPTION OF THE INVENTION

In one aspect, the present invention provides a hydrocarbon-terminated
20 block copolymer of the formula (1)



In formula (1), a hydrocarbon group contains only carbon and hydrogen atoms. A polyether groups contains 2 or more ether groups, *i.e.*, groups of the formula hydrocarbon-O-hydrocarbon, where the hydrocarbon of one ether group can also serve
25 as the hydrocarbon of another ether group. A polyamide group contains 2 or more amide groups, *i.e.*, groups of the formula hydrocarbon-C(=O)-NR-hydrocarbon, where the hydrocarbon of one amide group may, or may not, also serve as the hydrocarbon of another amide group, and R is hydrogen or a hydrocarbon. Essentially, R in the amide group is determined by the choice of diamine used in the preparation of the polyamide
30 block of the block copolymer of the present invention. In one aspect, at least one amide group of the polyamide is flanked by polyether groups, while in another aspect all of the amide groups in the polyamide block are flanked by hydrocarbon groups.

Suitable hydrocarbon groups are formed from one or more of aliphatic and aromatic moieties. Suitable aliphatic moieties are alkyl, alkylene, alkenyl,

alkenylene, alkynyl, alkylnylene, cycloalkyl, cycloalkylene, cycloalkenyl, cycloalkenylene, cycloalkynyl, and cycloalkynylene moieties. Aromatic moieties are also referred to herein as aryl groups. The hydrocarbon groups that terminate the block copolymers of the present invention will be referred to herein as R^1 .

5 As used herein, alkyl, alkenyl, alkynyl, cycloalkyl, cycloalkenyl, and cycloalkynyl are monovalent radicals, while alkylene, alkenylene, alkylnylene, cycloalkylene, cycloalkenylene, and cycloalkynylene are polyvalent radicals. As used herein alkyl, alkylene, cycloalkyl, and cycloalkylene are saturated radicals, while
10 alkenyl, alkenylene, alkynyl, alkylnylene, cycloalkenyl, cycloalkenylene, cycloalkynyl, and cycloalkynylene are unsaturated radicals. The alkyl, alkylene, alkenyl, alkenylene, alkynyl, and alkylnylene moieties may be straight chain or branched. The cycloalkyl, cycloalkenyl, cycloalkynyl, cycloalkylene, cycloalkenylene and cycloalkynylene moieties may be monocyclic or polycyclic, where a polycyclic moiety may be, for example, bicyclic or tricyclic.

15 Exemplary alkyl moieties are methyl, ethyl, propyl, hexyl, and 2-ethylhexyl. Exemplary alkylene moieties are methylene ($-\text{CH}_2-$), methylenidene ($=\text{CH}_2$), and ethylene ($-\text{CH}_2\text{CH}_2-$). Exemplary cycloalkyl groups are cyclohexyl and norbornyl.

Suitable aromatic moieties are monocyclic or polycyclic. An exemplary monocyclic aryl group is phenyl, while exemplary polycyclic aryl groups are naphthyl
20 and fulverenyl. The aromatic moiety may be monovalent, *e.g.*, phenyl, or polyvalent, *e.g.*, phenylene.

The hydrocarbon group may be a combination of aromatic and aliphatic groups. For example, benzyl (phenyl- CH_2- , an arylalkylene group), tolyl (CH_3 -phenylene-, an alkylarylene group), and xylyl ($(\text{CH}_3)_2$ phenylene-, a dialkylarylene
25 group). The hydrocarbon group may be a combination of two or more aromatic groups, *e.g.*, biphenyl (phenyl-phenylene-, an arylarylene group).

The R^1 group necessarily contains at least one carbon. In one embodiment, the R^1 group contains 1-32 carbons. In one embodiment, the R^1 alkyl group contains 1-12 carbons. In one embodiment, R^1 is an alkyl group containing 1-4
30 carbons. In one embodiment, the R^1 group is an alkyl group. In one embodiment, the R^1 alkyl group is straight-chained. In one embodiment, the R^1 alkyl group is branched. In one embodiment, R^1 is methyl.

The block copolymer of formula (1) contains at least two polyether blocks. As its name implies, a polyether block contains a plurality of ether groups, *i.e.*,
35 groups of the formula $-\text{C}-\text{O}-\text{C}-$. In other words, a polyether block contains the repeating formula $-\text{O}-\text{R}^2-$ where R^2 is a hydrocarbon group. In one aspect, R^2 is an alkylene

group. The alkylene group R^2 may be aliphatic (saturated and/or unsaturated) or aromatic, straight chain and/or branched, independently at each occurrence in the polyether block. In one aspect, R^2 has 1-6 carbons at each occurrence in the polyether block, while in another aspect R^2 has 2-4 carbons at each occurrence. In one aspect, R^2 has the formula $-CH_2-CH(R^{2a})-$ wherein R^{2a} is selected from hydrogen, methyl and ethyl.

In one aspect, the polyether component of the block copolymer has a molecular weight (measured as either number or weight average) of less than 10,000. In another aspect, the molecular weight is between 100 and 4,000.

The block copolymer of formula (1) contains a polyamide block. As its name implies, the polyamide block contains a plurality of amide groups, *i.e.*, groups of the formula $-NH-C(=O)-$ and/or $-C(=O)-NH-$. In the polyamide block, two or more amide groups are separated by hydrocarbon groups, *e.g.*, alkylene groups and/or polyether groups.

In one aspect, the polyamide block contains $-C(=O)-R^3-C(=O)-$ moieties wherein R^3 is a hydrocarbon group. In one aspect, the polyamide block includes R^3 groups having at least 30 carbons. In one aspect, the polyamide block includes R^3 groups having 30-42 carbons.

In one aspect, the polyamide block includes R^3 groups that are formed from fatty acid polymerization. Fatty acids derived from vegetable oils, tallow, and tall oil (the latter are known as tall oil fatty acids, or TOFA) are commonly subjected to thermal polymerization, typically in the presence of a clay catalyst, to provide a commercially-available product known as dimer acid. These fatty acids contain 18 carbons, so that corresponding dimer acid consists mainly of C_{36} dicarboxylic acids. This dimer acid may be denoted by the structure $HOOC-C_{34}-COOH$, where the C_{34} group is an exemplary R^3 group of the present invention. C_{34} is a mixture of isomeric structures, as more fully described in detailed descriptions of dimer acid, as found in, for example, *Naval Stores - Production, Chemistry and Utilization*, D.F. Zinkel and J. Russel (eds.), Pulp. Chem. Assoc. Inc., 1989, Chapter 23.

Suitable polymerized fatty acids are available commercially as, for example, SYLVADYM™ dimer acid and UNIDYME™ dimer acid, both from Arizona Chemical, company of International Paper, (Jacksonville, FL), EMPOL™ dimer acid from Henkel Corporation, Emery Oleochemicals Division (Cincinnati, OH); and PRIPOL™ dimer acid from Unichema North America (Chicago, IL).

Dimer acid, as commercially available, typically contains some by-products of the fatty acid polymerization process. One common byproduct is so-called

trimer acid, which results when three fatty acid molecules react together to form a C_{64} tricarboxylic acid. It may happen, in the preparation of a block copolymer of the present invention, that two of the carboxylic acid groups of trimer acid will react with, *e.g.*, a diamine, leaving one carboxylic acid group unreacted. When this occurs, the
5 block copolymer will contain a carboxylic acid-substituted R^3 group, which is technically not a hydrocarbon. Accordingly, while block copolymers of the present invention contain hydrocarbon groups between two $NHC(=O)$ groups, they may also contain some, typically a minor amount, of carboxylic acid-substituted hydrocarbon groups between two $NHC(=O)$ groups. For convenience, as used herein, C_{34} refers to
10 the incorporation of dimer acid into a polyamide block, where C_{34} includes the reaction product of some trimer acid that may be a by-product in the commercial dimer acid.

In one aspect, the present invention provides block copolymers of formula (1) wherein each of the $C(=O)$ groups is bonded to C_{34} , *i.e.*, the block copolymer is formed from dimer acid as the exclusive polyacid reactant. However, in
15 another aspect, the polyamide block includes both C_{34} and "co-diacid"-derived R^3 groups. Thus, the polyamide block may be formed by reacting both dimer acid and co-diacid with a diamine. However, in a preferred embodiment of the invention, dimer acid is used without any co-diacid in preparing the polyamide block of the block copolymer.

20 As used herein, a co-diacid is a compound of formula $HOOC-R^3-COOH$ where R^3 is not C_{34} as defined above. In one aspect, the polyamide block in copolymers of formula (1) includes R^3 groups having 2-32 carbons, which are referred to herein a co-diacid R^3 groups. Suitable co-diacid R^3 groups include ethylene (from, *e.g.*, succinic acid) and *n*-butylene (from, *e.g.*, adipic acid).

25 In one aspect, the C_{34} R^3 groups constitute at least 50 mol% of the total of the R^3 groups. In other aspects, the C_{34} R^3 groups constitute at least 60 mol%, or 70 mol%, or 80 mol%, or 90 mol%, or 95 mol% of the R^3 groups. Stated another way, dimer acid contributes at least 50% of the diacid equivalents, or at least 60%, or 70%, or 80%, or 90%, or 95% of the diacid equivalents in the polyamide block of the
30 copolymer of formula (1).

In one aspect, the polyamide block contains $-NH-R^4-NH-$ moieties wherein R^4 is a hydrocarbon group. In one aspect, the R^4 hydrocarbon groups has 1-20 carbons. In one aspect, the polyamide block includes R^4 groups having 1-10 carbons. In one aspect, the R^4 group is an alkylene group. In one aspect, R^4 is a straight-chained
35 alkylene group. In one aspect, the polyamide block includes R^4 groups having 2

carbons, while in another aspect at least 50% of the R^4 groups have 2 carbons, while in another aspect all of the R^4 groups have 2 carbons.

In one aspect, the polyamide block contains $-NH-R^4-NH-$ moieties wherein R^4 is a polyether group. As defined above, a polyether block contains a plurality of ether groups, *i.e.*, groups of the formula $-C-O-C-$. In other words, a polyether block contains the repeating formula $-O-R^2-$ where R^2 is a hydrocarbon group. In one aspect, R^2 is an alkylene group. The alkylene group R^2 may be aliphatic (saturated and/or unsaturated) or aromatic, straight chain and/or branched, independently at each occurrence in the polyether block. In one aspect, R^2 has 1-6 carbons at each occurrence in the polyether block, while in another aspect R^2 has 2-4 carbons at each occurrence. In one aspect, R^2 has the formula $-CH_2-CH(R^{2a})-$ wherein R^{2a} is selected from hydrogen, methyl and ethyl.

In one aspect, the polyether component of the R^4 portion of the block copolymer of the present invention has a molecular weight (number or weight average) of less than 10,000. In another aspect, the molecular weight is between 100 and 4,000.

Compounds of the formula $H_2N-R^4-NH_2$ are commonly known as diamines, and are available from a large number of vendors. Compounds of the formula $HOOC-R^3-COOH$ are commonly known as diacids, or dibasic acids, and are likewise available from a large number of vendors. Aldrich (Milwaukee, WI; www.sigma-aldrich.com); EM Industries, Inc. (Hawthorne, NY; <http://www.emscience.com>); Lancaster Synthesis, Inc. (Windham, NH; <http://www.lancaster.co.uk>) are three representative vendors.

In formula (1), the bond '-' between hydrocarbon and polyether represents a C-O bond where the carbon is contributed by the hydrocarbon and the oxygen is contributed by the polyether.

In formula (1), in one aspect, the bond between polyether and polyamide is $C-NH-C(=O)-C$ where $C-NH$ may be seen as being contributed by the polyether and $C(=O)-C$ may be seen as being contributed by the terminal acid group of a polyamide. Block copolymers according to this aspect may be formed by, for example, reacting an amino and hydrocarbon terminated polyether of the formula $R^1-(O-R^2)-NH_2$ with a carboxylic acid terminated polyamide of the formula $HOOC-NH-R^4-NH-$ etc. so as to form $R^1-(O-R^2)-N-C(=O)-R^4$. Thus, an amide group may be present as the link between polyether and polyamide in formula (1).

In formula (1), in one aspect, the bond between polyether and polyamide is $C-C(=O)-NH-C$ where $C-C(=O)$ may be seen as being contributed by the polyether and $NH-C$ may be seen as being contributed by the terminal amine group of a

polyamide. Block copolymers according to this aspect may be formed by, for example, reacting a carboxylic acid and hydrocarbon terminated polyether of the formula $R^1-(O-R^2)-COOH$ with an amine terminated polyamide of the formula $H_2N-R^4-NH-C(=O)-R^3$ -etc. so as to form $R^1-(O-R^2)-C(=O)-NH-R^4-NH-C(=O)-R^3$ -etc. Thus, once again, an amide group may be present as the link between polyether and polyamide in formula (1). However, urethane groups are preferably not a part of the block copolymer of the present invention.

In formula (1), in one aspect, the bond between polyether and polyamide is $C-O-C(=O)-C$ where $C-O$ may be seen as being contributed by the polyether and $C(=O)$ may be seen as being contributed by the terminal acid group of a polyamide. Block copolymers according to this aspect may be formed by, for example, reacting a hydroxyl and hydrocarbon terminated polyether of the formula $R^1-(O-R^2)-OH$ with a carboxylic acid terminated polyamide of the formula $HOOC-NH-R^4-NH$ -etc. so as to form $R^1-(O-R^2)-O-C(=O)-R^4$. Thus, an ester group may be present as the link between polyether and polyamide in formula (1). In various aspects of the invention, the block copolymer contains 0 ester groups (*e.g.*, when the polyether is amine terminated rather than hydroxyl terminated), or no more than 1 ester group (when a mixture of amine terminated and hydroxyl terminated polyether are used), or no more than 2 ester groups.

In one aspect, the present invention provides a composition comprising a hydrocarbon-terminated polyether-polyamide block copolymer of the present invention having an acid number of less than 25, or less than 20, or less than 15, or less than 10. The hydrocarbon-terminated polyether-polyamide block copolymer of formula (1) does not have any free carboxylic acid groups, and accordingly has an acid number of zero. However, when prepared from diacid, diamine and hydrocarbon-terminated polyether according to a process described herein, some of the diacid may not react with the diamine and/or polyether, and according the final product may have some unreacted carboxylic acid that will be responsible for the product having an acid number greater than zero. Preferably, the product has a minor amount of this unreacted diacid, and thus has only a small acid number. Esterification catalysts may be used to encourage all of the diacid to react with hydroxyl groups, so as to minimize the amount of free acid, *i.e.*, to reduce the acid number of the product.

In one aspect, the present invention provides a composition comprising a hydrocarbon-terminated polyether-polyamide block copolymer of the present invention having an amine number of less than 25, or less than 20, or less than 15, or less than 10, or less than 5 or less than 2 or less than 1. The hydrocarbon-terminated polyether-polyamide block copolymer of formula (1) does not have any free amine groups, and

accordingly has an amine number of zero. However, when prepared from diacid, diamine and hydrocarbon-terminated polyether according to a process described herein, some of the diamine may not react with the diacid, and according the final product may have some unreacted amine groups that will be responsible for the product having an amine number greater than zero. Preferably, the product has a minor amount of this unreacted diamine, and thus has only a small amine number. Amidification catalysts may be used to encourage all of the diamine to react with carboxyl groups, so as to minimize the amount of free amine, *i.e.*, to reduce the amine number of the product.

In one aspect, the present invention provides hydrocarbon-terminated polyether-polyamide block copolymers, and compositions containing these copolymers, that has a softening point of 50-150°C (Ring and Ball, or Mettler). In another aspect, the softening point is 75-125°C, while in another aspect the softening point is 75-100°C, while in another aspect the softening point is 80-120°C.

In one aspect, the present invention provides hydrocarbon-terminated polyether-polyamide block copolymers, and compositions containing these copolymers, that has a weight or number average molecular weight of 2,000 to 30,000. The molecular weight is measured by preparing a solution of the copolymer or composition in a suitable solvent, *e.g.*, tetrahydrofuran (THF) and identifying the retention time of the copolymer by gel permeation chromatography, and comparing that retention time to the retention times of solutions of polystyrene having known molecular weight characterizations. In one aspect, the copolymers have a weight or number average molecular weight of greater than 1,000. Among other features, the hydrocarbon termination on the polyether reactant allows for control of the molecular weight of the copolymer. If both ends of the polyether reactant were reactive, *e.g.*, the polyether contained hydroxyl functionality at both ends, then the polyether could not be utilized as a terminator in the preparation of copolymers of the present invention.

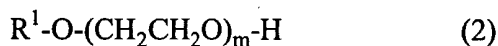
In one aspect, the present invention provides hydrocarbon-terminated polyether-polyamide block copolymers, and compositions containing these copolymers, that have a viscosity, as measured on the neat copolymer or composition at 160°C, of less than 5,000 centipoise (cPs, or cps), or less than 4,000 cPs, or less than 3,000 cPs, or less than 2,000 cPs, or less than 1,000 cPs. Typically, the copolymer and compositions will have a melt viscosity, as measured on the neat copolymer or composition at 160°C, of more than 50 cPs, typically more than 500 cPs.

Block copolymers of the present invention may be prepared by reacting together compounds of the formulae $R^1-(O-R^2)_x-W$, $HOOC-R^3-COOH$, and $H_2N-R^4-NH_2$, where W represents either an amine, hydroxyl or carboxylic acid group. As used

herein an amine group (-NH₂), a carboxylic acid group (-COOH) and a hydroxyl group (-OH) include reactive equivalents thereof. For instance, HOOC-R³-COOH includes reactive equivalents, such as monoesters and diesters, *i.e.*, compounds wherein a carboxylic acid is in esterified form.

5 Compounds of the formula R¹-(O-R²)_x-W wherein W is hydroxyl are also known as ether-terminated polyalkylene glycols. These compounds are generally well known and may be readily prepared by methodology described in the scientific and patent literature. For example, a monohydric initiator, *i.e.*, a compound of the formula R¹-OH is reacted with an alkylene oxide (an R² group that includes an epoxide group),
 10 *e.g.*, ethylene oxide, propylene oxide, etc. to provide a compound of the formula R¹-(O-R²)_x-OH. These compounds are available from, *e.g.* Aldrich Chemical (Milwaukee, WI).

In one aspect, block copolymers are prepared from compounds of formula R¹-(O-R²)_x-W wherein W is hydroxyl and R² is ethylene (-CH₂CH₂-). Such
 15 compounds of formula R¹-(O-R²)_x-W may be referred to herein as ethoxylates or alcohol ethoxylates. Ethoxylates may be obtained from many commercial sources (*e.g.*, Dow, Midland MI) or may be prepared by reacting alcohols of formula R¹-OH with ethylene oxide to give the structure (2) below

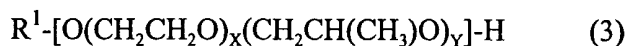


20 where R¹ is a hydrocarbon group as defined previously, and in one aspect is a C₆₋₂₂ alkyl or aralkyl group. Ethoxylates are typically colorless liquids to low melting point pasty solids depending on the chain length (m). Exemplary ethoxylates having various combinations of R¹ groups and molecular weight are given in TABLE A (TABLE A – TYPICAL ETHOXYLATES AND THEIR PROPERTIES). In TABLE A, Manuf. is an
 25 abbreviation for manufacturer, EO is an abbreviation for ethylene oxide, %EO refers to the weight percent ethylene oxide in the product, EO/OH refers to the molar ratio of ethylene oxide to hydroxyl, HLB refers to the hydrophile lipophile balance, Shell refers to the Shell Chemical division of the Royal Dutch/Shell Group of Companies (www.shell.com) where Shell sells alcohol ethoxylates under the NEODOL™
 30 trademark. Also in TABLE A, Condea refers to CONDEA Vista Company (Houston, TX; www.condea.de) which sells a number of alcohol ethoxylates under their brandnames NONFIX™, BIODACT™, LORODACT™, LIALET™, EMULDACT™ and ALFONIC™ where these materials differ by the R¹ group, and the number of ethylene oxide groups in the product.

TABLE A
Typical Ethoxylates and Their Properties

Ethoxylate	Manuf.	R ¹	% EO	EO/OH	MW	HLB
NEODOL™ 23-6.5	Shell	C ₁₂₋₁₃	60	6.6	484	12
NEODOL™ 45-13	Shell	C ₁₄₋₁₅	71.8	12.9	790	14.4
NEODOL™ 91-8	Shell	C ₉₋₁₁	69.7	8.3	524	13.9
ALFONIC™ 610-3.5	Condea	C ₆₋₁₀	50	3.1	276	10
ALFONIC™ 1618-5	Condea	C ₁₆₋₁₈	46	5.1	469	9

In another aspect, block copolymers are prepared from compounds of formula R¹-(O-R²)_x-W wherein W is hydroxyl and R² is one or both of ethylene (-CH₂CH₂-), propylene (-CH₂-CH(CH₃)-), and n-butylene (-CH₂CH₂CH₂CH₂-). Such compounds of formula R¹-(O-R²)_x-W may be referred to herein as polyalkylene glycol derivatives. Polyalkylene glycol derivatives may be obtained from many commercial sources (*e.g.*, Dow, Midland MI; Union Carbide, Danbury, CT; Aldrich, Milwaukee, WI) or may be prepared by reacting alcohols of formula R¹-OH with ethylene oxide and/or propylene oxide to give the structure (3) below:

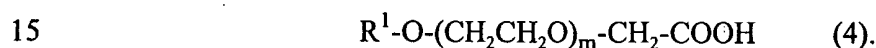


As commercially available, R¹ is commonly methyl or n-butyl, but R¹ can be any hydrocarbon group. Some typical properties of these materials, which are available from, *e.g.*, Union Carbide and Dow, are given in TABLE B (TABLE B – TYPICAL GLYCOLS AND THEIR PROPERTIES). In TABLE B, MPEG stands for methyl ether poly(ethylene glycol) (*i.e.*, R¹ is methyl and the repeating unit is always ethylene so that Y = 0) MBPPG stands for monobutyl ether poly(propylene glycol) (*i.e.*, R¹ is butyl and the repeating unit is always propylene so that X = 0), and MBPEGCPG stands for monobutyl ether poly(ethylene glycol-co-propylene glycol), 50/50 PPG/PPE (*i.e.*, R¹ is butyl and the repeating unit is both ethylene and propylene, so that X and Y are each equal to or greater than 1).

TABLE B
Typical Polyalkyl Glycols and Their Properties

Glycol	Manuf.	R ¹	MW	T _m (°C) or Visc @ 20°C (cSt)
MPEG 350	DOW	CH ₃	350	-8
MPEG 550	DOW	CH ₃	550	20
MPEG 750	DOW	CH ₃	750	30
MPEG 2000	Aldrich	CH ₃	2000	52
MBPPG 340	Aldrich	CH ₃ (CH ₂) ₃	340	20
MBPPG 1000	Aldrich	CH ₃ (CH ₂) ₃	1000	140
MBPPG 2500	Aldrich	CH ₃ (CH ₂) ₃	2500	1,300
MBPEGCPG 1700	Aldrich	CH ₃ (CH ₂) ₃	1700	350
MBPEGCPG 3900	Aldrich	CH ₃ (CH ₂) ₃	3900	3,600

In another aspect, block copolymers are prepared from hydrocarbon-terminated polyethers of the formula R¹-(O-R²)_x-W wherein W is carboxylic acid, which are also known as oxa acids. These compounds are generally well known and may be readily prepared by methodology described in the scientific and patent literature. For example, a monohydric initiator, *i.e.*, a compound of the formula R¹-OH, is reacted with an alkylene oxide (an R² group derived from an epoxide group), *e.g.*, ethylene oxide, propylene oxide, etc., to provide a compound of the formula R¹-(O-R²)_x-OH. This R¹-terminated polyalkylene glycol is then subjected to oxidation conditions to convert the terminal hydroxyl group to a carboxylic acid group. The resultant oxa acids have the structure (4) shown below, when prepared from ethylene oxide:



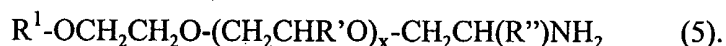
Compounds of formula (4) where m = 1 or 2 are available from Hoechst (now Aventis), as experimental products. Some properties of these acids are given in TABLE C (TABLE C – TYPICAL OXA ACIDS AND THEIR PROPERTIES). In TABLE C, AN stands for acid number.

TABLE C
Typical Oxa Acids and Their Properties

Acid	m	MW	Visc @ 20°C (mP)	AN (mg KOH/g)
3,6-dioxaheptanoic acid	1	134.1	35	410
3,6,9-trioxadecanoic acid	2	178.2	73	310

In another aspect, block copolymers are prepared from compounds of formula $R^1-(O-R^2)_x-W$ wherein W is amine and R^2 is one or more of ethylene ($-\text{CH}_2\text{CH}_2-$), propylene ($-\text{CH}_2-\text{CH}(\text{CH}_3)-$), and *n*-butylene ($-\text{CH}_2-\text{CH}(\text{CH}_2\text{CH}_2)-$). Such compounds of formula $R^1-(O-R^2)_x-W$ may be referred to herein as polyoxyalkyleneamines. These compounds are generally well-known to one of ordinary skill in the art and may be readily prepared by methodology described in the scientific and patent literature. For example, a monohydric initiator, *i.e.*, a compound of the formula $R^1-\text{OH}$, is reacted with an alkylene oxide (an R^2 group is derived from an epoxide-containing group), *e.g.*, ethylene oxide, propylene oxide, etc., to provide a compound of the formula $R^1-(O-R^2)_x-\text{OH}$. This R^1 -terminated polyalkylene glycol is subjected to reaction conditions to convert the terminal hydroxyl group to a terminal amino group.

Generally, polyoxyalkyleneamines (also known as poly(oxyalkylene) monoamines) have the structure (5) below:



where R^1 is preferably an alkyl group; R' is preferably H, CH_3 , or C_2H_5 ; and R'' is preferably H or CH_3 . Common commercially-available polyoxyalkyleneamines are typically prepared from ethylene oxide and/or propylene oxide and are available commercially in varying ratios of propylene oxide-to ethylene oxide-based residues. Polyoxyalkyleneamines may be obtained from, *e.g.*, BASF, Mt.Olive, NJ and Huntsman Chemical, Salt Lake City, UT. Commercially available polyoxyalkyleneamines and selected properties are given in TABLE D (TABLE D – TYPICAL POLYOXYALKYLENEAMINES AND THEIR PROPERTIES). In TABLE D, both the XTJ and JEFFAMINE™ tradenames are used by Huntsman Chemical.

TABLE D
Typical Polyoxyalkyleneamines and Their Properties

amine	R ¹	R ²	PO/EO (mole ratio)	MW	T _m (°C)
XTJ-505	CH ₃	CH ₃	9/1	600	-40
XTJ-506	CH ₃	CH ₃	3/19	1,000	29
XTJ-507	CH ₃	CH ₃	39/6	2,000	-36
JEFFAMINE® M-2070	CH ₃	CH ₃	10/32	2,000	17
XTJ 234	CH ₃	CH ₃	8/49	3000	36
Diglycol amine	H	H	0/2	105 (m=0)	

The diamine may be a polyether diamine, also referred to herein as a
5 PAO (for polyalkyleneoxy) diamine. Polyetherdiamines may be obtained from
Huntsman Chemical. A suitable polyether diamine is a poly(propyleneoxy)diamine
such as JEFFAMINE® D-400. Another suitable diamine is a poly(ethyleneoxy)-co-
propyleneoxy) diamine such as HUNTSMAN XTJ-500. Yet another suitable diamine is
JEFFAMINE® EDR-148, which is also known as triethyleneglycoldiamine, having
10 CAS Registry No. 929-59-9 and the chemical structure H₂N-CH₂CH₂-O-CH₂CH₂-O-
CH₂CH₂-NH₂. In one embodiment, the polyetherdiamine has the structure
NH₂CH(CH₃)CH₂O-(CH₂CHR'O)_x-CH₂CH(CH₃)NH₂, where R and R' are methyl or H.

Use of a significant level of both polyether diamine and polyether
monoamine provides resins having the ability to form clear solutions and/or clear gels
15 in a wide range of polar solvents including dimethylsulfoxide, propylene glycol,
ethanol, polypropylene glycol and polyethylene glycol and their monoalkyl ethers. At
high weight percentage use levels of terminator (*i.e.*, hydrocarbon-terminated
polyether), the resins are extremely soft. As the total level of polyether in the
polyamide block decreases, the resin gains the feel and flexibility of a polyamide
20 prepared from ethylene diamine and dimer acid, thus retaining some softness even at
low levels of polyether. Some of these resins may dissolve in ethanol, but most
demonstrated good solubility in propanol, however gelling behavior was infrequent. In
general, propylene glycol is a preferred solvent to prepare gels from solvent and resins
of the invention (*i.e.*, resins prepared from polyether diamine and polyether
25 monoamine). In general, formation of dimer-acid based polyamides, even those
including a significant level of both polyether diamine and polyether monoamine
among the reactants leads to a resin that it not particularly compatible with glycerol.

When a polyether diamine and polyether monoamine-derived resin is dissolved in a polar solvent, and then this solution is diluted with water, it is typically observed that the solution remains homogeneous, *i.e.*, the resin does not precipitate. Frequently, upon dilution with water, the resin/polar solvent/water mixture takes on a bluish cast, indicating the presence of a microemulsion form.

In preparing the resins of the present invention, it may be noted that the diamine may be a mixture of hydrocarbon diamine and polyether diamine. In addition, it is generally observed that increasing the level of termination, *i.e.*, increasing the relative amount of monoreactive hydrocarbon-terminated polyether, tends to provide a resin with a relatively lower softening point and melt viscosity. The use of hexamethylene diamine (HMDA), in lieu of some or all of ethylene diamine (EDA), tends to lower the softening point of the resin. In one aspect of the invention, ethylene diamine is a reactant used in preparing the block copolymer, and in particular is used in preparing the polyamide block of the block copolymer. Typically, EDA is blended with a polyetherdiamine, in order to prepare the polyamide block of the block copolymer of the present invention, where the diamine(s) are reacted with diacid, *e.g.*, dimer acid.

The inclusion of co-diacid, *i.e.*, diacid other than dimer acid, *e.g.*, sebacic acid, in the reaction mixture tends to raise the softening point of the resulting resin. The polyether monoamine should not contain any hydroxyl groups. The inclusion of hydroxyl groups is detrimental to the gelling ability of the resin made from the monoamine. Accordingly, hydroxyl terminated polyethers are not included within the polyether monoamine reactants of the present invention. Indeed, in one aspect of the invention, no hydroxyl-containing materials, *e.g.*, alcohols (compounds containing one hydroxyl group) or polyols (compounds containing two or more hydroxyl groups), are used as a reactant to prepare a resin of the present invention. In one aspect, no polyol is included among the reactants to prepare a block copolymer of the invention. In other aspects, if hydroxyl-containing materials are included as a reactant(s), then the hydroxyl-containing materials contribute less than 5 wt%, or less than 3 wt%, of the total weight of the reactants.

Some of the inventive resins, particularly those prepared from polyether diamines and polyether hydrocarbon-terminated monoamines, have the unusual ability to form microemulsions in mixtures of water and a polar solvent. These blends are clear and homogeneous but have a distinct blue cast and can be either immobile gels or fluid liquids, depending on the concentration of the resin and the polar solvent. They can be diluted with water without formation of a precipitate. Block copolymers of the present

invention that form such microemulsions may be particularly useful as corrosion inhibitors in aqueous systems.

As described herein, diamines, dicarboxylic acids, and hydrocarbon-terminated polyethers having a reactive group W selected from hydroxyl, amine and carboxyl are preferred starting materials to form the triblock copolymers of the invention. These starting materials are preferably reacted together with a stoichiometry, and under reaction conditions, such that the acid number of the resulting block copolymer is less than 25, preferably less than 15, and more preferably less than 10, while the amine number is preferably less than 10, more preferably less than 5, and still more preferably less than 1. The softening point of the block copolymer is preferably greater than room temperature, more preferably is about 50°C to about 150°C, and still more preferably is about 75°C to about 125°C.

It is important to control the stoichiometry of the reactants in order to prepare a block copolymer according to the invention. The following discussion regarding reactant stoichiometry uses the terms "equivalent(s)" and "equivalent percent", where these terms are intended to have their standard meanings as employed in the art. However, for additional clarity, it is noted that equivalents refer to the number of reactive groups present in a molar quantity of a molecule, such that a mole of a dicarboxylic acid (e.g., sebacic acid) has two equivalents of carboxylic acid, while a mole of monoamine has one equivalent of amine. Furthermore, it is emphasized that in preparing a triblock copolymer of the invention, the diacid has only two reactive groups (both carboxylic acids, although dimer acid may contain a small amount of tricarboxylic acid), the diamine has only two reactive groups (both primary amines) and the hydrocarbon terminated polyether reactant has a single reactive group selected from amine, hydroxyl and carboxyl. Furthermore, these are preferably, although not necessarily, the only reactive materials present in the reaction mixture.

When co-diacid is employed to prepare a block copolymer, the co-diacid preferably contributes no more than about 50% of the equivalents of carboxylic acid present in the reaction mixture. Stated another way, the co-diacid contributes from 0-50 equivalent percent of the acid equivalents in the reaction mixture. Preferably, the co-diacid contributes 0-30 equivalent percent, and more preferably contributes 0-10 equivalent percent of the acid equivalents in the reaction mixture.

The stoichiometry of the reactants will have a significant impact on the composition of the block copolymer. For example, triblock copolymers made with increasing amounts of polyether will tend to have lower (number and weight) average molecular weights. On the other hand, as less polyether is used, the average molecular

weight of the molecules that comprise the block copolymer will increase. In general, increasing the average molecular weight of the copolymer will tend to increase the melting point and melt viscosity of the copolymer. When a high melting point copolymer is combined with a solvent to thereby form a gel, the gel will tend to have a
5 firmer consistency than does a gel formed from a copolymer with a low melting point.

In order to prepare a block copolymer of the present invention, the above-described reactants (diacid, diamine and polyether, or reactive equivalents thereof) may be combined in any order. In one embodiment of the invention, the reactants are simply mixed together and heated for a time and at a temperature sufficient
10 to achieve essentially complete reaction, to thereby form the block copolymer. In another embodiment, the diacid and diamine are reacted together, followed by addition of the monoreactive polyether. During formation of the block copolymer, the diacid and diamine compounds will alternate to form what may be termed an alternating copolymer, *i.e.*, the polyamide block of the block copolymer is an alternating copolymer
15 of diacid and diamine. The terms "complete reaction" and "reaction equilibrium" as used herein have essentially the same meaning, which is that further heating of the product does not result in any appreciable change in the acid or amine numbers of the copolymer.

Thus, the block copolymer may be formed in a one-step procedure,
20 wherein all of the diacid (including co-diacid), diamine (preferably including ethylene diamine) and polyether are combined and then heated to about 180-250°C for a few hours, typically 2-8 hours. When lower temperatures are used, a longer reaction time is typically needed to achieve complete reaction. When the reaction temperature is too high, the reactants and/or products may undergo undesirable thermally-induced
25 decomposition. Typically, the reactants must be exposed to a temperature in excess of 100°C in order to drive off the water formed by the condensation of the reactants. Since one or more of the reactants may be a solid at room temperature, it may be convenient to combine each of the ingredients at a slightly elevated temperature, and then form a homogeneous mixture prior to heating the reaction mixture to a temperature sufficient
30 to cause reaction between the diacid, diamine and polyether. Alternatively, although less preferably, two of the reactants may be combined and reacted together, and then the third reactant is added followed by further heating until the desired product is obtained. Reaction progress may be conveniently monitored by periodically measuring the acid and/or amine number of the product mixture.

35 As one example, dimer acid may be reacted with diamine so as to form polyamide, and then this intermediate polyamide may be reacted with polyether to form

a hydrocarbon terminated polyether-polyamide-polyether block copolymer. Because the components of the block copolymer are preferably in reaction equilibrium (due to transamidation and/or transesterification reactions), the order in which the reactants are combined typically does not impact on the properties of the product copolymer.

5 Any catalyst that may accelerate amide and/or ester formation between carboxyl, amine and/or hydroxyl groups may be present in the reaction mixture described above. Thus, mineral acid such as phosphoric acid, or tin compounds such as dibutyltin oxide, may be present during the reaction. In addition, it is preferred to remove water from the reaction mixture as it is formed upon amide and, optionally,
10 ester formation. This is preferably accomplished by maintaining a vacuum on the reacting mixture, or by passing a stream of an inert gas (e.g., nitrogen) across the top of the reaction mixture.

The block copolymers of the invention may be used to thicken and/or gel a solvent (where the term "a solvent" includes a mixture of solvents). As used herein,
15 the term solvent includes any substance which is a liquid at a temperature between 10-60°C, and which forms a gel upon being combined with a block copolymer of the present invention. As used herein, the term solvent will be used to encompass oils and other fluids that may be gelled by the block copolymer of the invention, and is not otherwise limited.

20 The block copolymer and solvent may be combined so as to provide a mixture that has a gel-like consistency. In general, materials that have a gel-like character will maintain their shape when undisturbed but flow upon being rubbed. Gels prepared with block copolymers of the present invention may be anywhere from soft to hard, where a "hard" gel has a rigid structure and is very resistant to deformation, while
25 a "soft" gel exhibits some, but not too much, resistance to deformation. An illustration of "soft" gel may be seen in the preparation of Jell-O® dessert, which is a well known food product from Kraft Foods Inc. (division of Philip Morris Companies Inc., Northfield, IL). When prepared according to the package instructions, Jell-O® dessert is mixed with water to form a relatively soft gel. A gellant may be distinguished from a
30 rheological additive, where a rheological additive increases the shear thinning of a solvent/additive combination, while a gellant imparts a solid phase to the solvent/gellant combination. In one aspect of the invention, the block copolymer of the present invention is not a rheological additive. In one aspect, the present invention provides a gel comprising the block copolymer of the present invention and a suitable solvent.

35 The solvent is a liquid at room temperature or slightly above room temperature. A preferred solvent is a polar solvent, where exemplary polar solvents

- include lower alcohols (e.g., methanol, ethanol, propanol, butanol), glycols, ethers, glycol ethers (i.e., polyalkyleneglycol ethers), and polyols. The polar solvent may be a mixture of solvents. Exemplary polar solvents are described in TABLE E (TABLE E – POLAR SOLVENTS CONTAINING HYDROXYL AND/OR ETHER FUNCTIONALITIES). DOWANOL™ E-200 and E-300 are two exemplary polyethylene glycols from the DOWANOL™ family of glycol ethers from Dow (Midland, MI; www.dow.com) while DESMOPHEN™ 550 U and 1600 U are polyether polyols from the DESMOPHEN™ family of products from Bayer Corporation (Pittsburgh, PA; www.bayer.com).

10

TABLE EPolar Solvents Containing Hydroxyl and/or Ether Functionalities

Name	CAS	Structure	Functionality
Hexylene glycol (a.k.a. 2-methyl-2,4-pentandiol)	107-41-5	$\text{CH}_3\text{CH}(\text{OH})\text{CH}_2\text{C}(\text{CH}_3)_2\text{OH}$	1 secondary OH 1 tertiary OH
Propylene glycol (a.k.a. 1,2-propanediol)	57-55-6	$\text{CH}_3\text{CH}(\text{OH})\text{CH}_2\text{OH}$	1 primary OH 1 secondary OH
Ethylene glycol	107-21-1	$\text{HOCH}_2\text{CH}_2\text{OH}$	2 primary OH
Di(propylene glycol) Mixture of 1,2 and 1,3 isomers	25265-71-8	$\text{HOC}_3\text{H}_6\text{OC}_3\text{H}_6\text{OH}$	2 primary OH's 2 secondary OH's 1/1 prim/sec OH 1 ether
Di(ethylene glycol) ethyl ether	111-90-0	$\text{C}_2\text{H}_5\text{OCH}_2\text{CH}_2\text{OCH}_2\text{CH}_2\text{OH}$	2 ether 1 prim. OH
Diethylene glycol dimethyl ether (a.k.a. 2-methoxyethyl ether)	111-96-6	$\text{CH}_3\text{OCH}_2\text{CH}_2\text{OCH}_2\text{CH}_2\text{OCH}_3$	3 ether
DOWANOL™ E-200 Poly(ethylene glycol) MW = 200	25322-68-3	$\text{H}(\text{OCH}_2\text{CH}_2)_n\text{OH}$	2 prim. OH ~ 4 ether
DOWANOL™ E-300 Poly(ethylene glycol) MW = 300	25322-68-3	$\text{H}(\text{OCH}_2\text{CH}_2)_n\text{OH}$	2 prim. OH ~ 6 ether
DESMOPHEN™ 1600 U Linear polyether polyol	25322-69-4	NOT KNOWN	NOT KNOWN
DESMOPHEN™ 550 U Branched polyether polyol	25723-16-4	NOT KNOWN	NOT KNOWN
Poly(ethylene glycol) dimethyl ether MW = 250	24991-55-7	$\text{CH}_3(\text{OCH}_2\text{CH}_2)_n\text{OCH}_3$	~ 6 ether

Preferably, the solvent is a polar liquid as described above, and more preferably the solvent is a liquid that contains ether and/or hydroxyl groups. In one

aspect of the invention, the solvent is DMSO, *i.e.*, dimethylsulfoxide. The liquid may contain more than one component, *e.g.*, ether as well as hydroxyl-containing material. In the mixture, the gellant (block copolymer) typically contributes 10-95%, and the solvent typically contributes 5-90%, of the combined weight of the gellant and the solvent. Preferably, the gellant is combined with the solvent such that the weight percent of gellant in the gellant + solvent mixture is about 5-50%, and preferably is about 10-45%. Such gels may be transparent, translucent or opaque, depending on the precise identities of the gellant and solvent, as well as the concentration of gellant in the mixture.

In order to prepare a gel from a solvent and block copolymer, the two components are mixed together and heated until homogeneous. A temperature within the range of about 80-150°C is typically sufficient to allow the block copolymer to completely dissolve in the solvent. A lower temperature may be used if a solution can be prepared at the lower temperature. Upon cooling, the mixture forms the gelled composition of the invention. Optional components may be added to the molten composition, and are dispersed and/or dissolved to provide a homogeneous composition prior to cooling of the molten composition.

In another embodiment, the block copolymer-containing gels of the present invention may be formulated such that they are transparent. There are various degrees of transparency, ranging from "crystal" clear to hazy, which may be achieved with gels of the invention. In order to provide some measure of the absolute transparency of a gel, the following test has been devised. A white light is shined through a gel sample of a given thickness at room temperature, and the diffuse transmittance and the total transmittance of the light are determined. The percent haze for a sample is determined by the equation: $\% \text{haze} = (\text{diffuse transmittance} / \text{total transmittance}) \times 100$. Samples are prepared by melting the gel (or product made therefrom) and pouring the melt into 50 mm diameter molds. The samples may be prepared at two thicknesses, *e.g.*, 5.5 ± 0.4 mm and 2.3 ± 0.2 mm.

Clarity measurements are made on a Hunter Lab Ultrascan Sphere Spectrocolorimeter using the following settings: specular included, UV off, large area of view, illuminate D65, and observer 10°. Using this protocol with a 2.3 mm thickness sample, an ATPA gel of the present invention may have a %haze value of less than 75, while paraffin wax has a %haze value of over 90. The %haze value for a gel of the present invention can be increased if desired, by appropriate selection of solvent and gellant. Thus, the present invention provides gels (and articles made therefrom) having a transparency (measured by %haze) of less than 75, preferably less than 50, more

preferably less than 25, still more preferably less than 10, and yet still more preferably of 5 or less.

In one embodiment, the gels containing block copolymer of the present invention are also stable, in that they do not display syneresis. As defined in the
5 McGraw-Hill Dictionary of Scientific and Technical Terms (3rd Edition), syneresis is the spontaneous separation of a liquid from a gel or colloidal suspension due to contraction of the gel. Typically, syneresis is observed as the separation of liquid from a gel, and is sometimes referred to as "bleeding", in that wetness is seen along the surfaces of a gel that displays syneresis. From a commercial point of view, syneresis is
10 typically an undesirable property, and the gels of the present invention desirably, and surprisingly do not exhibit syneresis. In one embodiment, the gels of the invention, and articles prepared therefrom, may be stable in the sense that they do not exhibit syneresis. Thus, they do not have an oily feeling when handled.

A gel formed from a block copolymer and the present invention may be
15 used to prepare an antiperspirant or deodorant. The antiperspirant may also contain one or more of aluminum chlorohydrate, aluminum-zirconium tetrachlorohydrate, aluminum-zirconium polychlorohydrate complexed with glycine, and aluminum-zirconium complexed with any of trichlorohydrate, octachlorohydrate, and sesquichlorohydrate. The gels, and the formulated antiperspirant, are preferably
20 transparent.

The block copolymer-containing gels of the invention may be (although need not be) essentially transparent. When transparent, the gels may be combined with colorants (as well as other ingredients) to form lipstick or other cosmetic products, without the gel interfering with or tainting the appearance of the colorant. The gels of
25 the present invention may be combined with aluminum zirconium salts, as well as other ingredients, to form colorless underarm deodorant/antiperspirant, which is currently quite popular. The gels of the invention are also useful in other personal care products, *e.g.*, cosmetics such as eye make-up, lipstick, foundation make-up, costume make-up, as well as baby oil, make-up removers, bath oil, skin moisturizers, sun care products, lip
30 balm, waterless hand cleaner, medicated ointments, ethnic hair care products, perfume, cologne, oral care bases (*e.g.*, for toothpaste) and suppositories.

In addition, the gels of the present invention may be used in household products such as air fresheners, decorative table-top food warmers (*i.e.*, they may be burned slowly to heat, *e.g.*, an overhead chafing dish), automobile wax/polish, candles,
35 furniture polish, metal cleaners/polishes, household cleaners, paint strippers and insecticide carriers.

Formulations to prepare such materials are well known in the art. For example, U.S. Patent Nos. 3,615,289 and 3,645,705 describe the formulation of candles. U.S. Patent Nos. 3,148,125 and 5,538,718 describe the formulation of lipstick and other cosmetic sticks. U.S. Patent Nos. 4,275,054, 4,937,069, 5,069,897, 5,102,656 and
5 5,500,209 each describe the formulation of deodorant and/or antiperspirant.

The block copolymer of the invention may be incorporated into commercial products such as those listed above, as well as cable filling compounds, urethane/alkyl paint additives, and soaps/surfactants. These products may be prepared by blending the block copolymer with the other components of the product. In these
10 commercial products, the block copolymer will typically be present at a concentration of about 1% to about 50% of the composition, based on the total weight of the composition. It is a routine matter to optimize the amount of block copolymer in a composition, and indeed the amount will vary depending on the actual product and the desired consistency of the product. In general, as more block copolymer is used in a
15 formulation, the product will display a more pronounced gel character, and will form a more rigid, or hard, gel.

The following examples are offered by way of illustration and not by way of limitation.

EXAMPLES

20 In the following Examples, softening point was measured using a Model FP83HT Dropping Point Cell from Mettler Instruments, Mettler-Toledo International, Inc. (CH-8606 Greifensee, Switzerland; <http://www.mt.com>), with a heating rate of 1.5°C/min. Techniques to measure acid and amine numbers are well known in the art and need not be described here. *See, e.g.*, ASTM D-465 (1982) from American Society
25 for Testing and Materials (West Conshohocken, PA; <http://www.astm.org>).

EMPOL™ dimer acid is available from Henkel Corporation, Emery Oleochemicals Division (Cincinnati, OH; <http://www.henkelcorp.com>). Ethylene diamine (EDA) is available from Aldrich (Milwaukee, WI; www.sigma-aldrich.com). NEODOL™ alcohol ethoxylates are available from Shell Chemical Company (Houston,
30 TX; www.shell.com).

EXAMPLE 1

HYDROCARBYL ETHOXYLATE-TERMINATED BLOCK COPOLYMER

A mixture of 67.4 parts EMPOL™ 1008 dimer acid (100 eq. % of acid equivalents), 5.1 parts ethylene diamine (EDA) (72.2 eq. % of amine + hydroxyl equivalents, based on acid equivalents) and 27.4 parts NEODOL™ 23-6.5 alcohol ethoxylate (27.4 eq. % of amine + hydroxyl equivalents, based on acid equivalents) was prepared and heated to about 200-250°C under a nitrogen atmosphere with simultaneous removal of water. A small amount (ca. 0.1-1.0 parts) hypophosphorous acid was added to minimize coloration of the product. Progress of the reaction was monitored by periodically pulling samples and measuring the acid and/or amine number of the product mixture. A nitrogen sparge was introduced to reduce the amine number to a desired level. The product block copolymer was characterized and found to have an acid number of 18.3 (higher than the theoretical value of 6, indicating incomplete reaction of the alcohol ethoxylate), an amine number of 1.1, a softening point of 90.3°C and a viscosity at 160°C of 85 cPs.

EXAMPLE 2

HYDROCARBYL ETHOXYLATE-TERMINATED BLOCK COPOLYMER

The procedure of Example 1 was followed using 57.6 parts EMPOL™ 1008 (100 eq.% acid), 4.4 parts EDA (71.7 eq.% amine + hydroxyl, based on acid equivalents) and 38.0 parts NEODOL™ 45-13 (23.9 eq.% amine + hydroxyl, based on acid equivalents). The product had an acid number of 16.9 (higher than the theoretical value of 6, indicating incomplete reaction of the alcohol ethoxylate), an amine number of 0.6, a softening point of 92°C and a viscosity at 160°C of 94 cPs. The softening point is approximately the same as the block copolymer of Example 1, indicating that ethoxylate molecular weight does not have a large impact on softening point. The gelling behavior of this block copolymer is described in Example 4.

EXAMPLE 3

HYDROCARBYL ETHOXYLATE-TERMINATED BLOCK COPOLYMER

The procedure of Example 1 was followed using 47.8 parts EMPOL™ 1008 (100 eq.% acid), 2.8 parts EDA (56.2 eq.% amine + hydroxyl, based on acid equivalents) and 49.4 parts NEODOL™ 45-13 (37.4 eq.% amine + hydroxyl, based on acid equivalents). The product had an acid number of 21.4 (higher than the theoretical value of 6, indicating incomplete reaction of the alcohol ethoxylate), an amine number

of 0.4, a softening point of 83.7°C and a viscosity at 160°C of 67 cPs. The softening point and melt viscosity are both lower than that of the copolymer of Example 2, indicating that a higher degree of termination reduces the molecular weight of the block copolymer. The gelling behavior of this block copolymer is described in Example 4.

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EXAMPLE 4

GELLING BEHAVIOR OF HYDROCARBYL ETHOXYLATE-TERMINATED BLOCK COPOLYMER

The copolymers of Examples 2 and 3 were combined with various solvents at a 15 wt% copolymer concentration. The observed gelling properties of the hydrocarbyl-ethoxylate-terminated polyamides are described in TABLE F (TABLE F -
 10 GELATION PROPERTIES OF ETHOXYLATE-POLYAMIDES COPOLYMERS AT 15% RESIN). The gelling behavior indicates that the higher level of ethoxylate termination (Example 3) makes the resin more compatible with the polar solvents. This is demonstrated by the fact that the copolymer of Example 2 gels hexylene glycol to form a clear gel, 2-methoxyethyl ether to form an opaque gel, and forms two phases in
 15 dipropylene glycol; while the copolymer of Example 3 dissolves in hexylene glycol, forms a clear gel in methoxyethyl ether, and forms an opaque liquid in dipropylene glycol. This indicates that the gelling ability of these resins is a balance between their compatibility (ethoxylate content) and amide content (MW). However, neither of the copolymers of Examples 2 or 3 was capable of gelling propylene glycol, polyethylene
 20 glycol, dipropylene glycol. This may be due to the hydrophobic alkyl chain within the ethoxylate molecule. In TABLE F, and elsewhere in the TABLES set forth herein, "ND" indicates not determined.

TABLE F

Gellation Properties of Ethoxylate-Polyamide Copolymers at 15% Resin

Solvent	Example 2	Example 3
Hexylene glycol	Transl. Gel	Clear liquid
Propylene glycol	2 phases	2 phases
Polyethylene glycol (E-200)	2 phases	2 phases
Poly(ethylene glycol) dimethyl ether	Opaque gel	Opaque gel
Diethylene glycol ethyl ether	Opaque gel	N/D
Dipropylene glycol	2 phases	Opaque liquid
2-Methoxyethyl ether	Opaque gel	Clear gel

EXAMPLE 5

HYDROCARBYL POLYALKYL GLYCOL-TERMINATED BLOCK COPOLYMER

The procedure of Example 1 was followed using 61.8 parts EMPOL™ 1008 (100 eq.% acid), 4.3 parts EDA (66.5 eq.% amine + hydroxyl, based on acid equivalents) and 33.9 parts MPEG 550 (28.5 eq.% amine + hydroxyl, based on acid equivalents). The product had an acid number of 20.5 (higher than the theoretical value of 6, indicating incomplete reaction of the alcohol ethoxylate), an amine number of 1.0, a softening point of 91°C and a viscosity at 160°C of 52 cPs. The gelling behavior of this block copolymer is described in Example 8. At high termination levels (see Examples 6 and 7), the properties of the block copolymer are dominated by the polyalkyl glycol.

EXAMPLE 6

HYDROCARBYL POLYALKYL GLYCOL-TERMINATED BLOCK COPOLYMER

The procedure of Example 1 was followed using 37.3 parts EMPOL™ 1008 (100 eq.% acid), 2.7 parts EDA (68.9 eq.% amine + hydroxyl, based on acid equivalents) and 59.9 parts MPEG 2000 (23.0 eq.% amine + hydroxyl, based on acid equivalents). The product had an acid number of 17.1 (higher than the theoretical value of 6, indicating incomplete reaction of the alcohol ethoxylate), an amine number of 0.4, a softening point of 75.4°C and a viscosity at 160°C of 224 cPs. The gelling behavior of this block copolymer is described in Example 8.

EXAMPLE 7

HYDROCARBYL POLYALKYL GLYCOL-TERMINATED BLOCK COPOLYMER

The procedure of Example 1 was followed using 26.1 parts EMPOL™ 1008 (100 eq.% acid), 1.6 parts EDA (56.5 eq.% amine + hydroxyl, based on acid equivalents) and 31.8 parts MBPPG 2500 (31.8 eq.% amine + hydroxyl, based on acid equivalents). The product had an acid number of 17.3 (higher than the theoretical value of 6, indicating incomplete reaction of the alcohol ethoxylate), an amine number of 0.5, a softening point of 41.9°C and a viscosity at 160°C of 35 cPs. The gelling behavior of this block copolymer is described in Example 8.

EXAMPLE 8

GELLING BEHAVIOR OF HYDROCARBYL ETHOXYLATE-TERMINATED BLOCK COPOLYMER

- The copolymers of Examples 5, 6 and 7 were combined with various solvents at a 15 wt% copolymer concentration. The observed gelling characteristics of these copolymers is given in TABLE G (TABLE G – GELLATION PROPERTIES OF POLYALKYL GLYCOL-POLYAMIDE COPOLYMERS AT 15% RESIN). The copolymers of Examples 5 and 6 gelled hexylene glycol, but the copolymer of Example 6 gave an opaque gel. The opaque gel is likely caused by the MPEG 2000, which dissolves in hexylene glycol at elevated temperature, but crystallizes out when cooled.
- This result suggests that the terminal molecule is preferably a liquid that is soluble in the glycol, if a transparent gel is desired. The copolymer of Example 5 gelled the various solvents with combinations of hydroxyl and ether functionality, but was incompatible with polyethylene glycol and propylene glycol. This result suggests that the level of liquid terminator is desirably high in some instances.
- However, at >70 wt % of a liquid terminator, the copolymer of Example 7 was a very soft opaque solid that was incompatible with propylene glycol. This behavior may be due to unreacted dimer in the resin that is incompatible with the glycol. Thus, the hydrocarbon-terminated polyalkyl glycol-polyamide block copolymers have excellent gelling properties when a liquid terminator is used and the level of termination is not too great. As with the hydrocarbon-terminated ethoxylate-polyamide copolymers, the gelling characteristics of these resins is a balance between the amide density and polyalkyl glycol content.

TABLE GGellation Properties of Polyalkyl Glycol-Polyamide Copolymers at 15% Resin

Solvent	Example 5	Example 6	Example 7
Hexylene glycol	Clear gel	Opaque gel	ND
Propylene glycol	2 phases	2 phases	2 phases
Polyethylene glycol (E-200)	2 phases	2 phases	ND
Diethylene glycol ethyl ether	Transl. gel	ND	ND
Poly(ethylene glycol) dimethyl ether	Opaque gel	ND	ND
2-Methoxyethyl ether	Transl. gel	ND	ND
Dipropylene glycol	Opaque gel	ND	ND

EXAMPLE 9

HYDROCARBYL OXA ACID-TERMINATED BLOCK COPOLYMER

The procedure of Example 1 was followed using 74.4 parts EMPOL™ 1008 (75 eq.% acid, based on total acids), 15.7 3,6,9-trioxadecanoic acid (25 eq.% based on total acids) and 9.9 parts EDA (94.7 eq.% amine, based on acid equivalents). The product had an acid number of 11.6, an amine number of 1.1, a softening point of 88.1°C and a viscosity at 183°C of 35 cPs. The use of an oxa acid tends to provide a darker colored block copolymer, relative to the use of polyalkyl glycols and alcohol ethoxylates. The gelling behavior of this block copolymer is described in TABLE H below.

TABLE H

Gellation Properties of Oxa Acid-Polyamide Copolymer at 15% Resin

Solvent	Gel Description
15% in hexylene glycol	Clear gel
15% in Propylene glycol	2 phases
15% in polyethylene glycol (E-200)	2 phases
15% in diethylene glycol ethyl ether	Transl. Gel
15% in dipropylene glycol	Opaque gel
15% in poly(ethylene glycol) dimethyl ether	opaque liquid
15% in 2-methoxyethyl ether	Opaque gel

EXAMPLES 10 - 18

HYDROCARBYL POLYOXYALKYLENEAMINE-POLYAMIDE BLOCK COPOLYMER

The procedure of Example 1 was followed using EMPOL™ 1008, UNIDYME 18 dimer acid (from Arizona Chemical, Jacksonville, FL), EDA, hexamethylene diamine (HMDA, Aldrich), sebacic acid (sebacic, Aldrich), polyoxyalkyleneamine, etc. in the amounts shown in TABLE I. TABLE I also provides the acid number (AN), amine number (AM), softening point in °C (s.p. (°C)), molecular weight as determined by gel permeation chromatography using THF as the solvent and reported as both Mn and Mw by reference to polystyrene standards, and viscosity as measured in centipoise at 160°C (Visc. @ 160°C (cPs)) for the corresponding product.

Unlike the polyalkyl glycol-polyamide block copolymers, the reactants used to prepare the polyoxyalkyleneamine-polyamide block copolymers react almost

completely with the terminator (theoretical acid number = 6). Increasing the level of termination (Examples 14 and 13) resulted in a lower softening point and viscosity. The addition of HMDA lowers the softening point (Examples 13 and 17) relative to the use of EDA only, while the addition of sebacic acid as a co-diacid raised the softening point.

The diglycol amine polymer (Example 18) was made by reacting at 180°C without vacuum in order to only react the amine and not the hydroxyl group. This material was made to determine the effect of free hydroxyl on the gelling characteristics.

The MW of the copolymers as determined by GPC indicates that the copolymers that contain JEFFAMINE™ M-2070 amine have number average MW's (M_n) of 4000 to 5000. This result indicates that these resins primarily comprise copolymers having either two or four amide groups, *i.e.*, the resin is primarily a mixture of bis-amide and tetra-amide.

The gelling behavior of this group of block copolymers is described in TABLE J (TABLE J – GELLATION PROPERTIES OF POLYOXYALKYLENEAMINE-POLYAMIDE COPOLYMERS AT 15% RESIN).

The copolymers terminated with high levels of >65 wt % M-2070 formed clear or transparent gels in all of the glycols, ethers, and polyols except hexylene glycol, where they dissolved. The addition of sebacic acid raised the softening point of the copolymer, but appeared to make the gels in propylene glycol feel softer. Decreasing the amount of termination (increasing MW) resulted in firmer gels in propylene glycol, but the gels were transparent rather than clear. The use of HMDA versus EDA increased the hardness of the gels in propylene glycol. Thus, the clearest and hardest gels are obtained by using HMDA and the maximum level of termination possible.

Generally, the gel characteristics are related to the level of termination and the density of amide groups. The use of HMDA versus EDA increased the hardness of the gels in propylene glycol. Thus, the clearest and hardest gels are obtained by using HMDA and the maximum level of termination possible. Resins having high levels of M-2070 were slightly soluble in water (at concentrations up to about 3-4%). Thus, these resins are extremely hydrophilic materials and demonstrate some surfactant properties.

TABLE I
Composition and Properties of Polyoxalkyleneamine-Polyamides

Example No.	Composition (eq%/wt%)	AN/AM	s.p. (°C)	MW (GPC) M_n/M_w	Visc. @ 160°C (cPs)
10	100/60.0 EMPOL™, 66.4/4.2 EDA, 28.5/35.8 XTJ 505	8.0/0.9	93		68.5
11	100/48.4 EMPOL™, 79.6/4.1 EDA, 14.1/47.6 XTJ 507	8.3/0.6	103.1		225
12	100/22.5 EMPOL™ 1008, 44.7/1.1 EDA, 48.5/76.4 JEFFAMINE™ M-2070	7.1/0.5	89.2		57.5
13	100/25.7 EMPOL™, 47.6/1.3 EDA, 40.5/73.0 JEFFAMINE™ M-2070	8.7/0.4	89	5264/7658	59.5
14	100/30.1 EMPOL™, 57.5/1.8 EDA, 32.3/68.1 M-2070	6.2/0.6	98.2	5078/7804	75
15	90/24.6 EMPOL™, 10/1.0 sebacic, 50.6/1.5 EDA, 38.2/73.0 M-2070	8.0/0.3	115.5	4733/7884	63
16	75/21.0 EMPOL™, 25/2.5 sebacic, 50.8/1.5 EDA, 38.3/75.0 M-2070	6.9/0.6	140.9		85
17	100/25.5 EMPOL™, 47.5/2.5 HMDA, 40.5/72.1 M-2070	8.7/0.3	83	4325/7736	108
18	100/82.6 UNIDYME™ 18, 52.9/4.5 EDA, 43.3/12.9 diglycol amine	9.6/2.5	62.9	2004/4572	171

TABLE J
Gellation Properties of Polyoxyalkyleneamine-Polyamides at 15% Resin

Solvent	Example 10	Example 11	Example 13	Example 14	Example 15	Example 17	Example 18
Hexylene glycol	Clear gel	Transl. gel	Clear liq.	Clear liq.	Clear liq.	Clear liq.	Clear liq.
Propylene glycol	2 phases	2 phases	Clear gel	Transl. Gel	Clear gel	Clear gel	2 phases
Ethylene glycol	ND	ND	ND	ND	ND	2 phases	ND
Polyethylene glycol (E-200)	2 phases	2 phases	Clear gel	Clear gel	Clear gel	Transl. Gel	ND
Polyethylene glycol (E-300)	ND	ND	Clear gel	Clear gel	Clear gel	Clear gel	ND
Diethylene glycol ethyl ether	Clear gel	ND	ND	ND	ND	ND	ND
Dipropylene glycol	Opaque gel	Opaque gel	Clear gel	Transl. Gel	ND	Clear gel	ND
Poly(ethylene glycol) dimethyl ether	ND	Transl. Gel	Clear gel	ND	ND	Clear gel	ND
2-methoxyethyl ether	ND	Transl. gel	Clear gel	Transl. gel	ND	Clear gel	Opaque gel
DESMOPHEN™ 1600 U Linear polyether polyol	ND	ND	Clear gel	Transl. Gel	ND	ND	ND
DESMOPHEN™ 550 U Branched polyether polyol	ND	ND	Clear gel	Clear gel	ND	ND	ND

EXAMPLES 19 - 22

HYDROCARBYL POLYOXYALKYLENEEAMINE-POLYAMIDE BLOCK COPOLYMER

Four resins of the invention were prepared, essentially according to the procedure of Example 1, having the compositions, physical properties and gellation properties as set forth in Table K (Composition and Properties of Poly(oxyalkylene) Monoamine Terminated Polyamides Containing No Co-Diamine).

TABLE K

Composition and Properties of Poly(oxyalkylene) Monoamine Terminated Polyamides Containing No Co-Diamine

Example No.	Resin Composition EMPOL 1008 - M2070 - EDA (weight %)	AN/AM	Termination Eq.% on Dimer	Co-Diamine Fraction Total Diamines, Eq.	Propylene Glycol Cut (20 wt%)
19	22.5 - 76.3 - 1.1	2.9/0.6	47.8	0	Clear jelly
20	25.1 - 73.3 - 1.6	N.D.	41.2	0	Clear gel *
21	27.1 - 71.1 - 1.8	N.D.	37.0	0	Sl. hazy gel *
22	24.0 - 74.7 - 1.4	1.6/N.D.	44.0	0	Sl. hazy gel *

10

EXAMPLES 23 - 32

HYDROCARBYL POLYOXYALKYLENEEAMINE-POLYAMIDE BLOCK COPOLYMER

A series of resins was prepared having varying amounts of ethylene diamine and polyether diamine (specifically JEFFAMINE® EDR-148). The reactants for these resins, as well as the physical properties and gellation properties of the resin, are set forth in TABLE L (Composition and Properties of Poly(oxyalkylene) Monoamine-terminated Polyamides Containing JEFFAMINE® EDR-148).

These resins were prepared by heating about 100g of the ingredients (total charge) in a 250 mL Erlenmeyer flask in the presence of three drops of 25% aqueous hypophosphorous acid under a gentle nitrogen sweep with stirring. After the mixture reached 220°C, it was held at that temperature for about 3 h. All of these resins

were nearly water white in color. All of these resins are soft to one degree or another; in general, the higher the polyalkyleneoxy content, the softer the resin.

TABLE L

Composition and Properties of Poly(oxyalkylene) Monoamine-terminated Polyamides
Containing JEFFAMINE® EDR-148

Example No.	Resin Composition EMPOL 1008 - M-2070 - EDA - EDR148 (weight %)	Termination Eq.% on Dimer	Co-Diamine Eq.% Total Eq. Diamines	Propylene Glycol Cut (20 wt%)
23	26.8 - 70.3 - 0.9 - 2.0	37.0	46.0	Clear, weak jelly
24	31.1 - 65.2 - 1.4 - 2.2	29.6	39.4	Clear jelly
25	35.4 - 60.4 - 1.8 - 2.4	24.1	34.9	Clear firm gel
26	52.4 - 39.3 - 2.4 - 6.0	10.6	50.0	Sl. hazy firm gel
27	79.6 - 0 - 0 - 20.4	0	100	Incompatible
28	42.0 - 52.0 - 2.0 - 4.0	17.5	44.8	Clear gel
29	82.9 - 0 - 2.7 - 14.4	0	68.0	Incompatible
30	64.3 - 20.0 - 0 - 15.7	4.4	100	Incompatible
31	58.5 - 30.0 - 1.6 - 9.9	7.2	71.3	Cloudy paste
32	45.3 - 46.6 - 1.3 - 6.8	14.5	53.4	Clear jelly

A preferred range of termination, using M-2070, is about 15-18 eq.% with a co-diamine level of about 45-48 eq.% (more than this results in a clear, but mobile "jelly").

EXAMPLES 33 - 38

HYDROCARBYL POLYOXYALKYLENEAMINE-POLYAMIDE BLOCK COPOLYMER

A series of resins was prepared having varying amounts of ethylene diamine and polyether diamine (specifically JEFFAMINE® D-400). The reactants for these resins, as well as the physical properties and gellation properties of the resin, are set forth in Table M (Composition and Properties of Poly(oxyalkylene) Monoamine-terminated Polyamides Containing JEFFAMINE® D-400.)

These resins were prepared by heating about 100 g of the specified ingredients (total charge) in a 250 mL Erlenmeyer flask in the presence of three drops of

25% aqueous hypophosphorous acid under a gentle nitrogen sweep with stirring. After the mixture reached 220°C, it was held at that temperature for about 3 h. All of the resulting resins were nearly water white in color. All of these resins were soft to one degree or another; in general, the higher the polyalkyleneoxy content, the softer the resin.

TABLE M

Composition and Properties of Poly(oxyalkylene) Monoamine-terminated Polyamides
Containing JEFFAMINE® D-400

Ex. No.	Resin Composition EMPOL 1008 - M2070 - EDA - Jeff.D400 (weight %)	AN / AM	Termination Eq.% on Dimer	Co-Diamine Fraction Total Diamines, Eq.	Propylene Glycol Cut (20 wt%)
33	45.3 - 46.6 - 1.3 - 6.8	-- / --	16.9	36.7	Clear weak gel
34	35.6 - 55.9 - 2.0 - 6.4	2.8/0.6	22.2	30.3	Clear firm gel
35	35.9 - 55.6 - 2.0 - 6.4	3.2/1.3	21.9	30.2	Clear firm gel
36	59.3 - 24.7 - 4.2 - 11.9	4.5/0.8	5.9	28.1	Cloudy firm gel
37	69.8 - 13.8 - 5.6 - 10.8	--/--	2.8	20.9	Incompatible
38	59.4 - 24.6 - 4.2 - 11.8	4.4/0.6	5.9	28.0	nd

Formulations of dimer acid, EDA, M-2070, and D-400 gel propylene glycol over a wide range of compositional space, from about 45-60 wt% dimer, 47-25% monoamine, and 6-12% D-400, adjusted to have a termination level of 6-22 eq.% with about 30-35% eq. replacement of EDA with D-400.

Such resins, and formulations to prepare such resins, are a preferred embodiment of the present invention. For instance, in one aspect, the present invention provides a product prepared by a process of condensing reactants comprising polyoxyalkylenamine, polyoxyalkylenediamine and dimer acid, to provide a hydrocarbon-terminated block copolymer having a number average molecular weight of less than 10,000. The polyoxyalkylenamine may have the formula $R-O-[(R^a-O)_n-(R^b-O)_m]-R^c-NH_2$ where $(R^a-O)_n-(R^b-O)_m$ represents a plurality of R^a-O and R^b-O units arranged in any sequence, the sum of n and m provides a molecular weight of 1,500 to 2,500 g/mol and either m or n may be zero, R is C_1-C_6 alkyl, R^a is $-CH_2CH_2-$, R^b is $-CH(CH_3)-CH_2-$, and R^c is selected from R^a and R^b . The polyoxyalkylenamine may have the structure of JEFFAMINE M2070. The polyoxyalkylenediamine may have the formula $H_2N-[(R^a-O)_n-(R^b-O)_m]-R^c-NH_2$ where $(R^a-O)_n-(R^b-O)_m$ represents a plurality of

R^a-O and R^b-O units arranged in any sequence, the sum of n and m provides a molecular weight of 200 to 800 g/mol and either m or n may be zero, R^a is -CH₂CH₂-, R^b is -CH(CH₃)-CH₂-, and R^c is selected from R^a and R^b. The polyoxyalkylenediamine may have the structure of Jeffamine D-400. The final product is resin which may have an acid number of less than 10 and an amine number of less than 10. In a preferred embodiment, the reactants further comprise ethylene diamine, as shown in TABLE M. Thus, in one aspect, the polyoxyalkylenamine contributes 25-47 wt% of the reactants, polyoxyalkylenediamine contributes 6-12 wt% of the reactants, and dimer acid contributes 45-60 wt% of the reactants. In another aspect, polyoxyalkylenamine contributes 25-47 wt% of the reactants, polyoxyalkylenediamine contributes 6-12 wt% of the reactants, dimer acid contributes 45-60 wt% of the reactants, and ethylene diamine contributes 1-6 wt% of the reactants.

EXAMPLES 39-45

HYDROCARBYL POLYOXYALKYLENEAMINE-POLYAMIDE BLOCK COPOLYMER

A series of resins was prepared having varying amounts of ethylene diamine and polyether diamine (specifically HUNTSMAN XTJ-500 and/or HUNTSMAN XTJ-506). The reactants for these resins, as well as the physical properties and gellation properties of the resin, are set forth in Table N (Composition and Properties of Poly(oxyalkylene) Monoamine-terminated Polyamides Containing HUNTSMAN XTJ-500 and/or HUNTSMAN XTJ-506.)

These resins were prepared by heating about 100 g of the specified reactants (total charge) in a 250 mL Erlenmeyer flask in the presence of three drops of 25% aqueous hypophosphorous acid under a gentle nitrogen sweep with stirring. After the mixture reached 220°C, it was held at that temperature for about 3 h. All of the resulting resins were nearly water white in color. All of these resins were soft to one degree or another; in general, the higher the polyalkyleneoxy content, the softer the resin.

The resin of Example 45 represents a block copolymer of the present invention with a high molecular weight and viscosity that still exhibits useful gelation properties, although it is incompatible with propylene glycol. It had a softening point of 96.8°C, MW_w of 18,240 daltons and a viscosity at 160°C of 2,940 cPs. It dissolves in and forms a clear, firm gel with the polar solvent ethyl lactate.

TABLE N

Composition and Properties of Poly(oxyalkylene) Monoamine-terminated Polyamides
Containing Huntsman XTJ-500 and/or XTJ-506

Ex. No.	Resin Components & Composition	Termination Eq.% on Dimer	Co-Diamine Fraction Total Diamines, Eq.	Propylene Glycol Cut (20 wt%)
Empol 1008 - M2070 - EDA - XTJ500 (wt%)				
39	56.0 - 23.0 - 3.8 - 17.2	5.8	30.0	Cloudy firm gel
Empol 1008 - XTJ506 - EDA - Jeff.D400 (wt%)				
40	59.8 - 25.2 - 3.9 - 11.1	12.0	28.0	nd
41	42.0 - 49.3 - 2.1 - 6.6	33.5	29.6	Clear firm gel
42	69.9 - 12.6 - 5.1 - 25.0	5.1	25.1	Incompatible
Empol 1008 - XTJ506 - EDA - XTJ500 (wt%)				
43	63.3 - 15.6 - 4.5 - 16.6	7.0	25.9	Incompatible
44	73.9 - 4.2 - 6.0 - 16.0	1.6	20.3	Incompatible
45	70.0 - 6.5 - 5.2 - 18.2	2.7	20.3	Incompatible

5 All publications and patent applications mentioned in this specification are herein incorporated by reference to the same extent as if each individual publication or patent application was specifically and individually incorporated by reference.

10 It will be appreciated by those skilled in the art that changes could be made to the embodiments described above without departing from the broad inventive concept thereof. It is understood, therefore, that this invention is not limited to the particular embodiments disclosed, but it is intended to cover modifications within the spirit and scope of the present invention as defined by the appended claims.

CLAIMS

1. A block copolymer of the formula hydrocarbon-polyether-polyamide-polyether-hydrocarbon.

2. The copolymer of claim 1 wherein the polyamide block comprises the formula $\left(R^3 - \overset{\text{O}}{\parallel} \text{CNH} - R^4 - \text{HNC} \overset{\text{O}}{\parallel} \right)$, where R^3 is a hydrocarbon and R^4 is selected from hydrocarbons and polyethers.

3. The copolymer of claim 2 wherein the R^3 groups comprise a diradical that results when two carboxylic acid groups are removed from dimer acid.

4. The copolymer of claim 2 wherein the R^4 group is a hydrocarbon.

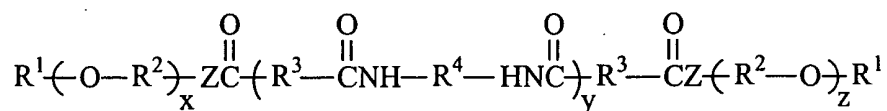
5. The copolymer of claim 2 wherein the R^4 group is a polyether.

6. The copolymer of claim 1 wherein the polyether block comprises the formula $\left(R^2 - O \right)$, where R^2 is a hydrocarbon.

7. The copolymer of claim 1 having C_{1-22} hydrocarbon radicals independently selected at either end of the copolymer.

8. The copolymer of claim 7 wherein the hydrocarbon radical is selected from alkyl, aralkyl, aryl, and alkaryl radicals.

9. The copolymer of claim 1 having the formula



wherein, independently at each occurrence, R^1 is a C_{1-22} hydrocarbon radical; R^2 is a C_{2-6} hydrocarbon diradicals; R^3 is a C_{2-52} hydrocarbon diradical, where at least 50% of the R^3 diradicals have at least 34 carbons; R^4 is selected from C_{2-36} hydrocarbon diradicals and C_4 -

C₁₀₀ polyether diradicals; Z is selected from O and NH; x is an integer from 2 to 100; and y is an integer from 1 to 10.

10. The copolymer of claim 8 wherein Z is NH.
11. The copolymer of claim 8 wherein R² is a C₂ hydrocarbon diradical.
12. The copolymer of claim 8 where at least 80% of the R³ diradicals have at least 34 carbon atoms.
13. A composition comprising a block copolymer according to claim 1, the composition having an acid number of less than 25.
14. A composition comprising a block copolymer according to claim 1, the composition having an amine number of less than 5.
15. A composition comprising a block copolymer according to claim 1, the composition having a softening point of 50-150°C.
16. A composition comprising a block copolymer according to claim 1, the composition having a weight average molecular weight of 2,000 to 30,000.
17. A composition comprising a block copolymer according to claim 1, the composition having a melting point above 50°C and a viscosity at 160°C of less than 5,000 cps.
18. A composition of claim 17 having a viscosity of less than 100 cps.
19. A process of preparing a block copolymer comprising reacting together reactants comprising dimer acid, diamine, and a polyether having both hydrocarbon termination and termination selected from amine, hydroxyl and carboxyl.
20. The process of claim 19 wherein the polyether has the formula R¹-(O-R²)_x-W where R¹ is selected from C₁-C₂₂ hydrocarbyl, R² is selected from C₂-C₆

hydrocarbyl, and W is selected from amine, hydroxyl and carboxyl, and x is an integer from 2 to about 100.

21. The process of claim 19 wherein the polyether has a number or weight average molecular weight between 100 and 4000.

22. The process of claim 19 wherein the diamine has the formula $H_2N-R^4-NH_2$ and R^4 is a C_{2-36} hydrocarbon diradical.

23. The process of claim 22 wherein the diamine is ethylene diamine.

24. The process of claim 19 wherein the diamine has the formula $H_2N-R^4-NH_2$ and R^4 has the formula $-R^5-O-R^5-$ wherein R^5 is a C_1-C_6 hydrocarbon diradical.

25. The process of claim 19 wherein the reactants are exposed to a reaction temperature in excess of $100^\circ C$.

26. The process of claim 19 wherein hypophosphorous acid is added to one or more of the reactants.

27. The process of claim 19 wherein the reactants are reacted together until at least one of the following criteria is met: the product has an acid number of less than 25; the product has an amine number of less than 5; the product has a softening point of $50-150^\circ C$; the product has a weight average molecular weight of 2,000 to 30,000; the product has a viscosity at $160^\circ C$ of less than 5,000 cps.

28. A composition prepared by the process of claim 19.

29. A gelled composition comprising a hydrocarbon-terminated block copolymer according to claim 1, and a solvent, the solvent being dimethylsulfoxide or having hydroxyl and/or ether functionality.

30. A gelled composition comprising a hydrocarbon-terminated block copolymer resulting from the process of claim 19, and a solvent, the solvent having hydroxyl and/or ether functionality.

31. A method for preparing a gel, comprising combining a hydrocarbon-terminated block copolymer according to claim 1 at elevated temperature with a liquid having hydroxyl and/or ether functionality to provide a mixture, and allowing the mixture to cool to room temperature to form the gel.

32. A composition comprising water, polar organic solvent, and copolymer of claim 1.

33. The composition of claim 32 in the form of a microemulsion.

34. A product prepared by a process of condensing reactants comprising polyoxyalkylenamine, polyoxyalkylenediamine and dimer acid, to provide a hydrocarbon-terminated block copolymer having a number average molecular weight of less than 10,000.

35. The product of claim 34 wherein the polyoxyalkylenamine has the formula $R-O-[(R^a-O)_n-(R^b-O)_m]-R^c-NH_2$ where $(R^a-O)_n-(R^b-O)_m$ represents a plurality of R^a-O and R^b-O units arranged in any sequence, the sum of n and m provides a molecular weight of 1,500 to 2,500 g/mol and either m or n may be zero, R is C_1-C_6 alkyl, R^a is $-CH_2CH_2-$, R^b is $-CH(CH_3)-CH_2-$, and R^c is selected from R^a and R^b .

36. The product of claim 35 wherein the polyoxyalkyleneamine has the structure of JEFFAMINE M2070.

37. The product of claim 34 wherein the polyoxyalkylenediamine has the formula $H_2N-[(R^a-O)_n-(R^b-O)_m]-R^c-NH_2$ where $(R^a-O)_n-(R^b-O)_m$ represents a plurality of R^a-O and R^b-O units arranged in any sequence, the sum of n and m provides a molecular weight of 200 to 800 g/mol and either m or n may be zero, R^a is $-CH_2CH_2-$, R^b is $-CH(CH_3)-CH_2-$, and R^c is selected from R^a and R^b .

38. The product of claim 37 wherein the polyoxyalkylenediamine has the structure of Jeffamine D-400.

39. The product of claim 34 wherein the product is resin with an acid number of less than 10 and an amine number of less than 10.

40. The product of claim 34 wherein the reactants further comprise ethylene diamine.

41. The product of claim 34 wherein polyoxyalkylenamine contributes 25-47 wt% of the reactants, polyoxyalkylenediamine contributes 6-12 wt% of the reactants, dimer acid contributes 45-60 wt% of the reactants.

42. The product of claim 34 wherein polyoxyalkylenamine contributes 25-47 wt% of the reactants, polyoxyalkylenediamine contributes 6-12 wt% of the reactants, dimer acid contributes 45-60 wt% of the reactants, and ethylene diamine contributes 1-6 wt% of the reactants.