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(54) **Lubricating Oil Composition**

(57) A low SAPS lubricating oil composition exhibiting excellent piston cleanliness having up to 0.3 wt.% sulfur, up to 0.08 wt.% phosphorus, and a sulfated ash content up to 0.80 wt.% comprising an overbased alkali

metal or alkaline earth metal alkyl salicylate detergent having a low soap content.

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Description

[0001] The present invention relates to lubricating oil compositions. More particularly, the present invention relates to lubricating oil compositions, which have low levels of phosphorus, sulfur and sulfated ash.

BACKGROUND OF THE INVENTION

[0002] Environmental concerns have led to continued efforts to reduce the CO, hydrocarbon and nitrogen oxide (NO_x) emissions of compression ignited (diesel-fueled) and spark ignited (gasoline-fueled) light duty internal combustion engines. Further, there have been continued efforts to reduce the particulate emissions of compression ignited light duty internal combustion engines. To meet the upcoming emission standards for passenger cars, original equipment manufacturers (OEMs) will rely on the use of additional exhaust gas after-treatment devices. Such exhaust gas after-treatment devices may include catalytic converters, which can contain one or more oxidation catalysts, NO_x storage catalysts, and/or NH₃ reduction catalysts; and/or a particulate trap.

[0003] Oxidation catalysts can become poisoned and rendered less effective by exposure to certain elements/compounds present in engine exhaust gasses, particularly by exposure to phosphorus and phosphorus compounds introduced into the exhaust gas by the degradation of phosphorus-containing lubricating oil additives. Reduction catalysts are sensitive to sulfur and sulfur compounds in the engine exhaust gas introduced by the degradation of both the base oil used to blend the lubricant, and sulfur-containing lubricating oil additives. Particulate traps can become blocked by metallic ash, which is a product of degraded metal-containing lubricating oil additives.

[0004] One of the most effective antioxidant and antiwear agents, from both a performance and cost-effectiveness standpoint, used conventionally in lubricating oil compositions for internal combustion engines comprises dihydrocarbyl dithiophosphate metal salts. The metal may be an alkali or alkaline earth metal, or aluminum, lead, tin, molybdenum, manganese, nickel or copper. Of these, zinc salts of dihydrocarbyl dithiophosphate (ZDDP) are most commonly used. While such compounds are particularly effective antioxidants and antiwear agents such compounds introduce phosphorus, sulfur and ash into the engine that can shorten the service life of exhaust gas after-treatment devices, as described *supra*.

[0005] To insure a long service life, lubricating oil additives that exert a minimum negative impact on such after-treatment devices must be identified, and OEM specifications for "new service fill" and "first fill" lubricants are expected to require maximum sulfur levels of 0.30 wt. %; maximum phosphorus levels of 0.08 wt. %, and sulfated ash contents below 0.80 wt. %. Such lubricating oil compositions can be referred to as "low SAPS" (low sulfated ash, phosphorus, sulfur) lubricating oil compositions.

[0006] At the same time, the selected lubricating oil composition must provide adequate lubricant performance, including adequate wear protection and detergency. The performance of lubricating oil compositions used in light duty spark and compression-ignited vehicular internal combustion engines, specifically antiwear and engine cleaning performance, must be maintained at the high level dictated by the "new service", and "first fill" specifications of the OEM's.

[0007] European patent application 1 167 497 A2 discloses a low SAPS lubricating oil composition comprising an ashless dispersant with a certain nitrogen content, a metal-containing detergent containing an organic acid metal salt selected from the group comprising an alkali or alkaline earth metal salt of an alkyl salicylic acid and an alkali or alkaline earth metal salt of an alkylphenol providing a certain sulphated ash content, a zinc dialkyldithiophosphate providing a specified phosphorus amount and an oxidation inhibitor. Lubricating oils formulated in accordance with this patent application are stated to exhibit good high temperature detergency despite the lower sulfur, phosphorus and sulphated ash levels of the compositions.

SUMMARY OF THE INVENTION

[0008] In accordance with the present invention there is provided a lubricating oil composition having a sulfur content of up to 0.3 wt.%, a phosphorus content of up to 0.08 wt.%, a sulfated ash content of up to 0.80 wt.% and containing less than 5 millimoles of salicylate soap per kilogram of lubricating oil composition which comprises an admixture of :

- (a) a major amount of an oil of lubricating viscosity selected from one or more of the group consisting of Group I, Group II, Group III, Group IV and synthetic ester base stock oils;
- (b) an overbased alkali metal or alkaline earth metal salicylate lubricating oil detergent having a salicylate soap content of 20 to 25 wt. %;
- (c) an ashless dispersant;
- (d) an antioxidant; and
- (e) a zinc dihydrocarbyldithiophosphate.

[0009] Unless otherwise stated, all amounts of additives are reported in wt. % on an active ingredient ("a.i.") basis, i.e., independent of the diluent or carrier oil.

Oil of Lubricating Viscosity

[0010] The oil of lubricating viscosity may be selected from Group I, II, III or IV base stocks, synthetic ester base stocks or mixtures thereof. The base stock groups are defined in the American Petroleum Institute (API) publication "Engine Oil Licensing and Certification System", Industry Services Department, Fourteenth Edition, December 1996, Addendum 1, December 1998. The base stock will have a viscosity preferably of 3-12, more preferably 4-10, most preferably 4.5-8 mm²/s (cSt.) at 100°C.

(a) Group I mineral oil base stocks contain less than 90% saturates and/or greater than 0.03% sulfur and have a viscosity index greater than or equal to 80 and less than 120 using the test methods specified in Table A below.

(b) Group II mineral oil base stocks contain greater than or equal to 90% saturates and less than or equal to 0.03% sulfur and have a viscosity index greater than or equal to 80 and less than 120 using the test methods specified in Table A below.

(c) Group III mineral oil base stocks contain greater than or equal to 90% saturates and less than or equal to 0.03% sulfur and have a viscosity index greater than or equal to 120 using the test methods specified in Table A below.

(d) Group IV base stocks are polyalphaolefms (PAO).

(e) Suitable ester base stocks that can be used comprise the esters of dicarboxylic acids (e.g., phthalic acid, succinic acid, alkyl succinic acids, alkenyl succinic acids, maleic acid, azelaic acid, suberic acid, sebacic acid, fumaric acid, adipic acid, linoleic acid dimer, malonic acid, alkyl malonic acids, alkenyl malonic acids, etc.) with a variety of alcohols (e.g., butyl alcohol, hexyl alcohol, dodecyl alcohol 2-ethylhexyl alcohol, ethylene glycol, diethylene glycol monoether, propylene glycol, etc.) Specific examples of these esters include dibutyl adipate, di(e-ethylhexyl) sebacate, din-n-hexyl fumarate, dioctyl sebacate, diisooctyl azelate, diisodecyl azelate, dioctyl phthalate, didecyl phthalate, dieicosyl sebacate, the 2-ethylhexyl diester of linoleic acid dimer, the complex ester formed by reacting one mole of sebacic acid with two moles of tetraethylene glycol and two moles of 2-ethylhexanoic acid and the like.

[0011] Esters useful as synthetic base stock oils also include those made from C₅ to C₁₂ monocarboxylic acids and polyols and polyol ethers such as neopentyl glycol, trimethylol propane, pentaerythritol, dipentaerythritol, tripentaerythritol, etc.

[0012] Preferably, the oil of lubricating viscosity does not comprise any Group I basestock oil.

Table A - Analytical Methods for Testing Base Stocks

Property	Test Method
Saturates	ASTM D2007
Viscosity Index	ASTM D2270
Sulfur	ASTM D2622, D4294, D4927, or D3120

[0013] The oil of lubricating viscosity used in this invention should have a viscosity index of at least 95, preferably at least 100. Preferred oils are (a) base oil blends of Group III base stocks with Group II base stocks, where the combination has a viscosity index of at least 110; or (b) Group III base stocks or blends of more than one Group III base stock. Mineral oils are preferred.

Metal Salicylate Detergent

[0014] The present invention requires the presence of at least one overbased alkali metal or alkaline earth lubricating oil detergent having a relatively low soap content, i.e., between 20 and 25 wt.%. These detergents surprisingly result in the oils having acceptable rating the XUD-IIBTE test for piston cleanliness while the same oil formulated with salicylates having a higher soap content show distinctly poorer results in the same test. Such a result is contrary to expectation, when conventionally the amount of soap is increased to provide improved piston cleanliness.

[0015] The overbased metal salicylate detergent may be C₈-C₃₀ alkyl salicylates or mixtures thereof, with C₁₀-C₂₀

alkyl salicylates being particularly preferred. Preferably, the detergent will be a calcium and/or magnesium salicylate and will have a Total Base Number at 100% active mass (TBN) between 10 and 700, more preferably between 50 and 650, and most preferably between 100 and 550. The most preferred detergent for use in this invention is an overbased calcium alkyl salicylate having a TBN between 100 and 550.

[0016] The process of overbasing a metal detergent means that a stoichiometric excess of the metal is present over what is required to neutralize the anion of the salt. It is the excess metal from overbasing that has the effect of neutralizing acids which may build up.

[0017] In the present invention, the amount of metal salicylate detergents used can vary broadly, but typically will be from about 0.2 to about 5 wt.%, preferably 0.3 to 1.5 wt.%, based on the total weight of the composition so as to provide less than 5 millimoles of salicylate soap per kilogram of the finished oil composition. Suitably, the amount of metal salicylate detergent used in the present invention provides the composition with at least 2 mmol soap per kilogram of the finished oil composition.

[0018] Preferably, the metal salicylate is the sole metal lubricating oil detergent present in the lubricating oil compositions of the invention. Alternatively, other metal-containing detergents, such as metal sulfonates or phenates, may be present in the lubricating composition, but preferably only in very minor amounts. In addition to being constrained by the amount of soap present in the finished oil composition, the total amount of detergent present is limited to provide the finished oil composition with a sulfated ash content of 0.80 wt. % or lower.

Ashless Dispersant

[0019] An ashless dispersant generally comprises an oil soluble polymeric hydrocarbon backbone having functional groups that are capable of associating with particles to be dispersed. Typically, the dispersants comprise amine, alcohol, amide, or ester polar moieties attached to the polymer backbone often via a bridging group. The ashless dispersant of the present invention may be, for example, selected from oil soluble salts, esters, amino-esters, amides, imides, and oxazolines of long chain hydrocarbon substituted mono and dicarboxylic acids or their anhydrides; thiocarboxylate derivatives of long chain hydrocarbons, long chain aliphatic hydrocarbons having a polyamine attached directly thereto; and Mannich condensation products formed by condensing a long chain substituted phenol with formaldehyde and polyalkylene polyamine.

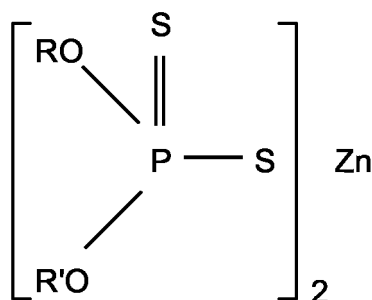
[0020] The ashless dispersant is suitably present in an amount of from 0.5 to 10.0 wt.%, preferably about 1 to 3 wt.%. Preferred are borated or non-borated polyisobutenyl succinimide dispersants wherein the polyisobutenyl has an Mn of about 500 to 3,000, preferably about 900 to 2,500. A preferred embodiment utilizes polyisobutenyl succinimide dispersants prepared using polyisobutylene prepared from a pure isobutylene stream or a Raffinate I stream to prepare reactive isobutylene polymers with terminal vinylidene olefins. Preferably, these polymers, referred to as highly reactive polyisobutylene (HR-PIB), have a terminal vinylidene content of at least 65%, e.g., 70%, more preferably at least 80%, most preferably at least 85%. The preparation of such polymers is described, for example, in U.S. Patent No. 4,152,499. HR-PIB is known and HR-PIB is commercially available under the tradenames Glissopal™ (from BASF) and Ultravis™ (from BP-Amoco).

Antioxidants

[0021] Antioxidants reduce the tendency of base stocks to deteriorate in service which deterioration can be evidenced by the products of oxidation such as sludge and varnish-like deposits on the metal surfaces and by viscosity growth. In the present invention they are suitably present in amount of from 0.1 to 5.0 wt.%, preferably 0.25 to 1.0 wt.%. Suitable oxidation inhibitors include hindered phenols, alkaline earth metal salts of alkylphenolthioesters having preferably C₅ to C₁₂ alkyl side chains, calcium nonylphenol sulfide, ashless oil soluble phenates and sulfurized phenates, phosphosulfurized or sulfurized hydrocarbons, alkyl substituted diphenylamine, alkyl substituted phenyl and naphthylamines, phosphorous esters, metal thiocarbamates, ashless thiocarbamates and oil soluble copper compounds as described in U.S. 4,867,890. Most preferred are the dialkyl substituted diphenylamines, wherein the alkyl is C₄-C₂₀, such as dinonyl diphenylamine and the hindered phenols, such as isooctyl-3,5-di-tert-butyl-4-hydroxycinnamate and mixtures of same.

Zinc Dihydrocarbyldithiophosphates

[0022] Zinc dihydrocarbyl dithiophosphates are oil soluble salts of dihydrocarbyl dithiophosphoric acids and may be represented by the following formula:



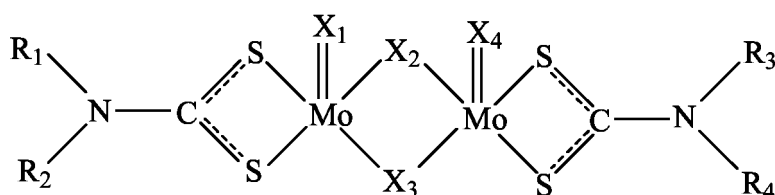
wherein R and R' may be the same or different hydrocarbyl radicals containing from 1 to 18, preferably 2 to 12, carbon atoms and including radicals such as alkyl, alkenyl, aryl, arylalkyl, alkaryl and cycloaliphatic radicals. Particularly preferred as R and R' groups are alkyl groups of 2 to 8 carbon atoms. Thus, the radicals may, for example, be ethyl, n-propyl, i-propyl, n-butyl, i-butyl, sec-butyl, amyl, n-hexyl, i-hexyl, n-octyl, decyl, dodecyl, octadecyl, 2-ethylhexyl, phenyl, butyl-phenyl, cyclohexyl, methylcyclopentyl, propenyl, butenyl. In order to obtain oil solubility, the total number of carbon atoms (i.e. R and R') in the dithiophosphoric acid will generally be about 5 or greater. The zinc dihydrocarbyl dithiophosphate (ZDDP) can therefore comprise zinc dialkyl dithiophosphates. ZDDP is the most commonly used antioxidant/antiwear agent in lubricating oil compositions for internal combustion engines, and in conventional passenger car diesel engines formulated to meet present European ACEA specifications. The lubricating oil compositions of the present invention suitably contain an amount of ZDDP (or other dihydrocarbyl dithiophosphate metal salt) that introduces about 0.02 to 0.08 wt.%, preferably 0.02 to 0.06 wt.% of phosphorus into the lubricating oil composition. The phosphorus content of the lubricating oil compositions is determined in accordance with the procedures of ASTM D5185.

[0023] Preferred, but optional ingredients, are oil soluble organomolybdenum compounds, friction modifiers, and viscosity modifiers.

Molybdenum Compound

[0024] For the lubricating oil compositions of this invention, any suitable oil soluble organo-molybdenum compound may be employed. The molybdenum compound is thought to function both as an antiwear and antioxidant additive. Preferably, dimeric and trimeric molybdenum compounds are used. Examples of such oil soluble organo-molybdenum compounds are the dialkyldithiocarbamates, dialkyldithiophosphates, dialkyldithiophosphinates, xanthates, thioxanthates, carboxylates and the like, and mixtures thereof. Particularly preferred are molybdenum dialkyldithiocarbamates.

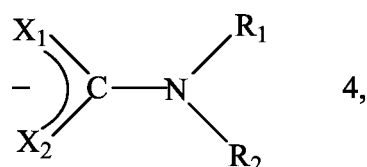
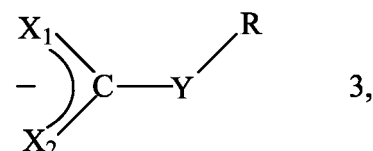
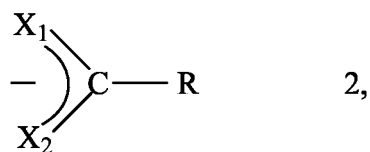
[0025] The molybdenum dialkyldithiocarbamate dimer to be used as an additive in the present invention is a compound expressed by the following formula:



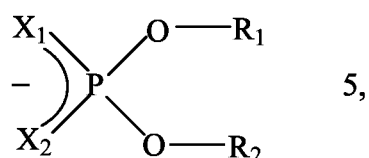
R₁ through R₄ independently denote a straight chain, branched chain or aromatic hydrocarbyl group; and X₁ through X₄ independently denote an oxygen atom or a sulfur atom. The four hydrocarbyl groups, R₁ through R₄, may be identical or different from one another.

[0026] Another group of organo-molybdenum compounds useful in the lubricating compositions of this invention are trinuclear (trimeric) molybdenum compounds, especially those of the formula Mo₃S_kL_nQ_z and mixtures thereof wherein the L are independently selected ligands having organo groups with a sufficient number of carbon atoms to render the compound soluble in the oil, n is from 1 to 4, k varies from 4 to 7, Q is selected from the group of neutral electron donating compounds such as water, amines, alcohols, phosphines, and ethers, and z ranges from 0 to 5 and includes non-stoichiometric values. At least 21 total carbon atoms should be present among all the ligands' organo groups, such as at least 25, at least 30, or at least 35 carbon atoms.

[0027] The ligands are selected from the group consisting of



and



and mixtures thereof, wherein X, X₁, X₂, and Y are independently selected from the group of oxygen and sulfur, and wherein R₁, R₂, and R are independently selected from hydrogen and organo groups that may be the same or different. Preferably, the organo groups are hydrocarbyl groups such as alkyl (e.g., in which the carbon atom attached to the remainder of the ligand is primary or secondary), aryl, substituted aryl and ether groups. More preferably, each ligand has the same hydrocarbyl group.

[0028] The term "hydrocarbyl" denotes a substituent having carbon atoms directly attached to the remainder of the ligand and is predominantly hydrocarbyl in character within the context of this invention. Such substituents include the following:

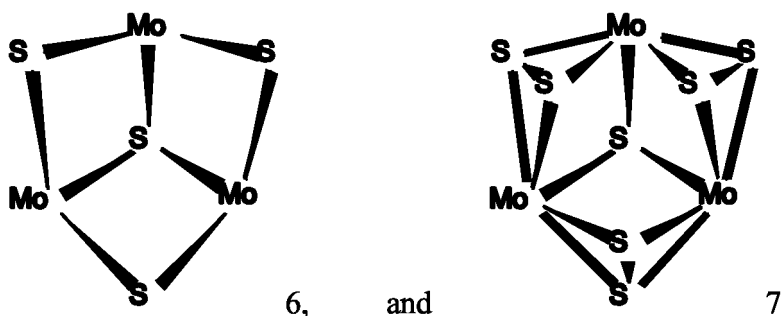
1. Hydrocarbon substituents, that is, aliphatic (for example alkyl or alkenyl), alicyclic (for example cycloalkyl or cycloalkenyl) substituents, aromatic-, aliphatic- and alicyclic-substituted aromatic nuclei and the like, as well as cyclic substituents wherein the ring is completed through another portion of the ligand (that is, any two indicated substituents may together form an alicyclic group).

2. Substituted hydrocarbon substituents, that is, those containing non-hydrocarbon groups which, in the context of this invention, do not alter the predominantly hydrocarbyl character of the substituent. Those skilled in the art will

be aware of suitable groups (e.g., halo, especially chloro and fluoro, amino, alkoxy, mercapto, alkylmercapto, nitro, nitroso, sulfoxy, etc.).

[0029] Importantly, the organo groups of the ligands should have a sufficient number of carbon atoms to render the compound soluble in the oil. For example, the number of carbon atoms in each group will generally range between about 1 to about 100, preferably from about 1 to about 30, and more preferably between about 4 to about 20. Preferred ligands include dialkyldithiophosphate, alkylxanthate, carboxylates, dialkyldithiocarbamate, and mixtures thereof. Most preferred are the dialkyldithiocarbamates. Those skilled in the art will realize that formation of the compounds requires selection of ligands having the appropriate charge to balance the core's charge (as discussed below).

[0030] Compounds having the formula $\text{Mo}_3\text{S}_k\text{L}_n\text{Q}_z$ have cationic cores surrounded by anionic ligands, wherein the cationic cores are represented by structures such as



which have net charges of +4. Consequently, in order to solubilize these cores the total charge among all the ligands must be -4. Four monoanionic ligands are preferred. Without wishing to be bound by any theory, it is believed that two or more trinuclear cores may be bound or interconnected by means of one or more ligands and the ligands may be multidentate, i.e., having multiple connections to one or more cores. It is believed that oxygen and/or selenium may be substituted for sulfur in the core(s).

[0031] Oil-soluble trinuclear molybdenum compounds are preferred and can be prepared by reacting in the appropriate liquid(s)/solvent(s) a molybdenum source such as $(\text{NH}_4)_2\text{Mo}_3\text{S}_{13} \cdot n(\text{H}_2\text{O})$, where n varies between 0 and 2 and includes non-stoichiometric values, with a suitable ligand source such as a tetraalkylthiuram disulfide. Other oil-soluble trinuclear molybdenum compounds can be formed during a reaction in the appropriate solvent(s) of a molybdenum source such as $(\text{NH}_4)_2\text{Mo}_3\text{S}_{13} \cdot n(\text{H}_2\text{O})$, a ligand source such as tetraalkylthiuram disulfide, dialkyldithiocarbamate, or dialkyldithiophosphate, and a sulfur abstracting agent such cyanide ions, sulfite ions, or substituted phosphines. Alternatively, a trinuclear molybdenum-sulfur halide salt such as $[\text{M}']_2[\text{Mo}_3\text{S}_7\text{A}_6]$, where M' is a counter ion, and A is a halogen such as Cl, Br, or I, may be reacted with a ligand source such as a dialkyldithiocarbamate or dialkyldithiophosphate in the appropriate liquid(s)/solvent(s) to form an oil-soluble trinuclear molybdenum compound. The appropriate liquid/solvent may be, for example, aqueous or organic.

[0032] The ligand chosen must have a sufficient number of carbon atoms to render the compound soluble in the lubricating composition. The term "oil-soluble" as used herein does not necessarily indicate that the compounds or additives are soluble in the oil in all proportions. It does mean that they are soluble in use, transportation, and storage.

[0033] A sulfurized molybdenum containing composition prepared by (i) reacting an acidic molybdenum compound and a basic nitrogen compound selected from the group consisting of succinimide, a carboxylic acid amide, a hydrocarbyl monoamine, a phosphoramidate, a thiophosphoramidate, a Mannich base, a dispersant viscosity index improver, or a mixture thereof, in the presence of a polar promoter, to form a molybdenum complex (ii) reacting the molybdenum complex with a sulfur containing compound, to thereby form a sulfur and molybdenum containing composition is useful within the context of this invention. The sulfurized molybdenum containing compositions may be generally characterized as a molybdenum/sulfur complex of a basic nitrogen compound. The precise molecular formula of these molybdenum compositions is not known with certainty. However, they are believed to be compounds in which molybdenum, whose valences are satisfied with atoms of oxygen or sulfur, is either complexed by, or the salt of one or more nitrogen atoms of the basic nitrogen containing compound used in the preparation of these compositions.

[0034] The lubricating compositions of the present invention may contain a minor amount of an oil soluble molybdenum compound. An amount of at least 10 ppm up to about 2,000 ppm of molybdenum from a molybdenum compound may be present in the lubricating oil composition. Preferably, about 500 ppm to 1,000 ppm of molybdenum from a molybdenum compound is used. These values are based upon the weight of the lubricating composition.

Friction Modifiers

[0035] At least one organic oil soluble friction modifier may preferably be incorporated in the lubricating oil composition. Typically, the friction modifier may make up about 0.02 to 2.0 wt.% of the lubricating oil composition. Preferably, from 0.05 to 1.0, more preferably from 0.1 to 0.5 wt.% of the friction modifier is used.

[0036] Friction modifiers include such compounds as aliphatic amines or ethoxylated aliphatic amines, aliphatic fatty acid amides, aliphatic carboxylic acids, aliphatic carboxylic esters of polyols such as glycerol esters of fatty acids as exemplified by glycerol oleate, which is preferred, aliphatic carboxylic ester-amides, aliphatic phosphonates, aliphatic thiophosphates, etc., wherein the aliphatic group usually contains above about eight carbon atoms so as to render the compound suitably oil soluble. Also suitable are aliphatic substituted succinimides formed by reacting one or more aliphatic succinic acids or anhydrides with ammonia.

Lubricating Oil Flow Improver

[0037] Pour point depressants, otherwise known as lube oil flow improvers, lower the minimum temperature at which the fluid will flow or can be poured. Such additives are well known. Typical of those additives which improve the low temperature fluidity of the fluid are C₈ to C₁₈ dialkyl fumarate/vinyl acetate copolymers, polyalkylmethacrylates and the like. These may be used in amounts of from 0.01 to 5.0 wt.%, preferably about 0.1 to 3.0 wt.%. They are preferably used when mineral oil base stocks are employed but are not generally required when the base stock is a PAO or synthetic ester.

Viscosity Modifier

[0038] A viscosity modifier (VM) functions to impart high and low temperature operability to a lubricating oil. The VM used may have that sole function, or may be multifunctional. It may be present in amounts of from 0.01 to 20.0 wt. %, preferably about 1.0 to 10.0 wt.%. These are preferably employed when the base stock is a mineral oil.

[0039] Multifunctional viscosity modifiers that also function as dispersants are also known. Suitable viscosity modifiers are polyisobutylene, copolymers of ethylene and propylene and higher alpha-olefins, polymethacrylates, polyalkylmethacrylates, methacrylate copolymers, copolymers of an unsaturated dicarboxylic acid and a vinyl compound, inter polymers of styrene and acrylic esters, and partially hydrogenated copolymers of styrene/isoprene, styrene/butadiene, and isoprene/butadiene, as well as the partially hydrogenated homopolymers of butadiene and isoprene and isoprene/divinylbenzene.

[0040] Foam control can be provided by many compounds including an antifoamant of the polysiloxane type, for example, silicone oil or polydimethyl siloxane.

[0041] Some of the above-mentioned additives can provide a multiplicity of effects; thus for example, a single additive may act as a dispersant-oxidation inhibitor. This approach is well known and does not require further elaboration.

[0042] The individual additives may be incorporated into a base stock in any convenient way. Thus, each of the components can be added directly to the base stock or base oil blend by dispersing or dissolving it in the base stock or base oil blend at the desired level of concentration. Such blending may occur at ambient temperature or at an elevated temperature. The invention comprising the product results from the admixture of the additive components to form a lubricating oil composition.

[0043] Preferably, all the additives except for the viscosity modifier and the pour point depressant are blended into a concentrate or additive package described herein as the additive package, that is subsequently blended into base stock to make the finished lubricant. The concentrate will typically be formulated to contain the additive(s) in proper amounts to provide the desired concentration in the final formulation when the concentrate is combined with a predetermined amount of a base lubricant.

[0044] The concentrate is preferably made in accordance with the method described in U.S. 4,938,880. That patent describes making a pre-mix of ashless dispersant and metal detergents that is pre-blended at a temperature of at least about 100°C. Thereafter, the pre-mix is cooled to at least 85°C and the additional components are added.

[0045] The final crankcase lubricating oil formulation may employ from 2 to 20 mass %, preferably 4 to 18 mass %, and most preferably about 5 to 17 mass % of the concentrate or additive package, with the remainder being base stock.

EXAMPLE 1

[0046] The following inventive oil A was prepared and tested for piston merits according to the XUD-IIBTE fired engine test, a European passenger car diesel engine test (CEC L-56-T-98) which is part of the ACEA B specification, the same test was carried out on comparative formulations oils B and C. The piston cleanliness results are given in Table 1. Oil A shows a distinct and surprising improvement notwithstanding the lower soap content.

[0047] Oil A: a lubricating oil composition was prepared containing 0.51 wt.% calcium alkyl salicylate (TBN at 100%

active matter 511, 23.6 mass % soap), organomolybdenum antiwear agent, friction modifier, dispersant, antioxidant, lubricating oil flow improver, viscosity modifier, antifoam agent, zinc dihydrocarbyl dithiophosphate and mineral oil base stocks.

[0048] This oil had 0.19 wt.% sulfur, 0.049 wt.% phosphorus and 0.5 wt.% sulfated ash and contained 3.6 millimoles of salicylate soap per kilogram of oil; the XUD-IIBTE piston merits value was 50.6

[0049] Oil B: the formulation of Oil A above was duplicated except that all of the calcium alkyl salicylate of Oil A was replaced by 0.89 wt% of a calcium alkyl salicylate having a soap content of 35.6%, and the final oil had 13.2 millimoles of soap per kilogram of oil.

[0050] Oil C: the formulation of Oil A above was duplicated except that the calcium alkyl salicylate of Oil A was replaced by 0.79 wt% of a calcium alkyl salicylate having a soap content of 37.1% and 0.30 wt% of a magnesium salicylate having a soap content of 30.3%, and the final oil had 9.5 millimoles of soap per kilogram of oil.

Table 1

Oil Tested	Oil A	Oil B	Oil C
Piston Merits	50.6	46.8	46.8

Claims

1. A lubricating oil composition having a sulfur content of up to 0.3 wt.%, a phosphorus content of up to 0.08 wt.%, a sulfated ash content of up to 0.80 wt.% and containing less than 5 millimoles of detergent salicylate soap per kilogram of oil composition which comprises an admixture of :

- (a) a major amount of an oil of lubricating viscosity; and
- (b) an overbased alkali metal or alkaline earth metal alkyl salicylate lubricating oil detergent having a salicylate soap content of 20 to 25 wt. %.

2. The composition of claim 1, further comprising one or more of a member of the group consisting of dispersants, suitably ashless dispersants, an antioxidant, a zinc dihydrocarbyl dithio phosphate, oil soluble organomolybdenum compounds, friction modifiers and viscosity modifiers.

3. The composition of claim 1 or claim 2, wherein the (b) ingredient is calcium or magnesium salicylate of 100% active mass TBN 10 - 700.

4. The composition of claim 2 or 3, wherein the dispersant is a polyisobutenyl succinimide

6. The composition of claim 2, 3, or 4, wherein the antioxidant is (i) a dialkyl diphenylamine wherein the alkyl is C₄-C₂₀ alkyl, (ii) a hindered phenol or (iii) a mixture thereof.

7. The composition of any of claims 2 to 6, wherein the hydrocarbyl groups of the zinc dihydrocarbyldithiophosphate have 2 to 8 carbon atoms.

8. The composition of any one of claims 2 to 7, wherein the organomolybdenum compound is a dialkyldithiocarbamate.

9. The composition of any one of the preceding claims, wherein the (a) ingredient is a mineral oil.

10. The composition of any one of the preceding claims, wherein the (b) ingredient is the sole metal detergent present.



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Munich		9 December 2005	Kazemi, P
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