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AUSTRALIA

PATENTS ACT 1990

PATENT REQUEST: STANDARD PATENT

I/We, the Applicant(s)/Nominated Person(s) specified below, request I/We be granted a patent for the invention disclosed in the accompanying standard complete specification.

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[54] Invention Title:

Process for Producing a Reduced Calorie Fat Mimetic Composition

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CPC International Inc., Arco Chemical Technology, L.P.

By:



Registered Patent Attorney

IRN: 253821

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NOTICE OF ENTITLEMENT

I, John Gordon Hinde, of Spruson & Ferguson, St Martins Tower, 31 Market Street, Sydney, New South Wales 2000, Australia, being the patent attorney for the Applicant(s)/Nominated Person(s) in respect of an application entitled:

Process for Producing a Reduced Calorie Fat Mimetic Composition

state the following:-

The Applicant(s)/Nominated Person(s) has/have entitlement from the actual inventor(s) as follows:-

The Applicant(s)/Nominated Person(s) is/are the assignee(s) of the actual inventor(s).

The Applicant(s)/Nominated Person(s) is/are entitled to rely on the basic application(s) listed on the Patent Request as follows:

The Applicant(s)/Nominated Person(s) is/are the assignee(s) of the basic applicant(s).

The basic application(s) listed on the Patent Request is/are the first application(s) made in a Convention country in respect of the invention.

DATED this TWENTY-SECOND day of OCTOBER 19 93

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AU 50235/93
US 5175323
US 4861613
- (57) Claim

1. A process for producing a reduced calorie fat mimetic comprising the steps of

(a) contacting a first esterified alkoxyated polyol characterized by the presence of at least one C₂₀-C₂₄ unsaturated linear acyl group with hydrogen in the presence of a transition metal catalyst for a time and at a temperature effective to accomplish hydrogenation of the C₂₀-C₂₄ unsaturated linear acyl group to yield a second esterified alkoxyated polyol characterized by the presence of at least one C₂₀-C₂₄ saturated linear acyl group and the ^{presence of less than 1 mol percent} ~~absence of any~~ C₂₂ unsaturated linear acyl group; and

(b) contacting the second esterified alkoxyated polyol with a third esterified alkoxyated polyol characterized by the presence of at least one C₆-C₁₉ unsaturated acyl group in the

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presence of a basic catalyst for a time and at a temperature effective to accomplish interchange of at least one $C_{20}-C_{24}$ saturated linear acyl group and at least one C_6-C_{19} unsaturated acyl group to yield the reduced calorie fat mimetic.

18. A process for producing a reduced calorie fat mimetic composition comprising the steps of

(a) contacting a first esterified alkoxyated polyol comprised of (i) a first polyol residue derived from a first polyhydric aliphatic compound and (ii) 2 to 8 fatty acid-esterified oxyalkylene groups connected to said first polyol residue wherein at least one-half of the fatty acid-esterified oxyalkylene groups have the general structure $-(OA^1)_nCR^1$ wherein OA^1 is a first oxyalkylene unit derived from a first C_2-C_{10} aliphatic epoxide, n is from 1 to 20, and $-CR^1$ is an acyl group derived from a $C_{20}-C_{24}$ unsaturated linear fatty acid with hydrogen in the presence of a catalyst containing nickel or copper at a pressure of from 0.5 to 20 atmospheres and a temperature of from $75^\circ C$ to $275^\circ C$ for a time effective to accomplish hydrogenation of the acyl group derived from the $C_{20}-C_{24}$ unsaturated linear fatty acid to yield a second esterified alkoxyated polyol characterized by the presence of at least one $C_{20}-C_{24}$ saturated linear acyl group and the ^{presence of less than 1 mol percent} ~~absence of any~~ C_{22} unsaturated linear acyl groups; and

(b) contacting the second esterified alkoxyated polyol with a third esterified alkoxyated polyol comprised of (i) a second polyol residue which is the same as or different from the first polyol residue derived from a second polyhydric aliphatic compound which is the same as or different from the first polyhydric aliphatic compound and (ii) from 2 to 8 fatty acid-esterified oxyalkylene groups connected to said second

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polyol residue wherein at least one of the fatty acid-esterified oxyalkylene groups has the general structure $-(OA^2)_m \overset{O}{\underset{O}{C}}R^2$ wherein OA^2 is a second oxyalkylene unit derived from a second C_2-C_{10} aliphatic epoxide which may be the same as or different from the first C_2-C_{10} aliphatic epoxide, m is from 1 to 20, and $\overset{O}{\underset{O}{C}}R^2$ is an acyl group derived from a C_6-C_{19} unsaturated fatty acid in the presence of an alkali metal or alkali metal compound at a temperature of from $0^\circ C$ to $275^\circ C$ for a time effective to accomplish interchange of at least one $C_{20}-C_{24}$ saturated linear acyl group in the second esterified alkoxyated polyol and at least one acyl group derived from C_6-C_{19} unsaturated fatty acid in the third esterified alkoxyated polyol to yield the reduced calorie fat mimetic compositions.

PF 01-2203A

PROCESS FOR PRODUCING A REDUCED CALORIE FAT MIMETIC COMPOSITION

FIELD OF THE INVENTION:

This invention relates to methods whereby reduced calorie fat substitutes may be conveniently and economically prepared. More specifically, the invention pertains to a synthetic process wherein an esterified alkoxyated polyol which is relatively rich in C_{20} - C_{24} saturated linear acyl groups and which is obtained by hydrogenation of a precursor relatively rich in C_{20} - C_{24} unsaturated linear acyl groups is reacted with a different esterified alkoxyated polyol composition which is relatively rich in C_6 - C_{19} unsaturated acyl groups so as to achieve interchange of acyl groups between the two esterified alkoxyated polyols.

BACKGROUND OF THE INVENTION:

A wide variety of substances have been proposed for use as fat substitutes in food compositions. The chemical structures of such substances are selected such that they are more resistant to breakdown by the metabolic processes of the human digestive system which normally occur upon ingestion of conventional triglyceride lipids. Because of their increased resistance to digestion and absorption, the number of calories per gram available from the fat substitutes is considerably reduced as compared to common vegetable oils, animal fats, and other lipids. The use of such substances thus enables the preparation of

reduced calorie food compositions useful in the control of body weight.

U.S. Pat. No. 4,861,613 (incorporated herein by reference in its entirety) describes one class of particularly useful fat
5 substitutes wherein a polyol such as glycerin is alkoxyated with an epoxide such as propylene oxide and then esterified with any of a number of fatty acids or fatty acid derivatives to form an esterified alkoxyated polyol. These substances have the physical and organoleptic properties of conventional triglyceride
10 lipids, yet are significantly lower in available calories than edible oils owing to their pronounced resistance towards absorption and pancreatic lipase enzymatic hydrolysis. The thermal and oxidative stability of the esterified alkoxyated polyols renders them especially suitable for use in the preparation of reduced calorie food compositions requiring exposure to high temperatures such as fried or baked foods.

Unfortunately, as a consequence of their hydrolytic stability and low digestibility, the esterified alkoxyated polyols described in U.S. Pat. No. 4,861,613 may tend to cause certain
15 undesirable gastrointestinal side effects when consumed at high levels in the diet. That is, since such esterified alkoxyated polyols are not readily broken down into simpler substances upon ingestion, they largely retain their oily, fat-like character and pass through the digestive tract in substantially unaltered form.
20 Non-digestible fat substitutes in general often function as

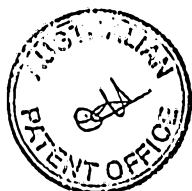
laxatives in much the same manner as mineral oil. Problems with diarrhea, leakage of the fat substitute through the anal sphincter, separation of the fat substitute as an oil from the excreted fecal matter, and shortened bowel transition times resulting in gastrointestinal discomfort can occur as a result of the non-digestibility of the fat substitutes. Other fat substitutes which are similarly resistant towards digestion are known to produce such gastrointestinal side effects. Examples include sucrose polyester which is esterified with up to 8 fatty acid groups; see U.S. Pat. Nos. 3,954,976, 4,005,195, 4,005,196, and 5,006,360. Obviously, such problems will greatly limit the maximum usage level of these substances which can be tolerated in various food compositions, thereby constraining the amount of conventional triglyceride and the number of calories which can be removed from certain foods.

One solution to this problem is provided in ~~copending~~ ^{EP-A-0571219.} application Ser. No. ~~07/880,538, filed May 20, 1992,~~ and entitled "Esterified Propoxylated Glycerin Fat Substitute Compositions Resistant to Gastrointestinal Side Effects" (incorporated herein by reference in its entirety). The copending application describes a fatty acid-esterified propoxylated glycerin composition useful as a reduced calorie fat substitute resistant to gastrointestinal side effects having an average number of oxypropylene units per equivalent of glycerin of from 3 to 20, a fatty acid acyl group content such that at least 40 mole percent



of the fatty acid acyl groups in the composition are derived from a C₂₀-C₂₄ saturated linear fatty acid, and a solid fat index at 27°C as measured by dilatometry of at least 30. The utilization of such a composition in combination with a conventional fully
5 digestible fatty acid triglyceride fat or oil in a food composition normally containing a fatty component is also described. The copending application suggests that these fatty acid-esterified propoxylated glycerin compositions may be obtained by first propoxylating glycerin with the desired number
10 of equivalents of propylene oxide and then esterifying with a fatty acid or a fatty acid equivalent such as a fatty acid ester, or fatty acid halide, or a fatty acid anhydride.

The use of fatty acid esters in such an esterification step is described in ^{U.S. Patent 5175323} ~~copending application Ser. No. 07/227,048, filed~~
15 ~~August 1, 1988~~, entitled "Preparation of Esterified Propoxylated Glycerin by Transesterification" (incorporated herein by reference in its entirety). The fatty acid esters employed in this process are C₁ to C₄ alkyl esters of saturated or
20 unsaturated C₁₀ to C₂₄ fatty acids. The esterification reaction is readily driven to completion by removing the C₁ to C₄ alkyl alcohol generated during the transesterification reaction by distillation or similar means. Although this approach works well
25 on a laboratory scale and affords a high yield of esterified alkoxyated polyol with minimal by-products or color formation, it suffers from the practical disadvantage that the required C₁



to C₄ alkyl esters are relatively expensive as compared to the corresponding free fatty acids. In addition, great care must be taken to ensure that all of the residual C₁-C₄ alkyl alcohol formed is removed from the product prior to use in a food composition since certain alcohols of this type (methanol, for example) are considered harmful when ingested.

However, if the C₂₀-C₂₄ saturated linear acyl groups in the esterified propoxylated glycerin compositions of ~~depending~~ ^{EP-A-0571219.} ~~application Ser. No. 07/886,538~~ are introduced using the corresponding free fatty acids rather than the C₁-C₄ alkyl esters in order to reduce the overall cost of the esterification, certain other processing problems are encountered. In particular, a direct esterification process must generally be run at a higher temperature than a transesterification process, especially when the only catalytic effect is from the excess fatty acid present. Additionally, a fairly large excess (10-20 % molar excess) of fatty acid relative to the initial hydroxyl concentration must be utilized in order to self-catalyze the reaction and to accomplish complete or near-complete esterification of the propoxylated glycerin. As a consequence, the excess fatty acid which remains at the completion of the esterification must be removed prior to formulation of the fat substitute into a food composition, as the excess fatty acid may cause severe taste, odor, and stability problems. A convenient way to remove the excess fatty acid is by vacuum steam stripping



the acids away from the esterified propoxylated glycerin composition. This procedure is quite difficult to accomplish when C₂₀-C₂₄ saturated linear fatty acids are being employed since such acids are relatively high melting (typically, over 74°C) and consequently readily form troublesome plugs in commercial processing equipment. At times, particularly in vacuum equipment, even steam tracing is not an effective solution due to temperature-lowering effects in the vacuum eductor. As a result, it is often nearly impossible to carry out a large scale non-catalyzed direct esterification of a propoxylated glycerin intermediate with C₂₀-C₂₄ saturated linear fatty acids without having to frequently shut down to remove plugs of unreacted fatty acid. If a transition metal esterification catalyst such as a zinc, titanium, or tin compound is utilized so as to permit the use of a stoichiometric amount of fatty acid relative to propoxylated glycerin, quantitative removal of the metal catalyst following esterification is often quite difficult to achieve. To be useable as a reduced calorie fat substitutes in food compositions, however, the esterified alkoxyated polyol must be essentially free of such metallic impurities.

EP-A-0571219

~~Depending application Ser. No. 07/886,538 suggests another~~

method by which the desired C₂₀-C₂₄ acyl groups may be introduced into an esterified propoxylated glycerin composition.

Unsaturated linear fatty acids containing 20 to 24 carbon atoms may be used to esterify a propoxylated glycerin intermediate and



the resulting esterified propoxylated glycerin composition may be hydrogenated so as to convert the long chain unsaturated acyl groups to long chain saturated acyl groups. This approach has the advantage of avoiding the use of free fatty acids which are high melting, since C₂₀-C₂₄ unsaturated fatty acids melt at significantly lower temperatures than their saturated analogues. For example, erucic acid (a C₂₂ mono-unsaturated fatty acid) melts at 33-35°C while behenic acid (the corresponding C₂₂ saturated fatty acid) melts at 80-82°C.

10 However, because the ingestion of lipids containing erucic acid residues has been associated with adverse physiological effects, it will generally be necessary to carry out the subsequent hydrogenation of the esterified propoxylated glycerin under conditions effective to accomplish substantially complete saturation of any acyl groups derived from erucic acid. Such conditions will generally also result in complete hydrogenation of any other mono-unsaturated acyl groups in the composition as well as at least partial hydrogenation of any di-or polyunsaturated acyl group. It will consequently be difficult to prepare an esterified propoxylated glycerin by this method wherein both C₂₀-C₂₄ saturated linear acyl groups and C₆-C₁₉ unsaturated acyl groups are connected via oxyalkylene units to the same glyceryl residue since possible harmful levels of erucic acid residues will likely also be present, thus limiting the usefulness of the composition as a fat substitute in food

compositions. It would be highly desirable to develop a method whereby an esterified propoxylated glycerin containing both C₂₀-C₂₄ saturated linear acyl groups and C₆-C₁₉ unsaturated acyl groups, but essentially no C₂₂ mono-unsaturated acyl groups
5 derived from erucic acid may be prepared. Such substances may have unique and advantageous properties (solid fat index, hardness, melting point, smoke point, flash point, plasticity, thermal and oxidative stability, etc.) rendering them extremely valuable as fully functional reduced calorie substitutes for
10 conventional triglycerides.

SUMMARY OF THE INVENTION:

This invention provides a process for producing a reduced calorie fat mimetic composition comprising the steps of contacting a first esterified alkoxyated polyol characterized by
15 the presence of C₂₀-C₂₄ unsaturated linear acyl groups with hydrogen in the presence of a transition metal catalyst for a time and at a temperature effective to accomplish hydrogenation of the C₂₀-C₂₄ unsaturated linear acyl group to yield a second esterified alkoxyated polyol characterized by the presence of at
20 least one C₂₀-C₂₄ saturated linear acyl group and the ^{presence} ~~absence~~ ^{less} of
^{than 1 mol percent} C₂₂ unsaturated linear acyl groups. The second esterified
25 alkoxyated polyol is contacted with a third esterified alkoxyated polyol characterized by the presence of at least one C₆-C₁₉ unsaturated acyl group in the presence of a basic catalyst for a time and at a temperature effective to accomplish



interchange of the C₂₀-C₂₄ saturated linear acyl group and the C₆-C₁₉ unsaturated acyl group to yield the reduced calorie fat mimetic composition.

The incorporation of C₂₀-C₂₄ saturated linear acyl groups into
5 the final esterified alkoxyated polyol at high levels renders it better tolerated in the digestive tract, as described in the aforementioned copending application. At any level, however, C₂₀-C₂₄ saturated linear acyl groups have the beneficial effect of increasing the melting or solidification point of an esterified
10 alkoxyated polyol. This increase in melting point may be utilized to help counteract the effect of introducing higher proportions of oxyalkylene groups in an esterified alkoxyated polyol. That is, an increasing degree of propoxylation (moles of propylene oxide reacted per mole of polyol) tends to enhance the
15 non-digestibility and lower the available caloric content of an esterified alkoxyated polyol but also generally depresses the melting point of such a composition. The solid fat index of the substance at a given temperature may consequently be too low for the substance to be directly substitutable for a conventional high-melting triglyceride in a margarine, shortening, cheese, or hard butter (confectionary) application. Increasing the proportion of C₂₀-C₂₄ saturated linear acyl groups relative to shorter chain, branched, and/or unsaturated acyl groups will favorably affect the melting characteristics of such substances. Another benefit of introducing C₂₀-C₂₄ linear acyl groups into an

esterified alkoxyated polyol is that the caloric availability of the fat mimetic tends to be lower when such groups are present rather than shorter chain acyl groups.

A distinct advantage of the present invention is that it completely avoids the use of free C₂₀-C₂₄ saturated linear fatty acids in a direct esterification step, thereby minimizing the handling and processing problems which are otherwise encountered. Another advantage is that the relative proportion of shorter chain unsaturated acyl groups in the esterified alkoxyated polyol composition may be varied as desired without introducing possible harmful levels of acyl groups derived from erucic acid.

DETAILED DESCRIPTION OF THE INVENTION:

Practice of the process of this invention requires the utilization of a first esterified alkoxyated polyol characterized by the presence of at least one C₂₀-C₂₄ unsaturated linear acyl group. Preferably, at least one-half of the acyl groups are C₂₀-C₂₄ unsaturated linear acyl groups. The use of C₂₂ monounsaturated linear acyl groups derived from erucic acid (cis-13- docosenoic acid) is especially desirable since erucic acid is readily available from natural sources such as rapeseed oil. The first esterified alkoxyated polyol is additionally characterized by having oxyalkylene units interspersed between attachment sites on a polyol residue (which is typically derived from a polyhydric aliphatic compound) and terminal long chain acyl groups derived

from fatty acids. Certain of the acyl groups may be advantageously attached directly to the polyol residue as described in U.S. Pat. Nos. 5,118,448 and 5,135,683 and European Pat. Pub. No. 481,523. The oxyalkylene units favorably influence the caloric availability and/or physical properties of these compositions as compared to triglycerides (natural fats and oils) wherein the polyol (glycerin) residue and all of the acyl groups are directly connected. Illustrative esterified alkoxyated polyols usable in the process of this invention are described, for example, in the following publications, the teachings of which are incorporated herein by reference in their entirety: U.S. Pat. No. 4,861,613 (White et al.), 4,983,329 (Cooper), 5,118,448 (Cooper), 5,135,683 (Cooper), 4,849,242 (Kershner), 5,059,443 (Ennis et al.), and 5,077,073 (Ennis et al.); European Pat. Publ. Nos. 481,523 (Sekula), 353,928 (Cooper), and 481,717 (Cooper). Methods for preparing such substances are also well-known and are provided in the foregoing publications.

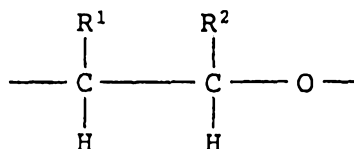
In an especially preferred embodiment of the invention, the first esterified alkoxyated polyol is comprised of a polyol residue derived from a polyhydric aliphatic compound and from 2 to 8 fatty acid-esterified oxyalkylene groups connected to the polyol residue (through ether linkages). At least one, and preferably at least one-half, of the fatty acid-esterified oxyalkylene groups have the general structure $-(OA)_n-\overset{O}{\parallel}CR$ wherein n is from 1 to 20, OA is an oxyalkylene unit derived from a C₂-C₁₀

epoxide, and $\overset{\text{O}}{\text{C}}\text{R}$ is an acyl group derived from a $\text{C}_{20}\text{-C}_{24}$ unsaturated linear fatty acid.

The polyhydric aliphatic compound may be selected from $\text{C}_2\text{-C}_{10}$ aliphatic diols (e.g., ethylene glycol, propylene glycol, 1,3-
5 propanediol, 1,4-butanediol, 1,2-butanediol, 2,3-butanediol, pinacol, 1,2-cyclohexanediol, 1,2-pentanediol, 1,4-pentanediol, 1,5-pentanediol, 2,4-pentanediol, 3,3-dimethyl-1,2-butanediol, 2-ethyl-2-methyl-1,2-propanediol, 1,2-hexanediol, 1,5-hexanediol, 1,6-hexanediol, 2,5-hexanediol, 2-methyl-2,4-pentanediol, 1,4-
10 cyclohexanediol, 1,7-heptanediol, 2-methyl-2-propyl-1,3-propanediol, 2,2-diethyl-1,3-propanediol, 2,4-dimethyl-2,4-pentanediol, 2-ethyl-1,3-hexanediol, 1,2-octanediol, 1,8-octanediol, 2,2,4-trimethyl-1,2-pentanediol, and the like), $\text{C}_3\text{-C}_{12}$ aliphatic triols (e.g., glycerin, 1,2,4-butanetriol, 2,3,4-pentanetriol, 2-ethyl-2-(hydroxymethyl)-1,3-propanediol, 1,1,1-tris(hydroxymethyl) ethane, 1,2,6-trihydroxyhexane, 1,2,3-heptanetriol, and the like), pentaerythritol, sugar
alcohols [including those compounds corresponding to the formula
HOCH₂(CHOH)_nCH₂OH wherein n is 2 to 6 such as erythritol,
xylitol, sorbitol, arabitol, mannitol, and the like],
20 monosaccharides (e.g., erythrose, threose, ribose, arabinose, xylose, lyxose, allose, altrose, glucose, mannose, gulose, idose, galactose, fructose, galactose, and the like), disaccharides (e.g., sucrose, maltose, lactose) and alkyl glycosides (e.g.,
25 methyl glycosides, ethyl glycosides, propyl glycosides, and other

glycoside molecules wherein the alkyl glycoside is an acetal formed by interaction of a C₁-C₂₀ alcohol with a carbonyl group of a mono- or disaccharide such as glucose). Most preferably, the polyhydric aliphatic compound is glycerin (also known as glycerol). The value of n (the number of oxyalkylene units per acyl group) in the first esterified alkoxyated polyol will preferably vary from 1 to 20, but can be manipulated as desired to alter the resistance of the final reduced calorie fat mimetic composition towards digestion and metabolic breakdown as well as the physical properties and characteristics (e.g., melting point, viscosity, relative polarity, solid fat index) of said composition. When the polyhydric aliphatic compound is glycerin, n is preferably 1 to 6. The oxyalkylene units ("OA") are preferably derived by ring-opening C₂-C₁₀ epoxides, especially aliphatic epoxides, such as ethylene oxide, propylene oxide, 1,2-butylene oxide, (cis and/or trans) 2,3-butylene oxide, isobutylene oxide, 1,2-pentene oxide, cyclohexene oxide, phenyl glycidyl ether, methyl glycidyl ether, ethyl glycidyl ether, styrene oxide, epichlorohydrin, allyl glycidyl ether, and the like. Due to their low cost, high reactivity, and favorable impact on esterified alkoxyated polyol fat substitute properties, the use of ethylene oxide, propylene oxide, 1,2-butylene oxide or mixtures thereof (either in random or block fashion) is especially desirable. Each oxyalkylene unit

has the general skeletal formula -C-C-O- containing two carbons and one oxygen. However, the oxyalkylene unit may be substituted with one or more alkyl, aryl, aralkyl, or other such substituent. In a preferred embodiment, the oxyalkylene units correspond to the structure



wherein R¹ and R² are the same or different and are hydrogen or a C₁-C₆ alkyl group such as methyl, ethyl, propyl, isopropyl, butyl, sec-butyl, iso-butyl, tert-butyl, pentyl, hexyl, cyclohexyl, and the like. Most preferably, one of R or R¹ is methyl and the other R group is hydrogen. In one desirable embodiment, R² in the oxyalkylene unit adjacent to the acyl group is a C₁-C₆ alkyl group since a secondary ester linkage resistant to enzymatic hydrolysis is thereby furnished.

The remaining acyl groups in the first esterified alkoxyated polyol may be nominally derived from a C₈-C₂₄ saturated or unsaturated fatty acid such as, for example, caprylic acid, capric acid, lauric acid, myristic acid, palmitic acid, palmitoleic acid, stearic acid, oleic acid, elaidic acid, linoleic acid, linolenic acid, arachidic acid, gadoleic acid, behenic acid, lignoceric acid, and the like, subject to the proviso, of course, that at least one of the acyl groups in the first esterified alkoxyated polyol is a C₂₀-C₂₄ linear

unsaturated acyl group (obtained, for example, from fatty acids such as eicosenoic acids, docosenoic acids (including erucic acid), and docosadienoic acids and the like).

The method by which a first esterified alkoxyated polyol
5 having an appropriate acyl group content as described hereinabove is prepared is not critical, but a particularly convenient method is to alkoxyate a polyhydric aliphatic compound such as glycerin with the desired epoxide or mixture of epoxides such as ethylene oxide, propylene oxide, or 1,2-butylene oxide in the presence of
10 a basic catalyst such as a sodium or potassium alkoxide and then esterifying the resulting alkoxyated polyol with a mixture of free fatty acids having a suitable C_{20} - C_{24} unsaturated fatty acid content obtained by hydrolytic splitting of a natural triglyceride rich in such C_{20} - C_{24} unsaturated fatty acids. For
15 example, many Cruciferous plants produce seeds in which erucic acid (a mono-unsaturated C_{22} fatty acid) is a major or main constituent of the triglycerides found therein.

Illustrative examples of seed fats which can be utilized to provide C_{20} - C_{24} unsaturated linear fatty acids useful in the
20 preparation of the first esterified alkoxyated polyol include, but are not limited to, lipids obtainable from plants such as Brassica alba (yellow mustard; ca. 7-8 wt. % C_{20} acyl groups and ca. 44-46 wt. % C_{22} acyl groups), Brassica campestris (turnip rape, colza; ca. 3-12% C_{20} acyl groups and ca. 40-60 wt. % C_{22}
25 acyl groups), Brassica juncea (mustard: ca. 45 wt. % C_{22} acyl

groups), Brassica tournefortii, Sinapis alba (ca. 51 wt. % erucic acid), Brassica nigra (black mustard; ca. 8-9 wt. % C₂₀ acyl groups and ca. 43-44 wt. % C₂₂ acyl groups), Brassica napus (rape), Cherianthus cheiri (wallflower; ca. 38-43 wt. % C₂₂ acyl groups), Coringia orientalis (hare's ear mustard; ca. 10 wt. % C₂₀ acyl groups and ca. 35-45 wt. % C₂₂ acyl groups), Erucastrum strigosum (ca. 48 wt. % C₂₂ acyl groups), Sisymbrium alliaria (ca. 47 wt. % erucic acid), Eruca sativa (jambo rape; ca. 11-12 wt. % C₂₀ acyl groups and ca. 37-38 wt. % C₂₂ acyl groups), and Thlaspe arvense (fanweed; ca. 0-7 wt. % C₂₀ acyl groups, ca. 37-49 wt. % C₂₂ acyl groups, and ca. 0-4 wt. % C₂₄ acyl groups). The seed fats of the Tropaeolum (nasturtium) family also contain high proportions of erucic acid oils. High erucic acid oils from Crambe abyssinica and Crambe hispanica (ca. 52-57 wt. % 22:1 fatty acid content) could also be used. Another excellent source of C₂₀-C₂₄ linear unsaturated fatty acids is the oil from the seeds of Limnathes douglasii (meadowfoam: ca. 63 wt. % C₂₀ acyl groups and ca. 34 wt. % C₂₂ acyl groups). Due to its availability and relatively low cost, the mixture of fatty acids derived by hydrolysis of high erucic rapeseed oil is especially preferred for use. The optimum conditions required to accomplish the desired level of esterification and to purify the resulting product will generally be similar to those described in U.S. Pat. No. 4,983,329, incorporated herein by reference in its entirety.

Since only minor quantities (generally, from 0 to a maximum of 10

mole % of the total fatty acid mixture) of high melting C₂₀-C₂₄ saturated linear fatty acids will be present during such a direct esterification step, minimal problems with plugging of overhead lines when vacuum steam stripping such esterification products to
5 remove excess unreacted fatty acid will be encountered.

The first esterified alkoxyated polyol is contacted with hydrogen in the presence of a transition metal catalyst for a time and at a temperature effective to accomplish hydrogenation of the C₂₀-C₂₄ unsaturated linear acyl groups (minimally,
10 essentially complete conversion of all erucic acid-derived acyl groups to $-\overset{\text{O}}{\text{C}}(\text{CH}_2)_{20}\text{CH}_3$ acyl groups) to yield a second esterified alkoxyated polyol characterized by the presence of C₂₀-C₂₄ saturated linear acyl groups. If the first esterified alkoxyated polyol contained any shorter chain (C₆-C₁₉)
15 unsaturated acyl groups, partial or complete hydrogenation of these groups will generally also take place during this step. It is desirable to conduct the hydrogenation under conditions sufficient to lower the C₂₀-C₂₄ unsaturated linear acyl group content to less than 1 mole %, especially if erucic acid residues
20 are initially present. The second esterified alkoxyated polyol must contain at least one C₂₀-C₂₄ saturated linear acyl group (more preferably, at least one-half of the acyl groups should be C₂₀-C₂₄ saturated linear acyl groups).

Surprisingly, it has been discovered that the C₂₀-C₂₄
25 unsaturated linear acyl groups may be fully hydrogenated by the

process of this invention without degradation or cleavage of the oxyalkylene units or generation of undesirable off-odors or flavors due to by-product formation. The hydrogenation is preferably conducted at a hydrogen pressure of from 0.5 to 20
5 (more preferably, 0.5 to 10) atmospheres and a temperature of from 75°C to 275°C (more preferably, 100°C to 225°C), although higher or lower temperatures and pressures may be suitably employed depending upon the reactivities of the particular first esterified alkoxyated polyol and transition metal catalyst
10 utilized. Reaction (contact) times under these conditions of from 0.5 to 24 hours (more preferably, 1 to 12 hours) will normally be effective to achieve a sufficient degree of hydrogenation. Any of the transition metal catalysts known to be
15 useful for the hydrogenation of natural triglycerides may also be utilized to advantage in the instant process, but catalysts wherein the transition metal is platinum, palladium, rhodium, ruthenium, zinc, nickel (e.g., Raney nickel, nickel boride) or copper (especially in the form of copper chromite) are especially
20 preferred for use. Promoters such as chromium, cobalt, thorium, zirconium, titanium, copper and silver, either as such or in the form of oxides or other compounds may also be present. The transition metal catalyst is typically utilized in finely divided form and may advantageously be supported on a porous inert refractory material such as diatomaceous earth, alumina, silica
25 gel, molecular sieves, or kieselguhr or on other types of

supports such as carbon (charcoal). Especially preferred for use are "wet-reduced" nickel catalysts containing nickel metal in a matrix of hardened vegetable oil. The catalyst may be heterogeneous (insoluble) or homogeneous (soluble); the

5 heterogeneous catalysts are preferred since they may be readily separated by filtration from the second esterified alkoxyated polyol composition after hydrogenation and reused in subsequent hydrogenations. The optimum amount of catalyst will be dependent upon its activity, the reactivity of the carbon-carbon double
10 bonds in the first esterified alkoxyated polyol, temperature, hydrogen pressure and other factors but will generally be selected such that the concentrations of the transition metal itself is from 100 to 10,000 parts per million. The reaction with hydrogen may be conducted in a batch, continuous or semi-
15 continuous manner in an appropriately configured closed reactor vessel, preferably with good agitation to ensure effective mass transfer of the hydrogen and esterified alkoxyated polyol to and from the surface of the catalyst. Although a solvent may be present, the use of a solvent is not necessary since the first
20 esterified alkoxyated polyol will usually be a free-flowing liquid at the reaction temperatures employed. The hydrogen may be dispersed into the reaction mixture by bubbling or sparging using either a recirculation or dead-end system, for example.

25 When the desired degree of reaction has taken place, the second esterified polyol thus obtained may be filtered or

otherwise treated to remove the transition metal catalyst. For example, nickel removal may be accomplished by a postbleaching step wherein the second esterified alkoxyated polyol after an initial filtration is treated with 0.05-1.0% bleaching earth, 5 activated carbon, or other adsorbent at an elevated temperature (50-150°C) and then refiltered. Treatment with acid or ion exchange resins may also be useful. The product thus obtained will be similar in composition to the initial first esterified alkoxyated polyol, with the exception that the product will 10 contain few, if any, C₂₀-C₂₄ unsaturated linear acyl groups, such groups being essentially entirely replaced by C₂₀-C₂₄ saturated linear acyl groups.

The second esterified alkoxyated polyol is thereafter contacted with a third esterified alkoxyated polyol 15 characterized by the presence of C₆-C₁₉ unsaturated acyl groups in the presence of a basic catalyst for a time and at a temperature effective to accomplish interchange of at least one C₂₀-C₂₄ saturated linear acyl group in the second esterified alkoxyated polyol and at least one C₆-C₁₉ unsaturated acyl group 20 in the third esterified alkoxyated polyol to produce the desired reduced calorie fat mimetic composition wherein individual esterified alkoxyated polyol molecules bear both C₂₀-C₂₄ saturated linear groups and C₆-C₁₉ unsaturated acyl groups.

It will typically be preferred to employ a third esterified 25 alkoxyated polyol wherein at least one-third of the acyl groups

present are C₆-C₁₉, unsaturated acyl groups. In a preferred embodiment, the third esterified alkoxyated polyol is comprised of a polyol residue derived from a polyhydric aliphatic compound which may be the same as or different from the polyol residue
5 present in the first esterified alkoxyated polyol and from 2 to 8 fatty acid esterified oxyalkylene groups attached to said polyol residue, provided, of course, that at least one C₆-C₁₉, unsaturated acyl group is present. The fatty acid-esterified oxyalkylene groups preferably have the general structure

10 $-(OA^2)_m \overset{O}{\parallel} CR^2$ wherein OA² is an oxyalkylene unit derived from a C₂-C₁₀ epoxide which may be the same as or different from the oxyalkylene unit(s) in the first and second esterified

alkoxyated polyols, m is from 1 to 20, and $\overset{O}{\parallel} CR^2$ is a C₆-C₂₄ acyl group, with the proviso that at least one acyl group is a
15 C₆-C₁₉, unsaturated acyl group. Preferably, the C₂-C₁₀ epoxide is ethylene oxide, propylene oxide, 1,2-butylene oxide, or a mixture thereof. Suitable third esterified alkoxyated polyols may be prepared by any appropriate method, but the methods described hereinabove for preparation of the first esterified alkoxyated
20 polyol are especially convenient, with the exception, of course, that the source of fatty acids will need to be selected so as to provide the desired level of C₆-C₁₉, unsaturated acyl groups. Other methods which are adoptable for this purpose are described in U.S. Pat. Nos. 4,861,613 and 4,983,329 and in copending

application Ser. No. 07/227,048. The third esterified alkoxyated polyol should contain essentially no C₂₂ mono-unsaturated acyl groups derived from erucic acid in order to avoid any potential health risks upon consumption of the reduced calorie fat mimetic product.

To minimize the costs associated with the practice of this invention, it will be particularly appropriate to utilize a fatty acid mixture in the preparation of the third esterified alkoxyated polyol directly obtainable by hydrolytic splitting of a natural triglyceride relatively rich in C₆-C₁₉ unsaturated fatty acids. Such natural triglycerides are well-known and readily available and include, for example, corn oil (ca. 43 wt. % oleic acid and 39 wt. % linoleic acid), cottonseed oil (ca. 19 wt. % oleic acid and 50 wt. % linoleic acid), olive oil (ca. 64.5-84.5 wt. % oleic acid and 4-15 wt. % linoleic acid), palm oil (ca. 38-53 wt. % oleic acid and 6-12 wt. % linoleic acid), peanut oil (ca. 42.3-61 wt. % oleic acid and 13-33.5 wt. % linoleic acid), low erucic rapeseed (canola) oil (ca. 55-63 wt. % oleic acid and 20-31 wt. % linoleic acid), safflower oil (ca. 9.7-13.1 wt. % oleic acid and 76.9-80.5 wt. % linoleic acid), sesame oil (ca. 35-46 wt. % oleic acid and 35-48 wt. % linoleic acid), soybean oil (ca. 23.5-30.8 wt. % oleic acid, 49-51 wt. % linoleic acid, and 2-10.5 % linolenic acid), sunflower oil (ca. 14-43 wt. % oleic acid and 44-68 wt. % linoleic acid), lard (ca. 1.3-3.6 wt. % palmitoleic acid, 38.3-44.4 wt. % oleic acid, and

4.5-8.8 wt. % linoleic acid), beef tallow (ca. 26-50 wt. % oleic acid and 1-2.5 wt. % linoleic acid), as well as partially hydrogenated derivatives thereof. Mixtures of fatty acids from different triglyceride sources can also be used.

5 The relative amounts of the second and third esterified alkoxyated polyols used in the process of this invention are not critical. However, it will typically be desirable to transfer a sufficient number of C_{20} - C_{24} saturated linear acyl groups from the second esterified alkoxyated polyol to the third esterified
10 alkoxyated polyol such that the latter component's tendency to provoke undesired gastrointestinal side effects is minimized and its melting profile is shifted upwards to an appropriate extent. The amount of the second esterified alkoxyated polyol required for these purposes will be a function of its initial content of
15 C_{20} - C_{24} saturated linear acyl groups. At the same time, it will often be desirable to transfer sufficient C_6 - C_{19} unsaturated acyl groups from the third esterified alkoxyated polyol to the second esterified alkoxyated polyol that beneficial effects such as
20 improved mouth feel or improved oxidative and/or thermal stabilities are realized. Thus, if there is a need to incorporate only a minor quantity of C_6 - C_{19} unsaturated acyl groups in the second esterified alkoxyated polyol composition, the amount of third esterified alkoxyated polyol composition utilized will be relatively small, especially if it is relatively
25 rich in unsaturated acyl groups. Generally speaking, the weight

ratio of second esterified alkoxyated polyol to third esterified alkoxyated polyol may be varied from at least 20:1 to 1:20.

The catalysts appropriate for use in the acyl group interchange step of the process will be those substances capable of catalyzing the desired transfer of acyl groups between the different starting components.

Such catalysts are typically basic in character and are preferably chosen from among those materials which are alkali metals, or alkali metal, alkaline earth, or ammonium compounds or tertiary amines since such substances exhibit high activity, tend to cause few problems with the formation of undesired by-products or impurities, may be readily removed by conventional techniques after the desired degree of acyl group interchange is accomplished, and do not generally raise any unusual concerns with respect to toxicity or other harmful effects if minor amounts remain in the reduced calorie fat mimetic product. Illustrative alkali metal, alkaline earth, or ammonium compounds which can be utilized include, but are not limited to ammonium, sodium, lithium, potassium, calcium, barium, or magnesium hydroxides, alkoxides (e.g., methoxides, ethoxides, salts of glycerin or other polyols such as diols, triols, tetrols, alkoxyated glycerin, and other polyhydric substances), carbonates, bicarbonates, hydrides, oxides, amides, carboxylates, phosphates, borates, sulfates, and the like. Metals such as sodium metal, potassium metal or a sodium-potassium alloy may

also be employed. Suitable tertiary amines include, for example, pyridine, triethylamine, N,N-dimethylaniline, N-ethyl morpholine and the like. The amount of catalyst is not critical and the optimum concentration can be readily determined by routine experimentation. If the catalyst is an alkali metal or alkali metal, alkaline earth, or ammonium compound, typically the concentration of alkali metal, or alkaline earth, or nitrogen can suitably be in the range of from 50 to 10,000 parts per million based on the total combined weight of the second and third esterified alkoxyated polyols. When tertiary amines are utilized, catalyst concentrations of from 0.2 to 10 weight percent are generally appropriate.

In one embodiment of this invention, the basic catalyst which is required to accomplish acyl group interchange between the second and third esterified alkoxyated polyol is present in the third esterified alkoxyated polyol as a result of the production of the third esterified alkoxyated polyol itself. That is, the same basic alkali metal, alkali metal compound, alkaline earth compound, or tertiary amine may be utilized to catalyze the alkoxylation reaction of a polyol with an epoxide to form an alkoxyated polyol intermediate and the esterification reaction of the alkoxyated polyol intermediate with a fatty acid or fatty acid ester of a C₁-C₆ alcohol to produce the third esterified alkoxyated polyol as well as the acyl group interchange reaction of the second and third esterified alkoxyated polyols. The

originally-charged basic catalyst is thus not removed prior to purification of the final desired reduced calorie fat mimetic composition. This embodiment provides a convenient and economical process for the preparation of such compositions since 5 tedious and costly catalyst removal steps as well as the total amount of basic catalyst required are minimized.

The second and third esterified alkoxyated polyols are contacted in the presence of the basic catalyst for a time and at a temperature effective to accomplish at least partial transfer 10 of the C₂₀-C₂₄ acyl groups present in the former substance to the latter substance. At the same time, C₆-C₁₉ unsaturated acyl group(s) are transferred from the third esterified alkoxyated polyol to the second esterified alkoxyated polyol replacing C₂₀-C₂₄ saturated linear acyl group(s). The reaction conditions 15 are selected such that the desired degree of acyl group interchange takes place within a practically short period of time (typically, from about 5 minutes to 12 hours). It has been found that the oxyalkylene units present in the esterified alkoxyated polyol components are not affected or degraded by operation of 20 the process of this invention, thus ensuring that the final product will be suitable for use in food compositions and that minimal purification or additional processing will be required.

Reaction temperatures of from 0°C to 275°C (more preferably, 50°C to 200°C) are normally suitable, although higher or lower 25 temperatures could be utilized depending upon the activity of the

catalyst. Although a solvent could be present in order to facilitate mixing, reduce viscosity, or aid in heat transfer, an important advantage of the process of this invention is that the use of a solvent is not required since both the second and third
5 esterified alkoxyated polyols are typically relatively free-flowing liquids at the reaction temperatures normally employed. The components of the reaction mixture are preferably stirred, mixed, or agitated in a suitable reaction vessel in order to assure intimate contact on a molecular level and to
10 facilitate the desired acyl group transfer reaction. The process of the invention is advantageously carried out under an inert atmosphere wherein air and oxygen are excluded in order to avoid oxidation of the reaction product. Unlike a conventional transesterification reaction of an alkoxyated polyol with C_1-C_4
15 alkyl esters of fatty acids or direct esterification with free fatty acids, no by-products (e.g., alcohol or water) need be removed from the reaction vessel during operation of the present process.

The reaction may be permitted to proceed until an equilibrium
20 is attained wherein the different acyl groups are randomly distributed with respect to the different positions available for acyl group substitution in the initial esterified alkoxyated polyol components. This will maximize the $C_{20}-C_{24}$ saturated linear acyl group content of the third esterified alkoxyated
25 polyol and the C_6-C_{19} unsaturated acyl group content of the

second esterified alkoxyated polyol. Alternatively, of course, the reaction may be halted at any point prior to reaching equilibrium by removing or deactivating the basic catalyst and/or cooling the mixture below the temperature at which acyl group interchange proceeds at a discernible rate. Another desirable benefit is that the equilibrium reaction product will be a reduced calorie lipid which is more homogeneous in character than the initial mixture of esterified alkoxyated polyols. That is, the second esterified alkoxyated polyol will tend to be a relatively high melting material which has a high solid fat index at or near room temperature owing to the high proportion of C₂₀-C₂₄ saturated acyl groups, while the third esterified alkoxyated polyol will tend to be a material which is completely or nearly completely liquid at room temperature, due to its high content of short chain unsaturated acyl groups. A simple mixture of these substances prior to acyl group interchange thus may be a heterogeneous blend at room temperature wherein solid particles of the second esterified alkoxyated polyol are dispersed in a matrix of liquid third esterified alkoxyated polyol. A blend having these characteristics may not be acceptable in all food applications. Once the acyl group interchange is carried out to equilibrium, however, the resulting reduced calorie fat mimetic composition will tend to be more uniform in appearance and exhibit a narrower melting range.

When the acyl group transfer reaction has proceeded to the extent desired, the basic catalyst may be removed or deactivated by any appropriate method. For example, if the basic catalyst is an alkali metal or an alkali metal, alkaline earth, or ammonium
5 compound, the reaction product can be contacted with a particulate absorbent such as magnesium or aluminum silicate at an appropriate temperature (typically, 50°C to 150°C) so as to absorb the catalyst onto the absorbent and then filtered.

Alternatively, the reaction product can be treated with an acid
10 such as a mineral acid (e.g., hydrochloric acid, sulfuric acid, phosphoric acid) or an organic acid (e.g., acetic acid, oxalic acid, citric acid, tartaric acid) so as to neutralize the basic catalyst. The neutralized catalyst typically forms a precipitate which can be removed by filtration. Treatment with an
15 appropriate ion exchange resin or extraction with water or dilute aqueous acid may also be utilized. Where the basic catalyst is a tertiary amine or other relatively volatile substance, it can be removed by distillation or steam stripping (preferably, under vacuum).

The reduced calorie fat mimetic produced by the process of this invention can be additionally purified or treated so as to render it more suitable for use in food compositions using any of the techniques known in the art for refining natural vegetable or animal oils and fats. Such techniques include, but are not
25 limited to, degumming, bleaching, filtration, deodorization,

hydrogenation, deacidification, steam stripping, dewaxing, and the like. Various additives such as stabilizers, anti-oxidants, vitamins and so forth can also be incorporated into the reduced calorie lipid.

5 Reduced calorie fat mimetic compositions produced in accordance with this invention can replace, in full or in part, conventional edible oils or fats in a cooking oil, frying oil, salad oil, or shortening, for example. Additional uses include combining the reduced calorie lipid with other foodstuff
10 ingredients to form foods such as frozen desserts (e.g., sherbert, ice cream, frozen yogurt, milk shakes), baked goods (cakes, doughnuts, muffins, brownies, breads, pies, rolls, pastries, cookies, biscuits, crackers), nut butters (peanut butter), dairy products (margarine, sour cream, coffee
15 lighteners, cheese, cheese spreads, flavored dips, filled cream, filled milk), mayonnaise, salad dressing, savory snacks (potato chips, corn chips, cheese puffs, pretzels, fried foods (fried poultry, fritters, fried pies, fried vegetables such as french
20 fried potatoes, fried fish), reformed and comminuted meats (lunch meats, sausage, hot dogs, hamburger), pet foods, meat and egg substitutes or extenders, whipped toppings, gravies and other sauces, frostings, fillings, icings, cocoa butter replacements or
25 blends, candies (especially those normally containing fatty ingredients such as chocolate or peanut butter), soups and dry baking mixes (for muffins, cakes, pancakes, waffles, brownies,

and the like). Owing to the fat-like properties and stability of the reduced calorie fat mimetic compositions, minimum reformulation of standard foods will generally be required. The viscosity, melting profile, yield point, hardness, thixotropic
5 area/liquid/solid stability, solid fat index, and other physical properties of the reduced calorie fat mimetic composition are preferably selected by manipulation of the chemical structures of the individual starting materials of the process such that the products mimic as closely as possible the analogous properties of
10 the conventional triglyceride being replaced.

Illustrative ingredients which may be used in combination
with the reduced calorie fat mimetic compositions obtainable by
practice of this invention include carbohydrates (flour,
starches, sugars, celluloses, polydextrose), edible lipids
15 (triglycerides), proteins (from animal or vegetable sources), vitamins, antioxidants, emulsifiers, thickeners, preservatives, colorants, flavors, fragrances, sugar substitutes (saccharin,
aspartame, sucralose, cyclamates, and the like), other fat
substitutes or fat mimetics (for example, sucrose polyester or
20 caprenin), water, milk, spices, eggs, and the like. Oil-in-water to water-in-oil emulsions can be readily prepared by combining water, the reduced calorie fat mimetic, and other ingredients such as emulsifiers. The reduced calorie fat mimetic s of this invention are particularly suitable for the preparation of food s
25 requiring exposure to elevated temperatures. Unlike other

proposed fat substitutes such as proteinacious macrocolloids or certain polysaccharide-based substances requiring water to render them fat-like in texture, the fat mimetic compositions produced by this invention are exceptionally stable thermally and do not readily decompose or lose their fat-like properties when heated. The compositions thus may readily be utilized in deep fat frying applications to prepare fried foods such as savory snacks, fried chicken, fried fish, french fries, and the like since they will function as effective heat transfer media (that is, they will transmit heat rapidly and uniformly to the food being fried and also provide crisping).

From the foregoing description, one skilled in the art can readily ascertain the essential characteristics of this invention and, without departing from the spirit and scope thereof, can make various changes and modifications of the invention to adapt it to various usages, conditions, and embodiments.

The following examples further illustrate the process of this invention, but are not limitative of the invention in any manner whatsoever.

EXAMPLE 1

A first esterified propoxylated glycerin containing a high proportion of C₂₂ monounsaturated linear acyl groups is prepared by combining 382 parts by weight of a propoxylated glycerin obtained by reacting glycerin with 5 moles of propylene oxide per mole of glycerin in the presence of a potassium catalyst with

1100 parts by weight of a mixture of fatty acids obtained by hydrolytic splitting of a high erucic rapeseed oil and heating to 250°C under a reduced pressure nitrogen atmosphere. When conversion of the hydroxyl groups in the initial propoxylated glycerin reaches 95%, the esterification is stopped and the product steam refined at 1 mm pressure and 5% steam per hour to an acid value of less than 0.3%.

The first esterified propoxylated glycerin thus obtained is then mixed with 0.2 weight percent Raney nickel hydrogenation catalyst and heated to 180°C under 50 psig hydrogen pressure. When the iodine value is less than 1, the second esterified propoxylated glycerin is cooled to 60°C and filtered. After a second deodorization to remove a small amount of residual fatty acid, analysis of the product confirms that ca. 45 weight percent of the acyl groups have the structure $-\overset{\text{O}}{\text{C}}(\text{CH}_2)_{20}\text{CH}_3$ and less than 0.1 weight percent of the acyl groups are C_{24} monounsaturated acyl groups.

The second esterified propoxylated glycerin (880 parts) is combined with a third esterified propoxylated glycerin (100 parts) and sodium methoxide (3 parts) and heated 3 hours at 150°C. The reduced calorie lipid composition thus obtained is filtered to remove most of the basic catalyst and then heated 1 hour at 110°C with magnesium silicate (20 parts) and filtered again to remove residual sodium.

EXAMPLES 2-11

These examples illustrate alternative embodiments of the process of this invention wherein a variety of first and third esterified alkoxyated polyols having differing chemical

5 compositions are utilized as shown in Table I. In each example, hydrogenation of the first esterified alkoxyated polyol is carried out for the time indicated or, in any event, for a time necessary to reduce the incidence of acyl groups having an erucic acid structure to less than 1 mole percent. Additionally, the
10 first and third esterified alkoxyated polyols are prepared using a 10-20% molar excess (relative to the equivalents of hydroxyl present in the alkoxyated polyol intermediate) under conditions effective to achieve at least 95% conversion of the hydroxyl groups, with the excess fatty acids being removed by vacuum steam
15 stripping.

TABLE 1

Example No.	First Esterified Alkoxylated Polyol					Hydrogenation				
	Polyol	Epoxide	Moles Epoxide/ Mole Polyol	pbw ¹	Fatty Acid Source	Catalyst	pbw	Time hr.	Temp., °C.	H ₂ Pressure atm
2	2,3-butane-diol	ethylene oxide	10	100	a	nickel on Kieselguhr (60% Ni)	1	4	160	1
3	trimethylol propane	1,2-butylene oxide	15	100	b	double Ni Al salt ⁵	1	4	160	1
4	sorbitol	EO/PO ²	12	100	c	Cu Ni on silica ⁶	1.4	6	200	5
5	sucrose	PO/EO ³	20	100	d	copper chromate ⁷	2	8	175	3.5
6	methyl glucoside	PO/BO ⁴	4	100	e	5% Pd on carbon	0.2	3	175	3
7	1,2,6-tri-hydroxyhexane	methyl glycidyl ether	8	100	a	wet reduced nickel ⁹	1	5	180	2
8	penta-erythritol	1,2-octene oxide	24	100	b	1% Pt on alumina	1	6	150	2
9	propylene glycol	phenyl glycidyl ether	6	100	c	nickel on silica/alumina (64% Ni)	0.75	10	200	1.5
10	1,2-cyclohexanediol	1,2 pentene oxide	10	100	d	Ni Ag on Kieselguhr ¹⁰	1.5	12	140	4
11	2,3,4-trihydroxy pentane	propylene oxide	9	100	e	Raney nickel	1	5	200	6

TABLE I - continued

Example No.	Third Esterified Alkoxylated Polyol					Acyl Group Interchange Conditions			
	Polyol	Epoxide	Moles Epoxide/ Mole Polyol	pbw ¹	Fatty Acid Source	Basic Catalyst	pbw	Time hr.	Temp., °C.
2	2,3-butane diol	ethylene oxide	10	10	f	potassium methoxide	0.4	1.5	175
3	trimethylol propane	1,2-butylene oxide	15	15	g	sodium hydroxide	1	0.5	225
4	sorbitol	EO/PO ²	12	20	h	sodium stearate	0.75	1.0	250
5	sucrose	PO/EO ³	20	25	i	sodium dispersion (in xylene)	0.5	2.0	95
6	methyl glycoside	PO/BO ⁴	4	5	j	potassium hydroxide	2	4.0	200
7	glycerin	propylene oxide	20	30	k	sodium	0.7	0.5	100
8	1,4-butane diol	propylene oxide	10	15	l	potassium hydride	1.0	0.25	170
9	1,2,4-butanetriol	propylene oxide	15	10	m	calcium oxide	3.0	5.0	200
10	penta-erythritol	propylene oxide	16	10	n	sodium amide (in toluene)	1.0	4.0	60
11	xylitol	propylene oxide	30	20	o	Na-K alloy 50/50 wt/wt	0.5	0.5	100

TABLE 1 -- FOOTNOTES

a. mixture of fatty acids obtained by hydrolytic splitting of meadow foam oil (ca. 62.6% 20:1 Δ 5, 2.6% 22:1 Δ 5, 9.7% 22:1 Δ 13, 22.1% 22:2 Δ 5, 13)

5 b. mixture of fatty acids obtained by hydrolytic splitting of Polish rapeseed oil (ca. 2.8% palmitic acid, 1.2% stearic acid, 0.9% arachidic acid, 0.6% behenic acid, 0.7% lignoceric acid, 2.9% hexadecenoic acid, 14.2% oleic acid, 3.5% eicosenoic acid, 52.5% erucic acid, 12.0% linoleic acid, 1.1% docosadienic acid, 7.6 % linolenic acid)

10
15
c. mixture of fatty acid obtained by hydrolytic splitting of ravisson oil (ca. 4.3% palmitic acid, 2.1% stearic acid, 1.8% arachidic acid, 0.5% behenic acid, 0.0% lignoceric acid, 0.6% hexadecenoic acid, 15.5% oleic acid, 4.1% eicosenoic acid, 38.7% erucic acid, 20.9% linoleic acid, 1.0% docosadienic acid, 9.9% linolenic acid)

20
d. mixture of fatty acids obtained by hydrolytic splitting of mustard seed oil (ca. 1.5% palmitic acid, 0.4% stearic acid, 0.5% arachidic acid, 2.0% behenic acid, 1.0% lignoceric acid, 22.0% oleic acid, 7.0% eicosenoic acid, 44.2% erucic acid, 14.2 % linoleic acid, 6.8% linolenic acid)

5 e. mixture of fatty acids obtained by hydrolytic splitting of Crambe abyssinica oil (ca. 2.0 wt. % 16:0, 0.4 wt. % 16:1, 0.1 wt. % 16:3, 0.4 wt. % 18:0, 16.9 wt. % 18:1, 8.6 wt. % 18:2, 6.4 wt. % 18:3, 0.5 wt. % 20:0, 3.2 wt. % 20:1, 0.2 wt. % 20:2, 2.0 wt. % 22:0, 57.2 wt. % 22:1, 0.8 wt. % 22:2, 1.4 wt. % 24:1)

10 f. mixture of fatty acids obtained by hydrolytic splitting of palm kernel oil (ca. 0.2 wt. % caproic acid, 4.8 wt. % caprylic acid, 6.6 wt. % caprice acid, 44.1 wt. % lauric acid, 15 wt. % myristic acid, 8.5 wt. % palmitic acid, 2.7 wt. % stearic acid, 0.2 wt. % arachidic acid, 16.1 wt. % oleic acid, 1.4 wt. % linoleic acid)

15 g. mixture of fatty acids obtained by hydrolytic splitting of cocoa butter (ca. 24.4 wt. % palmitic acid, 35.4 wt. % stearic acid, 38.1 wt. % oleic acid, 2.1 wt. % linoleic acid)

20 h. mixture of fatty acids obtained by hydrolytic splitting of lard (ca. 1.3 wt. % myristic acid, 28.3 wt. % palmitic acid, 11.9 wt. % stearic acid, 0.2 wt. % tetradecenoic acid, 2.7 wt. % hexadecenoic acid, 47.5 wt. % oleic acid, 6.0 wt. % linoleic acid, 2.1 wt. % C₂₀ + C₂₂ unsaturated fatty acids)

i. mixture of fatty acids obtained by hydrolytic splitting of beef tallow (ca. 6.3 wt. % myristic acid, 27.4 wt. % palmitic acid, 14.1 wt. % stearic acid, 49.6 wt. % oleic acid, 2.5 wt. % octadecenoic acid)

5 j. mixture of fatty acids obtained by hydrolytic splitting of cottonseed oil (ca. 1.4 wt. % myristic acid, 23.4 wt. % palmitic acid, 1.1 wt. % stearic acid, 1.3 wt. % arachidic acid, 0.1 wt. % tetradecenoic acid, 2.0 wt. % hexadecenoic acid, 22.9 wt. % oleic acid, 47.8 wt. % linoleic acid)

10 k. mixture of fatty acids obtained by hydrolytic splitting of peanut oil (ca. 0.5 wt. % myristic acid, 8.0 wt. % palmitic acid, 4.4 wt. % stearic acid, 2.4 wt. % arachidic acid, 3.1 wt. % behenic acid, 1.1 wt. % lignoceric acid, 1.7 wt. % hexadecenoic acid, 52.5 wt. % oleic acid, 26.3 wt. % linoleic acid)

15 l. mixture of fatty acids obtained by hydrolytic splitting of palm oil (ca. 1.6 wt. % myristic acid, 32.3 wt. % palmitic acid, 5.5 wt. % stearic acid, 52.4 wt. % oleic acid, 8.2 wt. % linoleic acid)

m. mixture of fatty acids obtained by hydrolytic splitting of sunflower oil (ca. 3.6 wt. % palmitic acid, 2.9 wt. % stearic acid, 0.6 wt. % arachidic acid, 0.4 wt. % lignoceric acid, 34.0 wt. % oleic acid, 57.5 wt. % linoleic acid)

5

n. mixture of fatty acids obtained by hydrolytic splitting of corn oil (ca. 13 wt. % palmitic acid, 4 wt. % stearic acid, 29 wt. % oleic acid, 54 wt. % linoleic acid)

10

o. mixture of fatty acids obtained by hydrolytic splitting of safflower oil (ca. 6.4 wt. % palmitic acid, 3.1 wt. % stearic acid, 0.2 wt. % arachidic acid, 13.4 wt. % oleic acid, 76.9 wt. % linoleic acid)

10

1 parts by weight

2 EO=ethylene oxide, PO=propylene oxide; 6 moles EO per mole
sorbitol reacted first, followed by 6 moles PO per mole
sorbitol

5 3 5 moles and 15 moles per mole sucrose reacted as a mixture.

4 PO=propylene oxide; BO=1,2-butene oxide; 2 moles of PO and 2
moles of BO per mole methyl glucoside reacted as a mixture

5 Example 1, U.S. Pat. No. 3,896,053 (Broecker et al.)

6 Example 1, U.S. Pat. No. 3,743,662 (Eurlings et al.)

7 Lazier et al., Org. Syn. Coll. 2, 142 (1943)

8 Mozingo, Org. Syn. Coll. 3, 685 (1955)

9 25% metallic nickel, 75% hardened vegetable oil

10 LeFebrure et al., Fette, Seifen, Anstrichm. 77, 125 (1975)

EXAMPLE 12

Propoxylated glycerin containing 5 moles of propylene oxide per mole of glycerin (382 parts by weight) is mixed with non-hydrogenated high erucic rapeseed fatty acids (1100 parts) in a reaction vessel and heated to 250°C under a reduced pressure nitrogen atmosphere until hydroxyl group conversion is 95%. The resulting mixture of esterified propoxylated glycerin and excess fatty acid is then fed through a continuous deodorizer at 1-3 mm pressure using 5% steam per hour to remove the excess fatty acid. As little or no C₂₀-C₂₄ saturated fatty acids are present, no problems with plugging are encountered. The acid value of the deodorized esterified propoxylated glycerin is 0.3% or less.

The esterified propoxylated glycerin containing acyl groups derived from the non-hydrogenated high erucic rapeseed fatty acids is then placed in a stirred hydrogenation vessel and a nickel hydrogenation catalyst is added to a concentration of 0.2 weight % Ni. The reactor is sealed and heated to 180°C under 50 psig hydrogen pressure. Hydrogen is introduced during the course of the hydrogenation to maintain a constant pressure. When the iodine value of the reaction mixture is less than 1, the product is cooled to 60°C, filtered through a pressurized plate filter, and returned continuously to the reactor until the filtrate is free of nickel catalyst. The product is redeodorized under the conditions described above. A different esterified propoxylated glycerin (142 parts) prepared as described above with the

exception that a mixture of fatty acids obtained by hydrolytic splitting of soybean oil is utilized in place of the non-hydrogenated rapeseed fatty acids, is then added to the reactor, followed by sufficient sodium methoxide to provide a sodium concentration of 0.2 weight %. The temperature is increased to 150°C for 3 hours to accomplish acyl group interchange. After treatment with magnesium silicate and filtration to remove the residual sodium catalyst, the reduced calorie fat mimetic composition is redeodorized to yield a final product which is indistinguishable from a product prepared from 382 molecular weight propoxylated glycerin and a 9:1 (w/w) mixture of hydrogenated rapeseed fatty acids and soybean fatty acids, yet which did not require the use of long chain saturated fatty acids in its preparation.

EXAMPLE 13

Propoxylated glycerin containing 5 moles of propylene oxide per mole of glycerin (382 parts by weight) is mixed with non-hydrogenated high erucic rapeseed fatty acids (1100 parts) in a batch deodorizer and heated to 250°C under a reduced pressure nitrogen atmosphere. No steam is introduced into the deodorizer during this step. Samples are taken hourly until the hydroxyl group conversion reaches 95%. Steam is then introduced at 1-3 mm pressure and 10% steam per hour to deodorize the esterified propoxylated glycerin and to remove the unreacted excess fatty acid; vacuum steam stripping is halted once the acid value is 0.3% or less.

The esterified propoxylated glycerin thus obtained is hydrogenated and then reacted with a second esterified propoxylated glycerin derived from soybean fatty acids in the same manner as described in Example 12. The reduced calorie fat mimetic composition produced is expected to be identical to the product of Example 12.

$-(\text{OA})_n\overset{\text{O}}{\text{C}}\text{R}$ wherein OA is an oxyalkylene unit derived from a $\text{C}_2\text{-C}_{10}$ epoxide, n is from 1 to 20, and $-\overset{\text{O}}{\text{C}}\text{R}$ is an acyl group derived from a $\text{C}_{20}\text{-C}_{24}$ unsaturated fatty acid.

4. The process of claim 2 wherein at least one-half of the fatty acid-esterified oxyalkylene groups have the general structure -

$(\text{OA})_n\overset{\text{O}}{\text{C}}\text{R}$ wherein OA is an oxyalkylene unit derived from a $\text{C}_2\text{-C}_{10}$ epoxide, n is from 1 to 20, and $-\overset{\text{O}}{\text{C}}\text{R}$ is an acyl group derived from a $\text{C}_{20}\text{-C}_{24}$ unsaturated fatty acid.

5. The process of claim 3 of claim 4 wherein the $\text{C}_{20}\text{-C}_{24}$ unsaturated linear fatty acid is selected from eicosenoic acids, docosenoic acids, and docosadienoic acids.

6. The process of any one of claim 1 to 5 wherein the polyhydric aliphatic compound is selected from $\text{C}_2\text{-C}_{10}$ aliphatic diols, $\text{C}_3\text{-C}_{12}$ aliphatic triols, pentaerythritol, sugar alcohols, monosaccharides, disaccharides, and alkyl glycosides.

7. The process of any one of claim 1 to 6 wherein step (a) is carried out at a hydrogen pressure of from 0.5 to 20 atmospheres.

8. The process of any one of claims 1 to 7 wherein the transition metal catalyst is selected from nickel- and copper-containing catalysts.

9. The process of any one of claims 1 to 8 wherein the temperature in step (a) is from 75° to 275°C .

10. The process of any one of claims 1 to 9 wherein the time in step (a) is from 0.5 to 24 hours.

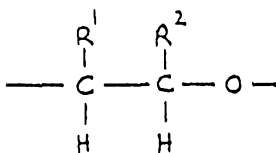
11. The process of any one of claims 1 to 10 wherein the basic catalyst is selected from tertiary amines, alkali metals, alkali metal compounds, alkaline earth compounds, and ammonium compounds.

12. The process of any one of claims 1 to 11 wherein the third esterified alkoxyated polyol is comprised of a polyol residue derived from a polyhydric aliphatic compound and from 2 to 8 fatty acid-esterified oxyalkylene groups connected to said polyol residue.

13. The process of claim 12 wherein at least one of the fatty acid-esterified oxyalkylene groups has the general structure $-(OA)_n\overset{\text{O}}{\parallel}\text{CR}$ wherein OA is an oxyalkylene unit derived from a C₂-C₁₀ epoxide, n is from 1 to 20, and $\overset{\text{O}}{\parallel}\text{CR}$ is an acyl group derived from a C₆-C₁₉ unsaturated fatty acid.

14. The process of claim 12 wherein at least one-third of the fatty acid-esterified oxyalkylene groups have the general structure $-(OA)_n\overset{\text{O}}{\parallel}\text{CR}$ wherein OA is an oxyalkylene unit derived from a C₂-C₁₀ epoxide, n is from 1 to 20, and $\overset{\text{O}}{\parallel}\text{CR}$ is an acyl group derived from a C₆-C₁₉ unsaturated fatty acid.

15. The process of claim 13 or claim 14 wherein OA has the general structure



Wherein R¹ and R² are the same or different and are selected from the group consisting of hydrogen, methyl, and ethyl.

16. The process of any preceding claim wherein the third esterified alkoxyated polyol is characterized by the absence of C₂₂ unsaturated acyl groups.

17. The process of any preceding claim wherein step (b) is carried out at a temperature of from 0°C to 275°C.

18. A process for producing a reduced calorie fat mimetic composition comprising the steps of

(a) contacting a first esterified alkoxyated polyol comprised of (i) a first polyol residue derived from a first polyhydric aliphatic compound and (ii) 2 to 8 fatty acid-esterified oxyalkylene groups connected to said first polyol residue wherein at least one-half of the fatty acid-esterified oxyalkylene groups have the general structure $-(OA^1)_n \overset{O}{\parallel} CR^1$ wherein OA¹ is a first oxyalkylene unit derived from a first C₂-C₁₀ aliphatic epoxide, n is from 1 to 20, and -CR¹ is an acyl group derived from a C₂₀-C₂₄ unsaturated linear fatty acid with hydrogen in the presence of a catalyst containing nickel or copper at a

pressure of from 0.5 to 20 atmospheres and a temperature of from 75°C to 275°C for a time effective to accomplish hydrogenation of the acyl group derived from the C₂₀-C₂₄ unsaturated linear fatty acid to yield a second esterified alkoxyated polyol characterized by the presence of at least one C₂₀-C₂₄ saturated linear acyl group and the ^{presence of less than 1 mol percent} ~~absence of any~~ C₂₂ unsaturated linear acyl groups; and

(b) contacting the second esterified alkoxyated polyol with a third esterified alkoxyated polyol comprised of (i) a second polyol residue which is the same as or different from the first polyol residue derived from a second polyhydric aliphatic compound which is the same as or different from the first polyhydric aliphatic compound and (ii) from 2 to 8 fatty acid-esterified oxyalkylene groups connected to said second polyol residue wherein at least one of the fatty acid-esterified oxyalkylene groups has the general structure $-(OA^2)_m \overset{O}{\parallel} CR^2$ wherein OA² is a second oxyalkylene unit derived from a second C₂-C₁₀ aliphatic epoxide which may be the same as or different from the first C₂-C₁₀ aliphatic epoxide, m is from 1 to 20, and $\overset{O}{\parallel} CR^2$ is an acyl group derived from a C₆-C₁₉ unsaturated fatty acid in the presence of an alkali metal or alkali metal compound at a temperature of from 0°C to 275°C for a time effective to accomplish interchange of at least one C₂₀-C₂₄ saturated linear acyl group in the second esterified alkoxyated polyol and at



least one acyl group derived from C₆-C₁₉ unsaturated fatty acid in the third esterified alkoxyolated polyol to yield the reduced calorie fat mimetic compositions.

19. The process of claim 18 wherein the first and second polyhydric aliphatic compounds are both glycerin.

6 20. The process of claim 18 or claim 19 wherein the first and second C₂-C₁₀ aliphatic epoxides are both selected from ethylene oxide, propylene oxide, 1,2-butylene oxide, and mixtures thereof.

21. The process of any one of claims 1 to 17 or 18 to 20, wherein C₂₂ unsaturated linear acyl groups are absent from the esterified alkoxyolated polyol.

10 22. A process for producing a reduced calorie fat mimetic, substantially as hereinbefore described with reference to any one of the Examples.

23. A process for producing a reduced calorie fat mimetic composition, substantially as hereinbefore described with reference to any one of the Examples.

15 24. A reduced calorie fat mimetic produced by the process of any one of claims 1 to 17 or 21 or 22.

25. A reduced calorie fat mimetic composition produced by the process of any one of claims 18 to 20 or 21 or 23.

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Process for producing a reduced calorie fat mimetic composition

ABSTRACT

A method of obtaining a reduced calorie esterified alkoxyated polyol containing both long chain saturated linear acyl groups and shorter chain
5 unsaturated acyl groups comprises the process of

(a) contacting a first esterified alkoxyated polyol characterized by the presence of at least one $C_{20}-C_{24}$ unsaturated linear acyl group with hydrogen in the presence of a transition metal catalyst for a time and at a temperature effective to
10 accomplish hydrogenation of the $C_{20}-C_{24}$ unsaturated linear acyl group to yield a second esterified alkoxyated polyol characterized by the presence of at least one $C_{20}-C_{24}$ saturated linear acyl group and the absence of any C_{22} unsaturated linear acyl group; and

15 (b) contacting the second esterified alkoxyated polyol with a third esterified alkoxyated polyol characterized by the presence of at least one C_6-C_{19} unsaturated acyl group in the presence of a basic catalyst for a time and at a temperature
20 effective to accomplish interchange of at least one $C_{20}-C_{24}$ saturated linear acyl group and at least one C_6-C_{19} unsaturated acyl group to yield the reduced calorie fat mimetic.