

Dark Mascara

with **Lysofix™ Liquid** and **Rosamox™**

Formulation: KPC/PD13010.01

Phases	Ingredients	% w/w
A	Deionized Water	50.48
	Sodium Dehydroacetate	0.12
B	Microcrystalline Cellulose (and) Cellulose Gum ¹	1.00
C	Glycerin	4.00
	Xanthan Gum	0.30
D	Lysofix™ Liquid - Glycerin (and) Glycine soja (Soybean) Seed Extract	5.00
E	Iron Oxides CI77499	10.00
	Kaolin	2.00
F	Glyceryl Stearate SE ²	2.50
	Beeswax	10.00
	Behenyl Alcohol ³	4.00
	VP/Hexadecene Copolymer ⁴	2.50
	Rosamox™ - Helianthus annuus (Sunflower) Seed Oil (and) Rosmarinus officinalis (Rosemary) Leaf Extract	0.10
	<i>Simmondsia chinensis</i> (Jojoba) Seed Oil	2.00
G	Phenoxyethanol (and) Ethylhexylglycerin ⁵	1.00
H	Water (and) Acrylates Copolymer (and) Propylene Glycol ⁶	5.00
		Total: 100

Bold denotes products available from Kemin.

¹VivaPur® Cos 5 - Gattefosse; ²Jeechem GMS-D - Jeen Products; ³Lanette® 22 - BASF; ⁴Unimer U-151 - Induchem; ⁵Euxyl® PE9010

- Schulke; ⁶Avalure™ AC 120 - Lubrizol

- ◆ Long Lasting
- ◆ Clump-free
- ◆ Non-irritating for eyes



Manufacturing Process:

1. Weigh Phase A in the main beaker, disperse Phase B with a homogenizer and mix for 30 minutes.
2. Add Phase C and mix while heating the batch to 82 °C.
3. Add Phase D and mix.
4. Pulverize Phase E until uniform. Add to the main phase and homogenize.
5. Heat Phase F to 82 °C, add to the main phase with the help of a high efficiency paddle to form a smooth emulsion.
6. Switch to slow paddle mixing until 40 °C.
7. Add Phases G and H and mix until uniformly dispersed.

Stability:

- Stable for 5 freeze-thaw cycles
- Stable for 3 months at 40 °C & 50 °C

Characteristics:

Appearance:	Smooth, uniform dispersion
Color:	Dark black
Odor:	Fragrance-free
pH:	6.0-8.0 at 20 °C
Viscosity:	More than 60,000 cP at 20 °C Brookfield Viscometer, Spindle RV6, 20 rpm

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