



IOI OLEOCHEMICAL

More Volume! Mascara

Mild formula, but strong volume

Mild O/W mascara, water-resistant, defines and coats every lash



**Natural
Origin
Content**
(ISO 16128)
98%



More Volume! Mascara

No.: 867

PHASE	TRADE NAME	INCI	%	FUNCTION
A	Water demin.	Aqua	46.98	Diluent
A1	Solagum™ AX	Acacia Senegal Gum (and) Xanthan Gum	1.50	Gelling Agent
A1	GreenDiol™	2,3-Butanediol	5.00	Humectant
A2	Sunpuro Black Iron Oxide	CI 77499	10.00	Pigment
A3	Vitacel® CS 300 FC	Cellulose	2.00	Fiber
B	IMWITOR® 375	Glyceryl Citrate/ Lactate/Linoleate/Oleate	5.00	Mild O/W Emulsifier
B	IMWITOR® 491	Glyceryl Stearate	4.00	Co-Emulsifier
B	2442L Carnauba Wax	Copernicia Cerifera Cera	3.00	Wax (MP: 80 – 86°C)
B	Compritol® 888 GG MB	Glyceryl Behenate	3.00	Wax (MP: 65 – 77°C)
B	SOFTISAN® 142	Hydrogenated Coco-Glycerides	3.00	Solid Lipid (MP: 42 – 44°C)
B	MIGLYOL® OE	Oleyl Erucate	7.00	Low Diffusion Emollient, Good Adhesion to Waxes
B	SOFTISAN® 649	Bis-Diglyceryl Polyacyladipate-2	8.00	Film-Protector, Long- Lasting-Agent, Anti- Crumbling Effect
C	Rosamox	Helianthus Annuus Seed Oil (and) Rosmarinus Officinalis Leaf Extract	0.02	Antioxidant
C	Lexgard Natural MHG MB	Methylheptylglycerine	1.50	Preservative

PROCESS

1. Heat phase A
2. Mix phase A1, add phase A to A1 (step by step, mix in between (e.g., Speedmixer, 1 min @ 1.600 rpm))
3. Add A2 to A/A1 and mix (Speedmixer, 3 min @ 1.600 rpm)
4. Add A3 to A/A1/A2 and mix (Speedmixer, 3 min @ 1.600 rpm); reheat to 80 – 85°C
5. Heat phase B to 80 – 85°C
6. Add phase B to A/A1/A2/A3 and mix (Speedmixer, 5 min @ 1.600 rpm)
7. Cool to < 40°C (Speedmixer, 800 rpm)
8. Add phase C and mix (Speedmixer, 1 min @ 1.000 rpm)
9. Check pH (5.3 ± 0.2), fill into packaging

FORMULA DATA

- Appearance:** Black paste
- pH:** 5.1 – 5.5
- Stability test:** Passed
(3 months @ 20 &
40°C, 10 days @ 50°C)
- Challenge test:** Passed
(according to
Ph.Eur. 5.01.03)



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personalcare@ioioleo.de

V2.0