

Section IX

Shaving Products

After Shave Balm

A soothing water-in-oil lotion containing Bentone Gel EUG rheological additive

<u>Ingredients:</u>	<u>Wt%</u>
Sorbitan Isostearate	2.50
Glycerine BP	3.00
Magnesium Sulphate	0.70
Caprylic/Capric Triglyceride	4.00
Octyldodecanol	4.00
Beeswax BP	0.50
Bisabolol	0.20
D-Panthenol	0.50
Cetearyl Octanoate, Isopropyl Myristate	5.00
2-Phenoxyethanol, Methylidibromoglutaronitrile, 2-Bromo-2-Nitropropane-1,3-Diol, Butyl 4-Hydroxy- benzoate, Isobutyl 4-Hydroxybenzoate	0.20
Perfume	0.20
Bentone Gel EUG	3.00
Demineralized Water	Bal to 100%

Method of Manufacture:

1. Thoroughly disperse the Bentone Gel EUG in the oil phase and heat to 75-80C.
2. In a separate vessel, heat 98% of the water with the Glycerine and the Magnesium Sulphate to 75-80C.
3. Add the water phase to the oil phase steadily mixing with a propeller stirrer on medium speed.
4. Dissolve the D-Panthenol in the remaining 2% of the water.
5. Add the D-Panthenol premix below 50C to the cooling emulsion.
6. Transfer to a high shear stirrer for around 10 minutes and continue to cool.
7. At 30C add the perfume and preservative.

The balance of richness and light, easy-to-spread characteristics provided by Bentone Gel EUG additive makes this After Shave Balm pleasant on the skin. This formulation is designed to be soothing and combat irritation on freshly shaved skin through the action of the Bisabolol.

SOURCE: Rheox, Inc.: Elementis Specialties: Suggested Formulas

After Shave Balsam

<u>Recipe:</u>	<u>Wt%</u>
A Hostaphat KML/Laureth-4 Phosphate, Polyglyceryl-2	
Sesquiosostearate	1.50
Hostacerin DGSB/Polyglyceryl-2 PEG-4 Stearate	2.50
Isopropyl palmitate	2.00
Isopropyl isostearate	3.00
Abil 100/Dimethicone	1.00
Menthol	0.10
Camphor	0.10
B Carbopol 980/Carbomer	0.30
C Caustic soda solution (10%)	1.75
Allantoin	0.30
PEG 400/PEG-8	3.00
Milfoil extract	2.00
Water	82.15
Preservative	q.s.
Dyestuff solution	q.s.
D Fragrance	0.30
1. Melt A at approx. 60C, then add B.	
2. Heat C to approx. 60C.	
3. Stir 2 into 1 and stir until cool.	
4. At approx. 35C add D to 3.	
5. Finally homogenize the emulsion.	
Formula A VI/1151	

Shaving Cream

<u>Recipe:</u>	<u>Wt%</u>
A Stearic acid	10.20
Myristic acid	5.10
Coconut fatty acid	5.80
B Water	46.20
Potassium hydroxide	6.80
Sodium hydroxide	0.35
Triethanolamine	0.95
PEG 400/PEG-8	5.40
C Stearic acid	10.20
Myristic acid	5.10
D Genapol LRO paste/Sodium Laureth Sulfate	2.70
E Menthol	0.20
Fragrance	1.00

Procedure:

1. Melt A at ca. 90C.
2. Heat the solution of B to ca. 90C.
3. Stir 2 into 1, continue stirring at 70-80C for ca. 30 minutes.
4. Melt C at ca. 90C.
5. Stir 4 into 3.
6. Carefully stir 5 until cool (avoid foam formation).
7. Stir D into 6 at ca. 50C, and at ca. 40C add solution E.
8. Homogenize at room temperature and homogenize again one day later.

Note: The loss of water is approx. 10%.

Formula A III/1003

SOURCE: Hoechst Aktiengesellschaft: Guide Recipes

After Shave Lotion

An after shave balm which uses SF1632 to add moisture due to its ability to reduce water loss from the skin (TEWL). SF1202, cyclopentasiloxane, is used to provide a quick dry which does not sting or cool the skin.

<u>Ingredient/Function:</u>	<u>Wt%</u>
Part A:	
Deionized Water/Diluent	59.61
Disodium EDTA/Chelating agent	0.02
SD Alcohol-40/Astringent	15.00
Phenoxyethanol (and) Methylparaben (and) Ethylparaben (and) Propylparaben (and) Butylparaben(1)/Preservative	0.60
Sorbital 70%/Humectant	3.00
Part B:	
Cyclopentasiloxane(SF1202) (2)/Emollient/Quick dry	5.00
Cetearyl Methicone(SF1632)(2)/Occlusive/TEWL reduction/ Emollient	8.00
Bisabolol/Reduces irritation and redness	0.20
Tocopheryl Acetate/Vitamin E/Antioxidant	0.20
Coco-Caprylate/Caprates/Emollient	0.80
Aluminum Starch Octenylsuccinate/Slip/Feel/Viscosity	5.00
Polysorbate-85/Preservative	1.50
Part C:	
Fragrance(3)	1.00
D&C Green No. 5(0.1% solution)/Color	0.07

Procedure:

1. Combine Part A at room temperature and mix for 15 minutes with moderate propeller agitation.
2. Combine Part B and mix with moderate propeller agitation for 20 minutes until uniform.
3. Add Part B to Part A SLOWLY with moderate stirring. Continue mixing for 15 minutes.
4. Add Part C to Part AB and mix with moderate propeller agitation for 20 minutes.

Trade Names/Suppliers:

- (1) Phenonip, Nipa Laboratories, Inc.
- (2) GE Silicones
- (3) Shaw-Mudge

SOURCE: GE Silicones: Personal Care Formulary: Formula SP 114

Clear Shaving Gel

<u>Ingredients/CTFA Name:</u>	<u>Wt%</u>
Deionized Water	46.5
Glucamate DOE-120/PEG 120 Methyl Glucose Dioleate	3.0
Sodium Laureth Sulfate	25.0
Schercotaine SCAB-G/Cocamidopropyl Hydroxy Sultaine	20.0
Schercomid AME-70/Acetamide MEA	2.0
Phytoderm Complex G/Propylene Glycol (and) Licorice Extract	1.0
Dow Corning 193 Surfactant/Dimethicone Copolyol	2.5
Preservative	q.s.
Fragrance	q.s.

Procedure:

Dissolve DOE-120 in water with gentle heat to 60-65C. Add the rest of the ingredients one by one, mixing well after each addition.

Formulation SK 89

Cooling After Shave
Oil Free/Alcohol Free

<u>Ingredients/CTFA Name:</u>	<u>Wt%</u>
Deionized Water	86.9
Carbopol 941 3% Aq. Sln.	5.0
Dow Corning 193 Surfactant/Dimethicone Copolyol	1.0
Schercomid AME-70/Acetamide MEA	1.0
Schercemol GMIS/Glyceryl Isostearate	4.0
Herbasol Extract Cucumber/Cucumber Extract	1.0
Herbasol Extract Chamomile/Chamomile Extract	1.0
Preservatives	q.s.
Triethanolamine (99.0%)	0.1
Fragrance	q.s.

Procedure:

Disperse Carbopol in water until uniform. Add the rest of the ingredients one by one, mixing well after each addition.

Formulation SK 88

SOURCE: Scher Chemicals, Inc.: Suggested Formulation

Moisturizing After Shave Treatment (Eashave)

Eashave in this pleasant light after shave cream has moisturizing properties and calms the skin after shaving.

<u>Item:</u>	<u>Ingredients/INCI Name:</u>	<u>Wt%</u>
1	A)Emulgade SE	6.00
2	Lanette O/Cetearyl Alcohol	1.00
3	Cetiol V/Dicaprylyl Ether	8.00
4	Eutanol G/Octyldodecanol	4.00
5	B)Deionized Water	69.20
6	Glycerin	3.00
7	Phenonip	0.50
8	Carbopol Ultrez 10/Carbomer	0.30
9	C)Triethanolamine	
10	D)Bisabolol	0.20
11	Ethyl Alcohol 96%	3.00
12	Eashave	4.00
13	Fragrance/Courage 0/243101	0.80

Procedure:

Heat the ingredients of fatty phase A) to 80C.

Heat the ingredients of water phase B) to 75C.

Under stirring add phase B) to phase A), cool to 50C, homogenize and cool to 30C.

Then adjust the pH with phase C) to 5.7.

Finally incorporate items of phase D) one after the other and stir cold.

Application No.: I 006.0/11.97

Refreshing After Shave (Eashave)

This alcohol containing, clear after shave formulation refreshes the face and leaves a decent touch of perfume on the skin. Eashave combats the negative effects of the alcohol (e.g. "burning" feeling and washing out of skin lipids).

<u>Item:</u>	<u>Ingredients/INCI Name:</u>	<u>Wt%</u>
1	A)Irgasan DP 300/Triclosan	0.01
2	Crodamol DA/Diisopropyl Adipate	1.00
3	Ethyl Alcohol 96%	50.00
4	B)Propylene Glycol	2.00
5	Deionized Water	41.49
6	C)Fragrance/Courage 0/243101	0.50
7	D)Eashave	5.00

Procedure:

Dissolve phase A). Mix phase B).

Slowly add phase B) to phase A). Then add item 6.

Finally add item 7.

Application No.: I 001.D/05.96

SOURCE: Pentapharm Ltd.: Suggested Formulations

Soft After Shave Balm (Eashave)

This white, elegant balm contains 20% alcohol and gives a fresh feeling on the face. Eashave reduces irritation and strengthens the lipid barrier of the skin after shaving. The balm has soothing and moisturizing properties.

<u>Item:</u>	<u>Ingredients/INCI Name:</u>	<u>Wt%</u>
1	A) Deionized Water	69.70
2	Allantoin	0.10
3	Carbopol 941/Carbomer 941	0.40
4	B) PCL Solid/Stearyl Heptanoate, Stearyl Caprylate	2.00
5	Bisabolol	0.20
6	Cremophor RH40/PEG-40 Hydrogenated Castor Oil	0.30
7	C) Ethyl Alcohol 96%	20.00
8	Menthol	0.10
9	Fragrance/Aras 0/221807	1.50
10	D) Eashave	5.00
11	Triethanolamine	0.70

Procedure:

Dissolve items 2+3 in water (1) and heat to 60C.

Heat the ingredients of phase B) to 60C.

Under stirring add phase B) to phase A), cool to 50C, homogenize and cool to room temperature.

Then add phase C). Finally incorporate item 10 and neutralize with item 11.

Application No. I 004.0/0.5.96

Mild After Shave Balm (Eashave)

This white, alcohol free balm is designed especially for men with sensitive skin. Eashave reduces the irritation from shaving and gives the skin a soft feeling.

<u>Item:</u>	<u>Ingredients/INCI Name:</u>	<u>Wt%</u>
1	A) Deionized Water	75.80
2	Glycerin	10.00
3	Phenoxyethanol	0.50
4	Allantoin	0.10
5	Imidazolidinyl Urea	0.20
6	Carbopol 980/Carbomer 980	0.20
7	B) Crodamol EHO/Oleyl Oleate	3.00
8	Glucamate SSE 20/PEG-20 Methyl Glucose	3.00
9	Glucate SS/Methyl Glucose Sesquistearate	1.00
10	C) Triethanolamine	0.20
11	D) Eashave	5.00
12	Fragrance/DRN-20/232146	1.00

Procedure:

Dissolve items 2-6 in water (1) and heat to 60C.

Heat the ingredients of fatty phase B) to 60C.

Under stirring add phase B) to phase A), homogenize and cool to room temperature.

Neutralize with item 10. Finally add items 11 and 12 one after the other.

Application No. I 005.0/05.96

SOURCE: Pentapharm Ltd.: Suggested Formulations