

Water-resistant mascara with Eastman AQ™ 55S polymer and Eastman Sustane™ SAIB MCT

Part	Product name	Wt%	Ingredient/INCI name	Manufacturer
A	Deionized water	46.40	Water (aqua)	—
	CELLOSIZETM hydroxyethyl cellulose (HEC)	0.5	Hydroxyethylcellulose	Dow
	Sodium hydroxide 50%	0.3	Sodium hydroxide	—
	Pro-vitamin B5 powder	0.1	Panthenol	DSM
	Zemea®	3.0	Propanediol	DuPont Tate & Lyle
	Dermofeel® PA-12	0.05	Sodium phytate	Evonik-Dr. Straetmans
B	Eastman AQ™ 55S polymer (30% solution)	15	Polyester-5	Eastman
C	Beeswax	5.0	Beeswax (cera alba)	Strahl & Pitsch
	Cutina® GMS-SE	2.5	Glyceryl stearate	BASF
	Carnauba wax	2.0	Carnauba wax	Strahl & Pitsch
	Stearic Acid USP (Triple Pressed)	5.0	Stearic acid	Vantage
	Eastman Sustane™ SAIB MCT	1.5	Sucrose acetate isobutyrate (and) caprylic/capric triglycerides	Eastman
	Covi-Ox® T 50	0.1	Tocopherol	BASF
	TEGOSOFT® DCE	2.0	Diethylhexyl carbonate	Evonik Industries
	Dermofeel® TEC eco	1.0	Triethyl citrate	Evonik-Dr. Straetmans
	XIAMETER™ PMX-200 Fluid 200	1.0	Dimethicone	Dow
	Neossance™ Hemisqualane	1.0	C13-15 alkane	Aprinova
D	INWP70EB	12.0	Iron oxides (and) isononyl isononanoate (and) ozokerite (and) isopropyl titanium trisostearate (and) polyhydroxystearic acid	Kobo Products
	Mineral base	0.25	Mica (and) zinc oxide (and) titanium dioxide (and) silica	—
E	KEM CP	0.8	Phenoxyethanol (and) chlorphenesin (and) ethylhexylglycerin	Akema
	VEEGUM®	0.5	Magnesium aluminum silicate	Vanderbilt Minerals, LLC

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PROCEDURE

1. Weigh out part A into a clean, sanitized, stainless steel mixing vessel with mixer/homogenizer attachment. Heat it to 70°–75°C. Incorporate hydroxyethylcellulose at medium speed of 500–700 rpm. Mix until homogenized.
2. Weigh out part C, heat to 70°–75°C, and add to part A. Mix at a speed of 800–1000 rpm until the part A/C mixture is homogeneous.
3. Once the part A/C mixture is homogeneous, incorporate part B and mix until homogeneous.
4. Stop heating and incorporate part D into the part A/B/C mixture. Increase mixing to 1800–2000 rpm, and mix until complete homogeneous dispersion of the pigment.
5. Start cooling, and then incorporate part E at < 50°C.
6. Adjust pH* if required.

*pH @ 25°C: 6.0–6.5

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