

THE CONCEPT:

This rich emollient cream was designed to penetrate quickly to moisturize feet. The cooling sensation relieves tired feet while the cream goes to work revealing soft, silky skin.

KEY INGREDIENTS:

Menthol provides a cooling sensation.

Vitamin E (Tocopheryl Acetate) is an antioxidant used to protect the skin.

Urea softens the skin.

Date Extract is derived from the Phoenix Dactylifera tree. It has soothing and anti-inflammatory properties. Trace elements and protein have a revitalizing effect on aging and tired skin.

Liponic™ EG-1 moisturizes the skin through humectancy.

Lipo® Polyglycol 400 a polymer that adds humectant properties for moisturizing the skin and also is a solubilizing agent. When used in an anhydrous product, it will generate heat when exposed to moisture.

Panalane® L-14E is a polymeric emollient that provides a light elegant feel on the skin and also functions as a solvent for other ingredients in the formulation.

Liponate® MM and **Liponate® TDTM** are emollients that improve the skin feel of the product.

GlyAcid™ EBP glycolic acid is a keratolytic agent for retexturizing the skin.

Lipo® Stearic Acid, Lipo® GMS-450, Lipowax® D, Liposorb® P-20, Liposorb® P and **Lipocol® C** provide an emulsion system that forms a stable cream.

Cinnamon Extract has astringent properties and is revitalizing and stimulating to tired or aged skin.

BENEFITS:

- ▶ Softens feet to reduce appearance of calluses.
- ▶ Moisturizes skin.
- ▶ Leaves skin soft and smooth.
- ▶ Absorbs quickly.

DIRECTIONS FOR USE:

Smooth a small amount of cream over tired feet every night and rest well.

FORMULATOR'S REFERENCE

AESTHETICS:

- × Cream
- Gel
- Serum
- Lotion
- × Anhydrous
- Powder
- Clear
- × Opaque
- Translucent
- Pearl
- Spray
- Fluid
- × Firm

MARKET FOCUS:

- × Women
- × All
- 20 – 30
- 30 – 50
- 50+
- × Men
- × All
- 20 – 30
- 30 – 50
- 50+
- × Teens (13-19)
- Children (5 – 12)
- Babies (3mo. – 4yrs.)

FUNCTION:

- × Basic
- Protect/Prevent
- Repair
- Treat
- Cleanse
- Exfoliate
- Conceal

SKIN TYPES

- × All
- Dry
- Normal
- Oily
- Sensitive

SPA42



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FORMULATION:

SEQUENCE	PERCENT	INGREDIENT	INCI NAME
1	59.88	Deionized Water	Water
2	2.00	Optigel WX (101)	Xanthan Gum (and) Bentonite
3	2.50	Liponic™ EG-1 (1)	Glycereth-26
3	5.00	Butylene Glycol	Butylene Glycol
3	0.75	Liposerve™ PP (1)	Phenoxyethanol (and) Methylparaben (and) Ethylparaben (and) Butylparaben (and) Propylparaben (and) Isobutylparaben
3	3.00	Lipo® Polyglycol 400 (1)	PEG-8
3	0.25	TEA, 99%	Triethanolamine
4	5.80	Lipowax® D (1)	Cetearyl Alcohol (and) Cetareth-20
4	1.40	Lipocol® C (1)	Cetyl Alcohol
4	0.60	Lipo® Stearic Acid (1)	Stearic Acid
4	1.00	Lipo® GMS 450 (1)	Glyceryl Stearate
4	1.75	Liposorb® P (1)	Sorbitan Palmitate
4	3.00	Liposorb® P-20 (1)	Polysorbate 40
4	2.50	Panalane® L-14E (88)	Hydrogenated Polyisobutene
4	1.00	Liponate® MM (1)	Myristyl Myristate
4	1.00	Liponate® TDTM (1)	Tridecyl Trimellitate
4	0.75	DC 200/200 Fluid (72)	Dimethicone
4	0.02	Vitamin E Acetate (37)	Tocopheryl Acetate
5	0.50	GlyAcid™ EBP (1)	Glycolic Acid
5	1.00	Deionized Water	Water
6	0.05	Kathon CG (14)	Methylchloroisothiazolinone (and) Methylisothiazolinone
7	1.00	Fragrance (137)	Fragrance
8	2.00	Deionized Water	Water
8	0.50	Urea	Urea
9	1.50	Butylene Glycol	Butylene Glycol
9	0.20	Menthol (125)	Menthol
10	0.05	Citrine	Citrine
10	0.50	Actiphyte of Cinnamon Lipo S (102)	Butylene Glycol (and) Water (and) Cinnamomum Zeylanicum (Cinnamon) Bark Extract
10	0.50	Actiphyte of Date BG50 (102)	Butylene Glycol (and) Water (and) Phoenix Dactylifera (Date) Fruit Extract
11	qs	TEA, 99%	Triethanolamine
	100.00%		

PROCEDURE:

- In main kettle, heat Sequence #1 to 80°C with propeller mixing.
- Slowly sprinkle Sequence #2 into Sequence #1 and mix until completely hydrated.
- Add Sequence #3 to batch, maintaining temperature at 80°C.
- In side kettle, combine Sequence #4 ingredients and heat to 80°C. Mix until clear and uniform.
- Slowly add Sequence #4 to batch and mix for 15 minutes or until emulsification is complete.
- Cool to 50°C and add Sequence #5 and Sequence #6 to batch and mix well.
- At 42°C, add Sequence #7 to batch with medium speed propeller mixing.
- At 25 – 30°C, add premixed Sequence #8 and premixed Sequence #9 to batch.
- Add Sequence #9 to batch and mix well.
- Adjust pH to 4.0 – 4.5 using Sequence #10

SPECIFICATIONS:

pH: 4.0 – 4.5
 Viscosity: T-E bar @ 0.3 rpm – 900,000 cps ±10%
 Stability: 30 days at 50°C

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| (1) Lipo Chemicals, Inc. | (101) Southern Clay Products |
| (14) Rohm & Haas Company, Inc. | (102) Active Organics, Inc. |
| (37) BASF Corporation | (125) Lipo (Takasago) |
| (72) Dow Corning Corporation | (137) Quest International |
| (88) Lipo (INEOS) | |

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SPA43



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