




# Formulation

Name	<b>DEEP CLEANSING MOISTURIZING HAND SOAP</b>	
No.	1227	
Description	Specialty hand soap formulated with moisturizers and oil microcapsules for deep cleansing.	
Formulation	<b>INGREDIENTS:</b>	<b><u>% by Weight</u>   <u>Functionality</u></b>
	=== Phase 1 ===	
	Deionized Water	q.s. to 100.00 Diluent
	Carbopol ETD 2020 (Lubrizol) Acrylates/C10-30 Alkyl Acrylate	0.65 Rheology Modifier
	Crosspolymer	0.75 Diluent
	Ethanol	0.10 Chelating Agent
	Versene 100 (Dow Chemical) Tetrasodium EDTA	30.00 Primary Surfactant
	STEPANOL® WA-EXTRA PCK	6.00 Secondary Surfactant
	AMPHOSOL® HCG (or AMPHOSOL® HCG-HP)	2.00 Foam Stabilizer
	STEPAN-MILD® SL3-BA	0.70 Moisturizing Agent
	STEPAN-MILD® L3	0.30 Additive
	Microencapsulated Oil Blend (Hallsrest LTD)	0.80 Additive
	Lipo WSF 35/60 (Lipo Chemical) Walnut Shell Powder	
	=== Phase 2 ===	
	Fragrance	1.00 Fragrance
	=== Phase 3 ===	
	Citric Acid, 50% solution	q.s. pH Adjuster
	Sodium Hydroxide, 10% solution	q.s. pH Adjuster
	Preservatives and Dye	q.s. Additives
	<b>Total</b>	<b>100.00</b>
Procedure	<ol style="list-style-type: none"> <li>1. In a suitable vessel equipped with heating and agitation capabilities, charge Deionized Water and Ethanol.</li> <li>2. Add Carbopol ETD 2020 and mix until completely dispersed</li> <li>3. Add Versene 100,STEPANOL® WA-EXTRA PCK, AMPHOSOL® HCG (or AMPHOSOL® HCG-HP),STEPAN-MILD® SL3-BA, STEPAN-MILD® L3 using moderate agitation. Mix for at least 30 minutes until ingredients are completely dissolved. Adjust mixing speed to minimize aeration.</li> <li>5. Add Microencapsulated Oil Blend and Lipo WSF 35/60 with continued mixing.</li> <li>6. Add Fragrance with mixing.</li> <li>7. Adjust pH to 6.0-6.5 with Sodium Hydroxide, 10% solution or Citric Acid, 50% solution.</li> <li>8. Add Preservative and Dye as desired.</li> </ol> <p>*Note: When formulating with AMPHOSHOL® HCG-HP, a greater amount of Citric Acid (50% solution) may be needed to adjust the pH within the recommended range as noted, than when formulating with AMPHOSOL® HCG.</p>	
Physical Properties	Appearance, as is	Viscous liquid
	pH, as is	6.0–6.5
	Viscosity at 25°C LVT #3 at 12 rpm, cps	10,000–12,000
Storage/	4 weeks at 5°C	Stable

Stability	4 weeks at 25°C 4 weeks at 45°C Freeze/Thaw 3 cycles	Stable Stable Pass
Instructions for Use	Pump into hands, lather and rinse.	
External Comment	Marketing Notes: BCI = 90. Total BCI (Biorenewable Carbon Index) was calculated only for the Stepan surfactants used in this formulation. For further information on Stepan's BCI, visit <a href="http://www.stepan.com">www.stepan.com</a> . This formulation is mild and naturally-derived. Naturally-derived is defined as derived from biorenewable resource originating from animal, plant or marine feedstock. All Stepan surfactants used in formulations labeled as naturally-derived have a minimum of 50% biorenewable carbon content (based on Stepan's BCI calculation).	
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