



# Formulation

|                      |  |  |
|----------------------|--|--|
| Name                 | <b>STREAK-FREE GLASS, MIRROR AND WINDOW CLEANER</b>  |  |
| No.                  | 1294   |  |
| Description          | Stepan has found that the pairing of MAKON® L61, an EO/PO block copolymer and STEPANTEX® CO-36, an ethoxylated castor oil used in this low-foam, easy-to-wipe formulation is highly effective at cleaning dirt and grime while maintaining a beautiful streak-free shine. Ethoxylated nonionic surfactants are not a typical choice in glass cleaners due to potential filming issues, but these nontraditional glass cleaning ingredients are a perfect combination, leaving even mirrors clean and bright. |  |
| Formulation          | <b>INGREDIENTS:</b>  | <b><u>% by Weight</u>   <u>Functionality</u></b> |
|                      | Deionized Water  | 98.20 Diluent                                    |
|                      | MAKON® L61   | 0.05 Cleansing Agent                             |
|                      | STEPANTEX® CO-36   | 0.15 Cleansing Agent                             |
|                      | Isopropanol  | 1.50 Solvent                                     |
|                      | Monoethanolamine   | 0.10 pH Adjuster                                 |
|                      | Preservative, Fragrance, and Dye   | q.s. Additives                                   |
|                      | <b>Total</b>   | <b>100.00</b>                                    |
| Procedure            | <ol style="list-style-type: none"> <li>1. Charge Deionized Water.</li> <li>2. Start mixing and add Isopropanol.</li> <li>3. Add Monoethanolamine.</li> <li>4. Add MAKON® L61 and STEPANTEX® CO-36.</li> <li>5. Lastly, add Preservative, Fragrance, and Dye if needed.</li> <li>6. Mix until homogeneous.</li> </ol>   |  |
| Physical Properties  | Appearance at 25°C   | Clear liquid                                     |
|                      | pH, as is  | 10-11  |
|                      | Viscosity at 25°C, cps   | Water thin                                       |
|                      | % VOC, as is   | 1.5  |
|                      | Flash Point (PMCC), °F   | 204.8  |
| Storage/Stability    | Freeze/Thaw, 3 cycles  | Pass   |
|                      | 4 weeks at 50°C  | Pass   |
|                      | 4 weeks at 25°C  | Pass   |
|                      | 4 weeks at 4°C   | Pass   |
| Instructions for Use | Spray on mirror or glass surface and wipe clean with paper towel or cloth.   |  |
| External Comment     | Marketing Notes: This formulation meets U.S. Federal and all State Volatile Organic Compounds (VOC) standards for Non-aerosol Glass Cleaners as of January 2019 (excluding additives). Label and/or trademark usage of the final product is the sole responsibility of the finished product manufacturer, for which Stepan bears no responsibility.  |  |
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