

# Personal care Formulation Guide



# CONTENT

| PRODUCT CATEGORY                   | PAGES     |
|------------------------------------|-----------|
| <b>BODY TREATMENT</b>              |           |
| Liquid Hand Soaps                  | 04 - 11   |
| Shower Gels                        | 12 - 41   |
| Shower Oils & Body Wash Emulsion   | 44 - 53   |
| Intimate Hygiene Products          | 54 - 63   |
| Skin Care Products                 | 64 - 79   |
| <b>FACE TREATMENT</b>              |           |
| Face Care Products                 | 80 - 95   |
| Make Up Removers & Micellar Fluids | 96 - 107  |
| Shaving Products                   | 108 - 121 |
| <b>HAIR TREATMENT</b>              |           |
| Shampoos & Conditioners            | 122 - 137 |
| <b>OTHER</b>                       |           |
| Products Dedicated To Babies       | 138 - 150 |
| Antiperspirants                    | 151 - 153 |







# LIQUID HAND SOAPS

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**Liquid hand soap** is a product formulated to wash and clean hands. It belongs to the group of common dirt removers in commercial and industrial cleaning processes. Liquid hand soaps are the most widely used products in cleaning sector.

Liquid hand soaps can be characterized by different features which are dependent on their components. There are plenty of various products available on the market such as liquid hand soaps for babies, mechanical workers, traditional or economic products.

Liquid hand soaps have to be effective general-purpose cleaners, easy to apply and use and their suppose to be capable of removing different types of dirt such as vegetable and animal oils, fat, wax deposits, dust and many others.

According to WHO, 70% cases of gastrointestinal intoxication, skin infections and conjunctivitis are caused by the germs transmitted to hands.



On one square centimeter of the skin there are plenty of various bacteria. All these germs are transferred every day from human to human when shaking hands, holding on to the handles in public transport, touching coins and banknotes that come into contact with hundreds of hands a day.

Only proper hand hygiene will protect us against dangerous germs and bugs. That is the reason why hands should be oftently washed with the usage of an appropriate designed formulations.

# LIQUID HAND SOAP [RD-01]

| PHASE | INCI NAME                             | BRAND NAME          | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|---------------------|-------------------|--------------------|
| A     | Aqua                                  |                     | up to 100         | solvent            |
|       | Sodium Benzoate,<br>Potassium Sorbate |                     | 0.50              | preservative       |
|       | MEA Lauryl Sulfate                    | ROSULfan M          | 12.00             | surfactant         |
|       | Sodium Laureth Sulfate                | SULFOROKAnol L227/1 | 10.00             | surfactant         |
|       | Cocamide DEA                          | ROKAmid KAD         | 1.00              | surfactant         |
|       | PEG-7 Glyceryl Cocoate                | ROKAcet KO300G      | 1.00              | re-oiling agent    |
| B     | Parfum                                |                     | 0.30              | fragrance          |
|       | Cocamidopropyl Betaine                | ROKAmina K30        | 7.00              | surfactant         |
|       | Sodium Chloride                       |                     | 0.80              | viscosity modifier |
| C     | Citric Acid                           |                     | q.s.              | pH modifier        |



|                |   |                          |
|----------------|---|--------------------------|
| APPEARANCE     | visual method                                     | clear, homogenous liquid |
| pH             |   | 4.8 - 5.5                |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 3000 - 6000              |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed                |

## Procedure:

1. Add ingredients from phase A to warm water (50-55°C). Mix until homogenous solution is obtained.
2. Cool the batch down to at least 35°C.
3. Add parfum and Cocamidopropyl Betaine during mixing. Mix until homogenous solution is obtained.
4. If necessary, add Sodium Chloride to adjust the viscosity. NOTE: it is very important to equilibrate a sample at 25°C for at least one hour to get an accurate viscosity measurement.
5. If necessary, adjust pH by Citric Acid to 4.8 – 5.5.

# TRADITIONAL LIQUID SOAP [MP-01]

| PHASE | INCI NAME                             | BRAND NAME          | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|---------------------|-------------------|--------------------|
| A     | Aqua                                  |                     | up to 100         | solvent            |
|       | Benzophenone-4                        |                     | 0.05              | UV absorber        |
|       | Sodium Laureth Sulfate                | SULFOROKAnol L227/1 | 30.00             | surfactant         |
|       | Sodium Lauroyl Sarcosinate            | ROKAtend LS         | 5.00              | surfactant         |
|       | Citric Acid                           |                     | 0.25              | pH modifier        |
|       | Sodium Benzoate,<br>Potassium Sorbate |                     | 0.60              | preservative       |
| B     | Parfum                                |                     | 0.50              | fragrance          |
|       | PEG-7 Glyceryl Cocoate                | ROKAcet KO300G      | 1.00              | re-oiling agent    |
|       | CI 19140                              |                     | q.s.              | colorant           |
|       | Cocamidopropyl Betaine                | ROKAmina K30        | 7.00              | surfactant         |
| C     | Sodium Chloride                       |                     | 2.20              | viscosity modifier |



|                |   |                   |
|----------------|---|-------------------|
| APPEARANCE     | visual method                                     | bright-yellow gel |
| pH             |   | 4.8 - 5.5         |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 2500 - 5000       |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed         |

## Procedure:

1. Add ingredients from phase A to the warm water (45-50°C). Mix until uniform.
2. Cool the batch down to at least 35°C.
3. Add fragrance, PEG-7 Glyceryl Cocoate and colorant during mixing. Mix until uniform.
4. Add slowly Cocamidopropyl Betaine during mixing. Mix until uniform.
5. Add Sodium Chloride to adjust the viscosity. NOTE. Add salt (not in one go) – after addition of each portion mix well.
6. Control the pH range – if necessary, add citric acid. Mix well after adjustment.
7. Control viscosity if necessary, add Sodium Chloride.



# LIQUID BLACK SOAP FOR MEN [MP-02]

| PHASE | INCI NAME                                    | BRAND NAME     | CONCENTRATION [%] | FUNCTION             |
|-------|--|----------------|-------------------|----------------------|
| A     | Aqua   |                | 48.23             | solvent              |
|       | Acrylates/C10-30 Alkyl Acrylate Crosspolymer |                | 1.00              | viscosity modifier   |
| B     | Aqua   |                | 16.00             | solvent              |
|       | Sodium Lauroyl Glycinate                     | ROKAtend GL    | 5.00              | surfactant           |
|       | Sodium Lauroyl Sarcosinate                   | ROKAtend LS    | 20.00             | surfactant           |
|       | Cocamidopropyl Betaine                       | ROKAmina K30   | 7.00              | surfactant           |
|       | PEG-7 Glyceryl Cocoate                       | ROKAcet KO300G | 1.00              | re-oiling agent      |
| C     | Parfum                                       |                | 0.50              | fragrance            |
|       | Activated Charcoal                           |                | 0.02              | black color additive |
|       | Ethylhexyl Glycerine, Phenoxyethanol         |                | 1.00              | preservative         |
| D     | Sodium Hydroxide (30% solution)              |                | 0.25              | pH modifier          |



|                |   |                    |
|----------------|---|--------------------|
| APPEARANCE     | visual method                                     | black, viscous gel |
| pH             |   | 5.5 - 6.5          |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 20°C | 15000 - 20000      |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed          |

## Procedure:

1. Pour the warm deionized water (40-50°C) into the main vessel and add the Acrylates/C10-30 Alkyl Acrylate Crosspolymer. Start mixing when the agent is completely wetted. Mix until the homogenous solution is obtained.
2. Combine ingredients from phase B in a separate vessel. Heat up to 60°C with gentle agitation. Mix until homogenous solution is obtained.
3. Add phase B to phase A. Mix until homogenous solution is obtained. Cool the batch down to 30°C. When the batch is around 30°C, add preservative, Activated Charcoal and fragrance. Mix for 20-30 minutes with slow agitation. If necessary, homogenise for 1-2 minutes.
4. Readjust the final pH to 5.5-6.5 with additional Sodium Hydroxide (30%) if necessary.

## MILD YELLOW HAND SOAP [MP-03]

| PHASE | INCI NAME  | BRAND NAME   | CONCENTRATION [%] | FUNCTION           |
|-------|--|--------------|-------------------|--------------------|
| A     | Aqua   |              | 46.55             | solvent            |
|       | Potassium Oleate                                   |              | 8.00              | surfactant         |
|       | Sodium Lauroyl Glycinate                           | ROKAtend GL  | 25.00             | surfactant         |
|       | Decyl Glucoside                                    |              | 7.00              | surfactant         |
| B     | Citric Acid  |              | 0.20              | pH modifier        |
| C     | Parfum   |              | 0.50              | fragrance          |
|       | Benzy Alcohol,<br>Ethylhexyglycerin,<br>Tocopherol |              | 1.00              | preservative       |
|       | Cocamidopropyl Betaine                             | ROKAmina K30 | 10.00             | surfactant         |
|       | Sodium Chloride                                    |              | 1.75              | viscosity modifier |



|                |   |               |
|----------------|---|---------------|
| APPEARANCE     | visual method                                     | yellow liquid |
| pH             |   | 8.5 - 9.0     |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 3000 - 5000   |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed     |

### Procedure:

1. Into the large vessel (big enough to provide adequate mixing while preparing batch) pour deionized water.
2. Add ingredients from phase A to the vessel while mixing. Heat up to 70 – 75°C. Mix until homogenous solution is obtained.
3. Cool the batch down to at least 35°C.
4. Adjust pH to 8.5 – 9.0 by using Citric Acid. Mix well after adjustment.
5. Add fragrance, preservative and Cocamidopropyl Betaine. Mix until homogenous solution is obtained.
6. If necessary, add Sodium Chloride to adjust the viscosity. NOTE: it is very important to equilibrate a sample at 25°C for at least one hour to get an accurate viscosity measurement.

## MILD LIQUID HAND SOAP [MP-04]

| PHASE | INCI NAME                                 | BRAND NAME           | CONCENTRATION [%] | FUNCTION           |
|-------|---|----------------------|-------------------|--------------------|
| A     | Aqua                                      |                      | 74.50             | solvent            |
|       | Potassium Oleate                          |                      | 4.00              | surfactant         |
|       | MIPA Laureth Sulfate and Propylene Glycol | SULFOROKAnol L390/1M | 10.00             | surfactant         |
|       | Cocamide DEA                              | ROKAmid KAD          | 1.50              | surfactant         |
|       | Parfum                                    |                      | 0.50              | fragrance          |
|       | Ethylhexyl Glycerine, Phenoxyethanol      |                      | 1.00              | preservative       |
|       | Cocamidopropyl Betaine                    | ROKAmina K30K        | 7.00              | surfactant         |
|       | Sodium Chloride                           |                      | 1.50              | viscosity modifier |
|       |   |                      |                   |                    |



|                |   |                     |
|----------------|---|---------------------|
| APPEARANCE     | visual method                                     | clear yellowish gel |
| pH             |   | 8.5 - 9.0           |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 4.0 RPM, T: 25°C | 3000 - 6000         |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed           |

### Procedure:

1. Heat up the water to (40-50°C) and add the ingredients one after another in the order from the table above.
2. Before adding a parfum cool the mixture down to room temperature and add the rest of ingredients.
3. Add Sodium Chloride to adjust the viscosity. NOTE. Add salt (not in one go) – after addition of each portion mix well.



## ECONOMIC LIQUID HAND SOAP [KD-103]

| PHASE | INCI NAME  | BRAND NAME   | CONCENTRATION [%] | FUNCTION     |
|-------|--|--------------|-------------------|--------------|
| A     | Aqua   |              | up to 100         | solvent      |
|       | Sodium Laureth Sulfate,<br>Cocamidopropyl Betaine,<br>Coco-Glucoside | EXOcare PC60 | 8.00              | surfactant   |
|       | Sodium Benzoate,<br>Potassium Sorbate                                |              | 0.50              | preservative |
|       | Betaine  |              | 0.50              | active       |
|       | Lactic Acid  |              | 0.15              | pH adjuster  |
|       | Cocamide DEA   | ROKamid KAD  | 0.50              | surfactant   |
| B     | Parfum   |              | 0.50              | fragrance    |
|       | CI 42090   |              | q.s.              | colorant     |
|       | CI 19140   |              | q.s.              | colorant     |
| C     | Sodium Chloride  |              | 2.50              | thickener    |



|                |   |                          |
|----------------|---|--------------------------|
| APPEARANCE     | visual method                                     | light-green, viscous gel |
| pH             |   | 4.8 - 5.3                |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 3.0 RPM, T: 25°C | 2000 - 5000              |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed                |

### Procedure:

1. Combine ingredients from phase A. Mix until uniform.
2. Add phase B ingredients. Mix until uniform.
3. Add Sodium Chloride while mixing. Mix until uniform.
4. Control viscosity and pH.



# SHOWER GELS

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**Shower gels** are designed to remove dirt, tallow and impurities of the epidermis, as well as prevent its drying. Products of this type should also adequately moisturize and nourish the skin.

**There are plenty of different shower gels available on the market such as:**

- pearly / transparent / coloured products,
- traditional / mild products,
- designed for babies / people with sensitive skin,
- moisturising products

and many others, although there are general requirements for this type of cosmetics.

The choice of products which contain an appropriate components, provides feeling of smoothness and softness to the skin.



**In general, shower gels should be characterized by:**

- good foaming properties (should quickly create high-volume, stable foam),
- good wettability of dirt and fat on the skin,
- not causing the skin dryness and be safe for the environment,
- ability to disperse emulsified dirt particles in the bath,
- good performance in the presence of hard water,
- improving skin condition after bathing,
- not irritating effect to the eyes, mucous membranes and skin.



# SHOWER GEL WITH PEARLY EFFECT [ZP-01]

| PHASE | INCI NAME   | BRAND NAME          | CONCENTRATION [%] | FUNCTION           |
|-------|---|---------------------|-------------------|--------------------|
| A     | Aqua  |                     | 46.12             | solvent            |
|       | Citric Acid   |                     | 0.15              | pH modifier        |
|       | Polyquaternium 10                                       |                     | 0.06              | conditioning agent |
|       | Disodium Laureth Sulfosuccinate                         | EXOsoft L3/40       | 2.50              | surfactant         |
|       | Sodium Laureth Sulfate                                  | SULFOROKAnol L227/1 | 20.00             | surfactant         |
|       | Sodium Lauroyl Sarcosinate                              | ROKAtend LS         | 20.00             | surfactant         |
|       | Sodium Benzoate, Potassium Sorbate                      |                     | 0.50              | preservative       |
| B     | PEG-120 Methyl Glucose Dioleate                         |                     | 0.50              | thickening agent   |
| C     | Coco Betaine  | ROKAmina K30B       | 5.50              | surfactant         |
|       | Parfum  |                     | 0.50              | fragrance          |
| D     | Sodium Laureth Sulfate, Cocamide DEA, Glycol Distearate | EXOpearl N          | 2.00              | pearling agent     |
| E     | Sodium Chloride   |                     | 2.00              | viscosity modifier |
|       | Citric Acid   |                     | 0.17              | pH modifier        |



|                |   |                     |
|----------------|---|---------------------|
| APPEARANCE     | visual method                                     | viscosus, pearl gel |
| pH             |   | 5.0 - 5.5           |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 3000 - 6000         |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed           |

## Procedure:

1. Add ingredients from phase A to the hot water (70-75°C). While mixing add ingredients one after another in the order from the table above. Mix until uniform.
2. Cool the batch down to at least 50°C.
3. Add PEG-120 Methyl Glucose Dioleate during mixing. Mix until uniform. Cool the batch down to at least 35°C.
4. Add fragrance and Coco Betaine during mixing. Mix until uniform.
5. Add pearling agent. Mix until uniform.
6. Add Sodium Chloride to adjust the viscosity. NOTE. Add salt (not in one go) – after addition of each portion mix well.
7. Control the pH range – if necessary, add Citric Acid. Mix well after adjustment.
8. Control the viscosity, if necessary add Sodium Chloride.

# CLASSIC SHOWER GEL [ZP-02]

| PHASE | INCI NAME                             | BRAND NAME          | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|---------------------|-------------------|--------------------|
| A     | Aqua                                  |                     | 49.15             | solvent            |
|       | Citric Acid                           |                     | 0.20              | pH modifier        |
|       | Lauryl Glucoside                      |                     | 5.00              | surfactant         |
|       | Sodium Laureth Sulfate                | SULFOROKAnol L227/1 | 15.00             | surfactant         |
|       | Sodium Lauroyl Sarcosinate            | ROKAtend LS         | 20.00             | surfactant         |
|       | Sodium Benzoate,<br>Potassium Sorbate |                     | 0.60              | preservative       |
| B     | PEG-120 Methyl<br>Glucose Dioleate    |                     | 0.70              | thickening agent   |
|       | PEG-7 Glyceryl Cocoate                | ROKAcet KO300G      | 1.50              | re-oiling agent    |
| C     | Parfum                                |                     | 0.50              | fragrance          |
|       | Cocamidopropyl Betaine                | ROKAmina K30        | 5.00              | surfactant         |
| D     | Citric Acid                           |                     | 0.20              | pH modifier        |
|       | Sodium Chloride                       |                     | 2.15              | viscosity modifier |



|                |   |                     |
|----------------|---|---------------------|
| APPEARANCE     | visual method                                     | clear, viscosus gel |
| pH             |   | 5.0 - 5.5           |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 3000 - 6000         |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed           |

## Procedure:

1. Add ingredients from phase A to the warm water (55-60°C). Mix until uniform.
2. Cool the batch down to at least 50°C.
3. Add PEG-120 Methyl Glucose Dioleate and PEG-7 Glyceryl Cocoate during mixing. Mix until uniform. Cool the batch down to at least 35°C.
4. Add fragrance and Cocamidopropyl Betaine during mixing. Mix until uniform.
5. Add Sodium Chloride to adjust the viscosity. NOTE. Add salt (not in one go) – after addition of each portion mix well.
6. Control the pH range – if necessary, add Citric Acid. Mix well after adjustment.

# WHITE SHOWER GEL [ZP-03]

| PHASE | INCI NAME                                    | BRAND NAME  | CONCENTRATION [%] | FUNCTION           |
|-------|--|-------------|-------------------|--------------------|
| A     | Aqua   |             | 33.37             | solvent            |
|       | Acrylates/C10-30 Alkyl Acrylate Crosspolymer |             | 0.40              | viscosity modifier |
|       | Sodium Hydroxide (30% solution)              |             | 0.25              | pH modifier        |
| B     | Aqua   |             | 20.00             | solvent            |
|       | Xanthan Gum                                  |             | 0.45              | viscosity modifier |
|       | Glycerin                                     |             | 2.00              | moisturising agent |
|       | Polyquaternium 10                            |             | 0.01              | conditioning agent |
| C     | Aqua   |             | 10.00             | solvent            |
|       | Talc   |             | 2.00              | skin conditioner   |
|       | Mica, Titanium dioxide                       |             | 0.02              | pearling agent     |
|       | Sodium Lauroyl Glycinate                     | ROKAtend GL | 10.00             | surfactant         |
|       | Sodium Lauroyl Sarcosinate                   | ROKAtend LS | 20.00             | surfactant         |
| D     | Parfum                                       |             | 0.50              | fragrance          |
|       | Ethylhexyl Glycerine, Phenoxyethanol         |             | 1.00              | preservative       |



|                |   |                   |
|----------------|---|-------------------|
| APPEARANCE     | visual method                                     | white viscous gel |
| pH             |   | 6.0 - 7.5         |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 6000 - 9000       |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed         |

## Procedure:

1. Pour the warm deionized water (40-50°C) into the main vessel and add the Acrylates/C10-30 Alkyl Acrylate Crosspolymer. Start mixing when the agent is completely wetted. Mix until the homogenous solution is obtained.
2. Add Sodium Hydroxide. Mix until homogenous solution is obtained.
3. Combine ingredients from phase B in a separate vessel. Add Xanthan Gum to Glycerin – mix until homogenous solution is obtained. Add warm water (40-50°C) and Polyquaternium-10. Mix until homogenous solution is obtained. If necessary, homogenise for 2-3 minutes.
4. Add phase B to main vessel. Mix until homogenous solution is obtained. If needed, homogenise for 2-3 minutes.
5. Combine ingredients from phase C in a separate vessel. Heat up to 40°C with gentle agitation. Mix until homogenous solution is obtained.
6. Add phase C to the main vessel. Mix until homogenous solution is obtained. Cool the batch down to 30°C.
7. Add fragrance and preservative. Mix gently until homogenous solution is obtained.



# BLACK-GOLD SHOWER GEL FOR MEN [ZP-04]

| PHASE | INCI NAME                             | BRAND NAME          | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|---------------------|-------------------|--------------------|
| A     | Aqua                                  |                     | 67.09             | solvent            |
|       | Xanthan Gum                           |                     | 0.90              | viscosity modifier |
|       | Glycerin                              |                     | 2.50              | moisturising agent |
|       | Sodium Benzoate,<br>Potassium Sorbate |                     | 0.30              | preservative       |
|       | Polyquaternium-7                      |                     | 0.01              | conditioning agent |
| B     | Ammonium Laureth Sulfate              | SULFOROKAnol A325/1 | 24.00             | surfactant         |
|       | CI 77000, CI 77491, Silica            |                     | 0.03              | pigment            |
|       | Activated Charcoal                    |                     | 0.02              | pigment            |
|       | PEG-7 Glyceryl Cocoate                | ROKAcet KO300G      | 1.00              | re-oiling agent    |
|       | Cocamidopropyl Betaine                | ROKAmina K30K       | 3.40              | surfactant         |
|       | Parfum                                |                     | 0.30              | fragrance          |
|       | Sodium Benzoate,<br>Potassium Sorbate |                     | 0.30              | preservative       |
|       | Citric Acid                           |                     | 0.15              | pH modifier        |



|                |   |                |
|----------------|---|----------------|
| APPEARANCE     | visual method                                     | black-gold gel |
| pH             |   | 4.8 - 5.5      |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 6.0 RPM, T: 25°C | 8000 - 15000   |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed      |

## Procedure:

1. In a main vessel combine ingredients from phase A by adding Xanthan Gum to Glycerin and mixing until homogenous solution is obtained. Then, take 2.5 g of water from phase A to a separate beaker add Polyquaternium-7 and mix them well.
2. Add the rest of warm water (50-55°C) from phase A to the main vessel and homogenise for 1-2 minutes. At the end of preparation, mix the solutions, add preservative and homogenise for 2-3 minutes.
3. Combine ingredients from the phase B and mix until uniform. Control the pH range – if necessary, add Citric Acid.
4. Add phase B to phase A and mix well. Cool the batch down to 30°C and homogenise for 2-3 minutes.

# BLACK SHOWER GEL FOR MEN [ZP-05]

| PHASE | INCI NAME                             | BRAND NAME          | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|---------------------|-------------------|--------------------|
| A     | Aqua                                  |                     | 56.58             | solvent            |
|       | Xanthan Gum                           |                     | 0.90              | viscosity modifier |
|       | Glycerin                              |                     | 2.50              | moisturising agent |
|       | Sodium Benzoate,<br>Potassium Sorbate |                     | 0.30              | preservative       |
|       | Polyquaternium-7                      |                     | 0.01              | conditioning agent |
| B     | Aqua                                  |                     | 1.24              | solvent            |
|       | Ammonium Laureth Sulfate              | SULFOROKAnol A325/1 | 24.00             | surfactant         |
|       | Sodium Lauroyl Sarcosinate            | ROKAtend LS         | 10.00             | surfactant         |
|       | Activated Charcoal                    |                     | 0.01              | pigment            |
|       | Parfum                                |                     | 0.50              | fragrance          |
|       | Sodium Benzoate,<br>Potassium Sorbate |                     | 0.30              | preservative       |
|       | Cocamidopropyl Betaine                | ROKAmina K30K       | 3.40              | surfactant         |
|       | Citric Acid                           |                     | 0.26              | pH modifier        |



|                |   |                 |
|----------------|---|-----------------|
| APPEARANCE     | visual method                                     | black clear gel |
| pH             |   | 4.8 - 5.5       |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 6.0 RPM, T: 25°C | 6000 - 15000    |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed       |

## Procedure:

1. In a main vessel combine ingredients from phase A by adding Xanthan Gum to Glycerin and mixing until homogenous solution is obtained. Then, take 2.5 g of water from phase A to a separate beaker add Polyquaternium-7 and mix them well.
2. Add the rest of warm water (50-55°C) from phase A to the main vessel and homogenise for 1-2 minutes. At the end of preparation, mix the solutions, add preservative and homogenise for 2-3 minutes.
3. Combine ingredients from the phase B and mix until uniform. Control the pH range – if necessary, add Citric Acid.
4. Add phase B to phase A and mix well. Cool the batch down to 30°C and homogenise for 2-3 minutes.

## MILD SHOWER GEL [ZP-10]

| PHASE | INCI NAME                             | BRAND NAME     | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|----------------|-------------------|--------------------|
| A     | Aqua                                  |                | 65.76             | solvent            |
|       | Xanthan Gum                           |                | 0.90              | viscosity modifier |
|       | Glycerin                              |                | 2.50              | moisturising agent |
|       | Sodium Benzoate,<br>Potassium Sorbate |                | 1.00              | preservative       |
| B     | Aqua                                  |                | 1.95              | solvent            |
|       | Magnesium Laureth Sulfate             | EXOsoft MG     | 23.10             | surfactant         |
|       | PEG-7 Glyceryl Cocoate                | ROKAcet KO300G | 1.00              | surfactant         |
|       | Parfum                                |                | 0.30              | fragrance          |
|       | Cocamidopropyl Betaine                | ROKAmina K30K  | 3.40              | surfactant         |
|       | Citric Acid                           |                | 0.09              | pH modifier        |



|                |   |                     |
|----------------|---|---------------------|
| APPEARANCE     | visual method                                     | colorless clear gel |
| pH             |   | 4.8 - 5.5           |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 6.0 RPM, T: 25°C | 7000 - 15000        |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed           |

### Procedure:

1. In a main vessel combine ingredients from phase A. Add Xanthan Gum to glycerin – mix until homogenous solution is obtained. Then, pour warm water (50-55°C) from phase A to the main vessel and mix. Add preservative. Homogenise for 2-3 minutes.
2. Combine ingredients from the phase B and mix until uniform. Control the pH range – if necessary, add Citric Acid.
3. Add phase B to phase A and mix well. Cool the batch down to 30°C and homogenise for 2-3 minutes.

# MILD BODY WASH EMULSION [RD-11]

| PHASE | INCI NAME                                 | BRAND NAME           | CONCENTRATION [%] | FUNCTION            |
|-------|---|----------------------|-------------------|---------------------|
| A     | Aqua                                      |                      | to 100            | solvent             |
| A     | Xanthan Gum                               |                      | 0.50              | rheology modifier   |
| B     | Ceteareth-25                              | ROKAnol T25          | 2.00              | emulsifier          |
| B     | Cetearyl Alcohol                          | EXOalc 1618 flakes   | 3.00              | emulsion stabilizer |
| C     | MIPA Laureth Sulfate and Propylene Glycol | SULFOROKAnol L390/1M | 2.00              | emollient           |
| E     | Sodium Lauroyl Sarcosinate                | ROKAtend LS          | 5.00              | surfactant          |
| A     | Glycerin                                  |                      | 2.00              | solvent             |
| C     | Helianthus annuus Seed Oil                |                      | 10.               | emolient            |
| A     | Phenoxyethanol, Ethylhexylglycerin        |                      | q.s               | preservative        |
| B     | Stearic Acid                              |                      | 1.00              | rheology modifier   |
|       | Lactic Acid                               |                      | 0.15              | pH adjuster         |
| D     | Parfum                                    |                      | 0.1               | fragrance           |



|            |                            |                |
|------------|----------------------------|----------------|
| APPEARANCE | visual method              | white emulsion |
| pH         |                            | 5.0 - 6.0      |
| STABILITY  | 1 month in 5°C, 20°C, 40°C | confirmed      |

## Procedure:

1. In main vessel combine ingredients from the phase A.
2. Add Xanthan gum to Glycerin – mix until homogenous solution is obtained.
3. Add the phase B components to phase A while mixing. Mix until uniform.
4. In a separate vessel combine ingredients from the phase C and add to main vessel.
5. Heat to 75-80°C.
6. At this temp of 75-80°C homogenize.
7. Cool the batch down to 40°C. Add phase D ingredients while mixing. Homogenize.
8. Cool the batch down to 25°C. Add phase E ingredients while mixing. Homogenize.

# LIQUID SHOWER GEL FOR WOMEN [ZP-11]

| PHASE | INCI NAME                                      | BRAND NAME           | CONCENTRATION [%] | FUNCTION           |
|-------|--|----------------------|-------------------|--------------------|
| A     | Aqua   |                      | 66.53             | solvent            |
|       | Xanthan Gum                                    |                      | 0.90              | viscosity modifier |
|       | Glycerin                                       |                      | 2.50              | moisturising agent |
|       | Sodium Benzoate,<br>Potassium Sorbate          |                      | 0.30              | preservative       |
| B     | Aqua   |                      | 8.30              | solvent            |
|       | MIPA Laureth Sulfate<br>(and) Propylene Glycol | SULFOROKAnol L390/1M | 7.00              | surfactant         |
|       | Sodium Lauroyl Sarcosinate                     | ROKAtend LS          | 10.00             | surfactant         |
|       | CI 77000,<br>Acrylates Crosspolymer            |                      | 0.02              | pigment            |
|       | Parfum   |                      | 0.50              | fragrance          |
|       | Sodium Benzoate,<br>Potassium Sorbate          |                      | 0.30              | preservative       |
|       | Cocamidopropyl Betaine                         | ROKAmina K30K        | 3.40              | surfactant         |
|       | Citric Acid                                    |                      | 0.25              | pH modifier        |



|                |   |                        |
|----------------|---|------------------------|
| APPEARANCE     | visual method                                     | gold scintillating gel |
| pH             |   | 4.8 - 5.5              |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 6.0 RPM, T: 25°C | 7000 - 15000           |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed              |

## Procedure:

1. In a main vessel combine ingredients from phase A. Add Xanthan Gum to glycerin – mix until homogenous solution is obtained. Then, pour warm water (50-55°C) from phase A to the main vessel and mix. Add preservative. Homogenise for 2-3 minutes.
2. Combine ingredients from the phase B and mix until uniform. Control the pH range – if necessary, add Citric Acid.
3. Add phase B to phase A and mix well. Cool the batch down to 30°C and homogenise for 2-3 minutes.



# MOISTURIZING BODY WASH GEL [KD-104]

| PHASE | INCI NAME  | BRAND NAME   | CONCENTRATION [%] | FUNCTION     |
|-------|--|--------------|-------------------|--------------|
| A     | Aqua   |              | 81.25             | solvent      |
|       | Sodium Laureth Sulfate,<br>Cocamidopropyl Betaine,<br>Coco-Glucoside | EXOcare PC60 | 15.00             | surfactant   |
|       | Aqua, Sodium Benzoate,<br>Potassium Sorbate                          |              | 0.50              | preservative |
|       | Allantoin  |              | 0.10              | active       |
|       | Lactic Acid  |              | 0.15              | pH adjuster  |
| B     | PEG-120 Methyl<br>Glucose Dioleate                                   |              | 0.50              | thickener    |
|       | Parfum   |              | 0.50              | fragrance    |
|       | Urea   |              | 0.50              | active       |
| C     | Sodium Chloride  |              | 1.50              | thickener    |



|                |   |                          |
|----------------|---|--------------------------|
| APPEARANCE     | visual method                                     | transparent, viscous gel |
| pH             |   | 4.8 - 5.5                |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 3.0 RPM, T: 25°C | 2000 - 7000              |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed                |

## Procedure:

- Combine ingredients from phase A. Mix until uniform.
- Add ingredients from phase B while mixing. Mix until uniform.
- Add Sodium Chloride while mixing. Mix until uniform.

## CLEANSING GEL [KD-121]

| PHASE | INCI NAME                               | BRAND NAME     | CONCENTRATION [%] | FUNCTION     |
|-------|---|----------------|-------------------|--------------|
| A     | Aqua                                    |                | up to 100         | solvent      |
|       | Sodium Laureth Sulfate,<br>Cocamide MEA | EXOcare ML70   | 5.00              | surfactant   |
|       | Sodium Benzoate,<br>Potassium Sorbate   |                | 0.50              | preservative |
|       | Lactic Acid                             |                | 0.25              | pH adjuster  |
|       | PEG-7 Glyceryl Cocoate                  | ROKAcet KO300G | 2.00              | surfactant   |
| B     | Parfum                                  |                | 0.25              | fragrance    |
|       | Cocamidopropyl Betaine                  | ROKAmina K30   | 8.00              | surfactant   |
| C     | Sodium Chloride                         |                | 0.50              | thickener    |



|                |   |              |
|----------------|---|--------------|
| APPEARANCE     | visual method                                     | viscous gel  |
| pH             |   | 4.6 - 5.3    |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.0 RPM, T: 25°C | 3000 - 10000 |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed    |

### Procedure:

- Combine ingredients from phase A. Mix until uniform.
- Add slowly Parfum and ROKAmina K30 while mixing – mix until uniform.
- Add slowly Sodium Chloride while mixing. Mix until uniform.

# SHOWER BAR [IT-204]

| PHASE | INCI NAME                                 | BRAND NAME          | CONCENTRATION [%] | FUNCTION          |
|-------|---|---------------------|-------------------|-------------------|
| A     | PEG-150                                   | POLIkol 6000        | 12.00             | thickener         |
| A     | Cera Alba                                 |                     | 3.00              | thickener         |
| A     | Cetearyl Alcohol                          | EXOalc 1618         | 20.50             | thickener         |
| A     | Hydrogenated castor oil                   |                     | 17.00             | thickener         |
| A     | Stearic Acid                              |                     | 2.00              | rheology modifier |
| B     | MIPA Laureth Sulfate,<br>Propylene Glycol | SULFOROKAnol L390/1 | 31.80             | surfactant        |
| B     | Cocamidopropyl Betaine                    | ROKAmina K30        | 10.00             | surfactant        |
| B     | Glycerin                                  |                     | 3.00              | solvent           |
| C     | Citric acid                               |                     | 0.50              | pH adjuster       |
| D     | Parfum                                    |                     | 0.20              | fragrance         |



|                |               |                |
|----------------|---------------|----------------|
| APPEARANCE     | visual method | white emulsion |
| pH             |               |                |
| VISCOSITY [cP] |               |                |
| STABILITY      |               |                |

## Procedure:

1. Add cera alba, hydrogenated castor oil, EXOalc 1618 and stearic acid into main vessel and heat up to 80°C and then mix.
2. Add POLIkol 6000 and citric acid then mix until homogeneous solution is obtained.
3. Cool down solution to 70°C and add phase B ingredients and mix well.
4. Cool down solution to 65°C and add phase D and mix until homogeneous solution is obtained.

## UREA SHOWER GEL [KD-123]

| PHASE | INCI NAME                                   | BRAND NAME           | CONCENTRATION [%] | FUNCTION     |
|-------|---|----------------------|-------------------|--------------|
| A     | Aqua  |                      | up to 100         | solvent      |
|       | Sodium Laureth Sulfate,<br>Cocamide MEA     | EXOcare ML70         | 5.00              | surfactant   |
|       | Sodium Laureth Sulfate                      | SULFOROKAnol L270/1  | 8.00              | surfactant   |
|       | Glycerin                                    |                      | 2.00              | solvent      |
|       | Aqua, Sodium Benzoate,<br>Potassium Sorbate |                      | 0.70              | preservative |
|       | Lactic Acid                                 |                      | 1.00              | pH adjuster  |
|       | Sodium Lactate                              | Sodium L-Lactate 50% | 1.40              | pH adjuster  |
|       | Arginine                                    |                      | 0.50              | active       |
|       | Urea  |                      | 4.00              | humectant    |
| B     | Parfum                                      |                      | 0.50              | fragrance    |
| C     | Cocamidopropyl Betaine                      | ROKAmina K30         | 6.00              | surfactant   |
| D     | Sodium Chloride                             |                      | 1.50              | thickener    |



|                |   |              |
|----------------|---|--------------|
| APPEARANCE     | visual method                                     | gel          |
| pH             |   | 4.7 - 5.7    |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 3.0 RPM, T: 25°C | 2500 - 10000 |
| STABILITY      | 1 month at 5°C, 20°C, -5/40°C                     | confirmed    |

### Procedure:

1. In main vessel combine ingredients from phase A – mix until uniform (cloudy solution).
2. Prepare the remaining ingredients in separate beakers.
3. Add Parfum – mix until uniform.
4. Add slowly ROKAmina K30 while mixing – mix until uniform.
5. Add slowly Sodium Chloride while mixing – mix until uniform.

## SHOWER GEL – MEN COMFORT [KD-126]

| PHASE | INCI NAME   | BRAND NAME   | CONCENTRATION [%] | FUNCTION          |
|-------|---|--------------|-------------------|-------------------|
| A     | Aqua  |              | to 100.00         | solvent           |
|       | Sodium Laureth Sulfate,<br>Cocamide MEA                             | EXOcare ML70 | 19.00             | surfactant        |
| B     | Acrylates Copolymer   |              | 6.00              | rheology modifier |
|       | Aqua  |              | 6.00              | solvent           |
| C     | Sodium Hydroxide  |              | 0.20              | pH adjuster       |
|       | Phenoxyethanol,<br>Methylparaben,<br>Ethylparaben,<br>Propylparaben |              | 0.80              | preservative      |
| D     | Sodium Chloride   |              | 0.50              | thickener         |
| E     | Petrolatum  |              | 3.00              | emollient         |
| F     | Parfum  |              | 0.50              | fragrance         |
| G     | CI 42090  |              | 0.005             | colorant          |



|            |                            |                   |
|------------|----------------------------|-------------------|
| APPEARANCE | visual method              | blue, viscous gel |
| pH         |                            | 6.0 - 7.5         |
| STABILITY  | 1 month at 5°C, 20°C, 40°C | confirmed         |

### Procedure:

- Combine ingredients from phase A and B in separate vessel – mix until uniform.
- Add slowly phase B to phase A during mixing – mix until uniform. In separate vessels prepare other ingredients.
- Add preservative and pH adjuster during mixing – mix until uniform.
- Add Sodium Chloride while mixing – mix until uniform.
- Add phase E,F,G while mixing – mix until uniform.



## BODY WASH WITH MENTHOL COOL [KD-210]

| PHASE | INCI NAME                                  | BRAND NAME     | CONCENTRATION [%] | FUNCTION     |
|-------|--|----------------|-------------------|--------------|
| A     | Aqua                                       |                | up to 100         | solvent      |
|       | Ammonium Lauryl Sulfate                    | ROSULfan A     | 22.00             | surfactant   |
|       | Coco-Glucoside                             |                | 4.00              | surfactant   |
| B     | Aqua, Sodium Benzoate, Potassium Sorbate   |                | 0.50              | preservative |
|       | Lactic Acid                                |                | 0.20              | pH adjuster  |
|       | Aqua, Coffea Arabica Seed Extract, Alcohol |                | 0.10              | active       |
| C     | Alcohol                                    |                | 0.50              | solvent      |
|       | Menthol                                    |                | 0.05              | refreshing   |
| D     | Cocamidopropyl Betaine                     | Rokamina K40HC | 7.00              | surfactant   |
| E     | Sodium Chloride                            |                | 0.50              | thickener    |



|                |   |             |
|----------------|---|-------------|
| APPEARANCE     | visual method                                     | gel         |
| pH             |   | 4.7 - 5.5   |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 3.0 RPM, T: 25°C | 2500 - 8000 |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed   |

### Procedure:

1. In a main vessel combine ingredients from phase A – mix until uniform. In separate vessel combine ingredients from phase C – mix until uniform.
2. Prepare the remaining ingredients in separate beakers.
3. Add ingredients from phase B while mixing – mix until uniform.
4. Add phase C ingredients while mixing – mix until uniform.
5. Add Rokamina K40HC while mixing – mix until uniform.
6. Add slowly Sodium Chloride while mixing – mix until uniform.

# MEN COOL BODY WASH WITH MENTHOL [KD-210]

| PHASE | INCI NAME   | BRAND NAME   | CONCENTRATION [%] | FUNCTION     |
|-------|---|--------------|-------------------|--------------|
| A     | Aqua  |              | to 100.00         | solvent      |
|       | Ammonium Lauryl Sulfate                           | ROSULfan A70 | 8.00              | surfactant   |
|       | Coco-Glucoside                                    |              | 4.00              | surfactant   |
| B     | Aqua, Sodium Benzoate, Potassium Sorbate          |              | 0.50              | preservative |
|       | Lactic Acid                                       |              | 0.25              | pH adjuster  |
|       | CI 42090  |              | 0.10              | colourant    |
| C     | Trideceth-9, PEG-40 Hydrogenated Castor Oil, Aqua | EXOcare HTW  | 0.20              | solvent      |
|       | Menthol   |              | 0.05              | refreshing   |
|       | Parfum  |              | 0.30              | fragrance    |
| D     | Cocamidopropyl Betaine                            | Rokamina K30 | 7.00              | surfactant   |
| E     | Sodium Chloride                                   |              | 0.60              | thickener    |



|                |   |             |
|----------------|---|-------------|
| APPEARANCE     | visual method                                     | gel         |
| pH             |   | 4.7 - 5.5   |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 3.0 RPM, T: 25°C | 3000 - 7000 |

## Procedure:

1. In main vessel combine ingredients from phase A – mix until uniform. In separate vessel combine ingredients from phase C – mix until uniform.
2. Prepare the remaining ingredients in separate beakers.
3. Add ingredients from phase B while mixing – mix until uniform.
4. Add phase C ingredients while mixing – mix until uniform.
5. Add Rokamina K30 while mixing – mix until uniform.
6. Add slowly Sodium Chloride while mixing – mix until uniform.

# BODY WASH JELLY IN THE FORM OF CRUSHED ICE [RD-08]

| PHASE | INCI NAME           | BRAND NAME    | CONCENTRATION [%] | FUNCTION     |
|-------|---------------------|---------------|-------------------|--------------|
| D     | Sodium Coco Sulfate | ROSULfan C/PH | 15.000            | surfactant   |
| B     | Glycerin            |               | 15.000            | active       |
| B     | Carrageenan         |               | 2.000             | thickener    |
| C     | Parfum              |               | 0.800             | fragrance    |
| A     | CI 42045            |               | 0.001             | colourant    |
| A     | Sodium Benzoate     |               | 0.300             | preservative |
| E     | Citric Acid         |               | 0.050             | pH adjuster  |
| A     | Aqua                |               | 66.848            | solvent      |



|            |                            |                         |
|------------|----------------------------|-------------------------|
| APPEARANCE | visual method              | turquoise crushed jelly |
| pH         |                            | 4.9 - 5.3               |
| STABILITY  | 1 month in 5°C, 20°C, 40°C | confirmed               |

## Procedure:

1. Add ingredients from phase A to water. Mix until homogenous solution is obtained.
2. Combine the ingredients from phase B, and mix until swollen.
3. Add phase B during mixing to phase A. Mix until homogenous solution is obtained.
4. Add ingredients from phase C to the main mixer and mix.
5. Add ingredient from phase D to the main mixer and mix.
6. Adjust pH by Citric Acid to 4.6-5.1.

## 3 IN 1 SHOWER GEL [RD-03]

| PHASE | INCI NAME                        | BRAND NAME    | CONCENTRATION [%] | FUNCTION         |
|-------|----------------------------------|---------------|-------------------|------------------|
| A     | Coco-Betaine                     | ROKAmina K30B | 9.00              | surfactant       |
| A     | Magnesium Laureth Sulfate        | EXOsoft MGB   | 7.00              | surfactant       |
| A     | PEG-6 Caprylic/Capric Glycerides | ROKAcet CC6   | 2.00              | surfactant       |
| B     | PEG-120 Methyl Glucose Dioleate  |               | 1.10              | thickening agent |
| B     | Allantoin                        |               | 0.60              | active           |
| B     | Betaine                          |               | 0.50              | active           |
| B     | Polysorbate 20                   | ROKwinol 20   | 0.50              | solubilizer      |
| C     | Parfum                           |               | 0.30              | fragrance        |
| D     | Sodium Benzoate                  |               | 0.40              | preservative     |
| E     | Lactic Acid                      |               | 0.40              | pH modifier      |
| E     | CI 19140                         |               | 0.01              | dye              |
| E     | CI 42090                         |               | 0.01              | dye              |
| A     | Aqua                             |               | 78.20             | solvent          |



|                       |   |                 |
|-----------------------|---|-----------------|
| <b>APPEARANCE</b>     | visual method                                     | clear green gel |
| <b>pH</b>             |   | 4.0 - 5.0       |
| <b>VISCOSITY [cP]</b> | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 1000 - 3000     |
| <b>STABILITY</b>      | 1 month in 5°C, 20°C, 40°C                        | confirmed       |

### Procedure:

1. Add ingredients from phase A to warm water (40-45°C). Mix until homogenous solution is obtained.
2. Cool the batch down to at least 35°C.
3. Add phase B-E during mixing. Mix until homogenous solution is obtained.
4. Adjust pH by Lactic Acid to 4.5-4.8.
5. Adjust Sodium Chloride to adjust the viscosity. NOTE Add salt (not in one go) – after addition of each portion mix well.



## BODY SCRUB [KD-92]

| PHASE | INCI NAME  | BRAND NAME          | CONCENTRATION [%] | FUNCTION           |
|-------|--|---------------------|-------------------|--------------------|
| A     | Aqua   |                     | up to 100         | solvent            |
|       | Acrylates/C10-30 Alkyl Acrylate Crosspolymer               |                     | 0.90              | viscosity modifier |
|       | Glycerin   |                     | 1.00              | solvent            |
|       | Betaine  |                     | 1.00              | active             |
| B     | Sodium Laureth Sulfate                                     | SULFOROKAnol L227/1 | 20.00             | surfactant         |
| C     | Parfum   |                     | 0.25              | fragrance          |
|       | Polysorbate 20   | ROKwinol 20         | 0.25              | surfactant         |
| D     | CI 17200   |                     | 0.0001            | colorant           |
|       | Cellulose Acetate  |                     | 1.00              | abrasive           |
|       | Phenoxyethanol, Methylparaben, Ethylparaben, Propylparaben |                     | 0.80              | preservative       |
| E     | Cocamidopropyl Betaine                                     | ROKAmina K30        | 4.00              | surfactant         |
| F     | Sodium Hydroxide (30% solution)                            |                     | 0.40              | pH modifier        |



|                |   |               |
|----------------|---|---------------|
| APPEARANCE     | visual method                                     | viscous gel   |
| pH             |   | 5.0 - 6.0     |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 20°C | 15000 - 20000 |
| STABILITY      | 1 month at 5°C, 20°C, 40°C                        | confirmed     |

### Procedure:

1. In a main vessel combine ingredients from the phase A. Add Acrylates/C10-30 Alkyl Acrylate Crosspolymer, Glycerin, Betaine to Aqua – mix until homogenous solution is obtained. Homogenise for 2-3 minutes.
2. Add SULFOROKAnol L227/1 – mix until uniform.
3. Prepare phase C, D and E.
4. Add phase D and E – mix until uniform.
5. Add ROKAmina K30 – mix until uniform.
6. Add Sodium Hydroxide (30%) if necessary. Mix until uniform.



## RASPBERRY JELLY BODY SCRUB [RD-16]

| PHASE | INCI NAME                       | BRAND NAME    | CONCENTRATION [%] | FUNCTION     |
|-------|---------------------------------|---------------|-------------------|--------------|
| A     | Magnesium Laureth Sulfate       | EXOsoft MG    | 26.600            | surfactant   |
| A     | Disodium Laureth Sulfosuccinate | EXOsoft L3/40 | 0.500             | surfactant   |
| A     | Cocamidopropyl Betaine          | ROKAmina K30  | 15.000            | surfactant   |
| A     | Glycerin                        |               | 1.000             | active       |
| A     | Panthenol                       |               | 0.500             | active       |
| B     | PEG-120 Methyl Glucose Dioleate |               | 10.000            | thickener    |
| B     | Parfum                          |               | 1.000             | fragrance    |
| A     | CI 16255                        |               | 0.001             | pigment      |
|       | Cellulose                       |               | 0.100             | abrasive     |
| A     | Sodium Benzoate                 |               | 0.400             | preservative |
|       | Citric Acid                     |               | 0.100             | pH adjuster  |
| A     | Aqua                            |               | 44.799            | solvent      |



|                   |                            |                        |
|-------------------|----------------------------|------------------------|
| <b>APPEARANCE</b> | visual method              | red jelly with peeling |
| <b>pH</b>         |                            | 4.7 - 5.2              |
| <b>STABILITY</b>  | 1 month in 5°C, 20°C, 40°C | confirmed              |

### Procedure:

1. Add ingredients from phase A to water. Mix until homogenous solution is obtained.
2. Dissolve phase B separately (40-45°C).
3. Add phase B during mixing. Mix until homogenous solution is obtained.
4. Adjust pH by Lactic Acid to 4.7-5.2.
5. Finally, add the abrasive.

# SHOWER GEL FOR MEN CARE [KD-106]

| PHASE | INCI NAME   | BRAND NAME          | CONCENTRATION [%] | FUNCTION          |
|-------|---|---------------------|-------------------|-------------------|
| A     | Aqua  |                     | up to 100         | solvent           |
|       | Sodium Laureth Sulfate,   | SULFOROKAnol L227/1 | 45.00             | surfactant        |
| B     | Acrylates Copolymer   |                     | 6.00              | rheology modifier |
|       | Aqua  |                     | 6.00              | solvent           |
| C     | Cocamide DEA  | ROKAmid KAD         | 1.50              | surfactant        |
|       | Phenoxyethanol,<br>Methylparaben,<br>Ethylparaben,<br>Propylparaben |                     | 0.60              | preservative      |
|       | CI 17200  |                     | 0.00008           | colorant          |
|       | CI 42090  |                     | 0.0015            | colorant          |
|       | Parfum  |                     | 0.5               | fragrance         |
| D     | Sodium Chloride   |                     | 0.90              | thickener         |
| E     | Petrolatum  |                     | 4.00              | emollient         |



|            |                            |                  |
|------------|----------------------------|------------------|
| APPEARANCE | visual method              | blue, visous gel |
| pH         |                            | 6.0 - 7.5        |
| STABILITY  | 1 month at 5°C, 20°C, 40°C | confirmed        |

## Procedure:

- Combine ingerdients from phase A and B in separate vessels – mix until uniform.
- Add slowly phase B ingredients to phase A while mixing – mix until uniform. In separate vessels prepare others ingredients.
- Add phase C ingredients while mixing – mix until uniform.
- Add Sodium Chloride while mixing – mix until uniform.
- Add Petrolatum while mixing – mix until uniform.

# COMFORT SHOWER GEL FOR MEN [KD-126]

| PHASE | INCI NAME   | BRAND NAME   | CONCENTRATION [%] | FUNCTION          |
|-------|---|--------------|-------------------|-------------------|
| A     | Sodium Laureth Sulfate,<br>Cocamide MEA                             | EXOcare ML70 | 19.00             | surfactant        |
|       | Aqua  |              | up to 100         | solvent           |
| B     | Acrylates Copolymer   |              | 6.00              | rheology modifier |
|       | Aqua  |              | 6.00              | solvent           |
| C     | Sodium Hydroxide  |              | 0.20              | pH adjuster       |
| D     | Phenoxyethanol,<br>Methylparaben,<br>Ethylparaben,<br>Propylparaben |              | 0.80              | preservative      |
| E     | CI 42090  |              | q.s.              | colorant          |
| F     | Sodium Chloride   |              | 0.5               | thickener         |
| G     | Petrolatum  |              | 3.00              | emollient         |
| H     | Parfum  |              | 0.50              | fragrance         |



|            |                            |                  |
|------------|----------------------------|------------------|
| APPEARANCE | visual method              | blue, visous gel |
| pH         |                            | 6.0 - 7.5        |
| STABILITY  | 1 month at 5°C, 20°C, 40°C | confirmed        |

## Procedure:

- Combine ingerdients from phase A and B in separate vessels – mix until uniform.
- Add slowly phase B ingredients to phase A while mixing – mix until uniform. In separate vessels prepare others ingredients.
- Add phase C and D ingredients while mixing – mix until uniform.
- Add Sodium Chloride while mixing – mix until uniform.
- Add Petrolatum and Parfum while mixing – mix until uniform.

## ECO SHOWER GEL FOR MEN [KD-207]

| PHASE | INCI NAME  | BRAND NAME   | CONCENTRATION [%] | FUNCTION     |
|-------|--|--------------|-------------------|--------------|
| A     | Aqua   |              | up to 100         | solvent      |
|       | Benzyl Alcohol, Benzoic Acid, Dehydroacetic Acid, Tocopherol |              | 0.70              | preservative |
|       | Betaine  |              | 0.50              | active       |
| B     | Ammonium Lauryl Sulfate                                      | ROSULfan A   | 25.00             | surfactant   |
| C     | Cocamidopropyl Betaine                                       | ROKAmina K30 | 5.00              | surfactant   |
| D     | Parfum   |              | q.s.              | fragrance    |
|       | Menthol  |              | 0.10              | refreshing   |
| E     | Sodium Chloride  |              | 1.80              | thickener    |



|                |   |                 |
|----------------|---|-----------------|
| APPEARANCE     | visual method                                     | transparent gel |
| pH             |   | 4.5 - 5.5       |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 6.0 RPM, T: 25°C | 2000 - 6000     |

### Procedure:

1. In a main vessel combine ingredients from phase A. Mix until uniform.
2. Add ROSULfan A while mixing. Mix until uniform.
3. Combine ingredients from phase D – mix until uniform
4. Add slowly ROKAmina K30 and Parfum/ Menthol while mixing. Mix until uniform.

5. Add slowly Sodium Chloride. Mix until uniform.

NOTE: Add Sodium Chloride in small portions. Control the viscosity after each portion.

# NATURAL SHOWER GEL FOR MEN WITH PIGMENT [KD-213]

| PHASE | INCI NAME                             | BRAND NAME   | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|--------------|-------------------|--------------------|
| A     | Aqua                                  |              | up to 100         | solvent            |
|       | Xanthan Gum                           |              | 0.90              | viscosity modifier |
|       | Glycerin                              |              | 2.50              | moisturising agent |
|       | Sodium Benzoate,<br>Potassium Sorbate |              | 0.60              | preservative       |
| B     | Ammonium Lauryl Sulfate               | ROSULfan A   | 24.00             | surfactant         |
|       | CI 77000, CI 77491, Silica            |              | 0.03              | colorant           |
|       | Cocamidopropyl Betaine                | Rokamina K30 | 3.40              | surfactant         |
|       | Parfum                                |              | 0.30              | fragrance          |
|       | Citric acid                           |              | 0.15              | pH modifier        |



|                |   |              |
|----------------|---|--------------|
| APPEARANCE     | visual method                                     | pearling gel |
| pH             |   | 4.8 - 5.5    |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 6.0 RPM, T: 25°C | 8000 - 15000 |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed    |

## Procedure:

1. In a main vessel combine ingredients from phase A by adding Xanthan Gum to Glycerin and mixing until homogeneous solution is obtained.
2. Add warm water (50-55°C) from phase A to the main vessel and homogenise for 1-2 minutes.
3. At the end of preparation, mix the solutions, add preservative and homogenise for 2-3 minutes.
4. Combine ingredients from the phase B and mix until uniform. Control the pH range – if necessary, add Citric Acid.
5. Add phase B to phase A and mix well. Cool the batch down to 30°C while mixing.

## GREEN FACE AND BODY SOAP [KD-350]

| PHASE | INCI NAME  | BRAND NAME    | CONCENTRATION [%] | FUNCTION     |
|-------|--|---------------|-------------------|--------------|
| A     | Aqua   |               | up to 100         | solvent      |
|       | Sodium Chloride                                      |               | 1.50              | thickener    |
|       | Lactic Acid  |               | 0.30              | pH adjuster  |
| B     | Potassium Oleate                                     | EXOsoft PO30  | 20.00             | surfactant   |
| C     | Potassium Cocoate                                    | EXOsoft PC35  | 8.00              | surfactant   |
| D     | Benzyl Alcohol,<br>Ethylhexylglycerin,<br>Tocopherol |               | 0.60              | preservative |
|       | Parfum   |               | 0.25              | fragrance    |
| E     | Coco Betaine   | ROKAmina K30B | 5.00              | surfactant   |



|                |   |             |
|----------------|---|-------------|
| APPEARANCE     | visual method                                     | gel         |
| pH             |   | 9.5 - 10.0  |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 3.0 RPM, T: 25°C | 2000 - 8000 |

### Procedure:

1. In a main vessel combine ingredients from phase A – mix until uniform.
2. Prepare the remaining ingredients in separate beakers.
3. Add EXOsoft PO30 (phase B) while mixing – mix until uniform
4. Add EXOsoft PC35 (phase C) while mixing – mix until uniform
5. Add preservative and fragrance while mixing – mix until uniform.
6. Add slowly ROKAmina K30B while mixing – mix until uniform.



# MEN COOL BODY WASH WITH MENTHOL [KD-210]

| PHASE | INCI NAME                                  | BRAND NAME     | CONCENTRATION [%] | FUNCTION     |
|-------|--|----------------|-------------------|--------------|
| A     | Aqua                                       |                | up to 100         | solvent      |
|       | Ammonium Lauryl Sulfate                    | ROSULfan A     | 22.00             | surfactant   |
|       | Coco-Glucoside                             |                | 4.00              | surfactant   |
| B     | Aqua, Sodium Benzoate, Potassium Sorbate   |                | 0.50              | preservative |
|       | Lactic Acid                                |                | 0.20              | pH adjuster  |
|       | Aqua, Coffea Arabica Seed Extract, Alcohol |                | 0.10              | active       |
| C     | Alcohol                                    |                | 0.50              | solvent      |
|       | Menthol                                    |                | 0.05              | refreshing   |
| D     | Cocamidopropyl Betaine                     | Rokamina K40HC | 7.00              | surfactant   |
| E     | Sodium Chloride                            |                | 0.50              | thickener    |



|                |   |             |
|----------------|---|-------------|
| APPEARANCE     | visual method                                     | gel         |
| pH             |   | 4.7 - 5.5   |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 3.0 RPM, T: 25°C | 2500 - 8000 |

## Procedure:

1. In a main vessel combine ingredients from phase A – mix until uniform. In a separate vessel combine ingredients from phase C – mix until uniform.
2. Prepare the remaining ingredients in separate beakers.
3. Add ingredients from phase B while mixing – mix until uniform
4. Add phase C ingredients while mixing – mix until uniform.
5. Add Rokamina K40HC MB while mixing – mix until uniform.
6. Add slowly Sodium Chloride while mixing – mix until uniform.

## FOAMING BODY GEL [KD-357]

| PHASE | INCI NAME  | BRAND NAME          | CONCENTRATION [%] | FUNCTION           |
|-------|--|---------------------|-------------------|--------------------|
| A     | Aqua   |                     | up to 100         | solvent            |
|       | Acrylates/C10-30 Alkyl Acrylate Crosspolymer               |                     | 0.90              | viscosity modifier |
|       | Glycerin   |                     | 1.00              | solvent            |
| B     | Sodium Laureth Sulfate                                     | SULFOROKAnol L227/1 | 20.00             | surfactant         |
| C     | Parfum   |                     | 0.25              | fragrance          |
|       | Polysorbate 20   | ROKwinol 20         | 0.25              | surfactant         |
| D     | CI 42090   |                     | 0.0001            | colourant          |
|       | Phenoxyethanol, Methylparaben, Ethylparaben, Propylparaben |                     | 0.80              | preservative       |
| E     | Cocamidopropyl Betaine                                     | ROKAmina K30        | 4.00              | surfactant         |
| F     | Sodium Hydroxide (30% solution)                            |                     | 0.40              | pH modifier        |



|                |   |               |
|----------------|---|---------------|
| APPEARANCE     | visual method                                     | viscous gel   |
| pH             |   | 5.0 - 6.0     |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 20°C | 15000 - 20000 |

### Procedure:

1. In a main vessel combine ingredients from the phase A. Add Acrylates/C10-30 Alkyl Acrylate Crosspolymer, Glycerin, to Aqua – mix until homogenous solution is obtained. Homogenise for 2-3 minutes.
2. Add SULFOROKAnol L227/1 – mix until uniform.
3. Prepare phase C, D and E..
4. Add phase C and D – mix until uniform.
5. Add ROKAmina K30 – mix until uniform.



# NOURISHING BODY MOUSSE [RD-24]

| PHASE | INCI NAME                       | BRAND NAME    | CONCENTRATION [%] | FUNCTION     |
|-------|---------------------------------|---------------|-------------------|--------------|
| A     | Sodium Cocoyl Isethionate       |               | 17.00             | surfactant   |
| A     | Decyl Glucoside                 |               | 4.00              | surfactant   |
| A     | Disodium Laureth Sulfosuccinate | EXOsoft L3/40 | 4.00              | surfactant   |
| B     | PPG-15 Stearyl Ether            | ROKAnol SP15L | 1.00              | surfactant   |
| B     | Glycerin                        |               | 12.00             | active       |
| B     | Sorbitol                        |               | 3.00              | active       |
| C     | Parfum                          |               | 0.30              | fragrance    |
| C     | CI 42090                        |               | 0.001             | dye          |
| C     | Sodium Lactate                  |               | 0.50              | active       |
| D     | Sodium Benzoate                 |               | 0.50              | preservative |
| D     | Potassium Sorbate               |               | 0.30              | preservative |
| E     | Lactic Acid                     |               | 0.30              | pH adjuster  |
| A     | Aqua                            |               | 52.60             | solvent      |



|            |                            |                  |
|------------|----------------------------|------------------|
| APPEARANCE | visual method              | light blue paste |
| pH         |                            | 5.0 - 5.5        |
| STABILITY  | 1 month in 5°C, 20°C, 40°C | 2500 - 8000      |

## Procedure:

1. Add ingredients from phase A to warm water (40-45°C). Mix until homogenous solution is obtained.
2. Cool the batch down to at least 35°C.
3. Add phase B during mixing. Mix until homogenous solution is obtained.
4. Add phase C-E ingredients while mixing – mix until uniform.
5. Adjust pH by Lactic Acid to 5,0-5,5.

## RICH CARING BODY MOUSSE [RD-22]

| PHASE | INCI NAME                 | BRAND NAME    | CONCENTRATION [%] | FUNCTION     |
|-------|---------------------------|---------------|-------------------|--------------|
| A     | Sodium Cocoyl Isethionate |               | 11.00             | surfactant   |
| A     | Magnesium Laureth Sulfate | EXOsoft MGB   | 1.20              | surfactant   |
| A     | Coco Betaine              | ROKamina K30B | 1.50              | surfactant   |
| B     | Glycerin                  |               | 30.00             | active       |
| B     | Sorbitol                  |               | 15.00             | active       |
| B     | Sodium Lactate            |               | 1.00              | active       |
| C     | Parfum                    |               | 0.40              | fragrance    |
| D     | Sodium Benzoate           |               | 0.50              | preservative |
| D     | Potassium Sorbate         |               | 0.30              | preservative |
| E     | Lactic Acid               |               | 0.30              | pH adjuster  |
| A     | Aqua                      |               | 38.80             | solvent      |



|            |                            |             |
|------------|----------------------------|-------------|
| APPEARANCE | visual method              | white paste |
| pH         |                            | 5.0 - 5.5   |
| STABILITY  | 1 month in 5°C, 20°C, 40°C | confirmed   |

### Procedure:

1. Add ingredients from phase A to warm water (40-45°C). Mix until homogenous solution is obtained.
2. Cool the batch down to at least 35°C.
3. Add phase B during mixing. Mix until homogenous solution is obtained.
4. Add phase C-E ingredients while mixing – mix until uniform.
5. Adjust pH by Lactic Acid to 5,0-5,5.





# SHOWER OILS & BODY WASH EMULSION

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**Shower oils** and body wash emulsions are suitable for dry and very dry skin. They gently cleanse and at the same time renew the lipid layer of the skin.

Beautiful fragrance, pleasant consistency, cleansing and moisturizing properties – these are the features of an ideal shower product. Usually consumers choose gels or lotions, although shower oils have recently become very popular on the market.

Shower oils turn into foam which is pleasant to the skin when exposed to water.

Shower oils and body wash emulsions are recommended for sensitive skin. They improve elasticity and strengthen the lipid layer of the epidermis. The shower oil gently oils and nourishes the skin.



They are oftently recommended for washing sensitive, dry skin, but in winter shower oils will be useful for any skin. They grease it well, rebuild protective film strained by winter conditions, prevent moisture loss, smooth, soften, nourish and strengthen. They are very delicate, so using them brings a real pleasure.

After bathing, the skin is lightly dry by a towel with no need to lubricate it with a moisturizer, because it is slightly oily.

# SHOWER AND BATH OIL [KD-115]

| PHASE | INCI NAME                                   | BRAND NAME           | CONCENTRATION [%] | FUNCTION   |
|-------|---|----------------------|-------------------|------------|
| A     | MIPA Laureth Sulfate (and) Propylene Glycol | SULFOROKAnol L390/1M | 15.00             | surfactant |
|       | Glycine Soja Oil                            |                      | 27.00             | emollient  |
|       | Helianthus Annuus Seed Oil                  |                      | 26.00             | emollient  |
|       | Tocopheryl Acetate                          |                      | 1.00              | active     |
| B     | Laureth-2                                   |                      | 30.00             | surfactant |
|       | Parfum                                      |                      | 1.00              | fragrance  |



|                |  |                                   |
|----------------|--|-----------------------------------|
| APPEARANCE     | visual method                                    | slightly yellowish viscous liquid |
| VISCOSITY [cP] | Brookfield LV, spindle 18, speed 10 RPM, T: 25°C | 70-120                            |
| STABILITY      | 1 month at 5°C, RT, 40°C                         | confirmed                         |

## Procedure:

1. In a main vessel combine ingredients from phase A and mix until uniform.
2. Combine ingredients from phase B in a separate vessel and mix until uniform.
3. Add ingredients from phase B to phase A while mixing. Mix until uniform.



## SHOWER OIL [KD-304]

| PHASE | INCI NAME                              | BRAND NAME           | CONCENTRATION [%] | FUNCTION   |
|-------|--|----------------------|-------------------|------------|
| A     | Helianthus Annuus Seed Oil             |                      | 54.50             | emollient  |
|       | Tocopheryl Acetate                     |                      | 1.00              | active     |
| C     | TIPA Laureth Sulfate, Propylene Glycol | SULFOROKAnol L385/1T | 20.00             | surfactant |
| C     | Laureth-2                              | ROKAnol LK2          | 24.00             | surfactant |
|       | Parfum                                 |                      | 0.50              | fragrance  |



**APPEARANCE** visual method

slightly yellowish  
viscous liquid

**VISCOSITY [cP]**

**STABILITY**

### Procedure:

1. In a main vessel combine ingredients from phase A. Mix until uniform.
2. Combine ingredients from phase B in a separate vessel and mix until uniform.
3. Add ingredients from phase B to phase A while mixing. Mix until uniform.

## WASHING POWDER [RD-15]

| PHASE | INCI NAME             | BRAND NAME  | CONCENTRATION [%] | FUNCTION     |
|-------|-----------------------|-------------|-------------------|--------------|
|       | Sodium Lauryl Sulfate | ROSULfan LP | 20.00             | surfactant   |
|       | Allantoin             | -           | 1.0               | activ        |
|       | Sorbitol              | -           | 78.5              | moisturizing |
|       | Parfum                | -           | 0.50              | fragrance    |



### APPEARANCE

visual method

slightly yellowish  
viscous liquid

## Procedure:

1. Mix all ingredients.

## SHOWER AND BATH OIL [KD-115]

| PHASE | INCI NAME                                      | BRAND NAME           | CONCENTRATION [%] | FUNCTION   |
|-------|--|----------------------|-------------------|------------|
| A     | MIPA Laureth Sulfate<br>(and) Propylene Glycol | SULFOROKAnol L390/1M | 15.00             | surfactant |
|       | Glycine Soja Oil                               |                      | 27.00             | emollient  |
|       | Helianthus Annuus Seed Oil                     |                      | 26.00             | emollient  |
|       | Tocopheryl Acetate                             |                      | 1.00              | active     |
| B     | Laureth-2                                      |                      | 30.00             | surfactant |
|       | Parfum   |                      | 1.00              | fragrance  |



|                |  |                                      |
|----------------|--|--------------------------------------|
| APPEARANCE     | visual method                                    | slightly yellowish<br>viscous liquid |
| VISCOSITY [cP] | Brookfield LV, spindle 18, speed 10 RPM, T: 25°C | 70-120                               |
| STABILITY      | 1 month at 5°C, RT, 40°C                         | confirmed                            |

### Procedure:

1. In a main vessel combine ingredients from phase A and mix until uniform.
2. Combine ingredients from phase B in a separate vessel and mix until uniform.
3. Add ingredients from phase B to phase A while mixing. Mix until uniform.

# MOISTURIZING BODY MOUSSE [RD-13]

| PHASE | INCI NAME                        | BRAND NAME    | CONCENTRATION [%] | FUNCTION     |
|-------|----------------------------------|---------------|-------------------|--------------|
| A     | Sodium Cocoyl Isethionate        |               | 10.00             | surfactant   |
| A     | Decyl Glucoside                  |               | 0.60              | surfactant   |
| A     | Disodium Laureth Sulfosuccinate  | EXOsoft L3/40 | 3.00              | surfactant   |
| A     | PEG-6 Caprylic/Capric Glycerides | ROKAcet CC6   | 1.00              | surfactant   |
| B     | Glycerin                         |               | 38.00             | active       |
| B     | Sorbitol                         |               | 16.00             | active       |
| B     | Poloxamer 184                    | EXOmer L64    | 0.50              | surfactant   |
| C     | Parfum                           |               | 0.30              | fragrance    |
| C     | Panthenol                        |               | 0.20              | active       |
| C     | CI 15510                         |               | 0.003             | dye          |
| D     | Sodium Benzoate                  |               | 0.50              | preservative |
| D     | Potassium Sorbate                |               | 0.30              | preservative |
| E     | Lactic Acid                      |               | 0.30              | pH adjuster  |
| A     | Aqua                             |               | 28.80             | solvent      |



|            |                            |              |
|------------|----------------------------|--------------|
| APPEARANCE | visual method              | orange paste |
| pH         |                            | 5.0 - 5.5    |
| STABILITY  | 1 month in 5°C, 20°C, 40°C | confirmed    |

## Procedure:

1. Add ingredients from phase A to warm water (40-45°C). Mix until homogenous solution is obtained.
2. Cool the batch down to at least 35°C.
3. Add phase B during mixing. Mix until homogenous solution is obtained.
4. Add phase C-E ingredients while mixing- mix until uniform.
5. Adjust pH by Lactic Acid to 5.0-5.5.

## NOURISHING BATH & SHOWER OIL [RD-14]

| PHASE | INCI NAME                                  | BRAND NAME           | CONCENTRATION [%] | FUNCTION   |
|-------|--|----------------------|-------------------|------------|
| A     | Helianthus Annuus Seed Oil                 |                      | 24.50             | emollient  |
| A     | Prunus Amygdalus Dulcis (Sweet Almond) Oil |                      | 10.0              | emollient  |
| A     | Ricinus Communis (Castor) Seed Oil         |                      | 10.0              | emollient  |
|       | Tocopheryl Acetate                         |                      | 1.00              | active     |
|       | TIPA Laureth Sulfate, Propylene Glycol     | SULFOROKAnol L385/1T | 20.00             | surfactant |
| C     | Laureth-2                                  | ROKAnol LK2          | 24.00             | surfactant |
|       | Parfum                                     |                      | 0.50              | fragrance  |



**APPEARANCE** visual method

slightly yellowish  
viscous liquid

### Procedure:

1. In a main vessel combine ingredients from phase A. Mix until uniform.
2. Combine ingredients from phase B in a separate vessel and mix until uniform.
3. Add ingredients from phase B to phase A while mixing. Mix until uniform.

## REFRESHING BODY MOUSSE [RD-17]

| PHASE | INCI NAME                    | BRAND NAME    | CONCENTRATION [%] | FUNCTION     |
|-------|------------------------------|---------------|-------------------|--------------|
| A     | Sodium Cocoyl Isethionate    |               | 21.00             | surfactant   |
| A     | Decyl Glucoside              |               | 1.20              | surfactant   |
| A     | PEG-4 Rapeseedamide          | ROKAmid MRZ4  | 3.00              | surfactant   |
| A     | Coco-Betaine                 | ROKAmina K30B | 1.00              | surfactant   |
| B     | Glycerin                     |               | 11.00             | active       |
| B     | Sorbitol                     |               | 6.00              | active       |
| B     | Betaine                      |               | 0.40              | active       |
| C     | Parfum                       |               | 0.30              | fragrance    |
| C     | CI 15510                     |               | 0.001             | dye          |
| C     | CI 45100                     |               | 0.001             | dye          |
| C     | Mentha Piperita Leaf Extract |               | 0.40              | active       |
| D     | Sodium Benzoate              |               | 0.50              | preservative |
| D     | Potassium Sorbate            |               | 0.30              | preservative |
| E     | Lactic Acid                  |               | 0.30              | pH adjuster  |
| A     | Aqua                         |               | 54.60             | solvent      |



|                   |                            |           |
|-------------------|----------------------------|-----------|
| <b>APPEARANCE</b> | visual method              | red paste |
| <b>pH</b>         |                            | 5.0 - 5.5 |
| <b>STABILITY</b>  | 1 month in 5°C, 20°C, 40°C | confirmed |

### Procedure:

1. Add ingredients from phase A to warm water (40-45°C). Mix until homogenous solution is obtained.
2. Cool the batch down to at least 35°C.
3. Add phase B during mixing. Mix until homogenous solution is obtained.
4. Add phase C-E ingredients while mixing – mix until uniform.
5. Adjust pH by Lactic Acid to 5.0-5.5.

## REFRESHING SHOWER GEL WITH ZINC [RD-18]

| PHASE | INCI NAME              | BRAND NAME   | CONCENTRATION [%] | FUNCTION           |
|-------|------------------------|--------------|-------------------|--------------------|
| A     | Zinc Coceth Sulfate    | EXOsoft ZN   | 8.00              | surfactant         |
| A     | PEG-4 Rapeseedamide    | ROKamid MRZ4 | 2.00              | surfactant         |
| A     | Cocamidopropyl Betaine | ROKamina K30 | 8.00              | surfactant         |
| A     | Coco Glucoside         |              | 9.00              | surfactant         |
| B     | Glycerin               |              | 0.50              | active             |
| C     | Parfum                 |              | 0.30              | fragrance          |
| D     | Sodium Benzoate        |              | 0.40              | preservative       |
| E     | Lactic Acid            |              | 0.40              | pH modifier        |
| E     | CI 19140               |              | 0.01              | dye                |
| E     | CI 17200               |              | 0.01              | dye                |
| F     | Sodium Chloride        |              | 1.20              | viscosity modifier |
| A     | Aqua                   |              | 70.18             | solvent            |



|            |   |                  |
|------------|---|------------------|
| APPEARANCE | visual method                                     | clear orange gel |
| pH         |   | 4.0 - 5.0        |
| VISCOSITY  | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 1000 - 3000      |
| STABILITY  | 1 month in 5°C, 20°C, 40°C                        | confirmed        |

### Procedure:

1. Add ingredients from phase A to warm water (40-45°C). Mix until homogenous solution is obtained.
2. Cool the batch down to at least 35°C.
3. Add phase B-E during mixing. Mix until homogenous solution is obtained.
4. Adjust pH by Lactic Acid to 4.6-4.8.
5. Adjust Sodium Chloride to adjust the viscosity. NOTE Add salt (not in one go) – after addition of each portion mix well.





# INTIMATE HYGIENE

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The intimate woman place is a unique ecosystem which is inhabited by over 100 species of microorganisms. Among them are the bacteria, whose metabolic product like lactic acid protects the vaginal environment from pathogens. Because of that the pH of intimate area is below 4.5.

A number of factors, can disrupt the balance of the vaginal microbiota and compromise women's health. Therefore, the proper care for the most delicate part of the body should be taken very seriously.

Formulations presented below combine an appropriate and well-thought components of the final formula which restores the natural pH balance.



**Intimate hygiene products provide a gentle care for places requiring special protection. The main function which suppose to be fulfilled by Intimate Hygiene Products are:**

- provide a feeling of well-being,
- provide protection from infection,
- be suitable for daily use,
- prevent skin dryness,
- destroy the lipid mantle of the skin,
- neutral and natural composition,
- be without potential ingredients that cause allergies and irritations,
- provide care and regeneration.

## GEL FOR INTIMATE HYGIENE [KD-01]

| PHASE | INCI NAME                             | BRAND NAME          | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|---------------------|-------------------|--------------------|
| A     | Aqua                                  |                     | 68.00             | solvent            |
|       | Sodium Benzoate,<br>Potassium Sorbate |                     | 0.50              | preservative       |
|       | Betaine                               |                     | 1.00              | active             |
|       | Glycerin                              |                     | 2.00              | moisturising agent |
|       | Lactic Acid                           |                     | 0.50              | pH adjuster        |
| B     | Sodium Laureth Sulfate                | SULFOROKAnol L227/1 | 18.00             | surfactant         |
|       | PEG-7 Glyceryl Cocoate                | ROKAcet KO300G      | 1.00              | surfactant         |
| C     | Parfum                                |                     | 0.25              | fragrance          |
| D     | Coco Betaine                          | ROKAmina K30B       | 8.75              | surfactant         |



|                |   |                  |
|----------------|---|------------------|
| APPEARANCE     | visual method                                     | light-yellow gel |
| pH             |   | 4.0- 4.5         |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 6.0 RPM, T: 25°C | 1000 - 7000      |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed        |

### Procedure:

1. In a main vessel combine ingredients from phase A. Mix until uniform.
2. Add ingredients from phase B. Mix until uniform.
3. Add parfum while mixing. Mix until uniform.
4. Add slowly Coco Betaine while mixing. Mix until uniform.
5. If nessesery, adjust pH by Lactic Acid to 4.0 – 4.5.

## GEL FOR INTIMATE HYGIENE [KD-02]

| PHASE | INCI NAME                             | BRAND NAME               | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|--------------------------|-------------------|--------------------|
| A     | Aqua                                  |                          | up to 100         | solvent            |
|       | Sodium Benzoate,<br>Potassium Sorbate |                          | 0.50              | preservative       |
|       | Betaine                               |                          | 1.00              | active             |
|       | Glycerin                              |                          | 1.00              | moisturising agent |
|       | Lactic Acid                           |                          | q.s               | pH adjuster        |
| B     | Sodium Laureth Sulfate                | SULFOROKAnol L227/1      | 12.00             | surfactant         |
|       | PEG-7 Glyceryl Cocoate                | ROKAcet KO300G           | 0.50              | surfactant         |
|       | Magnesium Laureth Sulfate             | EXOsoft MG / EXOsoft MGB | 6.00              | surfactant         |
| C     | Parfum                                |                          | 0.25              | fragrance          |
| D     | Coco Betaine                          | ROKAmina K30B            | 9.00              | surfactant         |



|                |   |                 |
|----------------|---|-----------------|
| APPEARANCE     | visual method                                     | transparent gel |
| pH             |   | 4.0 - 4.5       |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 6.0 RPM, T: 25°C | 1000 - 7000     |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed       |

### Procedure:

1. In a main vessel combine ingredients from phase A. Add ingredients from phase A to warm water (40-45°C). Mix until uniform.
2. Add ingredients from phase B. Mix until uniform. Cool the batch down to at least 30°C.
3. Add Parfum while mixing. Mix until uniform.
4. Add slowly Coco Betaine while mixing. Mix until uniform.
5. If necessary, adjust pH by Lactic Acid to 4.0 – 4.5.

## GEL FOR INTIMATE HYGIENE [KD-03]

| PHASE | INCI NAME                             | BRAND NAME          | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|---------------------|-------------------|--------------------|
| A     | Aqua                                  |                     | 70.65             | solvent            |
|       | Sodium Laureth Sulfate                | SULFOROKAnol L227/1 | 18.00             | surfactant         |
|       | Sodium Lauroyl Sarcosinate            | ROKAtend LS         | 3.00              | surfactant         |
|       | Betaine                               |                     | 0.50              | active             |
|       | Glycerin                              |                     | 1.00              | moisturising agent |
|       | Coco-Glucoside,<br>Glyceryl Oleate    |                     | 0.50              | surfactant         |
|       | Sodium Benzoate,<br>Potassium Sorbate |                     | 0.50              | preservative       |
|       | Lactic Acid                           |                     | 0.60              | pH adjuster        |
| B     | Parfum                                |                     | 0.25              | fragrance          |
| C     | Coco Betaine                          | ROKAmina K30B       | 5.00              | surfactant         |



|                |   |                 |
|----------------|---|-----------------|
| APPEARANCE     | visual method                                   | transparent gel |
| pH             |   | 4.0 - 4.5       |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 6 RPM, T: 25°C | 2000 - 7000     |
| STABILITY      | 1 month at 5°C, RT, 40°C                        | confirmed       |

### Procedure:

- Combine ingredients from phase A. Add ingredients from phase A to warm water (40-45°C). Mix until homogenous solution is obtained. Cool the batch down to at least 30°C.
- Add parfum while mixing.
- Add Coco Betaine while mixing. Mix until uniform.
- If necessary, adjust pH by Lactic Acid to 4.0 – 4.5.

## GEL FOR INTIMATE HYGIENE [KD-04]

| PHASE | INCI NAME                          | BRAND NAME               | CONCENTRATION [%] | FUNCTION           |
|-------|------------------------------------|--------------------------|-------------------|--------------------|
| A     | Aqua                               |                          | up to 100         | solvent            |
|       | MEA Lauryl Sulfate                 | ROSULfan M               | 18.00             | surfactant         |
|       | Magnesium Laureth Sulfate          | EXOsoft MG / EXOsoft MGB | 4.00              | surfactant         |
|       | Glycerin                           |                          | 1.00              | moisturising agent |
|       | PEG-7 Glyceryl Cocoate             | ROKAcet KO300G           | 1.00              | surfactant         |
|       | Decyl Glucoside                    |                          | 0.50              | surfactant         |
|       | Sodium Benzoate, Potassium Sorbate |                          | 0.50              | preservative       |
| B     | Coco Betaine                       | ROKAmina K30B            | 6.00              | surfactant         |
|       | Parfum                             |                          | 0.25              | fragrance          |
| C     | Lactic Acid                        |                          | q.s               | pH adjuster        |



|                |   |                   |
|----------------|---|-------------------|
| APPEARANCE     | visual method                                   | bright-yellow gel |
| pH             |   | 4.0 - 4.5         |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 6 RPM, T: 25°C | 2000 - 7000       |
| STABILITY      | 1 month at 5°C, RT, 40°C                        | confirmed         |

### Procedure:

- Combine ingredients from phase A. Add ingredients from phase A to water (25-30°C). Mix until homogenous solution is obtained.
- Add slowly Coco Betaine and parfum while mixing. Mix until uniform.
- If necessary, adjust pH by Lactic Acid to 4.0 – 4.5.

## GEL FOR INTIMATE HYGIENE [KD-05]

| PHASE | INCI NAME                             | BRAND NAME     | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|----------------|-------------------|--------------------|
| A     | Aqua                                  |                | up to 100         | solvent            |
|       | Magnesium Laureth Sulfate             | EXOsoft MGB    | 25.00             | surfactant         |
|       | Betaine                               |                | 2.00              | active             |
|       | Glycerin                              |                | 2.00              | moisturising agent |
|       | PEG-7 Glyceryl Cocoate                | ROKAcet KO300G | 1.00              | surfactant         |
|       | Sodium Benzoate,<br>Potassium Sorbate |                | 0.50              | preservative       |
|       | Coco-Glucoside,<br>Glyceryl Oleate    |                | 0.50              | surfactant         |
|       | Lactic Acid                           |                | q.s.              | pH adjuster        |
| B     | Parfum                                |                | 0.20              | fragrance          |
|       | Coco Betaine                          | ROKAmina K30B  | 8.00              | surfactant         |



|                |   |                 |
|----------------|---|-----------------|
| APPEARANCE     | visual method                                     | transparent gel |
| pH             |   | 4.0 - 4.5       |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.0 RPM, T: 25°C | 1000 - 4000     |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed       |

### Procedure:

1. Combine ingredients from phase A. Add ingredients from phase A to water and heat to 50°C. Mix until homogenous solution is obtained.
2. Cool the batch down to at least 30°C.
3. Add slowly Coco Betaine and Parfum while mixing. Mix until uniform.

## GEL FOR INTIMATE HYGIENE [KD-06]

| PHASE | INCI NAME   | BRAND NAME     | CONCENTRATION [%] | FUNCTION           |
|-------|---|----------------|-------------------|--------------------|
| A     | Aqua  |                | up to 100         | solvent            |
|       | Sodium Benzoate,<br>Potassium Sorbate                         |                | 0.50              | preservative       |
|       | Betaine   |                | 0.50              | active             |
|       | Glycerin  |                | 1.00              | moisturising agent |
|       | Lactic Acid   |                | q.s.              | pH adjuster        |
| B     | Magnesium Laureth Sulfate                                     | EXOsoft MGB    | 24.00             | surfactant         |
|       | PEG-120 Methyl<br>Glucose Dioleate                            |                | 0.25              | thickener          |
|       | PEG-7 Glyceryl Cocoate  | ROKAcet KO300G | 0.50              | surfactant         |
| C     | Coco Betaine  | ROKAmina K30B  | 8.00              | surfactant         |
| D     | Sodium Laureth Sulfate,<br>Cocamide DEA,<br>Glycol Distearate | EXOpearl N     | 1.50              | surfactant         |



|                |   |             |
|----------------|---|-------------|
| APPEARANCE     | visual method                                     | pearly gel  |
| pH             |   | 4.0 - 4.5   |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 3000 - 8000 |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed   |

### Procedure:

1. In a main vessel combine ingredients from phase A. Add ingredients from phase A to warm water (40-45°C). Mix until uniform.
2. Add ingredients from phase B. Mix until uniform. Cool the batch down to at least 30°C.
3. Add ingredients from phase C and D during mixing. Mix until uniform.

## FOAM FOR INTIMATE HYGIENE [KD-07]

| PHASE | INCI NAME                          | BRAND NAME               | CONCENTRATION [%] | FUNCTION           |
|-------|------------------------------------|--------------------------|-------------------|--------------------|
| A     | Aqua                               |                          | up to 100         | solvent            |
|       | Glycerin                           |                          | 4.00              | moisturising agent |
|       | Magnesium Laureth Sulfate          | EXOsoft MG / EXOsoft MGB | 4.00              | surfactant         |
|       | Disodium Laureth Sulfosuccinate    | EXOsoft L3/40            | 4.00              | surfactant         |
|       | Betaine                            |                          | 0.50              | active             |
|       | Sodium Benzoate, Potassium Sorbate |                          | 0.50              | preservative       |
|       | Lactic Acid                        |                          | q.s               | pH adjuster        |
| B     | Panthenol                          |                          | 0.10              | active             |
|       | PEG-120 Methyl Glucose Dioleate    |                          | 0.25              | thickener          |
| C     | Cocamidopropyl Betaine             | ROKAmina K30             | 2.00              | surfactant         |
|       | Parfum                             |                          | 0.20              | fragrance          |



|            |                          |                      |
|------------|--------------------------|----------------------|
| APPEARANCE | visual method            | bright-yellow liquid |
| pH         |                          | 4.0 - 4.5            |
| STABILITY  | 1 month at 5°C, RT, 40°C | confirmed            |

### Procedure:

1. In a main vessel combine ingredients from phase A. Add ingredients from phase A to warm water (40-45°C). Mix until uniform.
2. Add PEG-120 Methyl Glucose Dioleate and Panthenol. Mix until uniform. Cool the batch down to at least 30°C.
3. Add Cocamidopropyl Betaine and Parfum during mixing. Mix until uniform.
4. If necessary, adjust pH by Lactic Acid to 4.0 – 4.5.



## MILD INTIMATE HYGIENE EMULSION [RD-12]

| PHASE | INCI NAME   | BRAND NAME    | CONCENTRATION [%] | FUNCTION     |
|-------|---|---------------|-------------------|--------------|
| A     | Sodium Coco Sulfate                                   | ROSulfan C/PH | 20.00             | surfactant   |
| A     | Disodium Laureth Sulfosuccinate                       | EXOsoft L3/40 | 1.00              | surfactant   |
| A     | Coco Betaine  | ROKamina K30B | 6.00              | surfactant   |
| B     | Glycerin  |               | 0.60              | active       |
| B     | Sodium Lactate  |               | 0.60              | active       |
| B     | Panthenol   |               | 0.60              | active       |
| B     | Parfum  |               | 0.25              | fragrance    |
| C     | Sodium Benzoate                                       |               | 0.40              | preservative |
| D     | Glycol Distearate, Laureth-4, Cocoamidopropyl Betaine | EXOpearl SF   | 1.00              | surfactant   |
| E     | Lactic Acid   |               | 0.30              | pH adjuster  |
| A     | Aqua  |               | 70.15             | solvent      |



|            |   |                         |
|------------|---|-------------------------|
| APPEARANCE | visual method                                     | white with pearl effect |
| pH         |   | 4.0 - 4.8               |
| VISCOSITY  | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 1000 - 5000             |
| STABILITY  | 1 month in 5°C, 20°C, 40°C                        | confirmed               |

### Procedure:

1. Add ingredients from phase A to warm water (40-45°C). Mix until homogenous solution is obtained.
2. Cool the batch down to at least 35°C.
3. Add phase B-D during mixing. Mix until homogenous solution is obtained.
4. Adjust pH by Lactic Acid to 4.0-4.5.



# SKIN CARE PRODUCTS

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**Skin Care Products** are a big group of cosmetics which are available in many different categories. Generally each skin care product like balm, moisturiser or lotion should provide to the skin sufficient nourishment as well as protection.

In the beauty market there are plenty of brands and products to choose from. Selection of the suitable product should be connected with the skin type and it's compatibility.

In terms of oily skin, light weight lotion are recommended. In case of dry, mature skin, moisturiser with a thicker consistency should be chosen. Night creams will generally be thicker than a day cream.

Skin Care Products are designed for the body to help keep the smooth of skin.



Cosmetic companies are coming up with plenty of creative products to market what is increasing the range of them. Technically, beside of their different consistency and various names, skin care products like treatment balms, nourishing hand creams, intensive moisturisers and body lotions have one common goal: to hydrate, treat and repair the dry skin. Some may have anti-aging effects, others may include skin regenerating ingredients, but in general they work to protect our skin making it more supple and smooth.

## BB CREAM [KD-77]

| PHASE | INCI NAME  | BRAND NAME          | CONCENTRATION [%] | FUNCTION          |
|-------|--|---------------------|-------------------|-------------------|
| C     | Polysorbate 60   |                     | 2.00              | emulsifier        |
|       | Cetearyl Alcohol, Ceteareth-20                             | EXOcare TE20 flakes | 2.50              | emulsifier        |
|       | Ceteareth-12   | ROKAnol T12         | 1.00              | emulsifier        |
|       | Paraffinum Liquidum  |                     | 5.00              | emollient         |
|       | Butyl Methoxydibenzoylmethane                              |                     | 3.00              | UV filter         |
|       | Octocrylene  |                     | 3.00              | UV filter         |
|       | PPG-15 Stearyl Ether                                       | ROKAnol SP15L       | 5.00              | emollient         |
| A     | Aqua   |                     | 68.316            | solvent           |
|       | Glycerin   |                     | 2.00              | solvent           |
|       | Magnesium Aluminum Silicate                                |                     | 1.00              | rheology modifier |
| B     | CI 77492, Phytic Acid, Sodium Hydroxide                    |                     | 0.11              | colorant          |
|       | CI 77499, Phytic Acid, Sodium Hydroxide                    |                     | 0.031             | colorant          |
|       | CI 77891, Phytic Acid, Sodium Hydroxide                    |                     | 1.75              | colorant          |
|       | CI 77491, Phytic Acid, Sodium Hydroxide                    |                     | 0.043             | colorant          |
| D     | Acrylates/C10-30 Alkyl Acrylate Crosspolymer               |                     | 0.15              | rheology modifier |
|       | Dimethicone  |                     | 2.00              | emollient         |
|       | Cyclopentasiloxane   |                     | 2.00              | emollient         |
| E     | Phenoxyethanol, Methylparaben, Ethylparaben, Propylparaben |                     | 1.00              | preservative      |
| F     | Sodium Hydroxide   |                     | 0.10              | pH adjuster       |



|            |                            |                |
|------------|----------------------------|----------------|
| APPEARANCE | visual method              | beige emulsion |
| pH         |                            | 5.0 - 7.0      |
| STABILITY  | 1 month at 5°C, 20°C, 40°C | confirmed      |

## Procedure:

1. In a main vessel combine ingredients from phase A. Homogenize with 2000-3000 RPM, 5 min.
2. Add phase B ingredients. Homogenize with 2000-3000 RPM, 5 min.
3. In a separate vessel combine ingredients from phase C, D.
4. Heat phase A/B and C to 75-80°C.
5. Add C into A/B while mixing, keep A/B/C at 75-80°C. Homogenize with 2000-3000 RPM, 120 sec.
6. Cool the batch down to 50°C while mixing. Add phase D ingredients while mixing. Homogenize with 2500-3500 RPM, 90 sec.
7. Cool the batch down to 30°C while mixing.
8. Add phase E and F ingredients while mixing. Homogenize with 2500-3500 RPM, 90 sec.





## EYE CREAM [KD-79]

| PHASE | INCI NAME   | BRAND NAME          | CONCENTRATION [%] | FUNCTION          |
|-------|---|---------------------|-------------------|-------------------|
| A     | Polysorbate 60  |                     | 2.00              | emulsifier        |
|       | Cetearyl Alcohol, Ceteareth-20                                | ROKAnol TE20 Flakes | 3.00              | emulsifier        |
|       | Paraffinum Liquidum   |                     | 6.00              | emollient         |
|       | Palmitic Acid   |                     | 1.00              | emollient         |
|       | Cocos Nucifera (Coconut) Oil, Hydrogenated Soy Polyglycerides |                     | 3.00              | emollient         |
|       | PPG-15 Stearyl Ether  | ROKAnol SP15L       | 5.00              | emollient         |
| B     | Aqua  |                     | 72.33             | solvent           |
|       | Allantoin   |                     | 0.10              | active            |
|       | Betaine   |                     | 4.00              | active            |
|       | Acrylates/C10-30 Alkyl Acrylate Crosspolymer                  |                     | 0.07              | rheology modifier |
| C     | Carbomer  |                     | 0.05              | rheology modifier |
|       | Dimethicone   |                     | 2.00              | emollient         |
| D     | Sodium Hydroxide  |                     | 0.05              | pH adjuster       |
| E     | Phenoxyethanol, Methylparaben, Ethylparaben, Propylparaben    |                     | 0.80              | preservative      |
| F     | Sodium Polyacrylate, Ethylhexyl Stearate, Trideceth-6         |                     | 0.60              | rheology modifier |



|            |                            |                |
|------------|----------------------------|----------------|
| APPEARANCE | visual method              | white emulsion |
| pH         |                            | 5.0 - 7.0      |
| STABILITY  | 1 month at 5°C, 20°C, 40°C | confirmed      |

## Procedure:

1. In separate vessels combine ingredients from phase A and B. NOTE! Add slowly Acrylates/C10-30 Alkyl Acrylate Crosspolymer while mixing – mix until uniform.
2. Heat up to 75-80°C phase A and B. Combine ingredients from phase C – mix until uniform.
3. Add the phase B to phase A while mixing. Mix until uniform. Homogenize 1500-2000 RPM, 90-120 s.
4. Cool the batch down to 60°C while mixing. Add phase C ingredients while mixing. Homogenize 2000-2500 RPM, 90-120 s.
5. Add phase D and E ingredients while mixing. Homogenize 2500-3000 RPM, 90-120 s. NOTE! A 30% Sodium Hydroxide solution was used.
6. Add phase E and F ingredients while mixing. Homogenize 3000-4000 RPM, 90-120 s. Cool the batch down to 25-30°C while mixing.



## BODY MILK [KD-78]

| PHASE | INCI NAME  | BRAND NAME    | CONCENTRATION [%] | FUNCTION          |
|-------|--|---------------|-------------------|-------------------|
| A     | Ceteareth-12   | ROKAnol T12   | 1.00              | emulsifier        |
|       | Ceteareth-25   | ROKAnol T25   | 1.00              | emulsifier        |
|       | Cetearyl Alcohol   | EXOalc 1618   | 2.00              | thickener         |
|       | Paraffinum Liquidum  |               | 5.00              | emollient         |
|       | Helianthus Annuus Seed Oil                                 |               | 0.50              | emollient         |
|       | PPG-15 Stearyl Ether                                       | ROKAnol SP15L | 4.00              | emollient         |
| B     | Aqua   |               | 83.85             | solvent           |
|       | Betaine  |               | 0.50              | active            |
| C     | Glycerin   |               | 1.00              | solvent           |
|       | Xanthan Gum  |               | 0.05              | rheology modifier |
| D     | Carbomer   |               | 0.25              | rheology modifier |
| E     | Sodium Hydroxide   |               | 0.05              | pH adjuster       |
| F     | Phenoxyethanol, Methylparaben, Ethylparaben, Propylparaben |               | 0.80              | preservative      |



|            |                            |                |
|------------|----------------------------|----------------|
| APPEARANCE | visual method              | white emulsion |
| pH         |                            | 5.0 - 7.0      |
| STABILITY  | 1 month at 5°C, 20°C, 40°C | confirmed      |

### Procedure:

1. In separate vessels combine ingredients from phase A, B and C.
2. Add slowly phase D ingredients to phase B while mixing. Mix until uniform.
3. Add slowly phase C ingredients to phase B while mixing. Homogenize with 2000-3000 RPM, 90 sec.
4. Heat phase A and B to 75-80°C.
5. Add A into B while mixing. keep A/B at 75-80°C. Homogenize with 2000-3000 RPM, 120 sec.
6. Cool the batch down to 50°C while mixing. Add phase E ingredients while mixing. Homogenize with 2500-3500 RPM, 90 sec.
7. Cool the batch down to 25°C. Add phase F ingredients while mixing. Homogenize with 2500-3500 RPM, 90 sec.



## BODY LOTION [KD-82]

| PHASE | INCI NAME  | BRAND NAME     | CONCENTRATION [%] | FUNCTION            |
|-------|--|----------------|-------------------|---------------------|
| A     | Cetearyl Alcohol   |                | 2.50              | emulsion stabilizer |
|       | Ceteareth-12   | ROKAnol T12    | 1.00              | emulsifier          |
|       | Petrolatum   |                | 2.00              | emollient           |
|       | Helianthus Annuus Seed Oil                                       |                | 1.00              | emollient           |
|       | PPG-15 Stearyl Ether   | ROKAnol SP15L  | 6.00              | emollient           |
|       | Glyceryl Stearate,<br>PEG-100 Stearate                           |                | 1.50              | emulsifier          |
| B     | Aqua   |                | 78.35             | solvent             |
|       | PEG-7/PPG-2  | ROKAnol GA7LAW | 1.00              | emollient           |
|       | Betaine  |                | 2.00              | active              |
|       | Glycerin   |                | 2.00              | moisturising agent  |
| C     | Carbomer   |                | 0.30              | rheology modifier   |
|       | PPG-15 Stearyl Ether   | ROKAnol SP15L  | 1.00              | emollient           |
| D     | Phenoxyethanol,<br>Methylparaben, Ethylparaben,<br>Propylparaben |                | 1.00              | preservative        |
| E     | Sodium Hydroxide   |                | 0.05              | pH adjuster         |
|       | Parfum   |                | 0.30              | fragrance           |



|            |                          |                |
|------------|--------------------------|----------------|
| APPEARANCE | visual method            | white emulsion |
| pH         |                          | 5.0 - 7.0      |
| STABILITY  | 1 month at 5°C, RT, 40°C | confirmed      |

### Procedure:

- In a separate vessel combine ingredients from phase A, B and C. Heat the phase A and B to 75-80°C.
- Add A into B, stir well with hand stirring, keep A/B at 75-80°C. Homogenize with 2000-3000 RPM, 120 sec.
- Cool the batch down to 50°C while mixing. Add ingredients from phase C and D while mixing. Homogenise with 2500-3500 RPM, 120 sec.
- Cool the batch down to 25°C. Add phase E while mixing. Homogenize with 2500-3500 RPM, 120 sec.

## BODY LOTION [RD-07]

| PHASE | INCI NAME                           | BRAND NAME         | CONCENTRATION [%] | FUNCTION     |
|-------|-------------------------------------|--------------------|-------------------|--------------|
| A     | Ceteareth-25                        | ROKAnol T25 Flakes | 2.00              | emulsifier   |
|       | Cetearyl Alcohol                    | EXOalc 1618        |                   | emulsifier   |
|       | PPG-15 Stearyl Ether                | ROKAnol SP15L MB   | 2.00              | emollient    |
| A     | C12-15 Alkyl Benzoate               | EXOsoft AB25       | 4.00              | emollient    |
| A     | Glycereth-26                        | ROKAnol G26        | 1.00              | emollient    |
| A     | Glyceryl Stearate, PEG-100 Stearate |                    | 3.00              | emulsifier   |
| B     | Aqua                                |                    | to 100.00         | solvent      |
| C     | Sodium Benzoate, Potassium sorbate  |                    | q.s.              | preservative |
| D     | Parfum                              |                    | 0.50              | fragrance    |



|            |                            |                |
|------------|----------------------------|----------------|
| APPEARANCE | visual method              | white emulsion |
| pH         |                            | 5.0 - 7.0      |
| STABILITY  | 1 month in 5°C, 20°C, 40°C | confirmed      |

### Procedure:

1. In separate vessel combine ingredients from phase A, B, C, D.
2. Heat up to 75-80°C phase A and B.
3. Add phase A components to phase B/C while mixing. Mix until uniform. Homogenize 1500-2000 RPM, 90-120 s.
4. Cool the batch down to 30°C while mixing. Add phase D ingredients while mixing. Homogenize 2000-2500 RPM, 90-120 s.
5. Cool the batch down to 20-25°C while mixing.

## GLOW BODY LOTION [KD-160]

| PHASE | INCI NAME  | BRAND NAME    | CONCENTRATION [%] | FUNCTION          |
|-------|--|---------------|-------------------|-------------------|
| A     | Allantoin  |               | 0.10              | active            |
|       | Glycerin   |               | 4.00              | solvent           |
|       | CI 77491, CI 77891, Mica   |               | 0.30              | colorant          |
|       | CI 77891, Mica   |               | 0.20              | colorant          |
| B     | Sodium Polyacrylate,<br>Ethylhexyl Stearate,<br>Trideceth-6      |               | 0.80              | rheology modifier |
| C     | PPG-15 Stearyl Ether   | ROKAnol SP15L | 3.00              | emolient          |
|       | Parfum   |               | 0.50              | fragrance         |
|       | Phenoxyethanol,<br>Methylparaben, Ethylparaben,<br>Propylparaben |               | 0.80              | preservative      |
| A     | Aqua   |               | 90.30             | solvent           |



**APPEARANCE** visual method

**pH** 5.0 - 7.0

**STABILITY**

### Procedure:

1. Combine ingredients from phase A. Mix until uniform.
2. Add B ingredients while mixing. Mix until uniform. Homogenize with 2000-3000 RPM, 120-180 sec.
3. Add phase C ingredients while mixing. Homogenize with 2000-3000 RPM, 120-180 sec.

# HAND CREAM [KD-83]

| PHASE | INCI NAME  | BRAND NAME         | CONCENTRATION [%] | FUNCTION            |
|-------|--|--------------------|-------------------|---------------------|
| A     | Cetearyl Alcohol   | EXOalc 1618 flakes | 4.00              | emulsion stabilizer |
|       | Glyceryl Stearate,<br>PEG-100 Stearate                           |                    | 2.00              | emulsifier          |
|       | Ceteareth-12   | ROKAnol T12        | 1.50              | emulsifier          |
|       | Helianthus Annuus Seed Oil                                       |                    | 1.00              | emollient           |
|       | Petrolatum   |                    | 0.50              | emollient           |
|       | Stearic Acid   |                    | 1.50              | rheology modifier   |
|       | PPG-15 Stearyl Ether   | ROKAnol SP15L      | 8.00              | emollient           |
| B     | Aqua   |                    | 58.00             | solvent             |
|       | Betaine  |                    | 2.00              | active              |
|       | Glycerin   |                    | 20.00             | solvent             |
| C     | Phenoxyethanol,<br>Methylparaben, Ethylparaben,<br>Propylparaben |                    | 1.00              | preservative        |
| D     | Parfum   |                    | 0.50              | fragrance           |



|            |                          |                |
|------------|--------------------------|----------------|
| APPEARANCE | visual method            | white emulsion |
| pH         |                          | 5.0 - 7.0      |
| STABILITY  | 1 month at 5°C, RT, 40°C | confirmed      |

## Procedure:

1. In a separate vessel combine ingredients from phase A and B.
2. Heat phase A and B to 75-80°C.
3. Add A into B while mixing, keep A/B at 75-80°C. Homogenise with 2000-3000 RPM, 120 sec.
4. Cool the batch down to 50°C while mixing. Add phase C ingredients while mixing. Homogenise with 2500-3500 RPM, 90 sec.
5. Cool the batch down to 25°C. Add phase D ingredients while mixing. Homogenise with 2500-3500 RPM, 30 sec.

# ECONOMY HAND CREAM [KD-299]

| PHASE | INCI NAME   | BRAND NAME                  | CONCENTRATION [%] | FUNCTION            |
|-------|---|-----------------------------|-------------------|---------------------|
| A     | Cetearyl Alcohol, Ceteareth-20                        | EXOcare TE20 flakes         | 3.00              | emulsion stabilizer |
|       | Paraffinum Liquidum                                   |                             | 7.00              | emollient           |
|       | Ceteareth-12  | ROKAnol T12                 | 1.50              | emulsifier          |
|       | Tocopheryl Acetate                                    |                             | 0.10              | active              |
|       | PPG-15 Stearyl Ether                                  | ROKAnol SP15L               | 2.00              | emollient           |
| B     | Aqua  |                             | to 100.00         | solvent             |
|       | Allantoin   |                             | 0.10              | active              |
|       | Glycerin  |                             | 2.00              | solvent             |
|       | Aqua, Sodium Benzoate, Potassium Sorbate              |                             | 0.70              | preservative        |
|       | Lactic Acid   | KWAS L(+)- MLEKOWY 80% E270 | 0.15              | pH adjuster         |
| C     | Dimethicone   |                             | 1.00              | emollient           |
|       | Sodium Polyacrylate, Ethylhexyl Stearate, Trideceth-6 |                             | 1.00              | rheology modifier   |
| D     | Parfum  |                             | 0.30              | fragrance           |



|            |                            |                |
|------------|----------------------------|----------------|
| APPEARANCE | visual method              | white emulsion |
| pH         |                            | 5.0 - 5.5      |
| STABILITY  | 1 month at 5°C, 20°C, 40°C | confirmed      |

## Procedure:

1. In separate vessels combine ingredients from phase A and B.
2. Heat phase A and B to 75-80°C.
3. Add phase A into phase B while mixing, keep A/B at 75-80°C. Homogenize with 2000-3000 RPM, 120 sec.
4. Cool the batch down to 50°C while mixing. Add phase C ingredients while mixing. Homogenize with 2500-3500 RPM, 90 sec.
5. Cool the batch down to 25°C. Add phase D ingredients while mixing. Homogenize with 2500-3500 RPM, 30 sec.

# NIGHT FACE CREAM [KD-84]

| PHASE | INCI NAME  | BRAND NAME         | CONCENTRATION [%] | FUNCTION            |
|-------|--|--------------------|-------------------|---------------------|
| A     | Glyceryl Stearate,<br>PEG-100 Stearate                           |                    | 2.50              | emulsifier          |
|       | Ceteareth-12   | ROKAnol T12        | 1.00              | emulsifier          |
|       | Cetearyl Alcohol   | EXOalc 1618 flakes | 2.00              | emulsion stabilizer |
|       | PPG-15 Stearyl Ether   | ROKAnol SP15L      | 4.00              | emollient           |
|       | Caprylic/Capric Triglyceride                                     |                    | 5.00              | emollient           |
|       | Stearic Acid   |                    | 1.00              | rheology modifier   |
|       | Helianthus Annuus Seed Oil                                       |                    | 2.00              | emollient           |
|       | Butyrospermum Parkii Butter                                      |                    | 1.00              | emollient           |
| B     | Aqua   |                    | 73.10             | solvent             |
|       | Betaine  |                    | 5.00              | active              |
| C     | Glycerin   |                    | 2.00              | solvent             |
|       | Xanthan Gum  |                    | 0.10              | rheology modifier   |
| D     | Acrylates/C10-30 Alkyl<br>Acrylate Crosspolymer                  |                    | 0.20              | rheology modifier   |
| E     | Phenoxyethanol,<br>Methylparaben, Ethylparaben,<br>Propylparaben |                    | 0.80              | preservative        |
|       | Sodium Hydroxide   |                    | 0.05              | pH adjuster         |
| F     | Parfum   |                    | 0.25              | fragrance           |



|            |                          |                |
|------------|--------------------------|----------------|
| APPEARANCE | visual method            | white emulsion |
| pH         |                          | 5.0 - 7.0      |
| STABILITY  | 1 month at 5°C, RT, 40°C | confirmed      |

## Procedure:

1. In a separate vessel combine ingredients from phase A and B.
2. Add slowly phase D ingredients to phase B while mixing. Mix until uniform.
3. In a separate vessel combine ingredients from phase C. Mix until uniform. Add slowly phase C ingredients to phase B while mixing. Homogenise with 2000-3000 RPM, 90 sec.
4. Heat phase A and B to 75-80°C.
5. Add A into B while mixing, keep A/B at 75-80°C. Homogenise with 2000-3000 RPM, 120 sec.
6. Cool the batch down to 50°C while mixing. Add phase E ingredients while mixing. Homogenise with 2500-3500 RPM, 90 sec.
7. Cool the batch down to 25°C. Add phase F ingredients while mixing. Homogenise with 2500-3500 RPM, 120 sec.



# NIGHT CREAM [KD-89]

| PHASE | INCI NAME   | BRAND NAME          | CONCENTRATION [%] | FUNCTION          |
|-------|---|---------------------|-------------------|-------------------|
| A     | Glycerin  |                     | 4.00              | solvent           |
|       | Allantoin   |                     | 0.10              | active            |
| B     | Ceteareth-12  | ROKAnol T12         | 2.00              | emulsifiers       |
|       | Ceteareth-25,<br>Cetearyl Alcohol                                   | EXOcare TE25 Flakes | 3.50              | emulsifiers       |
|       | Palmitic Acid   |                     | 2.00              | rheology modifier |
|       | Butyrospermum Parkii<br>Butter                                      |                     | 1.00              | emollient         |
|       | Paraffinum Liquidum   |                     | 10.00             | emollient         |
|       | PPG-15 Stearyl Ether  | ROKAnol SP15L       | 4.00              | emollient         |
| C     | Dimethicone   |                     | 2.00              | emollient         |
| C     | Helianthus Annuus Seed Oil  |                     | 2.00              | emollient         |
| D     | Phenoxyethanol,<br>Methylparaben,<br>Ethylparaben,<br>Propylparaben |                     | 0.80              | preservative      |
| E     | Sodium Polyacrylate,<br>Ethylhexyl Stearate,<br>Trideceth-6         |                     | 0.85              | rheology modifier |
| A     | Aqua  |                     | 67.75             | solvent           |



## APPEARANCE

pH

5.0 - 7.0

## STABILITY

## Procedure:

1. In a main vessel combine ingredients from phase A – mix until uniform.
2. In a separate vessel prepare phase C – mix until uniform.
3. Add ingredients from phase B - E – mix until uniform.
4. Add slowly Coco Betaine while mixing. Mix until uniform.







# FACE CARE PRODUCTS

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**Face Care Products** are basic care cosmetics for every woman. Facial skin is our business card, that is why we should take care of it as best as possible. Today's Face Care Cosmetics are multi-tasking, but they also meet the needs of skin living under strong oxidative stress, which can lead to loss of collagen and elastin. There are many types of Face Care products, so it's worth knowing their purpose and application.

Selecting the best quality ingredients provides gentle, moisturizing, anti-wrinkle properties delivered to the skin.



Face Care products should first and foremost be chosen according to the needs of the skin and age. Currently, the use of multifunctional face care cosmetics which are suitable for day and night use is moving away.

During the day, our skin has different needs than at night, hence the need to use a different day and night care products. The face care products for the day have a protective function against harmful external factors. The consistency of the day cosmetic is much lighter than the night one. Many day cosmetics also have a small UV filter that protects from sunlight. The night cosmetic is designed to regenerate and nourish the face. The skin regenerates quickly at night, which is why the cosmetic applied during the evening care ritual should contain many nutrients.

## DEEPLY CLEANSING GEL FOR SKIN FACE [ST-02]

| PHASE | INCI NAME  | BRAND NAME   | CONCENTRATION [%] | FUNCTION           |
|-------|--|--------------|-------------------|--------------------|
| A     | Aqua   |              | 49.00             | solvent            |
|       | Acrylates/C10-30 Alkyl Acrylate Crosspolymer         |              | 1.00              | viscosity modifier |
| B     | Aqua   |              | 14.00             | solvent            |
|       | Sodium Lauroyl Glycinate                             | ROKAtend GL  | 10.00             | surfactant         |
|       | Sodium Lauroyl Sarcosinate                           | ROKAtend LS  | 20.00             | surfactant         |
|       | Cocamidopropyl Betaine                               | ROKAmina K30 | 3.40              | surfactant         |
| C     | Parfum   |              | 0.40              | fragrance          |
|       | Propylene Glycol                                     |              | 1.00              | solvent            |
|       | Benzyl Alcohol,<br>Ethylhexylglycerin,<br>Tocopherol |              | 1.00              | preservative       |
| D     | Sodium Hydroxide                                     |              | 0.20              | pH modifier        |



|                |   |   |
|----------------|---|---|
| APPEARANCE     | visual method                                     | clear, viscous gel with suspended air bubbles |
| pH             |   | 5.5 - 6.5                                     |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 15000 - 20000                                 |
| STABILITY      | 1 month st 5°C, RT, 40°C                          | confirmed                                     |

### Procedure:

- Pour the warm deionized water (40-50°C) in to the main vessel and add the Acrylates/C10-30 Alkyl Acrylate Crosspolymer. Start mixing when the polymer is completely wetted. Mix until the homogenous solution is obtained.
- Combine ingredients from phase B in a separate vessel. Heat up to 60°C with gentle agitation. Mix until homogenous solution is obtained.
- Add phase B to phase A. Mix until homogenous solution is obtained. Cool the batch down to 30°C.
- When the batch temperature is around 30°C, add preservative, Propylene Glycol and fragrance. Mix for 20 minutes with slow agitation.
- Readjust the final pH to 5.5 - 6.5 with addition of Sodium Hydroxide (30%) if necessary.



## MILD EMULSION FOR SKIN FACE [ST-03]

| PHASE | INCI NAME  | BRAND NAME  | CONCENTRATION [%] | FUNCTION           |
|-------|--|-------------|-------------------|--------------------|
| A     | Paraffinum Liquidum  |             | 1.50              | emollient          |
|       | Butyrospermum Parkii<br>(Shea Butter)                            |             | 0.50              | emollient          |
|       | Caprylic/Capric Triglyceride                                     |             | 1.00              | emollient          |
|       | Glyceryl Stearate,<br>PEG-100 Stearate                           |             | 3.00              | emulsifier         |
|       | Cetearyl Alcohol   |             | 2.50              | co-emulsifier      |
| B     | Aqua   |             | 25.30             | solvent            |
| C     | Xanthan Gum  |             | 0.40              | viscosity modifier |
|       | Glycerin   |             | 1.30              | moisturising agent |
|       | Aqua   |             | 50.20             | solvent            |
| D     | Citric Acid  |             | 0.10              | pH modifier        |
|       | Sodium Lauroyl Glycinate   | ROKAtend GL | 5.00              | surfactant         |
|       | Sodium Lauroyl Sarcosinate                                       | ROKAtend LS | 7.70              | surfactant         |
|       | Parfum   |             | 0.50              | fragrance          |
|       | Phenoxyethanol,<br>Methylparaben, Ethylparaben,<br>Propylparaben |             | 1.00              | preservative       |



|                |   |                |
|----------------|---|----------------|
| APPEARANCE     | visual method                                     | white emulsion |
| pH             |   | 6.5 - 7.5      |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 6.0 RPM, T: 25°C | 5000 - 10000   |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed      |

### Procedure:

1. In a main vessel heat all ingredients to 75-80°C and do the same with phase B.
2. Pour the hot water from phase B into phase A, mix well (avoid cooling) and homogenise for 5 minutes. Then, start cooling the formulation and repeat homogenization at 60°C. Do the same at 40°C.
3. At the same time, prepare phase C by mixing Xanthan Gum, Glycerin and warm water (50°C). To obtain homogenous solution, homogenize for 1 min.
4. Combine ingredients from the phase D and mix until uniform. If necessary, add Citric Acid.
5. Add phase D and B to main vessel (phase A) and mix for 5 min, then homogenise for 1 min.

## FOAMING FACE WASH [ST-04]

| PHASE | INCI NAME                               | BRAND NAME     | CONCENTRATION [%] | FUNCTION           |
|-------|---|----------------|-------------------|--------------------|
| A     | Aqua                                    |                | 48.20             | solvent            |
|       | PEG-7 Glyceryl Cocoate                  | ROKAcet KO300G | 1.50              | re-oiling agent    |
|       | Glycerin                                |                | 1.00              | moisturising agent |
|       | Sodium Lauroyl Sarcosinate              | ROKAtend LS    | 34.70             | surfactant         |
|       | Cocamidopropyl Betaine                  | ROKAmina K30K  | 9.70              | surfactant         |
|       | Parfum                                  |                | 0.50              | fragrance          |
|       | Ethylhexyl Glycerine,<br>Phenoxyethanol |                | 1.00              | preservative       |
|       | Propylene Glycol                        |                | 2.50              | solvent            |
|       | Cocamide DEA                            | ROKAmid KAD    | 0.50              | surfactant         |
|       | Citric acid                             |                | 0.40              | pH modifier        |



|                   |                          |                         |
|-------------------|--------------------------|-------------------------|
| <b>APPEARANCE</b> | visual method            | clear, colorless liquid |
| <b>pH</b>         |                          | 6.0 - 7.5               |
| <b>STABILITY</b>  | 1 month st 5°C, RT, 40°C | confirmed               |

### Procedure:

1. Add ingredients from phase A to the warm water (40-50°C). Mix until uniform.
2. Then, cool the mixture down to room temperature before adding a preservative and add the rest of ingredients.
3. Control the pH range – if necessary, add Citric Acid. Mix well after adjustment.

## TWO PHASE FOAMING FACE WASH [ST-05]

| PHASE | INCI NAME                               | BRAND NAME     | CONCENTRATION [%] | FUNCTION        |
|-------|---|----------------|-------------------|-----------------|
| A     | Aqua                                    |                | 38.40             | solvent         |
|       | Sodium Lauroyl Glycinate                | ROKAtend GL    | 10.00             | surfactant      |
|       | Sodium Lauroyl Sarcosinate              | ROKAtend LS    | 30.00             | surfactant      |
|       | Propylene Glycol                        |                | 3.00              | solvent         |
|       | Parfum                                  |                | 0.60              | fragrance       |
|       | Ethylhexyl Glycerine,<br>Phenoxyethanol |                | 1.00              | preservative    |
|       | PEG-7 Glyceryl Cocoate                  | ROKAcet KO300G | 1.60              | re-oiling agent |
|       | Mineral Oil                             |                | 15.00             | emollient       |
|       | Citric Acid                             |                | 0.40              | pH modifier     |



|                   |                          |                                      |
|-------------------|--------------------------|--------------------------------------|
| <b>APPEARANCE</b> | visual method            | clear colorless liquid (water phase) |
| <b>pH</b>         |                          | 6.0 - 7.5 (water phase)              |
| <b>STABILITY</b>  | 1 month at 5°C, RT, 40°C | confirmed                            |

### Procedure:

1. Add ingredients from phase A to the warm water (40-50°C). Mix until uniform.
2. Then, cool the mixture down to room temperature before adding a preservative and add the rest of ingredients.
3. Control the pH range – if necessary, add Citric Acid. Mix well after adjustment.
4. Add Sodium Chloride to adjust the viscosity. NOTE. Add salt (not in one go) – after addition of each portion mix well.

## MILD PEARLING GEL FOR SKIN FACE [ST-06]

| PHASE | INCI NAME   | BRAND NAME   | CONCENTRATION [%] | FUNCTION           |
|-------|---|--------------|-------------------|--------------------|
| A     | Aqua  |              | 45.90             | solvent            |
|       | Xanthan Gum   |              | 0.65              | viscosity modifier |
|       | Glycerin  |              | 2.00              | moisturising agent |
|       | Sodium Benzoate,<br>Potassium Sorbate                         |              | 0.60              | preservative       |
| B     | Aqua  |              | 15.70             | solvent            |
|       | Magnesium Laureth Sulfate                                     | EXOsoft MGB  | 20.00             | surfactant         |
|       | Sodium Lauroyl Sarcosinate                                    | ROKAtend LS  | 10.00             | surfactant         |
|       | Cocamidopropyl Betaine  | ROKAmina K30 | 3.40              | surfactant         |
| C     | Citric Acid   |              | 0.25              | pH modifier        |
|       | Sodium Laureth Sulfate,<br>Cocamide DEA,<br>Glycol Distearate | EXOpearl N   | 1.00              | pearling agent     |
|       | Parfum  |              | 0.50              | fragrance          |



|                |   |                      |
|----------------|---|----------------------|
| APPEARANCE     | visual method                                     | viscous pearling gel |
| pH             |   | 4.8 - 5.5            |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 4.0 RPM, T: 25°C | 6000 - 9000          |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed            |

### Procedure:

1. In a main vessel combine ingredients from phase A. Add Xanthan Gum to Glycerin - mix until homogenous solution is obtained. Add warm water (40-50°C) and preservative. Mix until homogenous solution is obtained. Homogenise for 2-3 minutes.
2. Combine ingredients from phase B. Add ingredients from phase B to warm water (40-45°C). Mix until homogenous solution is obtained.
3. Add phase B to phase A. Mix until homogenous solution is obtained. Cool the batch down to 30°C.
4. Adjust pH to 4.8 – 5.5 by using Citric Acid. Mix well after adjustment.
5. Add ingredients from phase C. Mix until homogenous solution is obtained.



## MILD GEL TO SKIN FACE WASHING [KD-61]

| PHASE | INCI NAME                                    | BRAND NAME     | CONCENTRATION [%] | FUNCTION           |
|-------|--|----------------|-------------------|--------------------|
| A     | Aqua   |                | 50.00             | solvent            |
|       | Acrylates/C10-30 Alkyl Acrylate Crosspolymer |                | 0.85              | rheology modifier  |
| B     | Aqua   |                | up to 100         | solvent            |
|       | Disodium Laureth Sulfosuccinate              | EXOsoft L3/40  | 5.00              | surfactant         |
|       | Cocamidopropyl Betaine                       | ROKAmina K30   | 6.00              | surfactant         |
|       | Betaine                                      |                | 1.00              | active             |
|       | Glycerin                                     |                | 1.00              | moisturising agent |
|       | PEG-7 Glyceryl Cocoate                       | ROKAcet KO300G | 0.50              | surfactant         |
|       | CI 42090                                     |                | q.s.              | colorant           |
|       | Benzophenone-4                               |                | 0.05              | UV filter          |
| C     | Phenoxyethanol, Ethylhexylglycerin           |                | 1.00              | preservative       |
|       | Parfum                                       |                | 0.30              | fragrance          |
|       | Sodium Hydroxide                             |                | 0.50              | pH adjuster        |



|                   |                          |  |
|-------------------|--------------------------|--|
| <b>APPEARANCE</b> | visual method            | clear, blue viscous gel with suspended air bubbles |
| <b>pH</b>         |                          | 5.0 - 6.0  |
| <b>STABILITY</b>  | 1 month at 5°C, RT, 40°C | confirmed  |

### Procedure:

1. Pour the warm deionized water (40-50°C) in to the main vessel and add the Acrylates/C10-30 Alkyl Acrylate Crosspolymer. Start mixing when the polymer is completely wetted. Mix until the homogenous solution is obtained.
2. Combine ingredients from phase B in a separate vessel. Heat up to 30°C with gentle agitation. Mix until homogenous solution is obtained.
3. Add phase B to phase A. Mix until homogenous solution is obtained. Cool the batch down to 30°C.
4. When the batch temperature is 30°C, add preservative, fragrance and Sodium Hydroxide. Mix for 20 minutes with slow agitation.
5. Readjust the final pH to 5.0 – 6.0 with addition of Sodium Hydroxide (30%) if necessary.

## GEL FOR WASHING SKIN FACE [KD-62]

| PHASE | INCI NAME                                    | BRAND NAME               | CONCENTRATION [%] | FUNCTION           |
|-------|--|--------------------------|-------------------|--------------------|
| A     | Acrylates/C10-30 Alkyl Acrylate Crosspolymer |                          | 0.90              | rheology modifier  |
|       | Aqua   |                          | 40.00             | solvent            |
| B     | Aqua   |                          | up to 100         | solvent            |
|       | Sodium Laureth Sulfate                       | SULFOROKAnol L270/1      | 7.00              | surfactant         |
|       | Magnesium Laureth Sulfate                    | EXOsoft MG / EXOsoft MGB | 4.00              | surfactant         |
|       | Betaine                                      |                          | 2.00              | active             |
|       | PEG-75 Lanolin                               | ROKAnol LN75/50          | 1.00              | surfactant         |
|       | Glycerin                                     |                          | 1.00              | moisturising agent |
|       | CI 17200                                     |                          | q.s.              | colorant           |
|       | Benzophenone-4                               |                          | 0.05              | UV filter          |
| C     | Phenoxyethanol, Ethylhexylglycerin           |                          | 1.00              | preservative       |
|       | Parfum                                       |                          | 0.30              | fragrance          |
|       | Cocamidopropyl Betaine                       | ROKAmina K30             | 3.00              | surfactant         |
| D     | Sodium Hydroxide                             |                          | q.s               | pH adjuster        |



|                |   |               |
|----------------|---|---------------|
| APPEARANCE     | visual method                                     | pink gel      |
| pH             |   | 5.0 - 6.0     |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 18000 - 22000 |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed     |

### Procedure:

1. Pour the deionized water (25-30°C) into the main vessel and add the Acrylates/C10-30 Alkyl Acrylate Crosspolymer. Start mixing when the polymer is completely wetted. Mix until the homogenous solution is obtained. Homogenise for 1-2 minutes.
2. Combine ingredients from phase B in a separate vessel. Heat up to 40-45°C with gentle agitation. Mix until homogenous solution is obtained.
3. Add slowly phase B to phase A while mixing. Mix until uniform.
4. Add Preservative, Cocamidopropyl Betaine and Parfum while mixing. Mix until uniform.

## CREAMY FACE SCRUB [KD-91]

| PHASE | INCI NAME  | BRAND NAME         | CONCENTRATION [%] | FUNCTION            |
|-------|--|--------------------|-------------------|---------------------|
| A     | Ceteareth-12   | ROKAnol T12        | 1.50              | emulsifier          |
|       | Ceteareth-25   | ROKAnol T25        | 0.50              | emulsifier          |
|       | Cetearyl Alcohol   | EXOalc 1618 flakes | 3.00              | emulsion stabilizer |
|       | PPG-15 Stearyl Ether                                       | ROKAnol SP15L      | 6.00              | emollient           |
|       | Caprylic/Capric Triglyceride                               |                    | 1.00              | emollient           |
|       | Helianthus Annuus Seed Oil                                 |                    | 5.00              | emollient           |
|       | Butyrospermum Parkii Butter                                |                    | 0.50              | emollient           |
|       | Tocopheryl Acetate   |                    | 0.20              | active              |
| B     | Aqua   |                    | 73.68             | solvent             |
|       | Betaine  |                    | 1.00              | active              |
|       | Glycerin   |                    | 4.00              | solvent             |
|       | Pentylene Glycol   |                    | 2.00              | solvent             |
|       | Magnesium Aluminum Silicate                                |                    | 0.10              | rheology modifier   |
| C     | Acrylates/C10-30 Alkyl Acrylate Crosspolymer               |                    | 0.27              | rheology modifier   |
| D     | Phenoxyethanol, Methylparaben, Ethylparaben, Propylparaben |                    | 0.50              | preservative        |
|       | Sodium Hydroxide   |                    | 0.10              | pH adjuster         |
| E     | Parfum   |                    | 0.30              | fragrance           |
|       | Cellulose acetate  |                    | 0.35              | abrasive            |



|            |                          |                               |
|------------|--------------------------|-------------------------------|
| APPEARANCE | visual method            | emulsion with scrub particles |
| pH         |                          | 5.0 - 7.0                     |
| STABILITY  | 1 month at 5°C, RT, 40°C | confirmed                     |

## Procedure:

1. In a main vessel combine ingredients from the phase B. Add Pentylene Glycol, Glycerin, Betaine to the water. Add Magnesium Aluminum Silicate while mixing. Mix for 10 min - 150-200 RPM. Homogenise with 2000-3000 RPM, 5-6 min.
2. Add Acrylates/C10-30 Alkyl Acrylate Crosspolymer while mixing. Mix for 10 min - 100-150 RPM. Homogenise with 700-1000 RPM, 60-90 sec.
3. In a separate vessel combine ingredients from phase A.
4. Heat phase A and B to 75-80°C.
5. Add A into B, while mixing, keep A/B at 75-80°C. Homogenise with 2000-3000 RPM, 120 sec.
6. Cool the batch down to 50°C while mixing. Add phase D ingredients while mixing. Homogenise with 2500-3000 RPM, 120 sec.
7. Cool the batch down to 25°C while mixing.
8. Add Parfum and abrasive while mixing. Mix until uniform.



## ZINC FACE WASH GEL [KD-67]

| PHASE | INCI NAME                             | BRAND NAME          | CONCENTRATION [%] | FUNCTION     |
|-------|---------------------------------------|---------------------|-------------------|--------------|
| A     | Zinc Coceth Sulfate                   | EXOsoft ZN          | 8.00              | surfactant   |
| A     | Sodium Laureth Sulfate                | SULFOROKAnol L227/1 | 4.00              | surfactant   |
| A     | Phenoxyethanol,<br>Ethylhexylglycerin |                     | 0.80              | preservative |
| A     | Allantoin                             |                     | 0.10              | active       |
| A     | Betaine                               |                     | 0.50              | active       |
| B     | PEG-120 Methyl<br>Glucose Dioleate    |                     | 1.00              | thickener    |
| C     | Parfum                                |                     | 0.25              | fragrance    |
| C     | Polysorbate 20                        | ROKwinol 20         | 0.25              | surfactant   |
| D     | CI 42090                              |                     | 0.0001            | colorant     |
| D     | CI 19140                              |                     | 0.0055            | colorant     |
| E     | Lactic Acid                           |                     | 0.05              | pH adjuster  |
| F     | Coco-Betaine                          | ROKAmina K30B       | 7.00              | surfactant   |
| A     | Aqua                                  |                     | 78.00             | solvent      |



|                |   |                        |
|----------------|---|------------------------|
| APPEARANCE     | visual method                                     | slightly gray emulsion |
| pH             |   | 4.5 - 5.2              |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 1500 - 5000            |

### Procedure:

1. In a main vessel combine ingredients from phase A – mix until uniform.
2. In a separate vessel prepare phase C – mix until uniform.
3. Add ingredients from phase B - E – mix until uniform.
4. Add slowly Coco Betaine while mixing. Mix until uniform.

## FACE MASK [KD-120]

| PHASE | INCI NAME  | BRAND NAME         | CONCENTRATION [%] | FUNCTION            |
|-------|--|--------------------|-------------------|---------------------|
| A     | Ceteareth-12   | ROKAnol T12        | 2.00              | emulsifier          |
|       | Ceteareth-25   | ROKAnol T25        | 0.50              | emulsifier          |
|       | Cetearyl Alcohol   | EXOalc 1618 flakes | 3.00              | emulsion stabilizer |
|       | PPG-15 Stearyl Ether                                       | ROKAnol SP15L      | 5.00              | emollient           |
|       | Caprylic/Capric Triglyceride                               |                    | 5.00              | emollient           |
|       | Glycine Soja Oil   |                    | 2.50              | emollient           |
|       | Stearic Acid   |                    | 1.00              | rheology modifier   |
| B     | Tocopheryl Acetate   |                    | 0.50              | active              |
|       | Butyrospermum Parkii Butter                                |                    | 1.00              | emollient           |
|       | Aqua   |                    | 71.50             | solvent             |
|       | Pentylene Glycol   |                    | 2.50              | solvent             |
|       | Betaine  |                    | 1.00              | active              |
| C     | Magnesium Aluminum Silicate                                |                    | 1.00              | rheology modifier   |
|       | Kaolin   |                    | 3.00              | absorbent           |
|       | Phenoxyethanol, Methylparaben, Ethylparaben, Propylparaben |                    | 0.50              | preservative        |



|                   |                          |                        |
|-------------------|--------------------------|------------------------|
| <b>APPEARANCE</b> | visual method            | slightly gray emulsion |
| <b>pH</b>         |                          | 5.0 - 7.0              |
| <b>STABILITY</b>  | 1 month at 5°C, RT, 40°C | confirmed              |

## Procedure:

- In a main vessel combine ingredients from the phase B. Add Pentylene Glycol, Betaine to the water. Add Magnesium Aluminum Silicate while mixing. Homogenise with 2000-3000 RPM, 5-6 min.
- In a separate vessel combine ingredients from the phase A.
- Heat phase A and B to 75-80°C.
- Add A into B, while mixing, keep A/B at 75-80°C. Homogenise with 2000-3000 RPM, 120 sec.
- Cool the batch down to 50°C while mixing. Add phase C ingredients while mixing. Homogenise with 2500-3500 RPM, 120 sec.
- Cool the batch down to 25°C.

# GEL WITH SCRUB FOR WASHING AND MASSAGING THE FACE AND BODY [RD-20]

| PHASE | INCI NAME                                   | BRAND NAME           | CONCENTRATION [%] | FUNCTION     |
|-------|---|----------------------|-------------------|--------------|
| B     | MIPA Laureth Sulfate (and) Propylene Glycol | SULFOROKAnol L390/1M | 5.000             | surfactant   |
| B     | Cocamidopropyl Betaine                      | ROKAmina K30         | 6.000             | surfactant   |
| B     | Sodium Lauroyl Sarcosinate                  | ROKAtend LS          | 1.000             | surfactant   |
| B     | Disodium Laureth Sulfosuccinate             | EXOsoft L3/40        | 0.5               | surfactant   |
| A     | Glycerin                                    |                      | 3.000             | active       |
| A     | Sclerotium gum (and) Xanthan gum            |                      | 2.000             | thickener    |
| C     | Parfum                                      |                      | 0.500             | fragrance    |
|       | Jojoba Esters                               |                      | 0.500             | peeling      |
| A     | CI 47005                                    |                      | 0.010             | pigment      |
| A     | Sodium Benzoate                             |                      | 0.400             | preservative |
|       | Citric Acid                                 |                      | 0.100             | pH adjuster  |
| A     | Aqua  |                      | 80.900            | solvent      |



|                   |                            |                        |
|-------------------|----------------------------|------------------------|
| <b>APPEARANCE</b> | visual method              | green gel with peeling |
| <b>pH</b>         |                            | 5.5 - 5.8              |
| <b>STABILITY</b>  | 1 month in 5°C, 20°C, 40°C | confirmed              |

## Procedure:

1. Add ingredients from phase A to water. Mix until homogenous solution is obtained.
2. Add phase B during mixing to phase A. Mix until homogenous solution is obtained.
3. Add ingredients from phase C to the main mixer and mix.
4. Add balls.
5. Adjust pH by Citric Acid to 5.5-5.8.

## FACE WASH MOUSSE WITH ZINC [RD-23]

| PHASE | INCI NAME                 | BRAND NAME   | CONCENTRATION [%] | FUNCTION     |
|-------|---------------------------|--------------|-------------------|--------------|
| A     | Sodium Cocoyl Isethionate |              | 14.00             | surfactant   |
| A     | Zinc Coceth Sulfate       | EXOsoft ZN   | 1.20              | surfactant   |
| A     | Cocoaminopropyl Betaine   | ROKamina K30 | 2.00              | surfactant   |
| B     | Glycerin                  |              | 18.00             | active       |
| B     | Sorbitol                  |              | 10.00             | active       |
| B     | Allantoin                 |              | 1.00              | active       |
| C     | Parfum                    |              | 0.20              | fragrance    |
| C     | CI 45100                  |              | 0.002             | dye          |
| C     | CI 42090                  |              | 0.001             | dye          |
| D     | Sodium Benzoate           |              | 0.50              | preservative |
| D     | Potassium Sorbate         |              | 0.30              | preservative |
| E     | Lactic Acid               |              | 0.30              | pH adjuster  |
| A     | Aqua                      |              | 52.50             | solvent      |



|                   |                            |              |
|-------------------|----------------------------|--------------|
| <b>APPEARANCE</b> | visual method              | purple paste |
| <b>pH</b>         |                            | 5.0 - 5.5    |
| <b>STABILITY</b>  | 1 month in 5°C, 20°C, 40°C | confirmed    |

### Procedure:

1. Add ingredients from phase A to warm water (40-45°C). Mix until homogenous solution is obtained.
2. Cool the batch down to at least 35°C.
3. Add phase B during mixing. Mix until homogenous solution is obtained.
4. Add phase C-E ingredients while mixing – mix until uniform.
5. Adjust pH by Lactic Acid to 5.0-5.5.







# MAKE UP REMOVERS & MICELLAR FLUIDS

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**Eye Make-up Remover and micellar fluid** products are intended to help easily remove make-up that has been applied. They help to remove the applied color and to make sure it easily wipes off using a tissue.

Ideally, we should remove our make-up not only before going to bed but refresh it after wake up. In the morning, it helps to get rid of perspiration and sebum accumulated on the skin overnight.



Makeup removal should be part of our daily skin care ritual because it is healthy for skin.

**The specific benefits of make-up removers are:**

- washes away cosmetics, impurities and dirt from the surface of our skin, which could lead to irritation or cause our skin to age more rapidly
- reduces the risk of developing pimples, redness, blackheads and other types of blemishes
- promotes cellular renewal by eliminating dead skin
- stimulates skin's microcirculation due to the massage action
- lets our skin breathe

# CLEANSING LOTION [KD-348]

| PHASE | INCI NAME                                      | BRAND NAME         | CONCENTRATION [%] | FUNCTION            |
|-------|--|--------------------|-------------------|---------------------|
| A     | Aqua   |                    | to 100.00         | solvent             |
|       | Benzyl Alcohol, Ethylhexylglycerin, Tocopherol |                    | 0.60              | preservative        |
|       | Sclerotium Gum, Xanthan Gum                    |                    | 0.25              | rheology modifier   |
|       | Lactic Acid                                    |                    | 0.20              | pH adjuster         |
| B     | Helianthus Annuus Seed Oil                     |                    | 6.00              | emollient           |
|       | Cetearyl Alcohol                               | ExoAlc 1618 flakes | 3.50              | emulsion stabilizer |
|       | Polysorbate 80                                 | ROKwinol 80        | 3.00              | emulsifiers         |
|       | PPG-15 Stearyl Ether                           | ROKAnol SP15       | 6.00              | emollient           |
|       | PPG-5-Ceteth-20                                | ROKAnol LP6066     | 2.00              | emollient           |
| C     | Potassium Cocoate                              | EXOsoft PC35       | 2.00              | surfactant          |
|       | Potassium Oleate                               | EXOsoft PO30       | 3.00              | surfactant          |



|            |                          |           |
|------------|--------------------------|-----------|
| APPEARANCE | visual method            | emulsion  |
| pH         |                          | 7.5 - 8.5 |
| STABILITY  | 1 month at 5°C, RT, 40°C | confirmed |

## Procedure:

1. In a main vessel combine ingredients from the phase A. Heat phase A to 75-80°C while mixing.
2. In a separate vessel combine ingredients from the phase B.
3. Heat phase B to 75-80°C.
4. Add B into A, stir well, keep A/B at 75-80°C. Homogenize with 2000-3000 RPM, 90 sec.
5. Cool the batch down to 30°C while mixing.
6. Add EXOsoft PC35, EXOsoft PO30 – mix until uniform.

## MICELLAR EMULSION [KD-86.1]

| PHASE | INCI NAME             | BRAND NAME         | CONCENTRATION [%] | FUNCTION            |
|-------|-----------------------|--------------------|-------------------|---------------------|
| A     | Aqua                  |                    | to 100.00         | solvent             |
|       | Methylparaben         |                    | 0.25              | preservative        |
|       | Ethylparaben          |                    | 0.25              | preservative        |
|       | Glycerin              |                    | 0.20              | solvent             |
|       | Cetearyl Alcohol      | EXOalc 1618 flakes | 2.40              | emulsion stabilizer |
|       | Stearic Acid          |                    | 0.30              | rheology modifier   |
|       | Sodium Lauryl Sulfate | ROSULfan L         | 1.50              | surfactant          |



|            |                          |                |
|------------|--------------------------|----------------|
| APPEARANCE | visual method            | white emulsion |
| pH         |                          | 5.0 - 7.0      |
| STABILITY  | 1 month at 5°C, RT, 40°C | confirmed      |

### Procedure:

1. In a main vessel combine ingredients. Heat to 75-80°C while mixing. Homogenize with 800-1200 RPM, 90 sec.
2. Cool the batch down to 50°C while mixing. Homogenize with 800-1200 RPM, 60 sec.
3. Cool the batch down to 25°C while mixing. Homogenize with 800-1200 RPM, 30 sec.



## MICELLAR CLEANSING FLUID [DEM-01]

| PHASE | INCI NAME                          | BRAND NAME     | CONCENTRATION [%] | FUNCTION           |
|-------|------------------------------------|----------------|-------------------|--------------------|
| A     | Aqua                               |                | 85.46             | solvent            |
|       | PEG-7/PPG-2 Propylheptyl Ether     | ROKAnol GA7LAW | 3.00              | surfactant         |
|       | PEG-40 Hydrogenated Castor Oil     | ROKAcet HR40   | 4.00              | surfactant         |
|       | Glycerin                           |                | 1.00              | moisturising agent |
|       | Propylene Glycol                   |                | 6.00              | solvent            |
|       | Parfum                             |                | 0.50              | fragrance          |
|       | Sodium Benzoate, Potassium Sorbate |                | 0.50              | preservative       |
|       | Citric Acid                        |                | 0.04              | pH modifier        |



|                   |                          |                        |
|-------------------|--------------------------|------------------------|
| <b>APPEARANCE</b> | visual method            | clear colorless liquid |
| <b>pH</b>         |                          | 4.8 - 5.5              |
| <b>STABILITY</b>  | 1 month at 5°C, RT, 40°C | confirmed              |

### Procedure:

1. Heat up the water to 40-50°C and add the ingredients one after another in order from the table above.
2. Before adding a parfum cool down the mixture to room temperature and add the rest of ingredients.
3. Add Citric Acid if necessary.

## MAKE-UP REMOVING LIQUID [KD-70]

| PHASE | INCI NAME                             | BRAND NAME  | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|-------------|-------------------|--------------------|
| A     | Aqua                                  |             | 92.85             | solvent            |
|       | Betaine                               |             | 0.10              | active             |
|       | Glycerin                              |             | 3.00              | moisturising agent |
|       | Citric Acid                           |             | 0.05              | pH adjuster        |
|       | Sodium Lauroyl Sarcosinate            | ROKAtend LS | 2.00              | surfactant         |
| B     | Phenoxyethanol,<br>Ethylhexylglycerin |             | 1.00              | preservative       |
|       | Propylene Glycol                      |             | 1.00              | solvent            |



|            |                          |                    |
|------------|--------------------------|--------------------|
| APPEARANCE | visual method            | transparent liquid |
| pH         |                          | 5.0 - 7.0          |
| STABILITY  | 1 month at 5°C, RT, 40°C | confirmed          |

### Procedure:

1. In a main vessel combine ingredients from phase A and heat up to 65-70°C.
2. Combine ingredients from phase B in a separate vessel and mix until uniform.
3. Cool the batch down to at least 50°C while mixing.
4. Add phase B to phase A and mix well.
5. Cool the batch down to at least 30°C while mixing.

## MAKE-UP REMOVING LIQUID [KD-71]

| PHASE | INCI NAME                             | BRAND NAME  | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|-------------|-------------------|--------------------|
| A     | Aqua                                  |             | 92.94             | solvent            |
|       | Betaine                               |             | 0.25              | active             |
| B     | Glycerin                              |             | 1.00              | moisturising agent |
|       | Xanthan Gum                           |             | 0.05              | rheology modifier  |
| C     | Sodium Lauroyl Sarcosinate            | ROKAtend LS | 4.00              | surfactant         |
| D     | Polysorbate 20                        | ROKwinol 20 | 0.20              | surfactant         |
|       | Phenoxyethanol,<br>Ethylhexylglycerin |             | 1.00              | preservative       |
|       | Propylene Glycol                      |             | 0.50              | solvent            |
| E     | Citric Acid                           |             | 0.06              | pH adjuster        |



|            |                          |                    |
|------------|--------------------------|--------------------|
| APPEARANCE | visual method            | transparent liquid |
| pH         |                          | 5.0 - 6.5          |
| STABILITY  | 1 month at 5°C, RT, 40°C | confirmed          |

### Procedure:

1. In a main vessel combine ingredients from phase A and heat up to 65-70°C.
2. Add Xanthan Gum to Glycerin - mix until uniform. Add phase B to phase A while mixing. Mix until uniform.
3. Cool the batch down to at least 50°C.
4. Combine ingredients from phase D in a separate vessel and mix until uniform.
5. Add ingredients from phase C, D and E to phase A while mixing. Mix until uniform.



## MAKE-UP REMOVING LIQUID [KD-72]

| PHASE | INCI NAME                  | BRAND NAME  | CONCENTRATION [%] | FUNCTION           |
|-------|----------------------------|-------------|-------------------|--------------------|
| A     | Aqua                       |             | 87.55             | solvent            |
|       | Pentylene Glycol           |             | 4.00              | solvent            |
|       | Methylparaben              |             | 0.15              | preservative       |
|       | Ethylparaben               |             | 0.15              | preservative       |
|       | Betaine                    |             | 0.10              | active             |
|       | Glycerin                   |             | 4.00              | moisturising agent |
| B     | Sodium Lauroyl Sarcosinate | ROKAtend LS | 4.00              | surfactant         |
| C     | Citric Acid                |             | 0.05              | pH adjuster        |



|            |                          |                    |
|------------|--------------------------|--------------------|
| APPEARANCE | visual method            | transparent liquid |
| pH         |                          | 5.0 - 7.0          |
| STABILITY  | 1 month at 5°C, RT, 40°C | confirmed          |

### Procedure:

1. Combine ingredients from phase A. Add ingredients from phase A to hot water (75-80°C). Mix until homogenous solution is obtained. Cool the batch down to at least 50°C.
2. Add Sodium Lauroyl Sarcosinate. Mix until uniform. Cool the batch down to at least 30°C.
3. If necessary, adjust pH by Citric Acid to 5.0 – 7.0.

## MAKE-UP REMOVING LIQUID [KD-73]

| PHASE | INCI NAME                             | BRAND NAME     | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|----------------|-------------------|--------------------|
| A     | Aqua                                  |                | 87.85             | solvent            |
|       | Betaine                               |                | 0.10              | active             |
|       | Glycerin                              |                | 5.00              | moisturising agent |
| B     | Phenoxyethanol,<br>Ethylhexylglycerin |                | 1.00              | preservative       |
|       | PEG-7 Glyceryl Cocoate                | ROKAcet KO300G | 2.00              | surfactant         |
|       | Sodium Lauroyl Sarcosinate            | ROKAtend LS    | 4.00              | surfactant         |
| E     | Citric Acid                           |                | 0.05              | pH adjuster        |



|            |                          |                    |
|------------|--------------------------|--------------------|
| APPEARANCE | visual method            | transparent liquid |
| pH         |                          | 5.0 - 7.0          |
| STABILITY  | 1 month at 5°C, RT, 40°C | confirmed          |

### Procedure:

1. Combine ingredients from phase A. Add ingredients from phase A to hot water (75-80°C). Mix until homogeneous solution is obtained. Cool the batch down to at least 50°C.
2. Add ingredients from phase B. Mix until uniform. Cool the batch down to at least 30°C.
3. If necessary, adjust pH by Citric Acid to 5.0 – 7.0.

## MAKE-UP REMOVING MILK [KD-85]

| PHASE | INCI NAME  | BRAND NAME     | CONCENTRATION [%] | FUNCTION            |
|-------|--|----------------|-------------------|---------------------|
| A     | Ceteareth-12   | ROKAnol T12    | 1.00              | emulsifier          |
|       | Ceteareth-25   | ROKAnol T25    | 1.00              | emulsifier          |
|       | Cetearyl Alcohol   |                | 2.00              | emulsion stabiliser |
|       | PPG-15 Stearyl Ether   | ROKAnol SP15L  | 5.00              | emollient           |
|       | Helianthus Annuus Seed Oil                                       |                | 1.00              | emollient           |
|       | Caprylic/Capric Triglyceride                                     |                | 2.00              | emollient           |
| B     | Aqua   |                | 83.35             | solvent             |
|       | Betaine  |                | 0.50              | active              |
| C     | Glycerin   |                | 1.00              | moisturising agent  |
|       | Xanthan Gum  |                | 0.05              | rheology modifier   |
| D     | Carbomer   |                | 0.25              | rheology modifier   |
| E     | Sodium Hydroxide   |                | 0.05              | pH adjuster         |
|       | Phenoxyethanol,<br>Methylparaben, Ethylparaben,<br>Propylparaben |                | 0.80              | preservative        |
| F     | PEG-7/PPG-2<br>Propylheptyl ether                                | ROKAnol GA7LAW | 2.00              | solvent             |



|            |                          |                |
|------------|--------------------------|----------------|
| APPEARANCE | visual method            | white emulsion |
| pH         |                          | 5.0 - 7.0      |
| STABILITY  | 1 month at 5°C, RT, 40°C | confirmed      |

### Procedure:

1. In a separate vessel combine ingredients from phase A, B and C.
2. Add slowly phase D ingredients to phase B while mixing. Mix until uniform.
3. Add slowly phase C ingredients to phase B while mixing. Homogenise with 2000-3000 RPM, 90 sec.
4. Heat phase A and B to 75-80°C.
5. Add A into B, stir well with hand stirring, keep A/B at 75-80°C. Homogenise with 2000-3000 RPM, 120 sec.
6. Cool the batch down to 50°C while mixing. Add phase E ingredients while mixing. Homogenise with 2500-3500 RPM, 90 sec.
7. Cool the batch down to 25°C. Add phase F ingredients while mixing. Homogenise with 2500-3500 RPM, 90 sec.

## MAKE-UP REMOVING LIQUID [RD-10]

| PHASE | INCI NAME                          | BRAND NAME  | CONCENTRATION [%] | FUNCTION          |
|-------|------------------------------------|-------------|-------------------|-------------------|
| A     | PEG-6 Caprylic/Capric Glycerides   | ROKAcet CC6 | 4.00              | surfactant        |
| A     | Polysorbate 20                     | ROKwinol 20 | 0.20              | solubilizer       |
| A     | Poloxamer 184                      | EXOmer L64  | 0.20              | surfactant        |
| B     | Glycerin                           |             | 1.00              | active            |
| B     | Xanthan Gum                        |             | 0.05              | rheology modifier |
| C     | Betaine                            |             | 0.25              | active            |
| C     | Parfum                             |             | 0.30              | fragrance         |
| C     | Phenoxyethanol, Ethylhexylglycerin |             | 1.00              | preservative      |
| C     | Propylene Glycol                   |             | 0.50              | solvent           |
| D     | Citric Acid                        |             | 0.06              | pH adjuster       |
| A     | Aqua                               |             | 92.50             | solvent           |



|                   |                            |                          |
|-------------------|----------------------------|--------------------------|
| <b>APPEARANCE</b> | visual method              | clear transparent liquid |
| <b>pH</b>         |                            | 5.0 - 5.5                |
| <b>STABILITY</b>  | 1 month in 5°C, 20°C, 40°C | confirmed                |

### Procedure:

1. Add ingredients from phase A to warm water (40-45°C). Mix until homogenous solution is obtained.
2. Cool the batch down to at least 35°C.
3. Mix phase B and add during mixing. Mix until homogenous solution is obtained.
4. Add phase C while mixing- mix until uniform.
5. Adjust pH by CitricAcid to 5.0-5.5.







# SHAVING PRODUCTS

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**Shaving products** are intended to be used to assist in the removal of unwanted body hair. Those products have to guarantee the ease and effective shaving for both women and men. Cosmetic category called "shaving products" beside of typical shaving product include cosmetics such as shaving soaps and creams as well as pre- and after shaving lotions.

Shaving products are oftenly dispensed as an aerosol foam or gel that produces a lather when rubbed on the skin. Shaving Creams typically contain ingredients that help lubricate the skin so that the razor can work effectively.

In every shaving cream formulation, each ingredient plays a role, however some ingredients are essential, others only have a minor effect.



The performance of the cream serves as the ultimate test for the formulation and indicates whether the correct blend of ingredients and concentrations has been used. In addition, shaving creams often contain ingredients including: botanicals, essential oil derivatives, chelators, preservatives and other chemicals. Besides modulating performance, these ingredients can add antiseptic qualities, serve as skin toners, increase shelf life, etc. but more importantly, they make each formulation unique.

## SHAVE GEL FOR MEN [KD-142]

| PHASE | INCI NAME   | BRAND NAME     | CONCENTRATION [%] | FUNCTION          |
|-------|---|----------------|-------------------|-------------------|
| A     | Aqua  |                | up to 100         | solvent           |
|       | Carbomer  |                | 0.40              | rheology modifier |
|       | Allantoin   |                | 0.20              | active            |
|       | Glycerin  |                | 3.00              | solvent           |
|       | CI 42090  |                | 0.0001            | colorant          |
| B     | Sodium Hydroxide  |                | 0.30              | pH adjuster       |
| C     | Sodium Polyacrylate,<br>Ethylhexyl Stearate,<br>Trideceth-6 |                | 1.00              | rheology modifier |
|       | PPG-15 Stearyl Ether  | ROKAnol SP15L  | 4.00              | emollient         |
|       | PPG-5-Ceteth-20   | ROKAnol LP6066 | 1.00              | emollient         |
|       | Dimethicone   |                | 1.00              | emollient         |
|       | Phenoxyethanol,<br>Ethylhexylglycerin                       |                | 1.00              | preservative      |



|                   |                            |                 |
|-------------------|----------------------------|-----------------|
| <b>APPEARANCE</b> | visual method              | blue opaque gel |
| <b>pH</b>         |                            | 5.0 - 7.0       |
| <b>STABILITY</b>  | 1 month at 5°C, 20°C, 40°C | confirmed       |

### Procedure:

1. Combine ingredients from phase A. Add slowly Carbomer to water while mixing. Mix until uniform. Add other phase A components. Homogenize with 2000-3000 RPM, 90-120 sec.
2. Add Sodium Hydroxide while mixing. Mix until uniform.
3. Add phase C ingredients while mixing. Homogenize with 2000-3000 RPM, 120-180 sec.





## ULTRA RICH AFTER SHAVE LOTION [KD-144]

| PHASE | INCI NAME                          | BRAND NAME          | CONCENTRATION [%] | FUNCTION          |
|-------|------------------------------------|---------------------|-------------------|-------------------|
| A     | Ceteareth-25, Cetearyl Alcohol     | ROKAnol TE25 Flakes | 3.50              | emulsifier        |
|       | Paraffinum Liquidum                |                     | 3.00              | emollient         |
|       | Dimethicone                        |                     | 0.50              | emollient         |
|       | PPG-15 Stearyl Ether               | ROKAnol SP15L       | 4.00              | emollient         |
| B     | Aqua                               |                     | 83.20             | solvent           |
|       | Betaine                            |                     | 2.00              | active            |
|       | Glycerin                           |                     | 1.00              | solvent           |
|       | Allantoin                          |                     | 0.20              | active            |
| C     | Carbomer                           |                     | 0.20              | rheology modifier |
|       | PPG-15 Stearyl Ether               | ROKAnol SP15L       | 1.00              | emollient         |
| D     | Sodium Hydroxide                   |                     | 0.15              | pH adjuster       |
| E     | Phenoxyethanol, Ethylhexylglycerin |                     | 0.90              | preservative      |
| F     | Parfum                             |                     | 0.35              | fragrance         |



|            |                            |                |
|------------|----------------------------|----------------|
| APPEARANCE | visual method              | white emulsion |
| pH         |                            | 5.0 - 7.0      |
| STABILITY  | 1 month at 5°C, 20°C, 40°C | confirmed      |

### Procedure:

1. In separate vessels combine ingredients from phase A and B. Heat up to 75-80°C.
2. Add phase A to phase B while mixing. Homogenize 60-90 sec. In separate vessel combine ingredients from phase C. Mix until uniform.
3. Cool the batch down to 50°C while mixing. Add phase C ingredients while mixing. Homogenize with 2500-3500 RPM, 90 sec.
4. Cool the batch down to 30°C while mixing.
5. Add phase D and F while mixing. Homogenize with 2500-3500 RPM, 90 sec.

## LIGHT AFTER SHAVE LOTION [KD-147]

| PHASE | INCI NAME                          | BRAND NAME          | CONCENTRATION [%] | FUNCTION          |
|-------|------------------------------------|---------------------|-------------------|-------------------|
| A     | Ceteareth-25, Cetearyl Alcohol     | ROKAnol TE25 Flakes | 4.00              | emulsifier        |
|       | Glycine Soja Oil                   |                     | 1.00              | emollient         |
|       | Dimethicone                        |                     | 1.00              | emollient         |
|       | PPG-15 Stearyl Ether               | ROKAnol SP15L       | 2.00              | emollient         |
| B     | Aqua                               |                     | 83.80             | solvent           |
|       | Betaine                            |                     | 1.00              | active            |
|       | Allantoin                          |                     | 0.10              | active            |
| C     | Carbomer                           |                     | 0.20              | rheology modifier |
|       | PPG-15 Stearyl Ether               | ROKAnol SP15L       | 0.50              | emollient         |
|       | Cyclopentasiloxane                 |                     | 1.00              | emollient         |
| D     | Sodium Hydroxide                   |                     | 0.10              | pH adjuster       |
| E     | Phenoxyethanol, Ethylhexylglycerin |                     | 0.80              | preservative      |
| F     | Aluminum Starch Octenylsuccinate   |                     | 1.00              | absorbent         |
|       | Parfum                             |                     | 0.50              | fragrance         |
| G     | Alcohol                            |                     | 3.00              | solvent           |



|                   |                            |                |
|-------------------|----------------------------|----------------|
| <b>APPEARANCE</b> | visual method              | white emulsion |
| <b>pH</b>         |                            | 5.0 - 7.0      |
| <b>STABILITY</b>  | 1 month at 5°C, 20°C, 40°C | confirmed      |

### Procedure:

- In separate vessels combine ingredients from phase A and B. Heat up to 75-80°C.
- Add phase A to phase B while mixing. Homogenize 60-90 sec. In separate vessel combine ingredients from phase C. Mix until uniform.
- Cool the batch down to 60°C while mixing. Add phase C and D ingredients while mixing. Homogenize with 2500-3500 RPM, 90 sec.
- Cool the batch down to 40-50°C while mixing. Add phase D, E and F ingredients while mixing. Homogenize with 2500-3500 RPM, 90 sec. Cool the batch down to 30°C while mixing.
- Add phase F and G while mixing. Homogenize with 2500-3500 RPM, 90 sec.

# UNIVERSAL AFTER SHAVE LOTION [KD-347]

| PHASE | INCI NAME                             | BRAND NAME                        | CONCENTRATION [%] | FUNCTION          |
|-------|---------------------------------------|-----------------------------------|-------------------|-------------------|
| A     | Aqua                                  |                                   | up to 100         | solvent           |
|       | Allantoin                             |                                   | 0.20              | active            |
| B     | Polysorbate 80                        | ROKwinol 80                       | 1.50              | emulsifier        |
|       | PPG-5-Ceteth-20                       | ROKAnol LP6066                    | 1.00              | emollient         |
|       | Paraffinum Liquidum                   |                                   | 2.50              | emollient         |
| C     | PPG-15 Stearyl Ether                  | ROKAnol SP15L                     | 1.50              | emollient         |
|       | Carbomer                              |                                   | 0.25              | rheology modifier |
| D     | Sodium Hydroxide                      | Sodium Hydroxide,<br>20% Solution | 0.35              | pH adjuster       |
| E     | Phenoxyethanol,<br>Ethylhexylglycerin |                                   | 0.80              | preservative      |
| F     | Aluminum Starch<br>Octenylsuccinate   |                                   | 1.00              | absorbent         |
| G     | Parfum                                |                                   | 0.50              | fragrance         |
| H     | Alcohol                               |                                   | 3.00              | solvent           |



|                   |                            |                |
|-------------------|----------------------------|----------------|
| <b>APPEARANCE</b> | visual method              | white emulsion |
| <b>pH</b>         |                            | 5.0 - 7.0      |
| <b>STABILITY</b>  | 1 month at 5°C, 20°C, 40°C | confirmed      |

## Procedure:

1. In separate vessels combine ingredients from phase A and B.
2. Add phase B to phase A while mixing. Homogenize 60-90 sec. In separate vessel combine ingredients from phase C. Mix until uniform.
3. Add phase C while mixing. Homogenize with 2500-3500 RPM, 45 sec.
4. Add phase D while mixing. Homogenize with 2500-3000 RPM, 45 sec.
5. Add phase E - F ingredients while mixing. Homogenize with 2500-3500 RPM, 90 sec.

## AFTER SHAVE GEL [KD-356]

| PHASE | INCI NAME                                    | BRAND NAME     | CONCENTRATION [%] | FUNCTION          |
|-------|--|----------------|-------------------|-------------------|
| A     | Aqua   |                | up to 100         | solvent           |
|       | Acrylates/C10-30 Alkyl Acrylate Crosspolymer |                | 0.40              | rheology modifier |
|       | Allantoin                                    |                | 0.20              | active            |
|       | CI 42090                                     |                | 0.0001            | colorant          |
| B     | Sodium Hydroxide                             |                | 0.30              | pH adjuster       |
| C     | PPG-15 Stearyl Ether                         | ROKAnol SP15L  | 3.00              | emollient         |
|       | PPG-5-Ceteth-20                              | ROKAnol LP6066 | 1.00              | emollient         |
|       | Starch Hydroxypropyl Trimonium Chloride      |                | 0.10              | emollient         |
|       | Phenoxyethanol, Ethylhexylglycerin           |                | 1.00              | preservative      |



|                   |                            |                 |
|-------------------|----------------------------|-----------------|
| <b>APPEARANCE</b> | visual method              | blue opaque gel |
| <b>pH</b>         |                            | 5.0 - 7.0       |
| <b>STABILITY</b>  | 1 month at 5°C, 20°C, 40°C | confirmed       |

### Procedure:

1. Combine ingredients from phase A. Add slowly Acrylates/C10-30 Alkyl Acrylate Crosspolymer to water while mixing. Mix until uniform. Add other phase A components. Homogenize with 2000-3000 RPM, 90-120 sec.
2. Add Sodium Hydroxide (20% solution) while mixing. Mix until uniform.
3. Add phase C ingredients while mixing. Homogenize with 2000-3000 RPM, 120-180 sec.

## AFTERSHAVE [KD-358]

| PHASE | INCI NAME   | BRAND NAME     | CONCENTRATION [%] | FUNCTION     |
|-------|---|----------------|-------------------|--------------|
| A     | Aqua  |                | up to 100         | solvent      |
|       | Allantoin   |                | 0.20              | active       |
| B     | PPG-5-Ceteth-20                                   | ROKAnol LP6066 | 0.20              | emollient    |
|       | Trideceth-9, PEG-40 Hydrogenated Castor Oil, Aqua | EXOcare HTW    | 1.25              | surfactant   |
|       | Parfum  |                | 1.00              | fragrance    |
| C     | Phenoxyethanol, Ethylhexylglycerin                |                | 1.00              | preservative |



|            |                            |                        |
|------------|----------------------------|------------------------|
| APPEARANCE | visual method              | clear colorless liquid |
| pH         |                            | 5.0 - 7.0              |
| STABILITY  | 1 month at 5°C, 20°C, 40°C | confirmed              |

### Procedure:

1. Combine ingredients from phase A – mix until uniform.
2. Combine ingredients from phase B – mix until uniform.
3. Add phase B and C ingredients while mixing.

## BEARD WASH GEL FOR MEN [KD-330]

| PHASE | INCI NAME  | BRAND NAME          | CONCENTRATION [%] | FUNCTION     |
|-------|--|---------------------|-------------------|--------------|
| A     | Aqua   |                     | up to 100         | solvent      |
|       | Oleth-5 Phosphate  | EXOcare PB-184      | 0.25              | surfactant   |
|       | Polyquaternium-7   |                     | 1.00              | conditioner  |
| B     | Ammonium Lauryl Sulfate, Ammonium Laureth Sulfate, Cocamidopropyl Betaine, Sodium Benzoate | EXOcare AAC 35 easy | 20.00             | surfactant   |
|       | Aqua, Sodium Benzoate, Potassium Sorbate   |                     | 0.60              | preservative |
|       | Parfum   |                     | 0.50              | fragrance    |
| C     | Sodium Chloride  |                     | 0.50              | thickener    |



|                       |   |             |
|-----------------------|---|-------------|
| <b>APPEARANCE</b>     | visual method                                     | gel         |
| <b>pH</b>             |   | 5.0 - 5.8   |
| <b>VISCOSITY [cP]</b> | Brookfield LV, spindle 34, speed 3.0 RPM, T: 25°C | 2000 - 7000 |
| <b>STABILITY</b>      | 1 month at 5°C, 20°C, -5/40°C                     | confirmed   |

### Procedure:

1. In a main vessel combine ingredients from phase A - mix until uniform.
2. Add EXOcare AAC 35 easy, preservative, fragrance while mixing – mix until uniform.
3. Add slowly Sodium Chloride while mixing – mix until uniform.

## AFTER SHAVING MOISTURIZING GEL [KD-101]

| PHASE | INCI NAME                                    | BRAND NAME    | CONCENTRATION [%] | FUNCTION          |
|-------|--|---------------|-------------------|-------------------|
| A     | Aqua   |               | up to 100         | solvent           |
|       | Acrylates/C10-30 Alkyl Acrylate Crosspolymer |               | 0.40              | rheology modifier |
|       | Betaine                                      |               | 2.00              | active            |
|       | CI 42090                                     |               | q.s.              | colorant          |
| B     | Sodium Hydroxide                             |               | 0.15              | pH adjuster       |
| C     | Parfum                                       |               | 0.30              | fragrance         |
|       | PPG-15 Stearyl Ether                         | ROKAnol SP15L | 3.00              | emollient         |
|       | Caprylic/Capric Triglyceride                 |               | 2.00              | emollient         |
|       | Starch Hydroxypropyl Trimonium Chloride      |               | 0.10              | conditioner       |
|       | Phenoxyethanol, Ethylhexylglycerin           |               | 0.80              | preservative      |



|                   |                          |                 |
|-------------------|--------------------------|-----------------|
| <b>APPEARANCE</b> | visual method            | blue opaque gel |
| <b>pH</b>         |                          | 4.5 - 5.5       |
| <b>STABILITY</b>  | 1 month at 5°C, RT, 40°C | confirmed       |

### Procedure:

1. In a separate vessel combine ingredients from phase A. Add slowly Acrylates/C10-30 Alkyl Acrylate Crosspolymer to water while mixing. Mix until uniform. Add other phase A components.
2. Homogenise with 2000-3000 RPM, 90-120 sec.
3. Add phase C ingredients while mixing. Homogenise with 2000-3000 RPM, 90-120 sec.



## AFTER SHAVE LOTION [KD-144]

| PHASE | INCI NAME                             | BRAND NAME          | CONCENTRATION [%] | FUNCTION          |
|-------|---------------------------------------|---------------------|-------------------|-------------------|
| A     | Cetearyl Alcohol,<br>Ceteareth-20     | ROKAnol TE20 Flakes | 3.50              | emulsifier        |
|       | Paraffinum Liquidum                   |                     | 3.00              | emollient         |
|       | Dimethicone                           |                     | 0.50              | emollient         |
|       | PPG-15 Stearyl Ether                  | ROKAnol SP15L       | 4.00              | emollient         |
| B     | Aqua                                  |                     | 83.20             | solvent           |
|       | Betaine                               |                     | 2.00              | active            |
|       | Glycerin                              |                     | 1.00              | solvent           |
|       | Allantoin                             |                     | 0.20              | active            |
| C     | Carbomer                              |                     | 0.20              | rheology modifier |
|       | PPG-15 Stearyl Ether                  | ROKAnol SP15L       | 1.00              | emollient         |
| D     | Sodium Hydroxide                      |                     | 0.15              | pH adjuster       |
| E     | Phenoxyethanol,<br>Ethylhexylglycerin |                     | 0.90              | preservative      |
| F     | Parfum                                |                     | 0.35              | fragrance         |



|            |                            |                |
|------------|----------------------------|----------------|
| APPEARANCE | visual method              | white emulsion |
| pH         |                            | 5.0 - 7.0      |
| STABILITY  | 1 month at 5°C, 20°C, 40°C | confirmed      |

### Procedure:

1. In separate vessels combine ingredients from phase A and B. Heat up to 75-80°C
2. Add phase A to phase B while mixing. Homogenize 60-90 sec. In a separate vessel combine ingredients from phase C. Mix until uniform.
3. Cool the batch down to 50°C while mixing. Add phase C ingredients while mixing. Homogenize with 2500-3500 RPM, 90 sec.
4. Cool the batch down to 30°C while mixing.
5. Add phase D and F while mixing. Homogenize with 2500-3500 RPM, 90 sec.

# AFTER SHAVE LOTION [KD-147]

| PHASE | INCI NAME                          | BRAND NAME          | CONCENTRATION [%] | FUNCTION          |
|-------|------------------------------------|---------------------|-------------------|-------------------|
| A     | Cetearyl Alcohol, Ceteareth-20     | ROKAnol TE20 Flakes | 4.00              | emulsifier        |
|       | Glycine Soja Oil                   |                     | 1.00              | emollient         |
|       | Dimethicone                        |                     | 1.00              | emollient         |
|       | PPG-15 Stearyl Ether               | ROKAnol SP15L       | 2.00              | emollient         |
| B     | Aqua                               |                     | 83.80             | solvent           |
|       | Betaine                            |                     | 1.00              | active            |
|       | Allantoin                          |                     | 0.10              | active            |
| C     | Carbomer                           |                     | 0.20              | rheology modifier |
|       | PPG-15 Stearyl Ether               | ROKAnol SP15L       | 0.50              | emollient         |
|       | Cyclopentasiloxane                 |                     | 1.00              | emollient         |
| D     | Sodium Hydroxide                   |                     | 0.10              | pH adjuster       |
| E     | Phenoxyethanol, Ethylhexylglycerin |                     | 0.80              | preservative      |
| F     | Aluminum Starch Octenylsuccinate   |                     | 1.00              | absorbent         |
| F     | Parfum                             |                     | 0.50              | fragrance         |
| G     | Alcohol                            |                     | 3.00              | solvent           |



|                   |                            |                |
|-------------------|----------------------------|----------------|
| <b>APPEARANCE</b> | visual method              | white emulsion |
| <b>pH</b>         |                            | 5.0-7.0        |
| <b>STABILITY</b>  | 1 month at 5°C, 20°C, 40°C | confirmed      |

## Procedure:

1. In separate vessels combine ingredients from phase A and B. Heat up to 75-80°C
2. Add phase A to phase B while mixing. Homogenize 60-90 sec. In a separate vessel combine ingredients from phase C. Mix until uniform.
3. Cool the batch down to 60°C while mixing. Add phase C and D ingredients while mixing. Homogenize with 2500-3500 RPM, 90 sec.
4. Cool the batch down to 40-50°C while mixing. Add phase D, E and F ingredients while mixing. Homogenize with 2500-3500 RPM, 90 sec. Cool the batch down to 30°C while mixing.
5. Add phase F and G while mixing. Homogenize with 2500-3500 RPM, 90 sec.

## AFTER SHAVE LOTION [RD-04]

| PHASE | INCI NAME                             | BRAND NAME                        | CONCENTRATION [%] | FUNCTION          |
|-------|---------------------------------------|-----------------------------------|-------------------|-------------------|
| A     | Aqua                                  |                                   | to 100            | solvent           |
| A     | Allantoin                             |                                   | 0.20              | active            |
| B     | Polysorbate 80                        | ROKwinol 80                       | 1.50              | emulsifier        |
| B     | C12-15 Alkyl Benzoate                 | EXOsoft AB25                      | 2.00              | emollient         |
| C     | PPG-15 Stearyl Ether                  | ROKAnol SP15L MB                  | 1.50              | emollient         |
| A     | Carbomer                              |                                   | 0.25              | rheology modifier |
| D     | Sodium Hydroxide                      | Sodium Hydroxide,<br>20% Solution | 0.35              | pH adjuster       |
|       | Phenoxyethanol,<br>Ethylhexylglycerin |                                   | 0.80              | preservative      |
|       | Parfum                                |                                   | 0.50              | fragrance         |
| H     | Alcohol                               |                                   | 3.00              | solvent           |



|            |                            |                |
|------------|----------------------------|----------------|
| APPEARANCE | visual method              | white emulsion |
| pH         |                            | 5.0-7.0        |
| STABILITY  | 1 month in 5°C, 20°C, 40°C | confirmed      |

### Procedure:

1. In separately vessel combine ingredients from phase A and B.
2. Add phase B to phase A while mixing. Homogenize 60-90 sec. In separately vessel combine ingredients from phase C. Mix until uniform.
3. Add phase C while mixing. Homogenize with 2500-3500 RPM, 45 sec.
4. Add phase D while mixing. Homogenize with 2500-3000 RPM, 45 sec.



# SHAMPOOS & CONDITIONERS

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Shampoo is a basic hair care product representing the largest segment of hair care cosmetics. Typically, hair products are in the form of a viscous liquid, that is used for cleaning hair with some exception of waterless solid form such as bar.

Shampoo is used by applying it to wet hair, massaging the product into the hair, and then rinsing it out. Some consumers may follow a shampooing with the use of products called 2 in 1. Conditioning shampoos, were introduced to global markets in the late 1980s. A conditioning shampoo is designed to deposit conditioning actives on hair while washing off dirt at the same time.

The typical reason of using shampoo is to cleansing scalp, environmental dust, residues of hair care products and to remove the unwanted build-up of sebum in the hair. Most of the dirt including sebum are water insoluble and cannot be effectively removed by water alone. Therefore, a shampoo contain a combination of surfactants. The content of surfactants in a shampoo is typically between 10% - 20%.

Formulated shampoos are designed to target every hair & lifestyle need by nourishing, strengthening and repairing hair with a variety of ingredients from natural to synthetic.



Specialty shampoos are design to people with dandruff, color-treated hair, gluten or wheat allergies, an interest in using an organic product, and infants and young children.

## SHAMPOO BAR [IT-207]

| PHASE | INCI NAME               | BRAND NAME   | CONCENTRATION [%] | FUNCTION          |
|-------|-------------------------|--------------|-------------------|-------------------|
| A     | Cetearyl Alcohol        | EXOalc 1618  | 24.0              | thickener         |
|       | Cera Alba               |              | 2.0               | thickener         |
|       | Hydrogenated Castor Oil |              | 20.0              | thickener         |
|       | Citric Acid             |              | 1.5               | pH adjuster       |
|       | PEG-150                 | POLIkol 6000 | 3.5               | thickener         |
|       | Stearic Acid            |              | 2.0               | rheology modifier |
| B     | Glycerin                |              | 4.0               | solvent           |
| B     | Cocamidopropyl Betaine  | ROKAmina K30 | 13.0              | surfactant        |
| C     | Sodium Lauryl Sulfate   | ROSULfan LP  | 30.0              | surfactant        |

### Procedure:

1. Into auxiliary vessel add homogeneous from phase A and heat up to 80°C, mix until homogenous solution is obtained.
2. Cool the batch down to 70°C and add ingredients from phase B, mix.
3. Into main vessel add ROSULfan LP and solution from auxiliary vessel while mixing.

# PEARL SHAMPOO FOR DAILY CARE [KD-131.1]

| PHASE | INCI NAME  | BRAND NAME   | CONCENTRATION [%] | FUNCTION       |
|-------|--|--------------|-------------------|----------------|
| A     | Aqua   |              | to 100.00         | solvent        |
|       | Aqua, Sodium Benzoate, Potassium Sorbate             |              | 0.70              | preservative   |
|       | Betaine  |              | 2.00              | active         |
|       | Lactic Acid  |              | 0.25              | pH adjuster    |
| B     | Ammonium Lauryl Sulfate                              | ROSULfan A   | 30.00             | surfactant     |
| C     | Cocamidopropyl Betaine                               | ROKAmina K30 | 5.00              | surfactant     |
| D     | Parfum   |              | 0.35              | fragrance      |
| E     | Glycol Distearate, Laureth-4, Cocamidopropyl Betaine | EXOpearl SF  | 1.00              | pearling agent |
| F     | Sodium Chloride                                      |              | 1.30              | thickener      |



|                |   |             |
|----------------|---|-------------|
| APPEARANCE     | visual method                                     | pearl gel   |
| pH             |   | 4.5 - 5.5   |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 6.0 RPM, T: 25°C | 2500 - 6000 |

## Procedure:

1. In a main vessel combine ingredients from phase A. Mix until uniform.
2. Add ROSULfan A while mixing. Mix until uniform.
3. Add slowly ROKAmina K30 and Parfum while mixing. Mix until uniform.
4. Add EXOpearl SF while mixing. Mix until uniform.
5. Add slowly Sodium Chloride. Mix until uniform. NOTE: Add Sodium Chloride in small portions. Control the viscosity after each portion.

# CLASSIC SHAMPOO [SZ-01]

| PHASE | INCI NAME                            | BRAND NAME          | CONCENTRATION [%] | FUNCTION           |
|-------|--------------------------------------|---------------------|-------------------|--------------------|
| A     | Aqua                                 |                     | 37.95             | solvent            |
|       | PEG-7 Glyceryl Cocoate               | ROKAcet KO300G      | 2.00              | re-oiling agent    |
|       | Polyquaternium 7                     |                     | 2.50              | conditioning agent |
|       | Disodium Laureth Sulfosuccinate      | EXOsoft L3/40       | 4.00              | surfactant         |
|       | Sodium Laureth Sulfate               | SULFOROKAnol L227/1 | 30.00             | surfactant         |
|       | Sodium Lauroyl Sarcosinate           | ROKAtend LS         | 15.00             | surfactant         |
| B     | Citric Acid                          |                     | 0.05              | pH modifier        |
| C     | PEG-120 Methyl Glucose Dioleate      |                     | 1.00              | thickening agent   |
| D     | Parfum                               |                     | 0.50              | fragrance          |
|       | Ethylhexyl Glycerine, Phenoxyethanol |                     | 1.00              | preservative       |
|       | Cocamidopropyl Betaine               | ROKAmina K30        | 4.50              | surfactant         |
| E     | Sodium Chloride                      |                     | 1.50              | viscosity modifier |



|                |   |             |
|----------------|---|-------------|
| APPEARANCE     | visual method                                     | turbid gel  |
| pH             |   | 5.0 - 7.0   |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 20°C | 1500 - 5000 |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed   |

## Procedure:

1. Add ingredients from phase A to the hot water (70-75°C).
2. While mixing add ingredients one after another in the order from the table above. Mix until uniform.
3. Cool the batch down to at least 50°C.
4. Control pH range. If necessary, adjust pH by Citric Acid to 5.0 – 7.0.
5. Add PEG-120 Methyl Glucose Dioleate during mixing. Mix until uniform. Cool the batch down to at least 35°C.
6. Add fragrance, preservative and Cocamidopropyl Betaine during mixing. Mix until uniform.



## PEARL SHAMPOO [SZ-02]

| PHASE | INCI NAME   | BRAND NAME          | CONCENTRATION [%] | FUNCTION           |
|-------|---|---------------------|-------------------|--------------------|
| A     | Aqua  |                     | 39.89             | solvent            |
|       | Citric Acid   |                     | 0.06              | pH modifier        |
|       | Polyquaternium 10                                       |                     | 0.15              | conditioning agent |
|       | Disodium Laureth Sulfosuccinate                         | EXOsoft L3/40       | 2.50              | surfactant         |
|       | Sodium Laureth Sulfate                                  | SULFOROKAnol L227/1 | 30.00             | surfactant         |
|       | Sodium Lauroyl Sarcosinate                              | ROKAtend LS         | 15.00             | surfactant         |
| B     | PEG-7 Glyceryl Cocoate                                  | ROKAcet KO300G      | 1.50              | re-oiling agent    |
|       | PEG-120 Methyl Glucose Dioleate                         |                     | 1.00              | thickening agent   |
| C     | Parfum  |                     | 0.50              | fragrance          |
|       | Ethylhexyl Glycerine, Phenoxyethanol                    |                     | 1.00              | preservative       |
|       | Cocamidopropyl Betaine                                  | ROKAmina K30        | 6.00              | surfactant         |
| D     | Sodium Laureth Sulfate, Cocamide DEA, Glycol Distearate | EXOpearl N          | 1.00              | pearling agent     |
| E     | Sodium Chloride   |                     | 1.40              | viscosity modifier |



|                |   |                    |
|----------------|---|--------------------|
| APPEARANCE     | visual method                                     | viscous, pearl gel |
| pH             |   | 5.0 - 7.0          |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 3000 - 6000        |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed          |

### Procedure:

1. Add ingredients from phase A to the hot water (70-75°C). While mixing add ingredients one after another in the order from the table above. Mix until uniform. NOTE. Add Polyquaternium-10 and mix until homogenous liquid is obtained. Add the rest of the phase A components.
2. Cool the batch down to at least 50°C.
3. Add PEG-120 Methyl Glucose Dioleate and PEG-7 Glyceryl Cocoate during mixing. Mix until uniform. Cool the batch down to at least 35°C.
4. Add fragrance, Cocamidopropyl Betaine and preservative during mixing. Mix until uniform.
5. Add pearling agent. Mix until uniform.
6. Add NaCl to adjust the viscosity. NOTE. Add salt (not in one go) – after addition of each portion mix well.
7. Control the pH range – if necessary, add Citric Acid. Mix well after adjustment.
8. Control the viscosity if necessary, add Sodium Chloride.

# SHAMPOO FOR DAMAGED AND FRAGILE HAIR [SZ-03]

| PHASE | INCI NAME                               | BRAND NAME     | CONCENTRATION [%] | FUNCTION           |
|-------|---|----------------|-------------------|--------------------|
| A     | Aqua                                    |                | 46.62             | solvent            |
|       | Xanthan Gum                             |                | 0.75              | viscosity modifier |
|       | Glycerin                                |                | 2.00              | moisturising agent |
|       | Microcrystalline Cellulose              |                | 0.50              | viscosity modifier |
| B     | Aqua                                    |                | 13.00             | solvent            |
|       | Citric Acid                             |                | 0.20              | pH modifier        |
|       | Polyquaternium 10                       |                | 0.03              | conditioning agent |
|       | PEG-7 Glyceryl Cocoate                  | ROKAcet KO300G | 2.00              | re-oiling agent    |
|       | Ammonium Lauryl Sulfate                 | ROSULfan A     | 10.00             | surfactant         |
|       | Sodium Lauroyl Sarcosinate              | ROKAtend LS    | 20.00             | surfactant         |
|       | Cocamidopropyl Betaine                  | ROKAmina K30   | 3.50              | surfactant         |
| C     | Parfum                                  |                | 0.40              | fragrance          |
|       | Ethylhexyl glycerine,<br>Phenoxyethanol |                | 1.00              | preservative       |



|                |   |                    |
|----------------|---|--------------------|
| APPEARANCE     | visual method                                     | viscosus milky gel |
| pH             |   | 5.0 - 7.0          |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 3.0 RPM, T: 25°C | 9000 - 11000       |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed          |

## Procedure:

- In a main vessel combine ingredients from the phase A. Add Xanthan Gum to Glycerin - mix until homogenous solution is obtained. Add warm water (50-55°C) and Microcrystalline Cellulose. Mix until homogenous solution is obtained. Homogenise for 2-3 minutes.
- Combine ingredients from the phase B. During mixing add Citric Acid and Polyquaternium-10 to warm water (50-60°C). Mix until homogenous solution is obtained.
- Add the rest of the phase B components. Mix until uniform.
- Add phase B to phase A. Mix until homogenous solution is obtained. Cool the batch down to 30°C.
- When the batch temperature is 30°C, add parfum and preservative. Mix until uniform.

## MILD BRIGHT-GREEN SHAMPOO [SZ-05]

| PHASE | INCI NAME                             | BRAND NAME          | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|---------------------|-------------------|--------------------|
| A     | Aqua                                  |                     | up to 100         | solvent            |
|       | Benzophenone-4                        |                     | 0.05              | UV absorber        |
|       | CI 19140                              |                     | q.s.              | colorant           |
|       | CI 42090                              |                     | q.s.              | colorant           |
|       | Ammonium Laureth Sulfate              | SULFOROKAnol A325/1 | 35.00             | surfactant         |
|       | Ammonium Lauryl Sulfate               | ROSULfan A          | 15.00             | surfactant         |
|       | Sodium Benzoate,<br>Potassium Sorbate |                     | 0.60              | preservative       |
| B     | Citric Acid                           |                     | q.s.              | pH modifier        |
|       | Aqua                                  |                     | 1.50              | solvent            |
|       | Citric Acid                           |                     | 0.01              | pH modifier        |
| C     | Polyquaternium 10                     |                     | 0.02              | conditioning agent |
|       | Parfum                                |                     | 0.50              | fragrance          |
|       | Cocamidopropyl Betaine                | ROKAmina K30        | 5.00              | surfactant         |
|       | Sodium Chloride                       |                     | 1.80              | viscosity modifier |



|                |   |                           |
|----------------|---|---------------------------|
| APPEARANCE     | visual method                                     | bright-green clear liquid |
| pH             |   | 4.7 - 5.5                 |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 2000 - 5000               |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed                 |

### Procedure:

- During mixing add Citric Acid and polyquaternium-10 to warm water (40-45°C). Mix until homogenous solution is obtained.
- Add ingredients from phase A to warm water (40-45°C). While mixing add ingredients one after another in the order from the table above. Mix until uniform.
- Add phase B to phase A. Mix until homogenous solution is obtained. Cool the batch down to 35°C.
- Add parfum and Cocamidopropyl Betaine during mixing. Mix until homogenous solution is obtained.
- If necessary, add Sodium Chloride to adjust the viscosity.
- Control pH range – if necessary, add Citric Acid. Mix well after adjustment.

## 2 IN 1 SHAMPOO AND CONDITIONER [KD-131]

| PHASE | INCI NAME   | BRAND NAME          | CONCENTRATION [%] | FUNCTION          |
|-------|---|---------------------|-------------------|-------------------|
| A     | Aqua  |                     | up to 100         | solvent           |
|       | Sodium Laureth Sulfate                                  | SULFOROKAnol L227/1 | 12.00             | surfactant        |
|       | Zinc Coceth Sulfate                                     | EXOsoft ZN          | 20.00             | surfactant        |
|       | Polyquaternium-7  |                     | 1.00              | film forming      |
| B     | Aqua, Sodium Benzoate, Potassium Sorbate                |                     | 0.50              | preservative      |
|       | Allantoin   |                     | 0.01              | active            |
|       | CI 77891, Mica  |                     | 0.01              | colorant          |
|       | PEG-7 Glyceryl Cocoate                                  | ROKAcet KO300G      | 0.50              | surfactant        |
|       | PEG-120 Methyl Glucose Dioleate                         |                     | 1.00              | thickener         |
| C     | Glycerin  |                     | 0.45              | solvent           |
|       | Xanthan Gum   |                     | 0.20              | rheology modifier |
| D     | Sodium Laureth Sulfate, Cocamide DEA, Glycol Distearate | EXOpearl N          | 1.00              | surfactant        |
| E     | Parfum  |                     | 0.50              | fragrance         |
| F     | Cocamidopropyl Betaine                                  | ROKAmina K30K       | 6.00              | surfactant        |
| G     | Sodium Chloride   |                     | 0.50              | thickener         |



|                |   |              |
|----------------|---|--------------|
| APPEARANCE     | visual method                                     | pearling gel |
| pH             |   | 4.7 - 5.5    |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 3.0 RPM, T: 25°C | 5000 - 12000 |
| STABILITY      | 1 month at 5°C, 20°C, -5/40°C                     | confirmed    |

### Procedure:

1. In a main vessel combine ingredients from phase A – mix until uniform (cloudy solution). In a separate vessel combine ingredients from phase C – mix until uniform.
2. Prepare the remaining ingredients in separate beakers.
3. Add ingredients from phase B – mix until uniform.
4. Add phase C ingredients while mixing – mix until uniform.
5. Add phase D-F ingredients while mixing – mix until uniform.
6. Add slowly Sodium Chloride while mixing – mix until uniform.

# HAIR CONDITIONER [KD-136]

| PHASE | INCI NAME  | BRAND NAME          | CONCENTRATION [%] | FUNCTION           |
|-------|--|---------------------|-------------------|--------------------|
| A     | Aqua   |                     | 84.195            | solvent            |
|       | Cetrimonium Chloride   |                     | 3.00              | conditioning agent |
|       | Glycerin   |                     | 1.00              | solvent            |
|       | Betaine  |                     | 2.00              | active             |
| B     | Cetearyl Alcohol,<br>Ceteareth-20                                | EXOcare TE20 flakes | 5.00              | emulsifier         |
|       | PPG-15 Stearyl Ether   | ROKAnol SP15L       | 2.00              | emollient          |
|       | Glycine Soja Oil   |                     | 0.50              | emollient          |
| C     | Dimethicone  |                     | 1.00              | emollient          |
|       | Phenoxyethanol,<br>Methylparaben, Ethylparaben,<br>Propylparaben |                     | 1.00              | preservative       |
| D     | Parfum   |                     | 0.30              | fragrance          |
| E     | Sodium Hydroxide   |                     | 0.005             | pH adjuster        |



|                |                            |                |
|----------------|----------------------------|----------------|
| APPEARANCE     | visual method              | white emulsion |
| pH             |                            | 5.0 - 6.0      |
| VISCOSITY [cP] |                            | –              |
| STABILITY      | 1 month in 5°C, 20°C, 40°C | confirmed      |

## Procedure:

1. In separate vessels combine ingredients from phase A and B. Heat up to 75-80°C. Add phase B to phase A while mixing.
2. Homogenize with 1500-2000 RPM, 90-120 sec.
3. Cool down batch to 70°C while mixing. Add C ingredients while mixing. Homogenize with 1500-2000 RPM, 90-120 sec.
4. Cool down batch to 30°C while mixing. Add the other ingredients while mixing. Homogenize with 1500-2000 RPM, 90-120 sec.

## SENSITIVES WASCHGEL & SHAMPOO [KD-382]

| PHASE | INCI NAME  | BRAND NAME    | CONCENTRATION [%] | FUNCTION           |
|-------|--|---------------|-------------------|--------------------|
| A     | Aqua   |               | up to 100         | solvent            |
|       | Glycerin   |               | 1.00              | moisturising agent |
|       | Allantoin  |               | 0.10              | active             |
|       | Sodium Coco Sulfate  | Rosulfan C/PH | 20.00             | surfactant         |
|       | Coco-Glucoside   |               | 2.00              | surfactant         |
|       | Betaine  |               | 1.00              | active             |
|       | Benzyl Alcohol,<br>Benzoic Acid,<br>DehydroaceticAcid,<br>Tocopherol |               | 0.50              | preservative       |
|       | Lactic Acid  |               | 0.20              | pH adjuster        |
| B     | Aloe Barbadensis Leaf Juice<br>Powder                                |               | 0.50              | active             |
|       | Cocamidopropyl Betaine   | Rokamina K30  | 6.00              | surfactant         |
|       | Sodium Chloride  |               | 1.50              | thickener          |



|                |   |                 |
|----------------|---|-----------------|
| APPEARANCE     | visual method                                     | transparent gel |
| pH             |   | 4.5 - 6.0       |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 6.0 RPM, T: 25°C | 1500 - 5000     |

### Procedure:

1. In a main vessel combine ingredients from phase A. Add ingredients from phase A to water. Mix until uniform.
2. Add Rokamina K30 during mixing. Mix until uniform.
3. Add slowly Sodium Chloride. Mix until uniform. NOTE: Add Sodium Chloride in small portions. Control the viscosity after each portion.

## 2 IN 1 SHAMPOO AND CONITIONER [RD-02]

| PHASE | INCI NAME   | BRAND NAME    | CONCENTRATION [%] | FUNCTION          |
|-------|---|---------------|-------------------|-------------------|
| A1    | Xanthan Gum   |               | 0.30              | rheology modifier |
| A1    | Glycerin  |               | 1.00              | solvent           |
| B     | Zinc Coceth Sulfate   | EXOsoft ZN    | 20.00             | surfactant        |
| B     | Cocamidopropyl Betaine                                      | ROKAmina K30  | 6.00              | surfactant        |
| C     | Glycol Distearate,<br>Laureth-4,<br>Cocoamidopropyl Betaine | EXOpearl SF   | 1.00              | surfactant        |
| D     | Panthenol   |               | 0.10              | active            |
| D     | Glycereth-26  | ROKAnol G26   | 1.00              | surfactant        |
| D     | PPG-15 Stearyl Ether  | ROKAnol SP15L | 0.50              | emollient         |
| D     | PEG-120 Methyl Glucose Dioleate                             |               | 0.90              | thickener         |
| D     | Parfum  |               | 0.50              | fragrance         |
| E     | Sodium Benzoate   |               | 0.40              | preservative      |
| F     | Lactic Acid   |               | 0.30              | pH adjuster       |
| A     | Aqua  |               | 68.20             | solvent           |



|                   |   |                         |
|-------------------|---|-------------------------|
| <b>APPEARANCE</b> | visual method                                     | white with pearl effect |
| <b>pH</b>         |   | 4.7 - 5.5               |
| <b>VISCOSITY</b>  | Brookfield LV, spindle 34, speed 3.0 RPM, T: 25°C | 5000 - 8000             |
| <b>STABILITY</b>  | 1 month in 5°C, 20°C, 40°C                        | confirmed               |

### Procedure:

- Mix ingredients from phase A1 and next add to warm water (40-45°C). Mix until homogenous solution is obtained.
- Cool the batch down to at least 35°C.
- Add phase B during mixing. Mix until homogenous solution is obtained.
- Add phase C-E ingredients (PEG-120 Methyl Glucose Dioleate you should heat in separately beaker) while mixing – mix until uniform.
- Adjust pH by Lactic Acid to 5.0-5.4.

# BLACK SHAMPOO BAR FOR MEN [RD-06]

| PHASE | INCI NAME                                 | BRAND NAME              | CONCENTRATION [%] | FUNCTION          |
|-------|---|-------------------------|-------------------|-------------------|
| A     | Cetearyl Alcohol                          | EXOalc 1618             | 20.50             | surfactant        |
| A     | PEG-135                                   | POLIkol 6000            | 12.0              | thickener         |
| B     | Cocamidopropyl Betaine                    | ROKAmina K30            | 10.0              | surfactant        |
| C     | MIPA Laureth Sulfate,<br>Propylene Glycol | SULFOROKAnol<br>L390/1M | 29.4              | surfactant        |
| A     | Charcoal Powder                           | -                       | 0,6               | activ             |
| A     | Hydrogenated Castor Oil                   | -                       | 20.0              | thickener         |
| A     | Stearic Acid                              | -                       | 4.0               | rheology modifier |
| A     | Glycerin                                  | -                       | 3.0               | solvent           |
| C     | Parfum                                    | -                       | 0.50              | fragrance         |



**APPEARANCE** visual method

slightly yellowish  
viscous liquid

## Procedure:

1. Into auxiliary vessel add ingredients from phase A and heat up to 80°C, mix until homogenous solution is obtained.
2. Cool the batch down to 70°C and add ingredients from phase B. mix.
3. Into main vessel add MIPA and solution from auxiliary vessel while mixing.



# SHAMPOO AND CONDITIONER 2 IN 1 FOR MEN

## [KD-131]

| PHASE | INCI NAME   | BRAND NAME          | CONCENTRATION [%] | FUNCTION          |
|-------|---|---------------------|-------------------|-------------------|
| A     | Aqua  |                     | up to 100         | solvent           |
|       | Sodium Laureth Sulfate                                  | SULFOROKAnol L227/1 | 12.00             | surfactant        |
|       | Zinc Coceth Sulfate                                     | EXOsoft ZN          | 20.00             | surfactant        |
|       | Polyquaternium-7  |                     | 1.00              | film forming      |
| B     | Aqua, Sodium Benzoate, Potassium Sorbate                |                     | 0.50              | preservative      |
|       | Allantoin   |                     | 0.01              | active            |
|       | CI 77891, Mica  |                     | 0.01              | colorant          |
|       | PEG-7 Glyceryl Cocoate                                  | ROKAcet KO300G      | 0.50              | surfactant        |
|       | PEG-120 Methyl Glucose Dioleate                         |                     | 1.00              | thickener         |
| C     | Glycerin  |                     | 0.45              | solvent           |
|       | Xanthan Gum   |                     | 0.20              | rheology modifier |
| D     | Sodium Laureth Sulfate, Cocamide DEA, Glycol Distearate | EXOpearl N          | 1.00              | surfactant        |
| E     | Parfum  |                     | 0.50              | fragrance         |
| F     | Cocamidopropyl Betaine                                  | ROKAmina K30K       | 6.00              | surfactant        |
| G     | Sodium Chloride   |                     | 0.50              | thickener         |



|                |   |              |
|----------------|---|--------------|
| APPEARANCE     | visual method                                     | pearling gel |
| pH             |   | 4.7 - 5.5    |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 3.0 RPM, T: 25°C | 5000 - 12000 |
| STABILITY      | 1 month at 5°C, 20°C, -5/40°C                     | confirmed    |

## Procedure:

1. In a main vessel combine ingredients from phase A – mix until uniform (cloudy solution). In a separate vessel combine ingredients from phase C – mix until uniform.
2. Prepare the remaining ingredients in separate beakers.
3. Add ingredients from phase B – mix until uniform
4. Add phase C ingredients while mixing – mix until uniform.
5. Add phase D-F ingredients while mixing – mix until uniform.
6. Add slowly Sodium Chloride while mixing – mix until uniform.

# HAIR GEL WAX [KD-380]

| PHASE | INCI NAME                             | BRAND NAME         | CONCENTRATION [%] | FUNCTION                 |
|-------|---------------------------------------|--------------------|-------------------|--------------------------|
| A     | Aqua                                  |                    | up to 100         | solvent                  |
|       | Glycerin                              |                    | 0.50              | solvent                  |
|       | PPG-5-Ceteth-20                       | ROKAnol LP6066     | 0.80              | surfactant/<br>emollient |
| A1    | Laureth-3                             | ROKAnol LK3        | 5.00              | surfactant               |
| B     | Ceteareth-25                          | ROKAnol T25 Flakes | 23.00             | emulsifying agent        |
| C     | Phenoxyethanol,<br>Ethylhexylglycerin |                    | 0.50              | preservative             |
| D     | Parfum                                |                    | 0.25              | fragrance                |



|                   |                            |                   |
|-------------------|----------------------------|-------------------|
| <b>APPEARANCE</b> | visual method              | clear, sticky gel |
| <b>pH</b>         |                            | 5.0 - 7.5         |
| <b>STABILITY</b>  | 1 month at 5°C, 20°C, 40°C | confirmed         |

## Procedure:

1. In a separate vessel combine ingredients from phase A and B.
2. Prepare others ingredients – phase A1, C and D.
3. Heat phase A and B to 75-80°C.
4. Add ROKAnol LK3 to phase A, keep A/A1 at 75-80°C.
5. Add ROKAnol® T25 Flakes (phase B) to phase A/A1 during mixing. Maintain the temperature of 75-80 ° C until dissolved.
6. Cool the batch down to 50°C. Add phase C and D ingredients while mixing.
7. Cool the batch down to 25°C.

## STRONG HAIR GEL WAX [KD-381]

| PHASE | INCI NAME                             | BRAND NAME           | CONCENTRATION [%] | FUNCTION                 |
|-------|---------------------------------------|----------------------|-------------------|--------------------------|
| A     | Aqua                                  |                      | up to 100         | solvent                  |
|       | Glycerin                              |                      | 0.50              | solvent                  |
|       | PPG-5-Ceteth-20                       | ROKAnol LP6066       | 0.50              | surfactant/<br>emollient |
| A1    | PVP                                   | PVP K-30 100% Powder | 1.00              | hair fixing              |
|       | PVP                                   | PVP K-90 100% Powder | 1.00              | hair fixing              |
| B     | Steareth-20                           | ROKAnol S20          | 32.00             | emulsifying agent        |
| C     | Phenoxyethanol,<br>Ethylhexylglycerin |                      | 0.50              | preservative             |



|            |                            |                   |
|------------|----------------------------|-------------------|
| APPEARANCE | visual method              | clear, sticky gel |
| pH         |                            | 5.0 - 7.5         |
| STABILITY  | 1 month at 5°C, 20°C, 40°C | confirmed         |

### Procedure:

1. In a separate vessel combine ingredients from phase A, A1.
2. Prepare others ingredients – phase B and C.
3. Heat phase A and B to 75-80°C.
4. Add slowly phase A1 to phase A while mixing. Keep (phase A/A1) temperature at 75-80°C.
5. Add very slowly ROKAnol S20 (add small portion while mixing. Wait until uniform) to phase A/A1 during mixing. Maintain the temperature of 75-80 ° C until dissolved.
6. Add phase C while mixing.
7. Cool the batch down to 70°C.



Other

# PRODUCTS DEDICATED TO BABIES

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The skin of infants, babies and children require special treatment. Each product form this category has to be developed in a way to support the natural functions of the skin. Carefully selected ingredients work together and strengthen each other, making cosmetics very effective in contact with even the most delicate, sensitive and problematic skin.

**Babies, just like grown-ups, are exposed to many chemicals via personal care products throughout the day including sunscreens, ointments, oils, shampoos and soaps. Many of these products are easily absorbed through the skin into the blood stream, and babies are at least ten times more vulnerable to the chemicals in these products than adults.**



Cosmetic products dedicated to babies must be safe for the health of infants and should only contain ingredients that are non-toxic; potent allergens or substances with endocrine disrupting activity should not be present and preservatives should be used at their lowest effective concentrations. Detailed recommendations for baby creams and lotions were agreed by experts in the field to provide guidance to manufacturers and safety assessors.

# MILD BABY SHAMPOO WITHOUT SALT ADDITION [SZ-06]

| PHASE | INCI NAME                             | BRAND NAME      | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|-----------------|-------------------|--------------------|
| A     | Aqua                                  |                 | up to 100         | solvent            |
|       | Sodium Benzoate,<br>Potassium Sorbate |                 | 0.60              | preservative       |
|       | Magnesium Laureth Sulfate             | EXOsoft MGB     | 17.70             | surfactant         |
|       | PEG-75 Lanolin                        | ROKAnol LN75/50 | 1.00              | moisturising agent |
|       | MEA Lauryl Sulfate                    | ROSULfan M      | 10.00             | surfactant         |
| B     | PEG-120 Methyl<br>Glucose Dioleate    |                 | 1.50              | thickening agent   |
| C     | Cocamidopropyl Betaine                | ROKAmina K30    | 6.50              | surfactant         |
|       | Parfum                                |                 | 0.30              | fragrance          |
|       | Citric acid                           |                 | q.s.              | pH modifier        |



|                |   |                         |
|----------------|---|-------------------------|
| APPEARANCE     | visual method                                     | clear, light-yellow gel |
| pH             |   | 5.0 - 5.5               |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 1500 - 5000             |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed               |

## Procedure:

- Combine ingredients from phase A. Add ingredients from phase A to warm water (55-60°C). Mix until homogenous solution is obtained.
- Add PEG-120 Methyl Glucose Dioleate during mixing. Mix until uniform.
- Cool the batch down to 35°C.
- Add parfum and Cocamidopropyl Betaine during mixing. Mix until uniform.
- If necessary, adjust pH by Citric Acid to 5.0 – 5.5.

## WASHING & BATHING LIQUID [2 in 1] FOR INFANTS [KD-21]

| PHASE | INCI NAME                             | BRAND NAME    | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|---------------|-------------------|--------------------|
| A     | Aqua                                  |               | 79.90             | solvent            |
|       | Xanthan Gum                           |               | 0.80              | rheology modifier  |
|       | Glycerin                              |               | 3.00              | moisturising agent |
| B     | Lactic Acid                           |               | 0.30              | pH adjuster        |
|       | Sodium Benzoate,<br>Potassium Sorbate |               | 0.50              | preservative       |
|       | Betaine                               |               | 2.00              | active             |
|       | Sodium Lauroyl Sarcosinate            | ROKAtend LS   | 5.00              | surfactant         |
|       | Panthenol                             |               | 0.50              | active             |
| C     | Cocamidopropyl Betaine                | ROKAmina K30K | 8.00              | surfactant         |



|                |   |                          |
|----------------|---|--------------------------|
| APPEARANCE     | visual method                                     | transparent, viscous gel |
| pH             |   | 4.8 - 5.3                |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 3000 - 9000              |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed                |

### Procedure:

1. In a main vessel combine ingredients from the phase A. Add Xanthan Gum to Glycerin – mix until homogenous solution is obtained. Add warm water (50-55°C). Mix until homogenous solution is obtained. Homogenise for 2-3 minutes.
2. Add the phase B components. Mix until uniform. Cool the batch down to 35°C.
3. When the batch temperature is 35°C, add Cocamidopropyl Betaine during mixing. Mix until uniform.
4. Control the pH range – if necessary, add Lactic Acid. Mix well after adjustment.

# WASHING & BATHING LIQUID [2 in 1] FOR INFANTS [KD-22]

| PHASE | INCI NAME                             | BRAND NAME   | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|--------------|-------------------|--------------------|
| A     | Aqua                                  |              | 82.25             | solvent            |
|       | Lauryl Glucoside                      |              | 2.00              | surfactant         |
|       | Betaine                               |              | 1.00              | active             |
|       | Glycerin                              |              | 4.00              | moisturising agent |
|       | Lactic Acid                           |              | 0.50              | pH adjuster        |
|       | Sodium Benzoate,<br>Potassium Sorbate |              | 0.50              | preservative       |
| B     | Sodium Lauroyl Sarcosinate            | ROKAtend LS  | 4.00              | surfactant         |
|       | Panthenol                             |              | 0.25              | active             |
| C     | PEG-120 Methyl<br>Glucose Dioleate    |              | 0.50              | thickener          |
| D     | Cocamidopropyl Betaine                | ROKAmina K30 | 5.00              | surfactant         |



|                |   |                    |
|----------------|---|--------------------|
| APPEARANCE     | visual method                                     | hazy, viscosus gel |
| pH             |   | 4.8 - 5.3          |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 3000 - 9000        |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed          |

## Procedure:

- Combine ingredients from phase A. Add ingredients from phase A to warm water (55-60°C). Mix until homogenous solution is obtained. Cool the batch down to at least 50°C.
- Add ingredients from phase B during mixing. Mix until uniform.
- Add PEG-120 Methyl Glucose Dioleate while mixing. Mix until uniform. Cool the batch down to at least 30°C.
- Add Cocoamidopropyl Betaine while mixing. Mix until uniform.



## WASHING & BATHING GEL FOR INFANTS [KD-23]

| PHASE | INCI NAME                             | BRAND NAME    | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|---------------|-------------------|--------------------|
| A     | Aqua                                  |               | 84.20             | solvent            |
|       | Lauryl Glucoside                      |               | 4.00              | surfactant         |
|       | Sodium Benzoate,<br>Potassium Sorbate |               | 0.50              | preservative       |
|       | Glycerin                              |               | 2.00              | moisturising agent |
|       | Lactic Acid                           |               | 0.30              | pH adjuster        |
| B     | Disodium Laureth<br>Sulfosuccinate    | EXOsoft L3/40 | 2.00              | surfactant         |
|       | Coco-Glucoside,<br>Glyceryl Oleate    |               | 0.50              | surfactant         |
| C     | PEG-120 Methyl<br>Glucose Dioleate    |               | 0.50              | thickener          |
| D     | Cocamidopropyl Betaine                | ROKAmina K30  | 6.00              | surfactant         |



|                |   |                               |
|----------------|---|-------------------------------|
| APPEARANCE     | visual method                                     | bright-yellow,<br>viscous gel |
| pH             |   | 4.8 - 5.3                     |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 2000 - 8000                   |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed                     |

### Procedure:

- Combine ingredients from phase A. Add ingredients from phase A to warm water (55-60°C). Mix until homogenous solution is obtained. Cool the batch down to at least 50°C.
- Add ingredients from phase B. Mix until uniform.
- Add PEG-120 Methyl Glucose Dioleate during mixing. Mix until uniform. Cool the batch down to at least 30°C.
- Add Cocamidopropyl Betaine during mixing. Mix until uniform.
- If necessary, adjust pH by Lactic Acid to 4.8 – 5.3.

# HAIR & BODY WASHING FOAM FOR CHILDREN [KD-25]

| PHASE | INCI NAME                             | BRAND NAME    | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|---------------|-------------------|--------------------|
| A     | Aqua                                  |               | 89.10             | solvent            |
|       | Sodium Benzoate,<br>Potassium Sorbate |               | 0.50              | preservative       |
|       | Betaine                               |               | 0.50              | active             |
|       | Glycerin                              |               | 2.00              | moisturising agent |
| B     | Disodium Laureth Sulfosuccinate       | EXOsoft L3/40 | 5.50              | surfactant         |
| C     | PEG-120 Methyl Glucose Dioleate       |               | 0.25              | thickener          |
| D     | Lactic Acid                           |               | 0.15              | pH adjuster        |
|       | Cocamidopropyl Betaine                | ROKAmina K30  | 2.00              | surfactant         |



|            |                          |                    |
|------------|--------------------------|--------------------|
| APPEARANCE | visual method            | transparent liquid |
| pH         |                          | 5.0 - 5.5          |
| STABILITY  | 1 month at 5°C, RT, 40°C | confirmed          |

## Procedure:

- Combine ingredients from phase A. Add ingredients from phase A to warm water (45-50°C). Mix until homogenous solution is obtained.
- Add Disodium Laureth Sulfosuccinate during mixing. Mix until uniform.
- Add PEG-120 Methyl Glucose Dioleate during mixing. Mix until uniform. Cool the batch down to at least 30°C.
- Add Cocamidopropyl Betaine during mixing. Mix until uniform.
- Readjust the final pH to 5.0-6.5 with additional Lactic Acid.

## BATHING LIQUID FOR INFANTS [KD-26]

| PHASE | INCI NAME                             | BRAND NAME               | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|--------------------------|-------------------|--------------------|
| A     | Aqua                                  |                          | up to 100         | solvent            |
|       | Lauryl Glucoside                      |                          | 2.00              | surfactant         |
|       | Glycerin                              |                          | 2.00              | moisturising agent |
|       | Betaine                               |                          | 0.50              | active             |
|       | Sodium Benzoate,<br>Potassium Sorbate |                          | 0.50              | preservative       |
|       | Lactic Acid                           |                          | q.s               | pH adjuster        |
| B     | Magnesium Laureth Sulfate             | EXOsoft MG / EXOsoft MGB | 12.00             | surfactant         |
|       | PEG-7 Glyceryl Cocoate                | ROKAcet KO300G           | 0.50              | surfactant         |
|       | PEG-120 Methyl<br>Glucose Dioleate    |                          | 0.80              | thickener          |
| D     | Cocamidopropyl Betaine                | ROKAmina K30             | 6.00              | surfactant         |



|                |  |                     |
|----------------|--|---------------------|
| APPEARANCE     | visual method                                    | light-yellow liquid |
| pH             |  | 4.8 - 5.3           |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 10 RPM, T: 25°C | 1000 - 3000         |
| STABILITY      | 1 month at 5°C, RT, 40°C                         | confirmed           |

### Procedure:

- Combine ingredients from phase A. Add ingredients from phase A to warm water (50-55°C). Mix until homogenous solution is obtained. Cool the batch down to at least 50°C.
- Add ingredients from phase B while mixing. Mix until uniform. Cool the batch down to at least 30°C.
- Add Cocoamidopropyl Betaine during mixing. Mix until uniform.

## BATHING & WASHING LIQUID FOR INFANTS [KD-27]

| PHASE | INCI NAME                             | BRAND NAME          | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|---------------------|-------------------|--------------------|
| A     | Aqua                                  |                     | 71.35             | solvent            |
|       | Sodium Benzoate,<br>Potassium Sorbate |                     | 0.50              | preservative       |
|       | Glycerin                              |                     | 2.00              | moisturising agent |
|       | Lactic Acid                           |                     | 0.35              | pH adjuster        |
| B     | Ammonium Laureth Sulfate              | SULFOROKAnol A325/1 | 15.00             | surfactant         |
|       | Sodium Lauroyl Sarcosinate            | ROKAtend LS         | 3.00              | surfactant         |
| C     | Coco-Glucoside,<br>Glyceryl Oleate    |                     | 1.00              | surfactant         |
|       | PEG-120 Methyl<br>Glucose Dioleate    |                     | 0.80              | thickener          |
| D     | Coco Betaine                          | ROKAmina K30B       | 6.00              | surfactant         |



|                |   |                     |
|----------------|---|---------------------|
| APPEARANCE     | visual method                                     | light-yellow liquid |
| pH             |   | 4.8 - 5.3           |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 1000 - 3000         |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed           |

### Procedure:

- Combine ingredients from phase A. Add ingredients from phase A to warm water (50-55°C). Mix until homogenous solution is obtained.
- Add ingredients from phase B during mixing. Mix until uniform.
- Add PEG-120 Methyl Glucose Dioleate and Coco-Glucoside, Glyceryl Oleate during mixing. Mix until uniform. Cool the batch down to at least 30°C.
- Add slowly Coco Betaine during mixing. Mix until uniform.

# BATHING & WASHING LIQUID FOR CHILDREN FROM 3 YEARS OLD [KD-33]

| PHASE | INCI NAME                             | BRAND NAME     | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|----------------|-------------------|--------------------|
| A     | Aqua                                  |                | 76.90             | solvent            |
|       | Sodium Benzoate,<br>Potassium Sorbate |                | 0.50              | preservative       |
|       | Betaine                               |                | 0.50              | active             |
|       | Glycerin                              |                | 2.00              | moisturising agent |
|       | Decyl Glucoside                       |                | 1.00              | surfactant         |
| B     | MEA Lauryl Sulfate                    | ROSULfan M     | 10.00             | surfactant         |
|       | PEG-7 Glyceryl Cocoate                | ROKAcet KO300G | 0.50              | surfactant         |
| C     | Polysorbate 20                        | ROKwinol 20    | 0.30              | surfactant         |
|       | Parfum                                |                | 0.30              | fragrance          |
| D     | Cocamidopropyl Betaine                | ROKAmina K30   | 8.00              | surfactant         |



|                |   |                  |
|----------------|---|------------------|
| APPEARANCE     | visual method                                     | light-yellow gel |
| pH             |   | 4.8 - 5.2        |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 1000 - 4000      |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed        |

## Procedure:

1. Combine ingredients from phase A. Add ingredients from phase A to water (30-35°C). Mix until homogenous solution is obtained. Cool the batch down to at least 30°C.
2. Add ingredients from phase B. Mix until uniform.
3. Combine ingredients from phase C in a separate vessel. Add Parfum to Polysorbate 20 – mix until uniform.
4. Add phase C to the main vessel while mixing. Mix until uniform.
5. Add Cocoamidopropyl Betaine while mixing. Mix until uniform.
6. If necessary, adjust pH by Lactic Acid to 4.8-5.2.

# BATHING LIQUID FOR CHILDREN FROM 3 YEARS OLD [KD-35]

| PHASE | INCI NAME                             | BRAND NAME          | CONCENTRATION [%] | FUNCTION           |
|-------|---------------------------------------|---------------------|-------------------|--------------------|
| A     | Aqua                                  |                     | 71.85             | solvent            |
|       | Sodium Laureth Sulfate                | SULFOROKAnol L227/1 | 13.00             | surfactant         |
|       | Sodium Lauroyl Sarcosinate            | ROKAtend LS         | 3.00              | surfactant         |
|       | Sodium Benzoate,<br>Potassium Sorbate |                     | 0.50              | preservative       |
|       | Glycerin                              |                     | 3.00              | moisturising agent |
|       | PEG-7 Glyceryl Cocoate                | ROKAcet KO300G      | 0.50              | surfactant         |
|       | Lactic Acid                           |                     | 0.25              | pH adjuster        |
|       | PEG-120 Methyl<br>Glucose Dioleate    |                     | 0.50              | thickener          |
| B     |                                       |                     |                   |                    |
| C     | Cocamidopropyl Betaine                | ROKAmina K30        | 6.00              | surfactant         |
|       | Parfum                                |                     | 0.50              | fragrance          |
| D     | Sodium Chloride                       |                     | 0.90              | thickener          |
|       |                                       |                     |                   |                    |



|                |  |                    |
|----------------|--|--------------------|
| APPEARANCE     | visual method                                    | transparent liquid |
| pH             |  | 4.8 - 5.3          |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 12 RPM, T: 25°C | 1000 - 4000        |
| STABILITY      | 1 month at 5°C, RT, 40°C                         | confirmed          |

## Procedure:

- Combine ingredients from phase A. Add ingredients from phase A to water (55-60°C). Mix until uniform. Cool the batch down to at least 50°C.
  - Add PEG-120 Methyl Glucose Dioleate during mixing. Mix until uniform. Cool the batch down to at least 30°C.
  - Add Cocamidopropyl Betaine and Parfum during mixing. Mix until uniform.
- Add Sodium Chloride during mixing (Add small portions and dissolve).
  - If necessary, adjust pH by Lactic Acid to 4.8 – 5.3.

# SHAMPOO FOR CHILDREN FROM 3 YEARS OLD [KD-37]

| PHASE | INCI NAME   | BRAND NAME          | CONCENTRATION [%] | FUNCTION     |
|-------|---|---------------------|-------------------|--------------|
| A     | Aqua  |                     | up to 100         | solvent      |
|       | Sodium Benzoate,<br>Potassium Sorbate                         |                     | 0.50              | preservative |
|       | Betaine   |                     | 1.00              | active       |
|       | Lactic Acid   |                     | 0.25              | pH adjuster  |
|       | Benzophenone-4  |                     | 0.05              | UV filter    |
|       | CI 42090  |                     | q.s.              | colorant     |
| B     | Ammonium Laureth Sulfate                                      | SULFOROKAnol A325/1 | 30.00             | surfactant   |
| C     | Polyquaternium-7  |                     | 0.25              | conditioner  |
|       | PEG-120 Methyl<br>Glucose Dioleate                            |                     | 0.50              | thickener    |
|       | PEG-7 Glyceryl Cocoate  | ROKAcet KO300G      | 0.50              | surfactant   |
| D     | Cocamidopropyl Betaine  | ROKAmina K30K       | 6.00              | surfactant   |
| E     | Parfum  |                     | 0.30              | fragrance    |
|       | Sodium Laureth Sulfate,<br>Cocamide DEA,<br>Glycol Distearate | EXOpearl N          | 1.00              | surfactant   |
| F     | Sodium Chloride   |                     | 1.80              | thickener    |



|                |   |                       |
|----------------|---|-----------------------|
| APPEARANCE     | visual method                                     | pearl, light-blue gel |
| pH             |   | 4.8 - 5.3             |
| VISCOSITY [cP] | Brookfield LV, spindle 34, speed 2.5 RPM, T: 25°C | 3000 - 8000           |
| STABILITY      | 1 month at 5°C, RT, 40°C                          | confirmed             |

## Procedure:

1. In a main vessel combine ingredients from phase A. Heat up to 55-60°C. Mix until uniform.
2. Add Ammonium Laureth Sulfate. Mix until uniform.
3. Add ingredients from phase C. Mix until uniform. Cool the batch down to 30°C.
4. Add slowly Cocoamidopropyl Betaine while mixing. Mix until uniform.
5. Add ingredients from phase E. Mix until uniform.
6. Add Sodium Chloride while mixing (Add small portions and dissolve).

# KIDS BODY MOUSSE [RD-09]

| PHASE | INCI NAME                  | BRAND NAME    | CONCENTRATION [%] | FUNCTION     |
|-------|----------------------------|---------------|-------------------|--------------|
| A     | Sodium Cocoyl Isethionate  |               | 12.00             | surfactant   |
| A     | Sodium Lauroyl Sarcosinate | ROKAtend LS   | 4.50              | surfactant   |
| A     | Coco Betaine               | ROKamina K30B | 1.00              | surfactant   |
| A     | C12-15 Alkyl Benzoate      | EXOsoft AB25  | 1.00              | emollient    |
| B     | Glycerin                   |               | 25.00             | active       |
| B     | Sorbitol                   |               | 10.00             | active       |
| B     | Panthenol                  |               | 1.00              | active       |
| C     | Parfum                     |               | 0.20              | fragrance    |
| C     | CI17200                    | INCI          | 0.01              | dye          |
| D     | Sodium Benzoate            |               | 0.50              | preservative |
| D     | Potassium Sorbate          |               | 0.30              | preservative |
| E     | Lactic Acid                |               | 0.30              | pH adjuster  |
| A     | Aqua                       |               | 44.60             | solvent      |



|            |                            |            |
|------------|----------------------------|------------|
| APPEARANCE | visual method              | pink paste |
| pH         |                            | 5.0 - 5.5  |
| STABILITY  | 1 month in 5°C, 20°C, 40°C | confirmed  |

## Procedure:

1. Add ingredients from phase A to warm water (40-45°C). Mix until homogenous solution is obtained.
2. Cool the batch down to at least 35°C.
3. Add phase B during mixing. Mix until homogenous solution is obtained.
4. Add phase C-E ingredients while mixing – mix until uniform.
5. Adjust pH by Lactic Acid to 5.0-5.5.



## ANTIPERSPIRANT [KD-155]

| PHASE | INCI NAME                      | BRAND NAME          | CONCENTRATION [%] | FUNCTION          |
|-------|--------------------------------|---------------------|-------------------|-------------------|
| A     | Aqua                           |                     | 80.00             | solvent           |
|       | Hydroxypropyl Starch Phosphate |                     | 1.00              | rheology modifier |
| B     | Cetearyl Alcohol, Ceteareth-20 | EXOcare TE20 Flakes | 5.00              | emulsifier        |
|       | PPG-15 Stearyl Ether           | ROKAnol SP15L       | 4.00              | emollient         |
| C     | Aluminum Chlorohydrate         |                     | 10.00             | antiperspirant    |



|            |                            |                |
|------------|----------------------------|----------------|
| APPEARANCE | visual method              | white emulsion |
| pH         |                            | 3.5 - 5.0      |
| STABILITY  | 1 month at 5°C, 20°C, 40°C | confirmed      |

### Procedure:

1. In separate vessels combine ingredients from phase A and B. Homogenize phase A: 1500-2000 RPM 90-120 s.
2. Heat phase A and B to 75-80°C.
3. Add phase B to A while mixing. Homogenize: 1500-2000 RPM 90-120 s.
4. Cool batch down to 30°C while mixing.
5. Add phase C ingredient while mixing. Homogenize: 1500-2000 RPM 90-120 s.

# ANTIPERSPIRANT [KD-156]

| PHASE | INCI NAME                      | BRAND NAME          | CONCENTRATION [%] | FUNCTION       |
|-------|--------------------------------|---------------------|-------------------|----------------|
| A     | Aqua                           |                     | up to 100         | solvent        |
| B     | Ceteareth-25, Cetearyl Alcohol | EXOcare TE25 flakes | 3.00              | emulsifier     |
|       | PPG-15 Stearyl Ether           | ROKAnol SP15L       | 5.00              | emollient      |
|       | Steareth-20                    | ROKAnol S20         | 3.00              | emulsifier     |
| C     | Aluminum Chlorohydrate         |                     | 15.00             | antiperspirant |
|       | Parfum                         |                     | 0.50              | fragrance      |



|            |                            |                |
|------------|----------------------------|----------------|
| APPEARANCE | visual method              | white emulsion |
| pH         |                            | 3.5 - 5.0      |
| STABILITY  | 1 month at 5°C, 20°C, 40°C | confirmed      |

## Procedure:

1. In separate vessels combine ingredients from phase A and B. Homogenize phase A: 1500-2000 RPM 90-120 s.
2. Heat phase A and B to 75-80°C.
3. Add phase B to A while mixing. Homogenize: 1500-2000 RPM 90-120 s.
4. Cool batch down to 30°C while mixing.
5. Add phase C ingredient while mixing. Homogenize: 1500-2000 RPM 90-120 s.

## ROLL ON FOR MEN [KD-155]

| PHASE | INCI NAME                      | BRAND NAME          | CONCENTRATION [%] | FUNCTION          |
|-------|--------------------------------|---------------------|-------------------|-------------------|
| A     | Aqua                           |                     | up to 100         | solvent           |
|       | Hydroxypropyl Starch Phosphate |                     | 1.00              | rheology modifier |
| B     | Ceteareth-25, Cetearyl Alcohol | EXOcare TE25 flakes | 5.00              | emulsifier        |
|       | PPG-15 Stearyl Ether           | ROKAnol SP15 MB     | 4.00              | emollient         |
| C     | Aluminum Chlorohydrate         |                     | 10.00             | antiperspirant    |



|            |                            |                |
|------------|----------------------------|----------------|
| APPEARANCE | visual method              | white emulsion |
| pH         |                            | 3.5 - 5.0      |
| STABILITY  | 1 month in 5°C, 20°C, 40°C | confirmed      |

### Procedure:

1. In separate vessel combine ingredients from phase A and B. Homogenize phase A 1500-2000 RPM 90-120 s.
2. Heat phase A and B to 75-80°C
3. Add phase B to A while mixing. Homogenize: 1500-2000 RPM 90-120 s.
4. Cool batch down to 30°C while mixing.
5. Add phase C ingredient while mixing. Homogenize: 1500-2000 RPM 90-120 s.



# About Us

PCC Exol SA is a major player in the European surfactants market. In the eastern and central-eastern part of the continent, it is the undisputed leader in its industry. Most of the production facilities and the company's headquarters are located in Brzeg Dolny, Poland. Here we develop, test and manufacture a wide range of anionic, non-ionic and amphoteric surfactants and speciality industrial formulations. New products are continuously added to the portfolio in response to market trends and individual customer requirements. The surfactants produced at the plants have a very wide range of industrial applications.

They are used as wetting agents, emulsifiers, auxiliaries in paper, metallurgy and many other industries, as well as in household chemicals, personal care products and textiles. PCC EXOL pays special attention to the issue of sustainable development, which is one of the key elements of the company's strategy. In order to strengthen its competitive position in the surfactants market, the company is committed to promoting responsible production and consumption throughout the value chain. The concept of sustainable development is therefore a key aspect of all the company's management and operational processes.

|   |  |  |  |   |
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**PCC Exol SA**  
Sienkiewicza 4  
56-120 Brzeg Dolny, Poland  
[products@pcc.eu](mailto:products@pcc.eu)

Please visit our capital group business platform:  
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The suggestions for product applications are based on our best knowledge.

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