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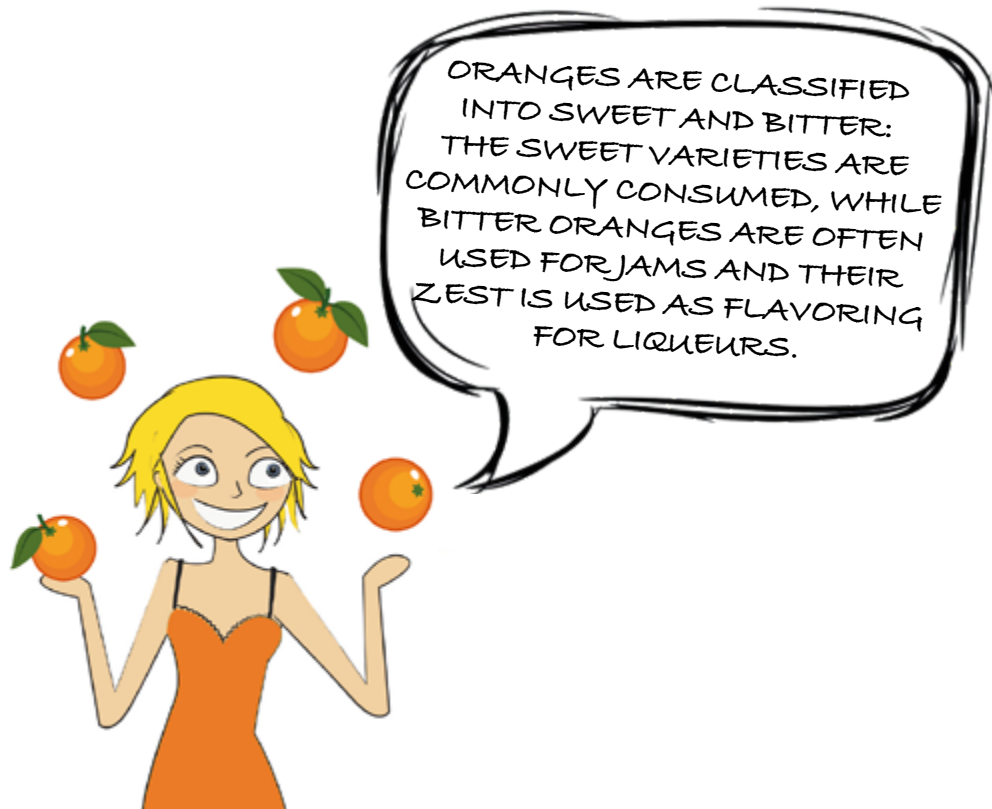
ORANGE WAX

KAHLWAX 6698 ORANGE

KahlWax 6698 Orange (INCI (EU): *Citrus Aurantium Dulcis Peel Cera*, *Rhus Verniciflua Peel Cera*) is medium hard, orange colored wax with a refreshing citrus scent. It is a 1:1 blend of orange peel wax and berry wax.

Orange peel wax is semi-solid natural wax derived from cold pressed orange oil by means of a physical concentration process. The wax surrounds the fruit, protecting it against environmental influences like high temperatures, while still allowing for moisture exchange. It is used in the cosmetic industry mainly as an emollient for its skin conditioning and smoothing properties. Orange peel wax is combined with berry wax to improve texture, hardness and convenience. Berry wax is a very soft, pale wax derived from berry fruit peels of the *Rhus Verniciflua* tree. Thanks to its unique structure it is ideal for enhancing crystal structures of other materials.

KahlWax 6698 Orange combines the emollient character of orange peel wax with the texture enhancing and stabilizing properties of berry wax, which makes it very versatile. It is perfectly suited for hair care products, as it conditions, provides smoothness, combability, and shine. Used in leave-on conditioners, it can improve the definition of curls. 6698 is also recommended for color cosmetic formulations, where it enhances pay-off, gloss, and color brilliance. In skin care applications, it provides a pleasantly smooth texture, a rich and nurturing skin feel and improves softness, while adding a protective layer on the skin. Due to its low melting point KahlWax 6698 Orange has no noticeable effect on the viscosity of formulations. Its uplifting and fresh natural orange scent can be best utilized in O/W emulsions. The recommended use level is 0.5–5%.



PEACOCKISH PEACH | SOFTENING LIPSTICK | CC-LIP-023-07 | STICK

This wonderfully smooth lipstick glides on comfortably thanks to the contained KahlWax 6698 Orange. The lightweight formula delivers a burst of creamy color and all-day moisture in a luxurious satin-soft finish.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	KahlWax 8104 White Beeswax	Cera Alba	KahlWax	7.00
A	KahlWax 2442L Carnauba	Copernicia Cerifera Cera	KahlWax	7.00
A	KahlWax 2039L Candelilla	Euphorbia Cerifera Cera	KahlWax	3.00
A	KahlWax 6607L MB Sunflower	Helianthus Annuus Seed Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	2.00
A	KahlWax 6698 Orange	Citrus Aurantium Dulcis Peel Cera, Rhus Verniciflua Peel Cera	KahlWax	3.00
A	Joboba Oil (refined)	Simmondsia Chinesis Seed Oil	Gustav Heess	ad 100
A	Castor Oil (refined)	Ricinus Communis Seed Oil	Gustav Heess	14.00
A	Meadowfoam Seed Oil	Limnanthes Alba Seed Oil	Natural Plant Products	10.00
B	FD&C Red 6 Ba LK CO Disp COD 8002	Ricinus Communis Seed Oil, CI 15850	Sun Chemical	1.00
B	Red FE Oxide Castor Oil Disp COD 8006	Ricinus Communis Seed Oil, CI 77491	Sun Chemical	1.50
B	White Castor Oil Disp COD 8008	Ricinus Communis Seed Oil, CI 77891	Sun Chemical	5.00
B	FD&C Yellow 6 Castor Oil Disp COD 8010	Ricinus Communis Seed Oil, CI 15985	Sun Chemical	0.50
C	SunShine C80-3201 Super White	Synthetic Fluorphlogopite, Titanium Dioxide	Sun Chemical	1.50
C	SynCrystal Ivory	Synthetic Fluorphlogopite, Titanium Dioxide, Iron Oxides, Tin Oxide	Eckart	3.00

PROCEDURE

Combine phase A ingredients and heat to 95 °C under stirring. Add phase B ingredients and stir for approx. 15 minutes with a dissolver. Homogenize for 30 seconds and add phase C under stirring. Cool to 85 °C and fill into suitable packaging.

MATTE ○○●○○ GLOSSY MOISTURIZING ○○●○○ LONG-LASTING

LAND OF MILK, HONEY, AND ORANGE | MASSAGE BALM | SC-BOD-042-06 | POT

Escape into another world with this relaxing massage balm. The nourishing formula combines sweet and invigorating orange fragrances with a pleasantly smooth and rich texture.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	Water	Aqua	--	10.65
A	Eumulgin SG	Sodium Stearoyl Glutamate	BASF	0.30
A	Glycerin	Glycerin	Merck	ad 100
B	Miglyol Coco 810	Coco-Caprylate/Caprates	IOI Oleo	35.65
B	Coconut Oil (refined)	Cocos Nucifera Oil	Gustav Heess	7.10
B	Emulium Mellifera	Polyglyceryl-6 Distearate, Jojoba Esters, Polyglyceryl-3 Beeswax, Cetyl Alcohol	Gattefossé	6.00
B	Cutina GMS-SE	Glycerol Stearate SE	BASF	3.00
B	KahlComplex 6427 Megasoft	Crambe Abyssinica Seed Oil, Euphorbia Cerifera Cera, Hydroxystearic Acid, Beta-Sitosterol, Rhus Verniciflua Peel Cera, Tocopherol, Helianthus Annuus Seed Oil	KahlWax	2.00
B	KahlWax 6698 Orange	Citrus Aurantium Dulcis Peel Cera, Rhus Verniciflua Peel Cera	KahlWax	2.50
C	Unicert Orange K7011-J (0.10 %)	Aqua, CI 15510	Sensient	1.00
C	Orange Ginger NaTrue	Parfum	Vögele	0.30
D	Preservative			q.s.

PROCEDURE

Combine phase A ingredients and stir until a homogenous gel is obtained. Heat phase A and B separately to 75 °C. Add phase B to A under slow stirring. Avoid the formation of foam. Cool to 45 °C and add phase C and D. Fill into packaging.

DON'T COMPARE APPLES AND ORANGES | BODY BUTTER | SC-BOD-051-06 | POT

This rich body butter features a velvety smooth texture that melts upon skin contact. Formulated with moisturizing ingredients, like KahlWax 6698 Orange, it is perfectly suited to nourish dry skin.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	Water	Aqua	--	ad 100
A	Glycerin	Glycerin	Merck	3.60
A1	Pure Gel B990	Sodium Hydroxypropyl Starch Phosphate	Paroxite	4.80
B	Arlacel 165	Glyceryl Stearate, PEG-100 Stearate	Croda	4.20
B	Lanette O	Cetearyl Alcohol	BASF	2.10
B	Almond Oil	Prunus Amygdalus Dulcis Oil	Henry Lamotte	23.20
B	KahlWax 6698 Orange	Citrus Aurantium Dulcis Peel Cera, Rhus Verniciflua Peel Cera	KahlWax	1.50
B	KahlComplex 6422 Veggiesoft	Rhus Verniciflua Peel Cera, Simmondsia Chinensis Seed Oil, Cetearyl Alcohol, Myristyl Alcohol, Caprylic/Capric Triglyceride, Copernicia Cerifera Cera, Tocopherol	KahlWax	4.00
C	Orange Ginger NaTrue	Parfum	Vögele	0.50
C	Preservative			q.s.

PROCEDURE

Blend phase A ingredients and add phase A1. Heat to 80–85 °C and stir until it is homogenous. Combine phase B ingredients and heat to 80–85 °C. Add phase B to A/A1 under agitation. Continue mixing at 80 °C for 3–5 minutes. Cool to 40 °C and add phase C. Cool further to 30 °C and fill into packaging.

ORANGE CREAMSICLE | HAIR MILK | HC-LEN-003-11 | TUBE

Featuring KahlWax 6698 Orange, this conditioner with vitalizing citrus scent protects and nourishes hair and scalp. The rinse-off formula detangles and softens strands for beautiful, shiny, healthy-looking hair.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	Water	Aqua	--	ad 100
A	Lexquat C-PF	Cocamidopropyl PG-Dimonium Chloride	Inolex	5.00
A	Varisoft EQ 100	Quaternium-98	Evonik	1.00
B	Arlacel 165	Glyceryl Stearate, PEG-100 Stearate	Croda	3.00
B	Lanette O	Cetearyl Alcohol	BASF	4.00
B	KahlWax 6698 Orange	Citrus Aurantium Dulcis Peel Cera, Rhus Verniciflua Peel Cera	KahlWax	3.00
B	Emulium Kappa 2	Candelilla/Joboba/Rice Bran Polyglyceryl-3 Esters, Glyceryl Stearate, Cetearyl Alcohol, Sodium Stearoyl Lactylate	Gattefossé	1.00
B	Apricot Kernel Oil (refined)	Prunus Armeniaca Kernel Oil	Gustav Heess	2.00
B	Miglyol 8810	Butylene Glycol Dicaprylate/Dicaprate	IOI Oleo	2.00
C	Unicert Orange K7011-J (0.10 %)	Aqua, CI 15510	Sensient	0.60
C	Orange Ginger NaTrue	Parfum	Vögele	0.30
C	Preservative			q.s.

PROCEDURE

Heat phase A ingredients to 80 °C. Blend phase B ingredients and heat to 80 °C. Add phase B to A under vigorous stirring. Mix until uniform. Cool mixture to 40 °C and add phase C. Cool down to RT under stirring and fill into suitable packaging.