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# SUNFLOWER WAXES

## 6607L SUNFLOWER SEED WAX

Waxes are natural components of sunflower oil, consisting mainly of esters of fatty acids with fatty alcohols, that are partially removed by the winterization process during oil refining. Depending on the seed variety and the production process, the wax content of sunflower oil can vary from 0.02 to 0.35 wt%. Extracted oils show higher concentrations of wax than those obtained by pressing. The hull contributes significantly to the wax content, therefore 6607L is carefully obtained from unhulled sunflower seeds. It is a double-refined wax which is mainly used to harden not poured, anhydrous systems.

## 6607H SUNFLOWER HYDROWAX

Sunflower Hydrowax is an entirely hydrolyzed sunflower seed wax. Due to the hydrolysis it is much more hydrophilic and polar than the regular wax. Therefore it is an outstanding co-emulsifier leading, even at low concentrations (0.5–1.5%), to a very high viscosity in W/O emulsions. Used in O/W emulsions it forms a stabilizing network – supporting body, texture, and substantivity. Sunflower Hydrowax can also be utilized as an opacifier for shampoos and as an alternative to fatty alcohol in hair conditioning formulations. 6607H leads to a superb velvety skin feel and is therefore the ideal choice for every cream or lotion. Recommended use level for O/W emulsions is 0.5–3%.

# TECHNICAL DATA

## 6607L SUNFLOWER SEED WAX

**INCI (EU)** HELIANTHUS ANNUUS SEED CERA, ASCORBYL PALMITATE, TOCOPHEROL

**INCI (USA)** HELIANTHUS ANNUUS (SUNFLOWER) SEED WAX, ASCORBYL PALMITATE, TOCOPHEROL

**COLOR** PALE-YELLOWISH

**APPEARANCE** WAXY PELLETS

**DROP MELTING RANGE** 74–80 °C



## 6607H SUNFLOWER HYDROWAX

**INCI (EU)** HYDROLYZED SUNFLOWER SEED WAX

**INCI (USA)** HYDROLYZED SUNFLOWER SEED WAX

**COLOR** YELLOWISH-LIGHT BROWN

**APPEARANCE** WAXY PELLETS

**DROP MELTING RANGE** 65–71 °C



## SYNERESIS

Syneresis is a problem that most formulators have to deal with sooner or later in their career. An oleogel with a minor oil-binding capacity, especially at elevated temperatures, starts sweating oil which forms tiny droplets on the surface. Usually an unbalanced oil-to-wax ratio is the reason, but incompatibilities of the oils and waxes used can cause this stability issue too. The problem can occur shortly after production, but also delayed, after it has been in use for a long time. However, if the oil bleeding is caused by an incompatibility, such as non-matching polarities, the use of a wax with a high oil-binding capacity might reduce the visible signs of the problem, but would not attack the real cause. In this case, it is better to revamp the formulation and adapt polarities. Sometimes the addition of powder fill can help, as it sits between the wax matrix, keeping liquids bound. But if too much powder fill is used, the formulation produces a dry skin feel or, in case of a stick, can break more easily as the crystalline network is no longer bound tight enough.



*Oleogel showing oil sweating.*



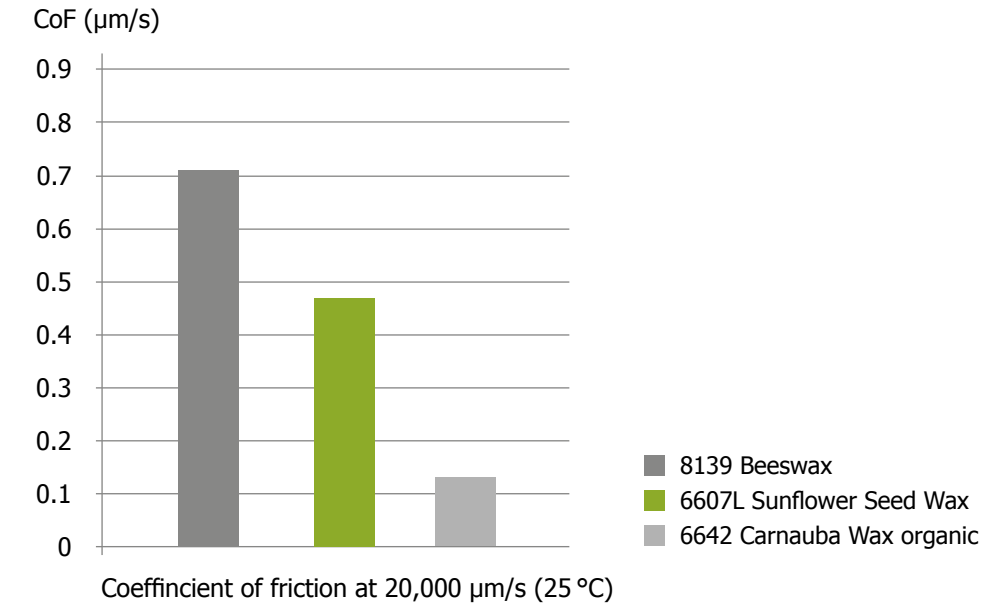
*Stabilized oleogel by adding 2.5 % 6607L Sunflower Seed Wax.*

The use level is 3–9 %. Higher concentrations are only recommended in combination with a high amount of soft components, such as butter and hydrogenated oil and a large oil load.

## RHEOLOGY

Measuring the rheology of pure waxes results in a ranking of lubricity. The higher the coefficient of friction, the duller the wax.

The material under test is sandwiched between two parallel plates. The bottom plate is fixed in rotational terms but can be moved in the vertical axis to facilitate sample loading, cleaning, etc. It also contains a device for accurate control of the temperature. The top plate consists of a circular metal plate fitted to a shaft "floated" on a sophisticated air bearing, which reduces friction to a very low level. A very sensitive electric motor is fitted to the other end of the shaft together with extremely sensitive torque and optical rotation sensors. To make a measurement, a sample of liquid wax is carefully placed on the base plate. The base plate is then raised until a pre-determined gap between it and the top plate is reached, sandwiching the wax between the two plates.



## CRYSTAL MORPHOLOGY & PERFORMANCE

Sunflower Seed Wax has platelet-like crystals which in oil form a tight and strong network with a high and stable oil-binding capacity. Due to the resulting crystal structure, Sunflower Seed Wax is very sensitive to shear force. Once congealed it forms a dense and rigid platelet network that shear would break down to fragments. In emulsions, however, Sunflower Seed Wax is not able to generate a stable and complete network, mainly because its crystals do not form co-crystals with other crystalline materials, such as emulsifiers. Depending on the other ingredients, the incomplete wax matrix can cause instabilities.

Due to the lamellar network structure, Sunflower Seed Wax creates very shiny surfaces. It is the wax with the highest oil-binding capacity and the broadest activity for polar and non-polar emollients. The impact on hardness of oleogels is very high, although Sunflower Seed Wax crystals do not form crystal bridges with other wax crystals (sintering).

## FORMULATIONS

Sunflower Seed Wax is difficult to stabilize in O/W emulsions, therefore most listed formulations are anhydrous. Sunflower Seed Wax has a melting range of 74–80 °C, nevertheless it creates the most stable oleogels, even stored at 50 °C. Therefore it has a great impact on heat resistance.

Please note that not all listed formulations are necessarily available as prototypes.

### COLOR COSMETIC

BRIGHT-EYED AND BUSHY-TAILED | CREAM BLUSH | CC-CHK-005-01 | POT

COVER-UP AGENT | HAIR COVER STICK | CC-HAR-001-01 | TWIST-UP STICK

ON-TIME HIGHLIGHTER | CREAM ILLUMINATOR | CC-FAC-025-02 | POT

ROWDY ROSEWOOD | NATURAL LIPSTICK | CC-LIP-024-06 | STICK 

BRISKLY BRONZE | METAL LIPSTICK | CC-LIP-025-04 | STICK

SINISTER CINNAMON | SUPER GLOSSY, VOLUMIZING SHEER LIPSTICK | CC-LIP-026-06 | STICK

MOANING MAUVE | HOT CLIMATE LIPSTICK | CC-LIP-029-03 | STICK

TIPSY TEA ROSE | SUPER MATTE LIPSTICK | CC-LIP-030-04 | STICK

CRIMINAL CRIMSON | SUPER<sup>3</sup> MOISTURIZING LIPSTICK | CC-LIP-032-02 | STICK

### LIP CARE


KISS FROM A ROSE | MOISTURIZING LIP BALM | SC-LIP-004-04 | STICK

HANG ON MY LIPS | NATURAL OPAQUE LIP BALM | SC-LIP-024-02 | STICK 

BITE YOUR LIP | NATURAL TRANSLUSCENT LIP BALM | SC-LIP-024-03 | SLIM STICK 

### SKIN CARE

THAT'S MY CUP OF TEA | BODY BUTTER BAR | SC-BOD-009-03 | HOT POURED BAR 

BUDDHA'S BLISS | BODY BUTTER BAR | SC-BOD-009-04 | HOT POURED BAR 

DOFT | DEODORANT STICK | SC-BOD-036-15 | TWIST-UP STICK 

GNUGGA | HAND PEELING PASTE | SC-HAN-009-01 | POT

OMSORG | SOLID HAND CREAM | SC-HAN-010-01 | BAR 

GET YOU GONE | BALM TO OIL CLEANSER | SC-FAC-008-02 | JUMBO PENCIL

### HAIR CARE & STYLING

BAREN | SOLID HAIR CONDITIONER | HC-LEN-017-04 | BAR

SNITSIG | HAIR CC CREAM | HC-LEN-018-02 | TUBE

WOLVERINE | WILD STYLE PASTE | MATTE HAIR PASTE | HC-STY-016-04 | POT

IRON MAN | IRONING HAIR FIBER | HAIR FIBER | HC-STY-022-03 | POT

## BRIGHT-EYED AND BUSHY-TAILED | CREAM BLUSH | CC-CHK-005-01 | POT

Ideal for all skin types, this dual cream bronzer and blush creates a gold sparkling, sheer, bronze touch of color on the skin.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	WITARIX MCT 60/40 coconut based	Caprylic/Capric Triglyceride	IOI Oleo	ad 100
	6607L Sunflower Seed Wax	Helianthus Annuus Seed Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	3.25
	6684 Jasmine Wax	Jasminum Grandiflorum Flower Cera	KahlWax	2.00
	6702 Natural Candelilla Wax Substitute	Helianthus Annuus Seed Cera, Shorea Robusta Resin, Rhus Verniciflua Peel Cera/Rhus Succedanea Fruit Cera, Tocopherol, Ascorbyl Palmitate	KahlWax	3.10
	Isopropyl Palmitate	Isopropyl Palmitate	BASF	24.10
B	Red FE Oxide Castor Oil Disp COD 8006	Ricinus Communis Seed Oil, CI 77491	Sun Chemical	4.00
	FD&C Blue Castor Oil Disp COD 8007	Ricinus Communis Seed Oil, CI 42090	Sun Chemical	1.10
	White Castor Oil Disp COD 8008	Ricinus Communis Seed Oil, CI 77891	Sun Chemical	4.60
	MiyoSILK Talc	Talc, Dimethicone	Miyoshi	8.40
C	SunShine C80-3201 Super White	Synthetic Fluorphlogopite, Titanium Dioxide	Sun Chemical	4.30
	SunPearl Super Bronze	Synthetic Fluorphlogopite, CI 77491	Sun Chemical	4.65
	Tapioca Pure	Tapioca Starch	Akzo Nobel	5.60
	RonaFlair Boroneige SF-15	Boron Nitride	Merck	2.00
	Dow Corning Cosmetic Powder 9701	Dimethicone/Vinyl Dimethicone Crosspolymer, Silica	Dow Corning	5.60
D	Istanbul V/40 568	Tapioca Starch	Vögele	0.30

## PROCEDURE

Combine phase A ingredients at 95 °C. Add phase B while homogenizing. Add phase C ingredients in given order with high shear mixing. Take care that the bulk is homogeneous after each addition. Maintain the temperature at 80 °C to allow entrapped air to dissipate. Add phase D and pour into jars at 70–75 °C.

## COVER-UP AGENT | HAIR COVER STICK | CC-HAR-001-01 | TWIST-UP STICK

A velvety, easy-to-apply, and long-lasting color stick to effectively cover up grey hair, refresh roots, and fill in sparse spaces. This water-free formula, in a natural brown shade with matte finish, comes in a portable twist-up stick, allowing mess-free application on the go—just set with a dash of hair spray.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	6607L Sunflower Seed Wax	Helianthus Annuus Seed Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	3.10
	6702 Natural Candelilla Wax Substitute	Helianthus Annuus Seed Cera, Shorea Robusta Resin, Rhus Verniciflua Peel Cera/Rhus Succedanea Fruit Cera, Tocopherol, Ascorbyl Palmitate	KahlWax	5.20
	Isopropyl Myristate	Isopropyl Myristate	BASF	6.70
	Isopropyl Palmitate	Isopropyl Palmitate	BASF	18.30
	WITARIX MCT 60/40 coconut based	Caprylic/Capric Triglyceride	IOI Oleo	ad 100
B	Soft-Tex C33-7734 Black Iron Oxide	CI 77499	Sun Chemical	2.10
	Soft-Tex C33-7715 Brown Iron Oxide	CI 77491, CI 77492, CI 77499	Sun Chemical	7.20
	Soft-Tex Titanium Dioxide	Titanium Dioxide	Sun Chemical	10.30
	MiyoSILK Talc	Talc, Dimethicone	Miyoshi	11.30
C	Tapioca Pure	Tapioca Starch	Akzo Nobel	10.20

## PROCEDURE

Combine phase A ingredients at 95 °C. Add phase B ingredients and homogenize for 1–2 minutes. Add phase C with high shear mixing. Take care that the bulk is homogeneous. Keep the temperature at about 80 °C and allow entrapped air to dissipate. Fill into suitable packaging.

## ON-TIME HIGHLIGHTER | CREAM ILLUMINATOR | CC-FAC-025-02 | POT

This cream highlighter has a powdery, dry, and perfectly light skin feel and adds a pearlescent shine, which becomes more intense on tanned skin. Perfect for every occasion, it can be worn on a carefree day at the beach as well as on glamorous evenings.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	Cetiol PGL	Hexyldecanol, Hexyldecyl Laurate	BASF	ad 100
	Xiameter PMX-245	Cyclopentasiloxane	Dow Corning	10.50
	Crodamol OP	Ethylhexyl Palmitate	Croda	10.50
	Schercemol SHS Ester	Isostearyl Hydroxystearate	Lubrizol	7.30
	6723 Shorea Robusta Resin + Octyldodecanol	Shorea Robusta Resin, Octyldodecanol	KahlWax	5.30
	6089 Microwax	Cera Microcristallina	KahlWax	5.30
	6607L Sunflower Seed Wax	Helianthus Annuus Seed Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	3.00
B	Soft-Tex C33-7720 Yellow Iron Oxide	CI 77942	Sun Chemical	0.30
	Soft-Tex C33-7715 Brown Iron Oxide	CI 77491, CI 77492, CI 77499	Sun Chemical	0.10
	Soft-Tex Titanium Dioxide	Titanium Dioxide	Sun Chemical	2.60
	Steasilk 5 CI	Talc	Imerys Minerals	7.30
C	SunShine Fine White C80-3100	Synthetic Fluorphlogopite, Titanium Dioxide	Sun Chemical	14.20
	SunPearl Gold	Mica, Titanium Dioxide	Sun Chemical	13.40

## PROCEDURE

Combine phase A ingredients and heat to 70–80 °C. Add phase B and homogenize for 1 minute. Add phase C under stirring. Remove entrapped air e.g. with vacuum. Fill into suitable packaging at 65 °C.

## ROWDY ROSEWOOD | NATURAL LIPSTICK | CC-LIP-024-06 | STICK



Give lips lush color and exquisite beauty with this natural lipstick. Elegant, moisturizing formulation with discreet shine and medium coverage.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	2811 Rice Bran Wax	Oryza Sativa Bran Cera	KahlWax	4.50
	6607L Sunflower Seed Wax	Helianthus Annuus Seed Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	4.00
	8104 Beeswax white	Cera Alba	KahlWax	3.80
	WITARIX MCT 60/40 coconut based	Caprylic/Capric Triglyceride	IOI Oleo	ad 100
	Almond Oil	Prunus Amygdalus Dulcis Oil	Henry Lamotte	11.10
B	Castor Oil	Ricinus Communis Seed Oil	Henry Lamotte	7.50
	Black FE Oxide Castor Oil Disp COD 8004	Ricinus Communis Seed Oil, CI 77499	Sun Chemical	0.50
	Red FE Oxide Castor Oil Disp COD 8006	Ricinus Communis Seed Oil, CI 77491	Sun Chemical	11.60
C	White Castor Oil Disp COD 8008	Ricinus Communis Seed Oil, CI 77891	Sun Chemical	16.40
	RonaFlair Mica M	Mica	Merck	5.00
	Dermofeel MT 70 non GMO	Tocopherol, Helianthus Annuus (Sunflower) Seed Oil	Evonik Dr. Straetmans	0.10
	Passioline	Passiflora Edulis Seed Oil	Expanscience Laboratoires	1.00

## PROCEDURE

Melt phase A at 90–95 °C. Add phase B and homogenize for 1 minute. Cool to 85 °C and add phase C ingredients in listed order. Stir until homogeneous and fill into molds.

MATTE ○○●○○ GLOSSY

MOISTURIZING ○○●○○ LONG-LASTING

## BRISKLY BRONZE | METAL LIPSTICK | CC-LIP-025-04 | STICK

Multi-dimensional color collides with a glistening silver-bronze effect for out-of-this world lips. Our creamy-smooth metal lipstick covers lips in a long-lasting, lustrous color, and a dazzling metallic finish.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	6642 Carnauba Wax LC organic	Copernicia Cerifera Cera	KahlWax	4.00
	5725 Araucaria Resin + Castor Oil	Glyceryl Rosinate, Ricinus Communis Seed Oil, Ascorbyl Palmitate, Tocopherol	KahlWax	16.40
	7236 OrganicJelly	Ricinus Communis Seed Oil, Cera Alba, Copernicia Cerifera Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	10.40
	6607H Sunflower Hydrowax	Hydrolyzed Sunflower Seed Wax	KahlWax	6.60
	Castor Oil (refined)	Ricinus Communis Seed Oil	Gustav Heess	ad 100
	WITARIX MCT 60/40 coconut based	Caprylic/Capric Triglyceride	IOI Oleo	20.00
B	Aerosil 200	Silica	Evonik	1.50
	Black FE Oxide Castor Oil Disp COD 8004	Ricinus Communis Seed Oil, CI 77499	Sun Chemical	2.50
	Red FE Oxide Castor Oil Disp COD 8006	Ricinus Communis Seed Oil, CI 77491	Sun Chemical	2.50
C	Colorona Patina Silver	Mica, Iron Oxides, Titanium Dioxide	Merck	5.00
	Timiron Liquid Silver	Bismuth Oxychloride, Ethylhexyl Hydroxystearate	Merck	9.50
D	Dermofeel MT 70 non GMO	Tocopherol, Helianthus Annuus (Sunflower) Seed Oil	Evonik Dr. Straetmans	0.20
	Silky Lips	Parfum	Bell Flavors	0.10

## PROCEDURE

Heat phase A ingredients to 85–90 °C and stir until everything is melted. Add phase B and stir for 10–15 minutes. Add phase C ingredients under stirring and homogenize for 30 seconds. Cool to 80 °C, add phase D, and fill into suitable packaging.

MATTE ○○●○○ GLOSSY

MOISTURIZING ○○○●○ LONG-LASTING

## SINISTER CINNAMON | SUPER GLOSSY, VOLUMIZING SHEER LIPSTICK | CC-LIP-026-06 | STICK

This innovative formula will make lips visibly moisturized and softer, topped off with a gorgeous opalescence-shine and sheer cinnamon color. It also protects the lips, helping to increase hydration levels, so lips appear to be soft, supple, and more voluminous.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	5725 Araucaria Resin + Castor Oil	Glyceryl Rosinate, Ricinus Communis Seed Oil	KahlWax	32.90
	7036PLUS VegoJelly	Ricinus Communis Seed Oil, Rhus Verniciflua Peel Cera/ Rhus Succedanea Fruit Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	12.80
	6607L Sunflower Seed Wax	Helianthus Annuus Seed Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	7.30
	6240 Vegetable Wax	Hydrogenated Vegetable Oil	KahlWax	3.00
	Castor Oil (refined)	Ricinus Communis Seed Oil	Gustav Heess	ad 100
	Jojoba Oil (refined)	Simmondsia Chinensis Seed Oil	Gustav Heess	5.00
B	Softigen Oil Baobab	Adansonia Digitata Seed Oil	IOI Oleo	2.50
	D&C Red 7 Castor Oil Disp COD 8001	Ricinus Communis Seed Oil, CI 15850	Sun Chemical	0.60
	Red FE Oxide Castor Oil Disp COD 8006	Ricinus Communis Seed Oil, CI 77491	Sun Chemical	2.40
	FD&C Blue Castor Oil Disp COD 8007	Ricinus Communis Seed Oil, CI 42090	Sun Chemical	0.20
	White Castor Oil Disp COD 8008	Ricinus Communis Seed Oil, CI 77891	Sun Chemical	2.60
C	RonaFlair Mica M	Mica	Merck	3.00
	RonaFlair LDP White	Sodium Potassium Aluminum Silicate, Titanium Dioxide, Silica	Merck	3.00
D	Dermofeel MT 70 non GMO	Tocopherol, Helianthus Annuus (Sunflower) Seed Oil	Evonik Dr. Straetmans	0.20

## PROCEDURE

Heat phase A ingredients to 90–95 °C and stir until everything is melted. Add phase B and stir for 5–10 minutes. Homogenize for 1–2 minutes and add phase C ingredients under stirring. Add phase D, cool to 80 °C, and fill into molds.

MATTE ○○○○● GLOSSY

MOISTURIZING ○●○○○ LONG-LASTING

## MOANING MAUVE | HOT CLIMATE LIPSTICK | CC-LIP-029-03 | STICK

This formulation is especially designed for hot climates and is therefore much more heat-resistant than an average lipstick. It coats lips in a comfortable, rich pigmented film with medium coverage, natural gloss, and good transfer resistance.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	6607L Sunflower Seed Wax	Helianthus Annuus Seed Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	6.80
	6642 Carnauba Wax LC organic	Copernicia Cerifera Cera	KahlWax	5.80
	2803 Polyethylene	Polyethylene	KahlWax	2.00
	Nexbase 2006	Hydrogenated Polydecene	Nesté Oil	ad 100
	Dermofeel BGC	Butylenglycol Dicaprylate/Dicaprate	Evonik Dr. Straetmans	17.50
	Castor Oil (refined)	Ricinus Communis Seed Oil	Gustav Heess	8.30
	Dehymuls PGPH	Polyglyceryl-2 Dipolyhydroxystearate	BASF	2.40
B	Silshine 151	Phenylpropyldimethylsiloxysilicate	Momentive	1.50
	FD&C Red 6 Ba LK CO Disp COD 8002	Ricinus Communis Seed Oil, CI 15850	Sun Chemical	9.20
	FD&C Blue Castor Oil Disp COD 8007	Ricinus Communis Seed Oil, CI 42090	Sun Chemical	2.90
	White Castor Oil Disp COD 8008	Ricinus Communis Seed Oil, CI 77891	Sun Chemical	6.50
C	SunShine C80-3201 Super White	Synthetic Fluorphlogopite, Titanium Dioxide	Sun Chemical	2.00
	Dermofeel MT 70 non GMO	Tocopherol, Helianthus Annuus (Sunflower) Seed Oil	Evonik Dr. Straetmans	0.05
	Silky Lips	Parfum	Bell Flavors	0.05

## PROCEDURE

Combine all phase A ingredients at 110–115 °C under stirring. Add phase B, stir approx. 15 minutes with a dissolver, and homogenize. Add phase C, cool to 80–85 °C, and fill into suitable packaging.

MATTE ○○●○○ GLOSSY

MOISTURIZING ○○○●○ LONG-LASTING

## TIPSY TEA ROSE | SUPER MATTE LIPSTICK | CC-LIP-030-04 | STICK

Ultra matte lipstick formula that does not dry out sensitive skin. The coverage is rich and creamy and has a velvet finish.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	6607L Sunflower Seed Wax	Helianthus Annuus Seed Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	3.30
	8138 Beeswax LC organic	Cera Alba	KahlWax	6.50
	6642 Carnauba Wax LC organic	Copernicia Cerifera Cera	KahlWax	8.20
	Miglyol 8810	Butylene Glycol Dicaprylate/Dicaprate	IOI Oleo	ad 100
	WITARIX MCT 60/40 coconut based	Caprylic/Capric Triglyceride	IOI Oleo	26.00
B	D&C Red 7 Castor Oil Disp COD 8001	Ricinus Communis Seed Oil, CI 15850	Sun Chemical	0.60
	Black FE Oxide Castor Oil Disp COD 8004	Ricinus Communis Seed Oil, CI 77499	Sun Chemical	0.60
	Red FE Oxide Castor Oil Disp COD 8006	Ricinus Communis Seed Oil, CI 77491	Sun Chemical	4.60
	White Castor Oil Disp COD 8008	Ricinus Communis Seed Oil, CI 77891	Sun Chemical	11.90
C	Dry-Flo TS	Tapioca Starch, Polymethylsilsesquioxane	Akzo Nobel	5.40
	RonaFlair Boroneige SF-15	Boron Nitride	Merck	1.70
	RonaFlair LDP White	Sodium Potassium Aluminum Silicate, Titanium Dioxide, Silica	Merck	5.40

## PROCEDURE

Combine phase A ingredients at 95 °C. Add phase B and stir for 5 minutes with a dissolver. Homogenize for 30 seconds. Add phase C ingredients at 95 °C and stir for 10 minutes. Cool to 85–90 °C and mold.

MATTE ●○○○○ GLOSSY

MOISTURIZING ○○○●○ LONG-LASTING



CRIMINAL CRIMSON | SUPER<sup>3</sup> MOISTURIZING LIPSTICK | CC-LIP-032-02 | STICK

High coverage, super moisturizing lipstick loaded with hydrating ingredients like 6422 Veggiesoft Complex. Has a very rich pay-off with super glossy, intense color.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	6290 Berry Wax	Rhus Verniciflua Peel Cera/Rhus Succedanea Fruit Cera	KahlWax	6.00
	6642 Carnauba Wax LC organic	Copernicia Cerifera Cera	KahlWax	7.00
	6607H Sunflower Hydrowax	Hydrolyzed Sunflower Seed Wax	KahlWax	6.90
	6422 Veggiesoft Complex	Rhus Verniciflua Peel Cera/Rhus Succedanea Fruit Cera, Simmondsia Chinensis Seed Oil, Cetearyl Alcohol, Myristyl Alcohol, Caprylic/Capric Triglyceride, Copernicia Cerifera Cera, Tocopherol	KahlWax	5.00
	Cetiol J 600	Oleyl Erucate	BASF	ad 100
	Lipocire A SG	C10-18 Triglycerides	Gattefossé	2.00
	Jojoba Oil (refined)	Simmondsia Chinensis Seed Oil	Gustav Heess	8.00
B	D&C Red 7 Castor Oil Disp COD 8001	Ricinus Communis Seed Oil, CI 15850	Sun Chemical	4.60
	FD&C Red 6 Ba LK CO Disp COD 8002	Ricinus Communis Seed Oil, CI 15850	Sun Chemical	14.00
	Black FE Oxide Castor Oil Disp COD 8004	Ricinus Communis Seed Oil, CI 77499	Sun Chemical	0.20
	White Castor Oil Disp COD 8008	Ricinus Communis Seed Oil, CI 77891	Sun Chemical	4.60
C	Virgin Maracuja Oil	Passiflora Edulis Seed Oil	Expanscience Laboratoires	1.00

## PROCEDURE

Combine all phase A ingredients at 90–95°C under stirring. Add phase B, stir approx. 10 minutes with a dissolver, and homogenize. Cool to 80–85°C, add phase C, and fill into suitable packaging.

MATTE ○○○○● GLOSSY

MOISTURIZING ●○○○○ LONG-LASTING

## KISS FROM A ROSE | MOISTURIZING LIP BALM | SC-LIP-004-04 | STICK

Enriched with skin protecting 6692 Rose Wax, and jojoba oil, this light but nourishing lip balm comforts on contact, providing smoothness and intense moisture.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	6692 Rose Wax	Rosa Damascena Flower Cera	KahlWax	2.00
	7235 NaturalJelly	Ricinus Communis Seed Oil, Cera Alba, Copernicia Cerifera Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	14.50
	6290 Berry Wax	Rhus Verniciflua Peel Cera/Rhus Succedanea Fruit Cera	KahlWax	5.00
	6607L Sunflower Seed Wax	Helianthus Annuus Seed Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	8.00
	6702 Natural Candelilla Wax Substitute	Helianthus Annuus Seed Cera, Shorea Robusta Resin, Rhus Verniciflua Peel Cera/Rhus Succedanea Fruit Cera, Tocopherol, Ascorbyl Palmitate	KahlWax	6.00
	5725 Araucaria Resin + Castor Oil	Glyceryl Rosinate, Ricinus Communis Seed Oil, Ascorbyl Palmitate, Tocopherol	KahlWax	6.00
	Nacol 16-95	Cetyl Alcohol	Sasol	2.00
	Jojoba Oil	Simmondsia Chinensis Seed Oil	Henry Lamotte	15.20
	Eutanol G	Octyldodecanol	BASF	ad 100
	Dehymuls PGPH	Polyglyceryl-2 Dipolyhydroxystearate	BASF	9.00
B	Water	Aqua		8.00
	Glycerin	Glycerin	Merck	0.50
C	Preservative			q.s

## PROCEDURE

Combine phase A and B ingredients separately at 80°C. Add phase B to A. Stir with a dissolver for 15 minutes and homogenize for 1 minute. Cool the bulk to 75°C, add phase C, and fill into molds.

## HANG ON MY LIPS | NATURAL OPAQUE LIP BALM | SC-LIP-024-02 | STICK



This simple beeswax based lip balm is great at maintaining soft, healthy-looking lips.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	7235 NaturalJelly	Ricinus Communis Seed Oil, Cera Alba, Copernicia Cerifera Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	ad 100
	8104 Beeswax white	Cera Alba	KahlWax	11.00
	5725 Araucaria Resin + Castor Oil	Glyceryl Rosinate, Ricinus Communis Seed Oil, Ascorbyl Palmitate, Tocopherol	KahlWax	21.50
	6607L Sunflower Seed Wax	Helianthus Annuus Seed Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	2.00
	Jjoba Oil	Simmondsia Chinensis Seed Oil	Henry Lamotte	15.50
	WITARIX MCT 60/40 coconut based	Caprylic/Capric Triglyceride	IOI Oleo	5.50
B	Dermofeel MT 70 non GMO	Tocopherol, Helianthus Annuus (Sunflower) Seed Oil	Evonik Dr. Straetmans	1.00

## PROCEDURE

Combine phase A ingredients and heat to 85–90 °C. When all ingredients are completely melted, cool to 75 °C. Add phase B and fill into molds.

## BITE YOUR LIP | NATURAL TRANSLUSCENT LIP BALM | SC-LIP-024-03 | SLIM STICK



Super soft and rich formulation that leaves a light, silky barrier on lips. Everything is naturally derived, so you can apply and apply, and reapply, with abandon.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	7235 NaturalJelly	Ricinus Communis Seed Oil, Cera Alba, Copernicia Cerifera Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	ad 100
	8104 Beeswax white	Cera Alba	KahlWax	10.30
	5725 Araucaria Resin + Castor Oil	Glyceryl Rosinate, Ricinus Communis Seed Oil, Ascorbyl Palmitate, Tocopherol	KahlWax	23.50
	6607L Sunflower Seed Wax	Helianthus Annuus Seed Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	1.80
	Jjoba Oil	Simmondsia Chinensis Seed Oil	Henry Lamotte	17.00
	WITARIX MCT 60/40 coconut based	Caprylic/Capric Triglyceride	IOI Oleo	5.40
B	Dermofeel MT 70 non GMO	Tocopherol, Helianthus Annuus (Sunflower) Seed Oil	Evonik Dr. Straetmans	1.00

## PROCEDURE

Combine phase A ingredients and heat to 85–90 °C. When all ingredients are completely melted, cool to 70 °C. Add phase B and fill into packaging.

## THAT'S MY CUP OF TEA | BODY BUTTER BAR | SC-BOD-009-03 | HOT POURED BAR



Let this rich body butter melt on your skin for a sublimely nourishing treat. Enriched with 6614 Tea Wax, it will make your skin feel more soft and supple after every use.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	6237 Rapeseed Wax	Hydrogenated Rapeseed Oil	KahlWax	ad 100
	6607L Sunflower Seed Wax	Helianthus Annuus Seed Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	12.00
	6614 Tea Wax	Camellia Sinensis Leaf Wax	KahlWax	1.50
	Apricot Kernel Oil	Prunus Armeniaca Kernel Oil	Henry Lamotte	22.00
	Almond Oil	Prunus Amygdalus Dulcis Oil	Henry Lamotte	10.00
	Jjoba Oil	Simmondsia Chinensis Seed Oil	Henry Lamotte	11.35
B	Black FE Oxide Castor Oil Disp COD 8004 (1%)	Ricinus Communis Seed Oil, CI 77499	Sun Chemical	0.10
	FD&C Blue Castor Oil Disp COD 8007 (1%)	Ricinus Communis Seed Oil, CI 42090	Sun Chemical	0.15
	White Castor Oil Disp COD 8008	Ricinus Communis Seed Oil, CI 77891	Sun Chemical	0.50
C	Ananas natural	Parfum	Vögele	0.15

## PROCEDURE

Combine oils and waxes at 85–90 °C. Add phase B and homogenize shortly. Cool under slow stirring to 75–80 °C. Add phase C and fill into molds.

## BUDDHA'S BLISS | BODY BUTTER BAR | SC-BOD-009-04 | HOT POURED BAR

Enriched with 2811 Rice Bran Wax, this buttery praline melts softly on the skin, providing a luxurious sensation and a nourishing effect.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	6237 Rapeseed Wax	Hydrogenated Rapeseed Oil	KahlWax	ad 100
	6607L Sunflower Seed Wax	Helianthus Annuus Seed Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	8.90
	2811 Rice Bran Wax	Oryza Sativa Bran Cera	KahlWax	3.00
	Rice Bran Oil	Oryza Sativa Bran Oil	Henry Lamotte	28.50
	Almond Oil	Prunus Amygdalus Dulcis Oil	Henry Lamotte	14.60
	White Castor Oil Disp COD 8008	Ricinus Communis Seed Oil, CI 77891	Sun Chemical	1.00
B	Macadamia Supreme Touch	Ricinus Communis Seed Oil, CI 42090	Düllberg	0.50

## PROCEDURE

Combine oils and waxes at 85–90 °C. Add phase B and homogenize shortly. Cool under slow stirring to 75–80 °C and fill into molds.

## DOFT | DEODORANT STICK | SC-BOD-036-15 | TWIST-UP STICK



With a clean, discreet and gender neutral scent, this water-free, vegan and completely natural deodorant stick offers effective protection against odors and wetness.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	Lanette 18	Stearyl Alcohol	BASF	14.60
	6607L Sunflower Seed Wax	Helianthus Annuus Seed Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	8.70
	WITARIX MCT 60/40 coconut based	Caprylic/Capric Triglyceride	IOI Oleo	ad 100
	Cetiol C5	Coco-Caprylate	BASF	21.70
	Dermofeel decalact deo	Sodium Caproyl/Lauroyl Lactylate, Triethyl Citrate, Salvia Officinalis Oil	Evonik Dr. Straetmans	4.30
B	White Castor Oil Disp COD 8008	Ricinus Communis Seed Oil, CI 77891	Sun Chemical	0.20
	ImerCare 400D	Diatomaceous Earth	Imerys Minerals	11.00
C	Mila natural	Parfum	Vögele	1.50

## PROCEDURE

Melt all ingredients of phase A at 80–85 °C while stirring. Add phase B one after the other and stir for 5 minutes. Homogenize shortly. Cool to 65–70 °C and add phase C. Fill into container.

## GNUGGA | HAND PEELING PASTE | SC-HAN-009-01 | POT

This creamy hand peeling paste is the perfect way to keep your hands in tip top condition. One small scoop will exfoliate with gentle 2811P Rice Bran Wax Beads, while softening at the same time with 6427 Megasoft Complex, leaving the skin feeling silky and moisturized.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	Water	Aqua		25.00
	Glycerin	Glycerin	Merck	1.30
	Euxyl K 350	Phenoxyethanol, Methylparaben, Ethylparaben, Ethylhexylglycerin, Propylene Glycol	Schülke & Mayr	0.50
	WorléeAqua Thix 150	Acrylates Copolymer	Worlée	0.60
	A1	NaOH (30 %)	Aqua, Sodium Hydroxide	
B	Arlacel 165	Glyceryl Stearate, PEG-100 Stearate	Croda	1.80
	Lanette O	Cetearyl Alcohol	BASF	1.40
	Tamanu Oil	Calophyllum Inophyllum Seed Oil	Starlight Products	2.20
	6427 Megasoft Complex	Crambe Abyssinica Seed Oil, Euphorbia Cerifera Cera, Hydroxystearic Acid, Beta-Sitosterol, Rhus Verniciflua Peel Cera/Rhus Succedanea Fruit Cera, Tocopherol, Helianthus Annuus Seed Oil	KahlWax	1.00
	6607H Sunflower Hydrowax	Hydrolyzed Sunflower Seed Wax	KahlWax	1.50
	6237 Rapeseed Wax	Hydrogenated Rapeseed Oil	KahlWax	9.00
C	2442P100N Carnauba Wax Powder	Copernicia Cerifera Cera	KahlWax	ad 100
	2811P Rice Bran Wax Beads	Oryza Sativa Bran Cera	KahlWax	4.50
D	Mint & Tangarine 1352/3	Parfum	Vanessence	0.60
	Unicert Yellow 08005-J (0.10 %)	Aqua, CI 19140	Sensient	0.60

## PROCEDURE

Blend phase A ingredients and neutralize with phase A1. Heat to 80–85 °C under stirring. Combine phase B ingredients and heat to 80–85 °C. Add phase B to A/A1 under agitation. Continue mixing for 3–5 minutes. Cool to 45 °C and add phase C. Add phase D below 40 °C and fill into suitable packaging.

## OMSORG | SOLID HAND CREAM | SC-HAN-010-01 | BAR



As you rub this hand cream bar between your hands or massage it directly on dry skin areas, your body heat will soften it, releasing skin-nourishing oils and protective ingredients. The natural and vegan formula is quickly absorbed, long-lasting, and great for travelling.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	7235 NaturalJelly	Ricinus Communis Seed Oil, Cera Alba, Copernicia Cerifera Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	ad 100
	6422 Veggiesoft Complex	Rhus Verniciflua Peel Cera/Rhus Succedanea Fruit Cera, Simmondsia Chinensis Seed Oil, Cetearyl Alcohol, Myristyl Alcohol, Caprylic/Capric Triglyceride, Copernicia Cerifera Cera, Tocopherol	KahlWax	20.00
	6607H Sunflower Hydrowax	Hydrolyzed Sunflower Seed Wax	KahlWax	5.00
	2225 Phyto Wax	Helianthus Annuus Seed Cera, Olea Europaea Oil Unsaponifiables, Rhus Verniciflua Peel Cera/Rhus Succedanea Fruit Cera, Shorea Robusta Resin	KahlWax	10.00
	Eutanol G	Octyldodecanol	BASF	18.00

## PROCEDURE

Melt all ingredients at 90 °C. Cool to 80 °C and fill into suitable packaging.

## GET YOU GONE | BALM TO OIL CLEANSER | SC-FAC-008-02 | JUMBO PENCIL

An on-the-go make-up removal stick to gently dissolve all traces of make-up. The silky, non-greasy formula dissolves even long-wearing make-up. Apply on face, massage in with fingertips, and remove with warm water or cotton pads.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	Miglyol DO	Decyl Oleate	IOI Oleo	ad 100
	Miglyol 812	Caprylic/Capric Triglyceride	IOI Oleo	8.50
	Nexbase 2006	Hydrogenated Polydecene	Nesté Oil	12.80
	6607L Sunflower Seed Wax	Helianthus Annuus Seed Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	1.80
	6237 Rapeseed Wax	Hydrogenated Rapeseed Oil	KahlWax	4.30
	6240 Vegetable Wax	Hydrogenated Vegetable Oil	KahlWax	4.30
	7791 Polyethylene	Polyethylene	KahlWax	4.30
	Protelan ENS	Glyceryl Stearate, Cetearyl Alcohol, Stearic Acid, Sodium Lauroyl Glutamate	Zschimmer & Schwarz	17.00
	Nikkol GO-430 NV	PEG-30 Sorbitan Tetraoleate	Nikkol	4.30
	Tobacco Oud FF ux	Parfum	Düllberg	0.20

## PROCEDURE

Melt all ingredients at 90–95 °C. Cool and pour into molds at 70–75 °C.

## BAREN | SOLID HAIR CONDITIONER | HC-LEN-017-04 | BAR

Apply on wet hair after shampooing and massage through – this solid conditioner saves on packaging material and water while leaving hair happy and healthy. The simply effective vegan formula is eco- and travel-friendly as well as long-lasting.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	ProCondition 22	Brassicamidopropyl Dimethylamine	Inolex	24.80
	Nacol 16-95	Cetyl Alcohol	Sasol	5.00
	6422 Veggiesoft Complex	Rhus Verniciflua Peel Cera/Rhus Succedanea Fruit Cera, Simmondsia Chinensis Seed Oil, Cetearyl Alcohol, Myristyl Alcohol, Caprylic/Capric Triglyceride, Copernicia Cerifera Cera, Tocopherol	KahlWax	ad 100
	6607H Sunflower Hydrowax	Hydrolyzed Sunflower Seed Wax	KahlWax	4.40
	Baobab Oil	Adansonia Digitata Seed Oil	Starlight Products	26.50
B	Zetesol NL-2 U	Sodium Laureth Sulfate	Zschimmer & Schwarz	14.60

## PROCEDURE

Melt all ingredients of phase A at 80°C. Add phase B under slow stirring and continue mixing until a clear solution is obtained. Remove entrapped air and fill into molds at 60–65°C.

## SNITSIG | HAIR CC CREAM | HC-LEN-018-02 | TUBE

This leave-on hair treatment hydrates, conditions, softens, and protects thanks to nourishing daikon seed extract. 6607H Sunflower Hydrowax stabilizes the lightweight formula that combines high gloss with low greasiness.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	Water	Aqua		ad 100
A1	Lecigel	Sodium Acrylates Copolymer, Lecithin	Lucas Meyer Cosmetics	0.50
B	Stearic Acid	Stearic Acid		1.00
	Lanette 22	Behenyl Alcohol	BASF	1.50
	6607H Sunflower Hydrowax	Hydrolyzed Sunflower Seed Wax	KahlWax	3.00
	Daikon Seed Extract	Raphanus Sativus Seed Extract	Natural Plant Products	6.80
C	Licorice V50 597	Parfum	Vögele	0.30
	Preservative			q.s.

## PROCEDURE

Add phase A1 to A under stirring and heat to 80–85°C. Stir until the product is thick and homogeneous. Heat phase B separately to 85°C and add to A/A1. Homogenize for 30 seconds and cool to 40°C. Add phase C and cool further to RT. Fill into suitable packaging.

WOLVERINE | WILD STYLE PASTE | MATTE HAIR PASTE | HC-STY-016-04 | POT

Get the wild look! Whether tousled, disheveled, tame or straight – the main thing is: it's matte. For creative styles with medium hold, this matte-effect texturizing paste is perfect.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	Water	Aqua		ad 100
	WorléeAqua Thix 150	Acrylates Copolymer	Worlée	1.50
B	NaOH (30 %)	Aqua, Sodium Hydroxide		0.40
	WorléeBase AQ 77491 (4 %)	Glycerin, Aqua, CI 77491, Methylpropanediol, Ammonium Acrylates Copolymer, Caprylyl Glycol, Phenylpropanol, Sodium Acrylates Copolymer, Simethicone	Worlée	0.50
	WorléeBase AQ 77499 (4 %)	Glycerin, Aqua, Ammonium Acrylates Copolymer, CI 77499, Methylpropanediol, Simethicone, Caprylyl Glycol, Phenylpropanol	Worlée	1.00
C	Apifil CG	PEG-8 Beeswax	Gattefossé	2.00
	8104 Beeswax white	Cera Alba	KahlWax	18.00
	6607L Sunflower Seed Wax	Helianthus Annuus Seed Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	5.00
	7235 NaturalJelly	Ricinus Communis Seed Oil, Cera Alba, Copernicia Cerifera Cera, Ascorbyl Palmitate, Tocopherol	KahlWax	3.00
	Isopropyl Myristate	Isopropyl Myristate	BASF	5.00
	Emulgade PL 68/50	Cetearyl Glucoside, Cetearyl Alcohol	BASF	5.00
D	Preservative			q.s.

#### PROCEDURE

Mix phase A ingredients until uniform. Add phase B ingredients one after the other. Heat phase A/B and C separately to 90 °C. Add phase C to A/B under stirring. Cool to 65 °C and add phase D. Fill into packaging at 60 °C.

MATTE ●○○○○ GLOSSY      FLEXIBLE ○○●○○ STRONG HOLD

IRON MAN | IRONING HAIR FIBER | HAIR FIBER | HC-STY-022-03 | POT

Pale yellow hair fiber with hold and low shine. This resinous product helps to thicken, texturize, and increase the fullness of hair. Enriched with 6723 Shorea Robusta Resin. Works best in short hair.

PHASE	TRADENAME	INCI (EU)	SUPPLIER	%
A	Water	Aqua		ad 100
	Propylene Glycol	Propylene Glycol		4.50
	Luviset One	Acrylates/Methacrylamide Copolymer	BASF	1.70
A1	NaOH (15 %)	Aqua, Sodium Hydroxide		0.30
B	8089 Web Effect Wax	Cera Alba, Cetearth-25, Oryza Sativa Bran Cera	KahlWax	12.20
	6607H Sunflower Hydrowax	Hydrolyzed Sunflower Seed Wax	KahlWax	13.80
	6723 Shorea Robusta Resin + Octyldodecanol	Shorea Robusta Resin, Octyldodecanol	KahlWax	18.00
	Promulgen D	Cetearyl Alcohol, Cetearth-20	Lubrizol	3.50
	Arlacel 165	Glyceryl Stearate, PEG-100 Stearate	Croda	3.50
	Eutanol G	Octyldodecanol	BASF	4.50
C	Unicert Yellow 08005-J (0.10 %)	Aqua, CI 19140	Sensient	1.00
	Preservative			q.s.

#### PROCEDURE

Mix phase A ingredients and add phase A1. Stir until homogeneous. Heat phase A/A1 to 80–85 °C. Mix phase B ingredients and heat to 85 °C. Add phase B to A/A1 under stirring. Stir for 2–3 minutes while adding phase C and pour into suitable packaging at 80 °C.

MATTE ○○●○○ GLOSSY      FLEXIBLE ○○○●○ STRONG HOLD