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## Water Resistant/Smudge Resistant Mascara with K-20W

*Products highlighted: Floraesters<sup>®</sup> K-20W Jojoba*

This formula produces a long-lasting, water resistant, smudge-resistant mascara that thickens and lengthens lashes. Floraesters K-20W Jojoba contributes to the long-lasting moisture resistance, but the product still comes off easily with makeup remover.

Phase	Trade Name	INCI Name	Supplier	%wt./wt.
A.	Carnauba Wax #1 Yellow SP 63	Copernicia Cerifera (Carnauba) Wax	Strahl & Pitsch	1.0
	Candelilla Wax SP 75	Euphorbia Cerifera (Candelilla) Wax	Strahl & Pitsch	5.0
	Beeswax Yellow SP 6	Beeswax	Lubrizol	5.0
	Ozokerite Wax White SP 1026P	Ozokerite	Strahl & Pitsch	2.0
	Pristerene 4911	Stearic Acid	Uniqema	5.0
	Lanette 16	Cetyl Alcohol	Cognis	3.0
	Fluilan	Lanolin Oil	Croda	3.0
B.	Propylene Glycol	Propylene Glycol	Ashland	3.0
	Potassium Hydroxide 28% Solution	Potassium Hydroxide (and) Water	Spectrum	3.0
C.	Deionized Water	Water	-----	Q.S.
	Dermacryl-79	Acrylates/Octylacrylamide Copolymer	National Starch	2.5
	<b>Floraesters K-20W Jojoba</b>	<b>Hydrolyzed Jojoba Esters (and) Water (Aqua)</b>	<b>Floratech</b>	<b>12.5</b>
D.	Pur Oxy Black BC #3068	Iron Oxide	Lubrizol	10.00
E.	Preservative	-----	-----	Q.S.
<b>TOTAL</b>				<b>100.00</b>

### Mixing Procedure:

1. Combine all ingredients of Phase A and heat to 85°C with moderate propeller agitation (PA).
2. Mix the water, Dermacryl-79, and Floraesters K-20W Jojoba from Phase C at 70°C with complete mixing. Premix the Propylene Glycol and the Potassium Hydroxide 28% solution of Phase B at 70°C. Add the Propylene Glycol/Potassium Hydroxide mixture Phase B to Phase A at 85°C with constant stirring. Add water/Dermacryl-79/K-20W Phase C mixture to Phase A at 85°C with constant stirring.
3. Add Phase D to Phase ABC and homomix until completely dispersed in the liquid wax phase.
4. Add Phase E to Phase ABCD while homomixing.
5. Pour the mixture into mascara containers while still hot and well stirred. Let cool to room temperature before use.

Note: The information herein is based on our research and the research of others and is believed to be accurate. No guarantee of their accuracy is made and the products discussed are sold without warranty, expressed or implied, and upon condition that purchasers shall make their own tests to determine the suitability of such products for their particular purposes. Likewise, statements concerning the possible use of these products are not intended as recommendations to use these products in infringement of any patent.