

# Formulation

Name	<b>HYDRATING FACIAL SERUM WITH NATURAL MOISTURIZERS</b>	
No.	1284	
Description	After cleansing, moisturize and promote healthy-looking skin with this hydrating facial serum. A combination of four 100% natural moisturizers deeply hydrates dry skin for a smooth, healthy feel. Vitamin E is added to help strengthen the skin barrier, improving skin's resilience to urban pollution.	
Formulation	<b>INGREDIENTS:</b>	<b>% by Weight</b>
	=== Phase 1 ===	
	Deionized Water	q.s. to 100.0
	STEPANQUAT® GA-90	2.2
	AMPHOSOL® 1C	2.0
	=== Phase 2 ===	
	STEPAN-MILD® GCC	6.0
	AMMONYX® LO	20.0
	=== Phase 3 ===	
	STEPAN-MILD® L3	1.0
	Vegetable Oil	5.0
	NEOBEE® M-5 COSMETIC	2.0
	Vitamin E (F. Hoffmann-La Roche Ltd)	0.5
	=== Phase 4 ===	
	Citric Acid	q.s.
	Fragrance	q.s.
	Preservative	q.s.
	<b>Total</b>	<b>100.0</b>
Procedure	<ol style="list-style-type: none"> <li>Charge Water into a vessel and heat to 40-50 °C (104-122 °F).</li> <li>Into a separate container, charge STEPANQUAT® GA-90 and AMPHOSOL® 1C. Mix and heat to 50 °C (122 °F), then add to Deionized Water.</li> <li>In a separate container, charge Phase 2 ingredients. Mix until homogenous and thick.</li> <li>Add Phase 3 ingredients to Phase 2 and mix gently until homogenous.</li> <li>Add Phase 1 to Phase 2/3. Then add Preservative and Fragrance.</li> <li>Mix vigorously without incorporating air until homogenous. Cool to room temperature.</li> <li>Adjust pH to 4.0-4.5 using Citric Acid.</li> </ol>	
Physical Properties	Appearance at 25 °C	White flowable lotion
	pH, as is	4.0 - 5.5
	Viscosity at 25 °C (LV3, 12 RPM), cps	2,000 - 3,000
Storage/Stability	4 weeks at 5 °C	Stable
	4 weeks at 25 °C	Stable
	4 weeks at 45 °C	Stable
	Freeze/Thaw, 3 cycles	Pass
Instructions for Use	Rinse face with water. Apply serum to palms and rub hands until palms are coated. Gently rub in serum onto the face, creating a smooth lather. Rinse off with water.	

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AMPHOSOL®  
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AMMONYX®  
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For applications or product handling assistance, call our Technical Service Department at 1-800-745-7837 (U.S.) or 011-334-76-505-100 (Europe).  
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