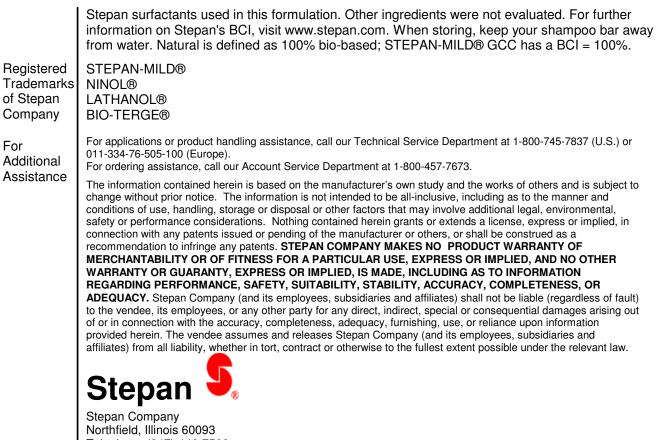
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_	Formulation
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Name	CLEANSING SHOWER BAR "BUBBLES IN A BAR"

Name	CLEANSING SHOWER BAR "BUBBLES IN A BAR"		
No.	1329		
Description	A modern twist on a classic concept, this soap-free syndet bar is packed with sulfate-free cleansers to get your skin feeling clean and fresh. Unlike some bar soaps that can leave skin feeling tight and dry, this unique shower bar formula contains STEPAN-MILD® GCC, a natural moisturizer that leaves skin feeling soft and smooth.		
Formulation	INGREDIENTS:	% by Weight Functionality	
	=== Phase 1 === NINOL® COMF-N HALLSTAR CO-1895 (The HallStar Company) Stearyl Alcohol STEPAN-MILD® GCC	<ul><li>27.0 Secondary Surfactant</li><li>20.0 Rheology Modifier</li><li>4.5 Emollient</li></ul>	
	=== Phase 2 === LATHANOL® LAL Coarse	27.0 Surfactant	
	BIO-TERGE® AS-90 Beads	21.0 Surfactant	
	=== Phase 3 === Lactic Acid (80% Solution)	q.s. pH Adjuster	
	=== Phase 4 === Fragrance, Dye	q.s Additives	
	Total	100.0	
Procedure	<ol> <li>In a suitable vessel equipped with heating and agitation capabilities, charge STEPAN-MILD® GCC, NINOL® COMF-N, and HALLSTAR CO-1895.</li> <li>Heat to 90 °C (104°F) with mixing.</li> <li>Add LATHANOL® LAL Coarse and BIO-TERGE® AS-90 Beads. Mix well at 90°C (104°F).</li> <li>Add Lactic Acid to adjust the pH close to pH 5.5. Measure the pH with 1 gram of the formulation in Deionized Water, and continue to adjust as needed until the desired pH range is reached.</li> <li>Add the fragrance and dye with mixing (if desired). Pour off into in the silicone molds and let cool to let the bar form.</li> </ol>		
Physical Properties	Appearance, as is pH (as a liquid)	Off-white solid bar 5.5	
Storage/ Stability	4 weeks at 5°C 4 weeks at 25°C 4 weeks at 45°C Freeze/Thaw 3 cycles	Stable Stable Stable Pass	
Instructions for Use	Rub between wet hands to create a lather, or directly onto wet hair. Massage into your hair and scalp. When you're happily lathered and massaged, rinse clean.		
External Comment	Marketing Notes: BCI = 64. Total Biorenewable Carbon Index (BCI) was calculated only for the		



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