MOISTURIZING FULL COVERAGE LIPSTICK

with Floraesters® 15, Floraesters 60, and Floraesters 70

This full coverage lipstick featuring **Floraesters** glides on smoothly leaving lips soft and silky. Each of the **Floraesters** have superior oxidative stability, and **Floraesters 60** and **Floraesters 70** increase stick strength without increasing hardness or sacrificing payout. Additionally, **Floraesters 60** increases skin hydration while decreasing syneresis, making it ideal for stick products.

Phase	Trade Name	INCI	Supplier	%WT
A	Castor Oil	Ricinus Communis (Castor) Seed Oil	Geo Chem	q.s.
	Floraesters 15	Jojoba Esters	Cargill Beauty	8.60
	Floraesters 70	Jojoba Esters	Cargill Beauty	1.00
	Floraesters 60	Jojoba Esters	Cargill Beauty	0.50
	Yellow Carnauba Wax NF T1 (#420F)	Copernicia Cerifera (Carnauba) Wax	Koster Keunen, Inc	3.00
	Candelilla N (#856P)	Euphorbia Cerifera (Candelilla) Wax	Koster Keunen, Inc	4.00
	Beeswax NF White, Wax #421P	Beeswax	Koster Keunen, Inc	3.50
	Multiwax W-445	Microcrystalline Wax	Sonneborn	4.00
	Preservative1	- - - - -	- - - - -	q.s.
	Granpowder Silica	Silica	Grant Industries	0.80
B	Dispersun DSP-OL300	Polyhydroxystearic Acid	Innospec Performance Chemicals	0.50
	Castor Oil	Ricinus Communis (Castor) Seed Oil Red 7 Lake	Geo Chem	q.s.
	SunCroma® D&C Red 7 Ca Lake C19-011	Titanium Dioxide	Sun Chemical Corp	2.85
	Unipure® White LC987	Yellow 5 Lake	Sensient Cosmetic Technologies	1.00
	Yellow 5/G35-6200 FD&C Yellow Al Lake	Red 6 Lake	Grances Chemical	0.35
	SunCroma® D&C Red 6 Ba Lake C19-7712	Black Iron Oxides	Sun Chemical Corp	0.15
	SunCroma® Black Iron Oxide C33-5198		Sun Chemical Corp	0.11
C	Mixed Tocopherols 95	Tocopherol	DSM Nutritional Products	0.05

[1] Preservative: Iscaguard® P [INCI: Propylparaben] supplied by ISCA

CHARACTERISTICS

- **pH:** 4.5
- **Viscosity:** 45°C

Cargill Beauty
Unleashing Nature *Sustainably*

PROCESS

1. Combine the ingredients of Phase A and heat to 90-95°C with moderate propeller agitation.
2. Combine the ingredients of Phase B, and mix until all pigments are uniform throughout.
3. Add Phase B to Phase A with moderate-slow propeller agitation at 90-95°C.
4. Once Phase AB is uniform, add Phase C with moderate propeller agitation at 90°C.
5. Pour into molds at 80-85°C.
6. Cool the molds at room temperature.
7. Remove the stick from the mold, and set into a lipstick tube.

Formula Number: *M034,* ***Revision Date:*** *January 2023*