

AHA/BHA FACE CLEANSER

Reinvigorate delicate, acne-prone skin with this cleanser that has a double dose of exfoliating power. Skin will feel refreshed with a healthy glow due to **GlySmart**® which lifts away dead skin cells in an effective yet gentle way while **Endicare**® **SAL** unclogs pores.

PHASE A

Deionized Water (Water)	44.50%
Endiquest ™ GLDA ¹ (Tetrasodium Glutamate Diacetate)	0.10%
Endinol ® MILD SCI-85 ¹ (Sodium Cocoyl Isethionate)	6.00%

PHASE B

Ethoxcare ® OCTG ^{1,2} (Glycereth-18 Ethylhexanoate (and) Glycereth-18)	4.00%
Endicare ® SAL ¹ (Salicylic Acid)	1.00%

PHASE C

Endinol ® KC ¹ (Potassium Cocoate)	3.00%
Enditeric ® C Surfactant ¹ (Cocamidopropyl Betaine)	14.00%
Endamox ™ CAW ¹ (Cocamidopropylamine Oxide)	6.00%
Endinol ® MILD SCGL-UP ¹ (Disodium Cocoyl Glutamate)	3.00%
Endamide ® CIPA Surfactant ¹ (Cocamide MIPA)	2.00%

PHASE D

JD Jojoba Colorless Oil ^{1,3} (Simmondsia Chinensis (Jojoba) Seed Oil)	1.00%
JD Jojoba Silk-Like Powder ^{1,3} (Tapioca Starch (and) Simmondsia Chinensis (Jojoba) Seed Oil)	0.50%

PHASE E

Synthalen ® W2000 ^{1,4} (Acrylates/Palmeth-25 Acrylate Copolymer)	6.00%
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PHASE F

GlySmart ® ^{1,5} (Glycolic Acid (and) Arginine)	2.50%
KOH, 30% (Potassium Hydroxide)	3.00%

PHASE G

Olivatis ® 15C ^{1,6} (Olive Oil PEG-8 Esters)	0.70%
Fragrance	qs

PHASE H

Activederm RP ^{1,4} (Oryza Sativa (Rice) Starch)	2.00%
Sharomix ™ EG10 Plus ^{1,7} (Phenoxyethanol (and) Ethylhexylglycerin (and) Tocopherol)	0.70%

NOTE: This formulation, which utilizes the minimum amount of salicylic acid specified by the current U.S. FDA Monograph and Code of Federal Regulations for over-the-counter topical drug products for the treatment of acne, may serve as a reference for formulating such products; however, this formula has not been tested or validated by the relevant regulatory authorities. Responsibilities including, but not limited to, product efficacy and regulatory compliance, ultimately remain with the user.

Suppliers

¹ Coast Southwest, Inc., ² Ethox Chemicals, LLC., ³ Jojoba Desert (A.C.S.) Ltd., ⁴ 3V Sigma USA, ⁵ CrossChem Limited, ⁶ Medolla Specialty Chemicals, ⁷ Sharon Personal Care

Properties

pH: 5.30 to 5.60

Viscosity: Spindle 5 @ 30 rpm (25°C) - 5,100 to 5,700 cP

Procedure

Phase A - Combine in main vessel and heat to 65°C to 70°C. **Phase B** - Pre-mix and add to main vessel at temperature. **Phase C** - Add ingredients in formula order. Continue heating to dissolve salicylic acid. **Phase D** - Pre-mix and add to batch. **Phase E** - Discontinue heat. Add Phase E gradually. Batch will thicken. **Phase F** - Pre-mix Phase F by slowly adding KOH 30% solution to GlySmart® to reach a pH of ~5.0. **Phase G** - Pre-mix Phase G and add to batch at or below 35°C. **Phase H** - Add Phase H in formula order and mix completely. Cool to room temperature.