

BEAMING BEYOND BRIGHTENING SERUM

Bring perfection to your complexion with this lightweight, smooth-feel serum. Stabilized Vitamin C derivatives **Endicare® C-EAA** and **Endicare® C-AG** provide potent anti-aging and brightening action near skin pH levels while the Arginine ionic complex in **GlySmart®** slowly absorbs into skin to maintain the action of glycolic acid in a gentle delivery system. Natural **Poleryl 10 LA** solubilizes the preservative for a crystal clear serum solution.

PHASE A

Deionized Water (Water)	77.50%
Disodium EDTA	0.10%
Ethoxcare® OCTG ^{1,2} (Glycereth-18 Ethylhexanoate (and) Glycereth-18)	5.00%
3V Allantoin ^{1,3} (Allantoin)	0.50%
EndiMoist® HA Solution ¹ (Sodium Hyaluronate)	8.00%

PHASE B

GlySmart ^{®1,4} (Glycolic Acid (and) Arginine)	3.20%
KOH, 50% (Potassium Hydroxide)	2.70%

PHASE C

Hydroxyethylcellulose	1.00%
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PHASE D

Endicare® C-EAA ¹ (3-O-Ethyl Ascorbic Acid)	0.50%
Endicare® C-AG ¹ (Ascorbyl Glucoside)	0.50%

PHASE E

Poleryl 10 LA ^{1,5} (Polyglyceryl-10 Laurate)	0.50%
Sharomix® Amplify AM24 ^{1,6} (Methylpropanediol (and) Caprylyl Glycol (and) Polyquaternium-80 (and) Didecylidimonium Chloride)	0.50%

Suppliers

¹Coast Southwest, Inc., ²Ethox Chemicals, LLC., ³3V Sigma USA, ⁴CrossChem Limited, ⁵Medolla Specialty Chemicals, ⁶Sharon Personal Care

Properties

pH: 5.25 to 5.75

Viscosity: Spindle 5 @ 10 rpm - 720 to 750 cP

Appearance: Clear serum

Procedure

Phase A - Combine in main vessel. **Phase B** - Add GlySmart® to side vessel and slowly add KOH, adjusting pH to ~5.0. This step will produce heat, so use proper equipment and PPE. If needed, use a lower concentration of KOH and adjust for total water in formula in Phase A. At room temperature and at desired pH, add to Phase A. **Phase C** - Slowly add to batch. Increase mixing speed as needed.

Phase D - Slowly add to batch and mix until fully dissolved. **Phase E** - Pre-mix and add to batch.