



## Formulation

Name	<b>SULFATE-FREE, MOISTURIZING GENTLE FOAMING HAND SOAP</b>	
No.	1179	
Description	This low-viscosity hand soap is perfect for self-foaming pump applications. It gently cleanses, leaving skin feeling soft and smooth. If a thicker hand soap is desired, replace the AMPHOSOL HCG with AMPHOSOL CBD-HP and use sodium chloride to adjust to the desired viscosity.	
Formulation	<b>INGREDIENTS:</b>	<b><u>% by Weight</u>   <u>Functionality</u></b>
	Deionized Water	q.s. to 100.00 Diluent
	Natrosol 250 HHR (Hercules) Hydroxyethylcellulose	0.05 Thickener
	Glycerin	0.50 Humectant
	ALPHA-STEP® PC-48	16.00 Primary Surfactant
	AMPHOSOL® HCG (or AMPHOSOL® CDB-HP)	3.50 Secondary Surfactant
	STEPAN-MILD® L3	1.50 Emollient
	Fragrance	0.25 Fragrance
	Citric Acid (50% solution)	q.s. pH Adjuster
	Preservative	q.s. Preservative
	<b>Total</b>	<b>100.00</b>
Procedure	<ol style="list-style-type: none"><li>1. In a suitable vessel equipped with heating and agitation capabilities, charge Deionized Water and begin mixing.</li><li>2. Sprinkle in Natrosol 250 HHP. Mix until dispersed.</li><li>3. Add Glycerin, ALPHA-STEP® PC-48, AMPHOSOL® HCG (or AMPHOSOL® CDB-HP). Mix well.</li><li>4. Start heating to 45°C (113°F).</li><li>5. Add STEPAN-MILD® L3. Mix until clear.</li><li>6. Add Fragrance. Mix until clear.</li><li>7. Cool to room temperature.</li><li>8. Adjust pH to 5.0–6.0 with Citric Acid (50% solution).</li><li>9. Add Preservative.</li></ol>	
Physical Properties	Appearance, as is	Clear liquid
	pH at 25°C, as is	5.0 – 6.0
	Viscosity at 25°C, cps	Water thin
Storage/ Stability	4 weeks at 5°C	Stable
	4 weeks at 25°C	Stable
	4 weeks at 40°C	Stable
	Freeze/Thaw 3 cycles	Pass
Instructions for Use	Apply to wet hands, lather, and rinse.	
External Comment	Marketing Notes: BCI = 89 (when using AMPHOSOL® HCG) BCI =92 (when using AMPHOSOL® CDB-HP) . Total Biorenewable Carbon Index (BCI) was calculated only for the Stepan surfactants used in this formulation. For further information on Stepan's BCI; visit <a href="http://www.stepan.com">www.stepan.com</a> .	

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**Stepan** 

Stepan Company  
Northbrook, Illinois 60062  
Telephone (847) 446-7500

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