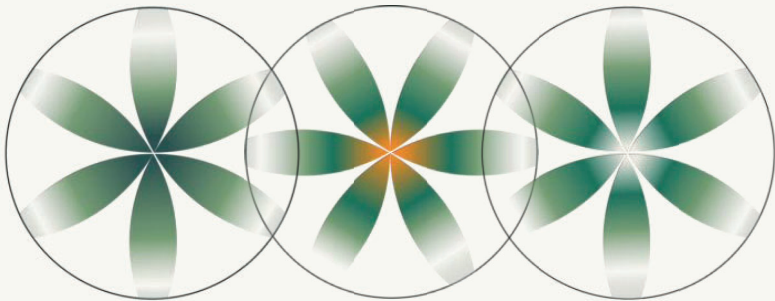


# Fresh'in Green + :

*Pentylene Glycol, Methyl Diisopropyl Propionamide*



# Purifying Clay Mask

***E-Leen Green A masks odours, moisturises the skin and creates a self-preserving formula.***

***Fresh'in Green+ provides a pleasant cooling and refreshing effect.***

Phase	Raw material	INCI	%
A	Water	Aqua	41.6
	<b>Fresh'in Green+ (1)</b>	<b>Pentylene Glycol, Methyl Diisopropyl Propionamide</b>	<b>0.3</b>
	Xanthan Gum PC (2)	Xanthan gum	0.5
B	Emulgade PL 68/50 (3)	Cetearyl Glucoside, Cetearyl Alcohol	5
	Refined Shea Butter (4)	Butyrospermum Parkii (Shea) Butter	3
	Jjoba Oil (4)	Simmondsia Chinensis (Jjoba) Seed Oil	3
	Hazelnut Oil (5)	Corylus Avellana (Hazel) Seed Oil	3
C premix	Water	Aqua	20
	CosGreen Surfine (6)	Illite	20
D	DL- $\alpha$ -Tocopherol (>97%)	Tocopherol	0.1
	Perfume Bambus & Zitronengras (7)	Parfum	0.5
	<b>E-Leen Green A (1)</b>	<b>Pentylene Glycol, Phenylpropanol</b>	<b>3</b>
E	Aq. Sodium Hydroxide solution	Aqua, Sodium Hydroxide	q.s.

## Manufacturing process:

1. Dissolve Fresh'in Green+ in water, then disperse the Xanthan Gum, mix until homogeneous. Heat up to 75-80 °C.
2. Prepare phase B and heat up to 75-80 °C.
3. Premix the Kaolin in the water of phase C.
4. Add B to A under high shear mixing (3 min with an Ultra-Turrax), then mix with a propeller mixer for 30 min at 1000 rpm. Slow down the mixing while cooling down.
5. At < 40 °C add phase C, mix well to obtain a homogeneous dispersion.
6. Add the Tocopherol, the perfume and E-Leen Green A, under good mixing.
7. At ambient temperature, adjust the pH to 8.0.

## Properties, stability and microbiology :

Aspect : Soft light khaki cream  
pH : 8.0  $\pm$  0.2

Stable 4 weeks at 42°C.

**Meets criteria A / ISO 11930**

(1) Minasolve ; (2) Jungbunzlauer ; (3) BASF ; (4) Caesar & Loretz ; (5) SanaBio ; (6) Argiles du Velay/Cameleon Chemicals ; (7) Bell Flavors and Fragrances

# Summer Refreshing Mist

***Fresh'in Green+ added to this tonic water provides a long-lasting cooling and refreshing effect.***

***E-Leen Green B preserves the formula and provides moisturizing benefits.***

Phase	Raw material	INCI	%
A	Water	Aqua	92.3
	Rewoteric AMC <sup>(1)</sup>	Sodium Cocoamphoacetate	2
B	<b>E-Leen Green B <sup>(2)</sup></b>	<b>Pentylene Glycol, Aqua, Sodium Benzoate, Benzoic Acid</b>	<b>3</b>
	Glycerin	Glycerin	2
C	Fleur de Coco <sup>(3)</sup>	Parfum	0.2
D	<b>Fresh'in Green+ <sup>(2)</sup></b>	<b>Pentylene Glycol, Methyl Diisopropyl Propionamide</b>	<b>0.5</b>
E	Citric Acid (50%)	Aqua, Citric Acid	Qs

<sup>(1)</sup> Evonik ; <sup>(2)</sup> **Minasolve** ; <sup>(3)</sup> Luzi

## Manufacturing process:

1. Disperse Rewoteric AMC in water and stir until complete homogenisation.
2. Add the ingredients from phase B in the given order to phase A. Stir until complete homogenisation.
3. Add the perfume from phase C. Stir until complete homogenisation.
4. Add phase D. Stir until complete homogenisation.
5. Adjust pH with phase E.

## Properties, stability and microbiology:

Aspect : Clear solution  
pH : 5.0 - 5.5

Stable during 3 months at 8°C, room temperature and 42 °C, as well as during centrifugation for 1 hr at 20 °C and 1500 g.

# Anti-Aging Eye Contour

*Hydra-Leen 5 Rose BIO provides a pleasant floral scent to the formula.*

*Flora-Leen Cistus provides anti-aging properties.*

*Fresh'in Green+ provides a long-lasting cooling and refreshing effect.*

*E-Leen Green C creates a self-preserving formula and provides mild moisturising properties.*

Phase	Raw material	INCI	%
A	Hydra-Leen 5 Rose BIO <sup>(1)</sup>	Rosa Damascena Flower Water, Pentylene Glycol	20.80
	Water	Water	52.05
	Arabic Gum	Acacia Senegal Gum	1
	Xanthan Gum	Xanthan Gum	0.5
B	Olivem 1000 <sup>(2)</sup>	Cetearyl Oliviate, Sorbitan Oliviate	3
	Phytowax olive 16L55 <sup>(2)</sup>	Hydrogenated Olive Oil Cetyl Esters	5
	Macadamia oil	Macadamia Integrifolia Seed Oil	8
	Liponate Jojoba 20 <sup>(3)</sup>	Jojoba Esters	5
C	Cellulose	Cellulose	0.15
D	Flora-Leen Cistus <sup>(1)</sup>	Water, Pentylene Glycol, Cistus Ladaniferus Leaf/Stem Extract, Ascorbic acid	1
	Fresh'in Green+ <sup>(1)</sup>	Pentylene Glycol, Methyl Diisopropyl Propionamide	0.4
	E-Leen Green C <sup>(1)</sup>	Pentylene Glycol, Glyceryl Caprylate / Caprate	3
	Tocopherol	Tocopherol	0.1
E	Citric Acid/Sodium Hydroxide	Citric Acid / Sodium Hydroxide	QS

<sup>(1)</sup> Minasolve ; <sup>(2)</sup> Sophim ; <sup>(3)</sup> Vantage

## Manufacturing Process :

1. Combine the water and Hydra-Leen 5 Rose BIO in a beaker.
2. Disperse the xanthan and arabic gums one by one in the water phase under high-shear mixing until homogeneous. Then heat the mixture to 75–80 °C.
3. Melt the ingredients of phase B at 75°C-80°C while stirring continuously.
4. Add phase B to phase A at 75-80°C and emulsify with a high shear mixer for 5 min (e.g. Ultra-Turrax, 9500 - 13500 rpm).
5. Add Cellulose under stirring with a high shear mixer (e.g. Ultra-Turrax, 9500 - 13500 rpm) and continue emulsifying for 5 min.
6. Continue mixing with a normal stirrer until the mixture is < 40°C.
7. Add phase D under mixing with a normal stirrer.
8. Adjust the pH.

## Properties, stability :

Aspect : Fluid off-white cream  
 pH : 6 ± 0,2  
 Stable for 3 months at RT & 40°C

# Fresh'Kiss Lipstick

***Fresh'in Green+ provides a long-lasting cooling and refreshing effect***

Phase	Raw material	INCI	%
A	Beeswax	Cera Alba	20
	Castor Seed Oil <sup>(1)</sup>	Ricinus Communis (Castor) Seed Oil	44.6
	Jjoba Oil <sup>(1)</sup>	Simmondsia Chinensis (Jjoba) Seed Oil	24.5
	Cacao Butter <sup>(2)</sup>	Theobroma Cacao Seed Butter	10
	<b>Fresh'in Green+ <sup>(3)</sup></b>	<b>Pentylene Glycol, Methyl Diisopropyl Propionamide</b>	<b>0.8</b>
B	DL- $\alpha$ -Tocopherol (>97%)	Tocopherol	0.1

<sup>(1)</sup> Caesar & Loretz ; <sup>(2)</sup> AAK ; <sup>(3)</sup> Minasolve

## Manufacturing process:

1. Mix ingredients from phase A while heating up to 75 °C. Stir until homogeneous.
2. Add phase B while stirring at 75 °C, then pour the mixture rapidly into a cold mold.
3. Leave to cool at 5 °C for at least 30 minutes.

## Properties, stability and microbiology:

Aspect : Opaque yellow solid

Stable during 3 months at 8°C, room temperature and 42 °C, as well as during centrifugation for 1 hr at 20 °C and 1500 rpm.

# Roll-on Deodorant

***Caprocin*** helps to control body odor.

***A-Leen 5*** helps to protect the formula and improves emollience.

***Fresh'in Green+*** provides a subtle refreshing effect.

Phase	Raw material	INCI	%
A	Water	Aqua	68.7
B	Xanthan Gum PC	Xanthan Gum	0.5
	Glycerin	Glycerin	3
C	Water	Aqua	20
	Sodium Hydroxide	Sodium Hydroxide	0.4
	<b>Caprocin<sup>(1)</sup></b>	<b>Capryloyl Glycine</b>	<b>2</b>
D	Cetiol C5C <sup>(2)</sup>	Coco-Caprylate/Caprates	1
	Tegosolve 90 <sup>(3)</sup>	Polyglyceryl-6 Caprylate/4 Caprate	2
	<b>Fresh'in Green+<sup>(1)</sup></b>	<b>Pentylene Glycol, Methyl Diisopropyl Propionamide</b>	<b>0.3</b>
	<b>A-Leen 5<sup>(1)</sup></b>	<b>Pentylene Glycol</b>	<b>2</b>
	Orchidee Perfume <sup>(4)</sup>	Parfum	0.1
E	Citric Acid (50%)	Aqua, Citric Acid	Qs

<sup>(1)</sup> Minasolve ; <sup>(2)</sup> BASF ; <sup>(3)</sup> Evonik ; <sup>(4)</sup> SFA - Orchidée Blanche

## Manufacturing process:

1. Mix ingredient of phase B and then disperse in water.
2. Mix ingredient of phase C until Caprocin is fully dissolved and then add to the formula.
3. Mix ingredient of phase D then add to the formula under stirring.
4. Adjust pH

## Properties, stability and microbiology:

Aspect : Translucent gel  
pH : 5 ± 0.5

## Stability in process

# Revitalizing Face Cleanser

***Hydra-Leen 5 Rose BIO*** provides a pleasant scent to the formula.

***Fresh'in Green+*** provides a long-lasting cooling and refreshing effect.

***E-Leen Green A*** creates a self-preserving formula and provides moisturizing benefits.

Phase	Raw material	INCI	%
A	Water	Aqua	36.5
	<b>Hydra-Leen 5 Rose BIO</b> <sup>(1)</sup>	<b>Rosa Damascena Flower Water, Pentylene Glycol</b>	<b>36.5</b>
	Xanthan Gum <sup>(2)</sup>	Xanthan_Gum	1
B	TEGO Betain F 50 <sup>(3)</sup>	Cocamidopropyl Betaine	7
	Plantapon ACG HC <sup>(4)</sup>	Sodium Cocoyl Glutamate	7
	TEGO Betain 810 <sup>(3)</sup>	Coco-Glucoside	7
C	Lamesoft PO 65 <sup>(4)</sup>	Coco-Glucoside, Glyceryl Oleate	2
D	<b>Fresh'in Green+</b> <sup>(1)</sup>	<b>Pentylene Glycol, Methyl Diisopropyl Propionamide</b>	<b>1</b>
E	<b>E-Leen Green A</b> <sup>(1)</sup>	<b>Pentylene Glycol, Phenylpropanol</b>	<b>2</b>
F	Citric acid	Citric Acid	Qs

<sup>(1)</sup> Minasolve; <sup>(2)</sup> Safic Alcan ; <sup>(3)</sup> Evonik ; <sup>(4)</sup> BASF

## Manufacturing process:

1. Combine water with Hydra-Leen 5 Rose BIO.
2. Disperse Xanthan Gum in the water phase and mix until homogeneous.
3. Add all ingredients from phase B under low agitation and stir well after each addition.
4. Add the ingredients from phases C, D and E under low agitation and stir well after each addition.
5. Adjust the pH to 5.5.

## Properties, stability and microbiology:

Aspect : Clear gel  
pH : 5.0 – 5.5

Stable during 1 months at 50°C

**Meets criteria A / ISO 11930.**

# Cleansing & Refreshing Intimate Gel

***Hydra-Leen 8 Camomile Bio* provides a pleasant scent to the formula.**

***Fresh'in Green+* provides a long-lasting refreshing effect.**

***E-Leen Green B* protects the formulation.**

Phase	Raw material	INCI	%
A	Water	Aqua	67.05
	<b>Hydra-Leen 8 Camomile BIO</b> <sup>(1)</sup>	<b>Anthemis Nobilis Flower Water, Caprylyl Glycol, Glycerin, Water</b>	<b>10</b>
B	Xanthan Gum	Xanthan Gum	0.5
	Glycerin	Glycerin	3
C	Allantoin	Allantoin	0.2
	Sorbitol	Sorbitol	2
	Plantacare 818 UP <sup>(2)</sup>	Coco-Glucoside	10
	Tego Betain F50 <sup>(3)</sup>	Cocamidopropyl Betaine	3
	Lamesoft PO 65 <sup>(2)</sup>	Coco Glucoside, Glyceryl Oleate	1
D	<b>Fresh'in Green+</b> <sup>(1)</sup>	<b>Pentylene Glycol, Methyl Diisopropylpropionamide</b>	<b>0.5</b>
	<b>E-Leen Green B</b> <sup>(1)</sup>	<b>Pentylene Glycol, Water, Sodium Benzoate, Benzoic Acid</b>	<b>3</b>
E	Citric Acid	Citric Acid	Qs

<sup>(1)</sup> Minasolve <sup>(2)</sup> BASF ; <sup>(3)</sup> Evonik

## Manufacturing process:

1. Mix ingredients of phase A.
2. Mix together ingredient of phase B and add under mixing into the the water phase
3. When the xanthan gum is fully dispersed, add Allantoin and make sure it is fully dissolved
4. Then add one by one the other ingredients of phase C.
5. Add E-Leen Green B and Fresh'in Green +.
6. Adjust the pH to 4.5.

## Properties, stability and microbiology:

Aspect : Soft translucide gel  
pH : 4.5± 0.2

Stable during 8 weeks at ambient temperature and 40°C.  
**Meets criteria A / ISO 11930**