

# Demand for Natural Cosmetics Grows, Plant Sources are Scrutinized



- Using natural and plant-based ingredients continues to be a macro trend in the cosmetic industry
- Many types of plants are used as oils or extracts such as jojoba, lavender, aloe vera, tea tree, etc.
- Other plants like palm and coconut are often used as building blocks for deriving more advanced plant-based cosmetic ingredients
- However, the palm industry faces consumer pressure for unsustainable practices



# **Consumer Behavior is Influenced by Dramatic Anti-Palm Campaigns**

Media outlets publish articles naming palm as an enemy to healthy ecosystems

HOW DID PALM OIL BECOME SUCH A PROBLEM

— AND WHAT CAN WE DO ABOUT IT?

Palm Oil Was Supposed to Help Save the Planet. Instead It Unleashed a Catastrophe.

A decade ago, the U.S. mandated the use of vegetable oil in biofuels, leading to industrial-scale deforestation — and a



Saving the Amazon started this petition to The world

We want to make a big change in how the palm oil industry works, how they grow palm oil trees and where. We also want to decrease deforestation and help save the forests that are being



Consumers react by seeking out palm oil-free and palm-free claims



# INOLEX Anticipates and Responds to Changes in the Palm Industry

2012

INOLEX joins the Roundtable on Sustainable Palm Oil

2016

INOLEX launches non-palm feedstock product line,
 SustOleo™

2019

 INOLEX continues to diversify feedstock plants with new product launches, including coconut-derived
 SustOleo™ TL and brassica-derived AminoSensyl™ HC

2020

 INOLEX converts to 100% RSPO Mass Balance certified palm-derived products





# **INOLEX Diversified Plant Feedstocks** for Sustainable Natural Ingredients



**Emulsifiers** SustOleo<sup>™</sup> GMS SustOleo<sup>™</sup> GMS-SE

Olive\*



Castor\*
Sensory
Enhancers
SustOleo™ DCS





Texturizers
SustOleo™ BA
SustOleo™ BG
SustOleo™ TSB



Corn\*
Sensory
Enhancers
SustOleo™ DCS



\*Non-GMO Plant Source



# **Benefits of INOLEX's Alternative Plant Sources**



New textures and unique sensory experience elevates formulations



Recognizable plant origins provide positive consumer perception



Reducing reliance on a single plant source improves supply chain sustainability



# Alternative Plant Sources + Green Chemistry Principles = Sustainable Design



The INOLEX Innovation Platform is guided by the 12 Principles of Green Chemistry and life-cycle thinking. Our goal is to provide ingredients that deliver objective, measurable improvements in performance, consumer preference, AND sustainability.

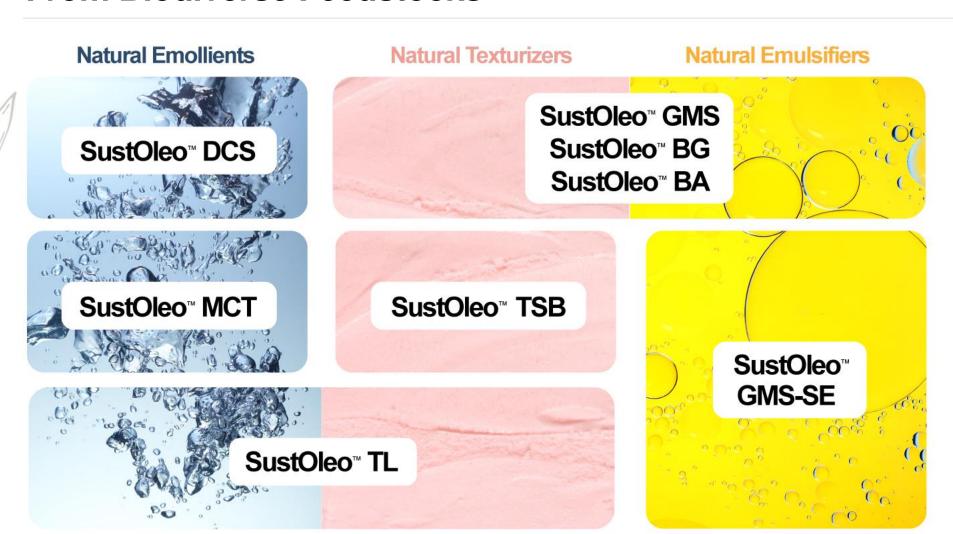
#### SustOleo™: Guided by Green Chemistry

- Effective use of sustainable, non-palm, plantbased feedstocks; pursuit of new biobased alternatives
- Create **readily biodegradable** chemistries in order to not contribute to product waste in the environment
- Articulating and minimizing trade-offs to avoid hidden costs/consequences of "natural"

Anastas, P. T.; Warner, J. C. Green Chemistry: Theory and Practice, Oxford University Press: New York, 1998, p. 30.



#### A Collection of Sensory Enhancers From Biodiverse Feedstocks



### 100% Natural Sensory Texturizer



#### NEW! SustOleo TL

**INCI: Trilaurin** 

✓ Skin-feel: Light and powdery

Sensory experience: Rapid absorption, fast dry

**Benefit in formulation:** Unique polymorphic crystalline structure gives dual melting points

✓ Sustainability benefit: Readily biodegradable

/ Plant origin: Coconut









Non-palm



Compliant





Halal & Kosher Vegan & Free of Animal Testing



# NEW! SustOleo TL Unique Sensory: Fast Melt and Powdery Feel

#### **Melt Temperatures**

SustOleo <sup>™</sup>	SustOleo <sup>™</sup>	SustOleo <sup>™</sup>	Shea	Coconut
TL	MCT	TSB	Butter	Oil
29.9 °C 43.9 °C	<-30 °C	60.0 °C	30.3 – 42.1 °C	25.3 °C



**Test Method** 

Differential Scanning Calorimetry 5°C/minute temperature ramp from 70°C → 30°C → 70°C Note: SustOleo MCT did not include initial heating phase



- SustOleo™ TL has two distinct melt temperatures that are close to the temperature of skin for fast breakdown
- SustOleo™ TL has a polymorphic crystalline structure – two distinct crystalline phases – resulting in its unique powdery form and sensory effects



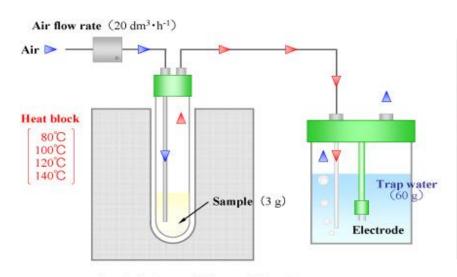
# NEW! SustOleo TL Resists Oxidation for Long-Term Stability

- SustOleo™ TL resists oxidation providing a palm-alternative with long-term stability
- SustOleo™ TL is 28% more resistant to oxidation than Shea Butter

Material	Oxidative Stability Index (OSI) @ 110°C
Shea Butter	21 hours
SustOleo™ TL	27 hours

#### **Test Method**

Test material added to chamber. Air bubbled through at 110°C. Exiting air scrubbed by water. Conductivity of water measured. Oxidative Stability Index (OSI) calculated. Rancimat method is an accelerated aging test. The time until secondary reaction products are detected is called induction time. IT characterizes the oxidation stability of oils and fats.



Analytical conditions of Rancimat



743 Rancimat (Metrohm AG)



### SustOleo™ TL in Icy Air Cream (SC-1087)

Trade Name	Ingredient (INCI)	(w/w)%
Deionized Water	Water	67.36
Unicent 05601-J	Blue1	0.10
Glycerin	Glycerin	5.00
Glutamic Acid	Glutamic Acid	0.04
Keltrol CG-SFT	Xanthan Gum	0.30
SustOleo <sup>™</sup> TL	Trilaurin	6.50
SustOleo <sup>™</sup> GMS-SE	Glyceryl Stearate SE	4.00
SustOleo <sup>™</sup> BA	Brassica Alcohol	2.00
Lexol <sup>™</sup> NBS MB	Butyl Stearate	5.00
SEPINOV™ EMT 10	Hydroxyethyl Acrylate/Sodium Acryloyldimethyl Taurate Copolymer	0.40
MAKIMOUSSE 25	Sodium Polyacrylate Starch	0.30
LexFeel <sup>™</sup> WOW-A DT	C13-15 Alkane (and) Heptyl Undecylenate	5.00
Organic Reconstituted Juice Aloe Vera	Aloe Barbadensis Leaf Juice	2.00
Spectrastat <sup>™</sup> OEL	Caprylhydroxamic Acid (and) Caprylyl glycol (and) Ethylhexylglycerin (and) Propanediol	2.00

Experience a whimsical winter with this airy and icy skin cream. It is lightweight in pick-up and after-feel with a subtly crystalized appearance.





<sup>\*</sup>percent naturality is based on carbon content as outlined by the ISO standard

### **SustOleo** TL in Solid Foundation (CC-1092)

Trade Name	Ingredient (INCI)	(w/w) %
Deionized Water	Water	39.45
Spectrastat <sup>™</sup>	Caprylhydroxamic Acid (and) Caprylyl glycol (and) Glycerin	1.50
LexFeel <sup>™</sup> WOW-A	C13-15 Alkane (and) Triheptanoin	18.50
Unipure Yellow LC182 NFW-R	Iron Oxides M/EA	1.15
Unipure Red LC381 NFW-R	Iron Oxides M/EA	0.30
Unipure Blk LC989 NFW-R	Iron Oxides M/EA	0.10
Unipure White LC981 NFW-R	Iron Oxides M/EA	6.00
MLB	Polyglyceryl-4 Isostearate (and) Coco-Caprylate/Caprate (and) Disteardimonium Hectorite (and) Polyglyceryl-3 Polyricinoleate (and) Sorbitan Isostearate	8.00
LexFeel™ Vibrant MB	Palm Acid/Adipic Acid/Pentaerythritol Crosspolymer	4.00
SP-16W-P	Microcrystalline Wax	6.00
Ozokerite Wax	Ozokerite Wax	5.00
Kahlwax 6607	Helianthus Annuus (Sunflower) Seed Wax (and) Ascorbyl Palmitate (and) Tocopherol	4.00
SustOleo <sup>™</sup> TL	Trilaurin	2.00
Vitamin E	Tocopheryl Acetate	1.00
Lexorez <sup>™</sup> 200 MB	Trimethylpentanediol/Adipic Acid/Glycerin Crosspolymer	3.00

This soft and creamy foundation stick is lightweight with a sheer to medium coverage. The unique formulation with almost 40% water makes for a more cost-effective formulation compared to typical foundation sticks. The skin-feel during application is soft and light and the finish is between satin and matte





<sup>\*</sup>percent naturality is based on carbon content as outlined by the ISO standard

### **SustOleo** TL in Moonlight Renewal (SC-1088)

Trade Name	Ingredient (INCI)	(w/w) %
SustOleo <sup>™</sup> TL	Trilaurin	2.00
LexFeel™ N5 MB	Diheptyl Succinate (and) Capryloyl Glycerin/Sebacic Acid Copolymer	75.00
TEGO® SP 13-6 Polymer	Poly C10-30 Alkyl Acrylate	8.00
SustOleo™ MCT	Triheptanoin	12.00
Vitamin E	Tocopheryl Acetate	1.00
Cucumber Hydroglycerin Extract	Cucumis Sativus (Cucumber) Extract (and) Glycerin (and) Water	0.20
Lotus Hydroglycerin Extract	Lotus Corniculatus (Lotus) Seed Extract (and) Glycerin (and) Water	0.10
PhytoTrace <sup>™</sup> Fig	Ficus Carica (Fig) Fruit Extract (and) Glycerin (and) Water	0.20
Green Tea Hydroglycerin Extract	Camellia Sinensis (Green Tea) Extract (and) Glycerin (and) Water	0.20
Matricaria Chamomile Hydroglycerin Extract	Chamomilla Recutita (Matricaria Chamomile) Extract (and) Glycerin (and) Water	0.20
Rosemary Hydroglycerin Extract	Rosemarinus Officinalis (Rosemary) Extract (and) Glycerin (and) Water	0.10
Licorice Hydroglycerin Extract	Krameria Triandra (Licorice) Extract (and) Glycerin (and) Water	0.10
Apple Hydroglycerin Extract	Pyrus Malus (Apple) Extract (and) Glycerin (and) Water	0.10
Spectrastat <sup>™</sup> PHL	Caprylhydroxamic Acid (and) 1,2-Hexanediol (and) Propanediol	0.80

<sup>\*</sup>percent naturality is based on carbon content as outlined by the ISO standard

This lustrous serum is best for overnight nourishment to undereye, face, and décolletage. This delicately soft oil is reminiscent of velveteen. User experience can be customized by the storage temperature of the product. For a thicker, fuller application and added benefit of depuffing the eyes, store in refrigerator. For a silky smooth traditional application, store at room temperature.





# **Comparing Sensory Enhancers**

Property	SustOleo™ TL	SustOleo™ MCT	SustOleo™ TSB
INCI	Trilaurin	Triheptanoin	Hydrogenated Rapeseed Oil
Sensory during application	Rapid absorption and quick dry with a cooling sensation	Long playtime with a soft and nourishing feel	Fast breakdown on skin and quick absorption
Skin Feel	Light and powdery	Light and nourishing	Rich, buttery, and creamy
Origin	Coconut	Coconut & Castor	Brassica
% in Demo Formulation	5%	5%	2%



### Sensory by SustOleo<sup>™</sup> Demo Set (SC-1086)

Trade Name	Ingredient (INCI)	(w/w)% B	(w/w) % C	(w/w) % D
SustOleo <sup>™</sup> GMS-SE	Glyceryl Stearate SE	3.50	3.50	3.50
SustOleo <sup>™</sup> GMS	Glyceryl Stearate (Olive)	4.00	4.00	4.00
LexFeel <sup>™</sup> Natural	Heptyl Undecylenate	5.00	5.00	5.00
Sunflower Seed Oil	Helianthus Annuus (Sunflower) Seed Oil	5.00	5.00	5.00
SustOleo <sup>™</sup> MCT	Triheptanoin	5.00		
SustOleo <sup>™</sup> TL	Trilaurin		5.00	
SustOleo <sup>™</sup> TSB	Hydrogenated Rapeseed Oil			2.00
25% Sodium Hydroxide	Sodium Hydroxide	0.25	0.25	0.25
Oil, Calla Lily Type PF*	Fragrance	0.10	0.10	0.10
Deionized Water	Deionized Water	72.75	72.75	75.75
Glycerin	Glycerin	3.00	3.00	3.00
Spectrastat <sup>™</sup> G2 Natural MB	Caprylhydroxamic Acid (and) Glyceryl Caprylate (and) Glycerin	1.20	1.20	1.20
Carbopol Ultrez 10	Carbomer	0.20	0.20	0.20

Directly compare the unique textures of 3 different sensory enhancers in a basic lotion chassis. SustOleo TSB makes a buttery, creamy lotion.

SustOleo TL this chassis light and airy. With SustOleo MCT, it's silky and smooth.





<sup>\*</sup>percent naturality is based on carbon content as outlined by the ISO standard

# 100% Natural Structuring Agent



#### SustOleo TSB

**INCI: Hydrogenated rapeseed oil** 

- Skin-feel: Buttery and nourishing
- Sensory experience: Fast breakdown and fast absorbing
- ✓ **Benefit in formulation:** Structuring agent, viscosity builder
- Sustainability benefit: Readily biodegradable
- Plant origin: Brassica















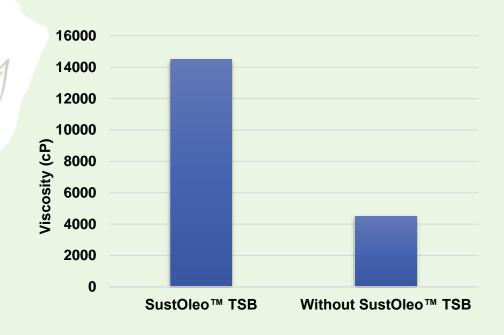








# SustOleo TSB Provides Functional Formulation Benefits



SustOleo™ TSB increases the viscosity of gels and emulsions

Self-tanning Gel Formulation (2% SustOleo<sup>™</sup> TSB)

#### **Test Details:**

- Test Formulation chassis: 2% SustOleo™ TSB / 13% Emollient blend / 1% Polyquaternium-37
- Quantitiatve formulation available upon request (630-089B)

- SustOleo™ TSB provides a rich, white color to emulsions
- SustOleo™ TSB rapidly recrystallizes on cool down which prevents the grainy texture experienced with shea butter



Mixed Triglycerides Oil Phase

#### **Test Details:**

- 2% SustOleo™ TSB / 13% Mixed Triglycerides blend
- · Mixture melted and cooled to room temperature



### **SustOleo** TSB in Butter Frosting Lotion (BB-1073)

Trade Name	Ingredient (INCI)	(w/w) %
Deionized Water	Water	73.38
Glycerin	Glycerin	4.00
Gluconal® CAM-P-IN	Calcium Gluconate	1.12
Spectrastat <sup>™</sup> G2 Natural MB	Caprylhydroxamic Acid (and) Glyceryl Caprylate (and) Glycerin	1.20
AminoSensyl <sup>™</sup> SC	Brassica Alcohol (and) Brassicyl Valinate Esylate (and) Brassica Glycerides	8.00
SustOleo <sup>™</sup> TSB	Hydrogenated Rapeseed Oil	2.00
LexFeel <sup>™</sup> N50 MB	Diheptyl Succinate (and) Capryloyl Glycerin/Sebacic Acid Copolymer	7.00
LexFeel <sup>™</sup> Natural	Heptyl Undecylenate	1.50
Cetiol® SB 45	Butyrospermum Parkii (Shea) Butter	1.50
Organic Reconstituted Aloe Vera Juice	Aloe Barbadensis (Aloe Vera) Leaf Juice	1.00
Oil, Wild Honeysuckle BBW	Fragrance	0.30



A silky body butter reminiscent of homemade frosting. The dynamic sensory experience begins with a firm viscous texture that quickly melts into the skin for a smooth, silky finish.



# 100% Natural Light Emollient



#### SustOleo<sup>™</sup> MCT

**INCI: Triheptanoin** 

- ✓ Skin-feel: Light and silky
- Sensory experience: Soft and elegant with a long playtime
- Benefit in formulation: Excellent solubilizer and pigment wetting emollient
- ✓ **Sustainability benefit:** Readily biodegradable
- ✓ Plant origin: Coconut and castor origin





















Vegan & Free of Animal Testing



# Trend Watch: Medium Chain Triglycerides (MCTs)

What it is: MCTs are lipids with two or three fatty acids with a tail length of 6-12 carbon atoms. MCTs are known to be a healthy alternative to long chain triglycerides, which have chain lengths of 13-21 carbon atoms.

**Health & Wellness** 



**CBD** 



**Cosmetics** 



Popular product categories for MCTs

"Grand View
Research predicts
that the global MCT
market will be
worth \$2.46 billion
per year by 2025"



Read more about MCTs
and other trends @
hiips://inolex.com/pc/
News-Events/BEAUTYFOOD



# **SustOleo** MCT Has Ideal Chain Length Distribution for Optimized Skin-Feel

SustOleo™ MCT INCI: Triheptanoin

Three equal, 7 carbon chains

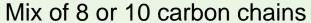
3 equivalent chain lengths results in a smooth, non-greasy sensory profile



Lexol® GT-865 MB

INCI: Caprylic/capric

Triglyceride



Mix of chain lengths results in a more oily, nourishing sensory profile



Long Chain Triglycerides

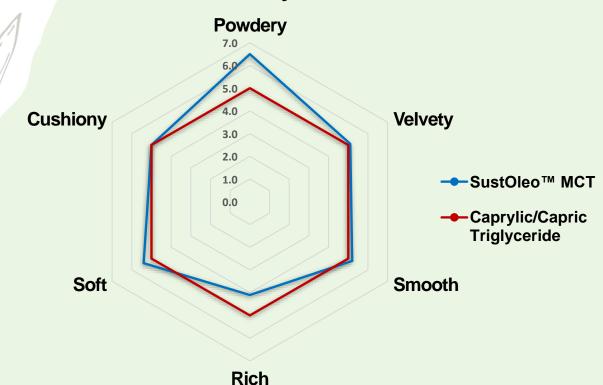
Chains of 12+ carbons

Longer chain lengths are found in oils such as safflower oil, olive oil



# SustOleo MCT is a Comparable, Non-Palm Alternative to CCT

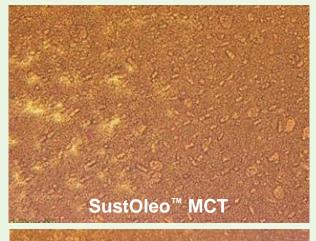
#### **Similar Sensory Profile**



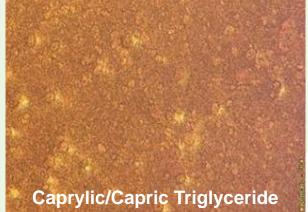
#### **Test Method**

Sensory: Panelist skin sensory evaluation of neat product (n=6). Add 30µL of emollient onto clean and dry skin on volar forearm. Sensory attributes were evaluated by rubbing the treated skin with fingers. Scale: 0 to 7

### Comparable performance in inorganic pigment dispersions



# Test Method Combine Zinc Oxide and emollient in 1:2 ratio. Disperse with propeller agitation until uniform. Assess visually and with optical microscope





### **SustOleo** MCT in Eye Protection Stick (SC-1089)

Trade Name	Ingredient (INCI)	(w/w) %
SustOleo <sup>™</sup> MCT	Triheptanoin	24.25
<b>LexFeel</b> <sup>™</sup> <b>Natural</b>	Heptyl Undecylenate	15.00
MSS-500	Silica	7.50
Mica	Mica	7.50
Artisan Coral	Mica (and) Titanium Dioxide (and) Iron Oxide (and) Carmine (and) Boron Nitride	0.50
Bees Wax	Cera Alba (Bees Wax)	7.00
Carnauba Wax	Copernicia Prunifera (Carnauba) Wax	7.00
Homosalate	3,3,5-Trimethylcyclohexyl Salicylate	8.00
Avobenzone	Butyl Methoxydibenzoyl Methane	3.00
Octocrylene	Octocrylene	2.75
Coconut Oil	Cocos Nucifera (Coconut) Oil	5.00
Shea Butter	Butyrospermum Parkii (Shea) Butter	5.00
PhytoTrace <sup>™</sup> Carrot	Daucus Carota Sativa (Carrot) Root Extract (and) Helianthus Annuus (Sunflower) Seed Oil	1.00
<b>LexFilm<sup>™</sup> Sun Natural MB</b>	Capryloyl Glycerin/Sebacic Acid Copolymer	5.00
Vitamin E Acetate	Tocopheryl Acetate	0.50
Lexgard® O	Caprylyl Glycol	1.00

<sup>\*</sup>percent naturality is based on carbon content as outlined by the ISO standard

This multifunctional eye serum is perfectly suited for the workout guru or athleisure afternoon. It delivers sweat-proof protection from UV rays and glides on smooth while moisturizing.





# 100% Natural Light Emollient



#### SustOleo DCS

**INCI: Diisooctyl succinate** 

- Skin-feel: Ultra-light and powdery
- Sensory experience: Rapid absorption, short playtime
- Benefit in formulation: Solubilizer for UV filters and pigment wetting emollient
- ✓ **Sustainability benefit:** Readily biodegradable
- ✓ Plant origin: Non-GMO corn and castor oil













Halal & Vegan & Free of Kosher Animal Testing



### Comparing Light Emollients

	SustOleo™ DCS	SustOleo™ MCT
Sensory	More Powdery	More Silky
Absorption	Quicker	Slower
Spreading	Faster	Slower
Polarity	Higher	Lower



# 100% Natural Texturizer & Co-emulsifier



#### SustOleo BG

**INCI: Brassica glycerides** 

- ✓ Skin-feel: Smooth
- ✓ **Sensory experience:** Soft texture, easy pick-up, long playtime
- ✓ Benefit in formulation: Structuring agent and stability enhancer
- ✓ Sustainability benefit: Readily biodegradable
- ✓ **Plant origin:** Brassica and coconut



















Halal & Kosher

Vegan & Free of Animal Testing



# 100% Natural Co-emulsifier



#### SustOleo GMS

**INCI:** Glyceryl stearate

- ✓ Skin-feel: Creamy
- **Sensory experience:** Firm structure with fast absorption
- ✓ Benefit in formulation: Structuring agent and viscosity builder
- Sustainability benefit: Readily biodegradable
- ✓ Plant origin: Olive and coconut

















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Vegan & Free of Animal Testing



# Comparing Texturizing Co-Emulsifiers

#### **Demo Formulation**

Trade Name	Ingredient (INCI)	(w/w)%	(w/w)%
Deionized Water	Water	74.90	74.90
Glycerin	Glycerin	3.00	3.00
Spectrastat <sup>™</sup> G2 Natural MB	Caprylhydroxamic Acid (and) Glyceryl Caprylate (and) Glycerin	1.00	1.00
Carbopol Ultrez 10	Carbomer	0.20	0.20
SustOleo <sup>™</sup> GMS-SE	Glyceryl Stearate SE	2.50	2.50
SustOleo <sup>™</sup> GMS	Glyceryl Stearate	4.00	-
SustOleo <sup>™</sup> BG	Brassica Glycerides	-	4.00
SustOleo <sup>™</sup> MCT	Triheptanoin	8.00	8.00
SustOleo <sup>™</sup> DCS	Diisooctyl Succinate	5.00	5.00
SustOleo <sup>™</sup> TSB	Hydrogenated Rapeseed Oil	1.00	1.00
25% Sodium Hydroxide Solution	Sodium Hydroxide	0.30	0.30
Fragrance	Fragrance	0.10	0.10

**SustOleo**™ co-emulsifers give options for creating different structures and textures

#### **Viscosity**

#### **Rigidity & Strength**

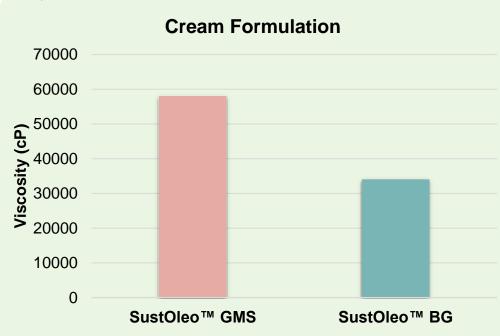
#### **Rub-In Resistance**

**SustOleo™ BG** creates less resistance on rub-in

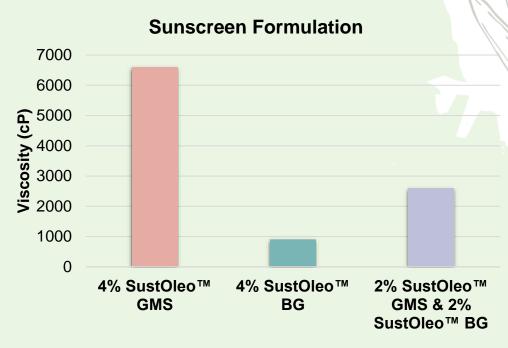


# Choosing a Co-Emulsifier: Versatility in Viscosity

**SustOleo™ GMS** creates higher viscosity emulsions in both cream and sunscreen type formulations.



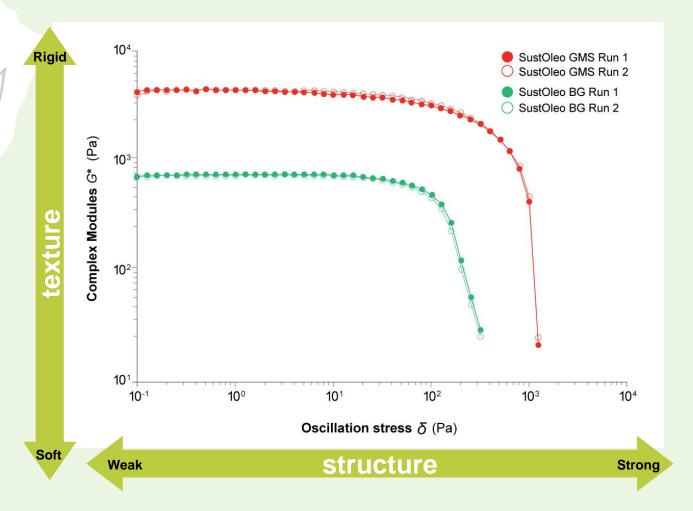
**Cream formulation** includes 4% co-emulsifier, 2.5% glyceryl stearate SE, 0.2% carbomer



Sunscreen formulation includes 29.80% organic UV filter blend, 3% ProCondition™ 22, 1% modified starch, and 4% co-emulsifier



# **Choosing a Co-Emulsifier: Rigidity and Strength in Cream Formulation**



- ✓ SustOleo™ BG provides a softer, yet firm lamellar structure with easy spreading.
- ✓ SustOleo™ GMS

  provides more rigid
  texture and strong
  lamellar structure.

#### **Test Method:**:

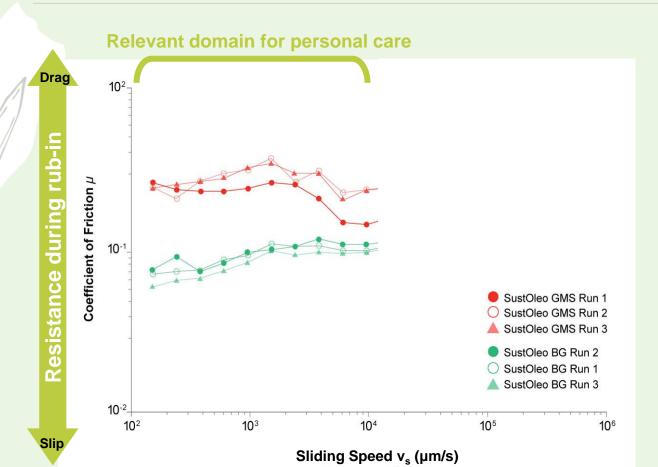
Apply gentle oscillatory stress to sample and measure the response. Slowly increase stress until sample eventually yields.

#### Instrumentation:

Research Rheometer DHR2, TA



### Choosing a Co-Emulsifier: Friction Profile in Cream Formulation



- Tribology can provide a relative comparison of the ease of rub-in.
- ✓ A lower co-efficient of friction indicates easier spreading onto skin.
- ✓ **SustOleo™ BG** had less friction, or less resistance during rub-in, which translates to a smoother and less waxy feel during application (or during rub-in)

#### **Test Method:**:

Place sample formulation between two surfaces in contact. Move one surface with defined load across stationary surface and record resulting friction.

#### **Instrumentation:**

Research Rheometer DHR2, TA



# Comparing Co-Emulsifiers: SustOleo GMS vs. SustOleo BG

	SustOleo <sup>™</sup> GMS	SustOleo <sup>™</sup> BG
Texture	Firmer	Softer
Viscosity Building	Higher	Lower
Playtime	Prolonged	Minimal
Appearance in Formulation	Opaque	Translucent



# 100% Natural Emulsifier



#### SustOleo GMS-SE

**INCI:** Glyceryl stearate SE

- ✓ Skin-feel: Creamy
- ✓ Sensory experience: Firm structure with fast absorption
- ✓ Benefit in formulation: Self-emulsifying structuring agent and stability builder
- Sustainability benefit: Readily biodegradable
- ✓ Plant origin: Olive and coconut origin

















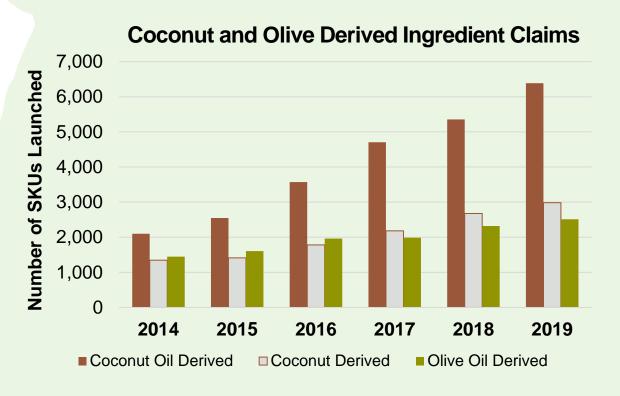
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Halal & Kosher

Vegan & Free of Animal Testing



# Plant Origin Claims are Popular and Growing





### Natural Glow CC Cream SPF 15 (CC-1044)

Trade Name	Ingredient (INCI)	%(w/w)
Deionized Water	Water	52.90
Glycerin	Glycerin	3.00
Solagum <sup>™</sup> AX	Acacia Senegal Gum (and) Xanthan Gum	0.30
NaOH, 10%	Deionized Water (and) Sodium Hydroxide	0.20
Lexgard <sup>®</sup> Natural MB	Glyceryl Caprylate (and) Glyceryl Undecylenate	1.00
SustOleo <sup>™</sup> GMS-SE	Glyceryl Stearate SE	3.00
Decyl Glucoside	Decyl Glucoside	3.00
SustOleo <sup>™</sup> BA	Brassica Alcohol	4.00
LexFilm <sup>™</sup> Sun Natural MB	Capryloyl Glycerin/Sebacic Acid Copolymer	3.00
LexFeel <sup>™</sup> Natural	Heptyl Undecylenate	10.00
SustOleo <sup>™</sup> MCT	Triheptanoin	10.00
Unipure White LC 981 SGP	CI 77891 (and) Sodium Glycerophosphate	8.00
Unipure Black LC 989 SGP	CI 77499 (and) Sodium Glycerophosphate	0.10
Unipure Red LC 381 SGP	CI 77491 (and) Sodium Glycerophosphate	0.30
Unipure Yellow LC 182 SGP	CI 77492 (and) Sodium Glycerophosphate	1.20
Citric Acid, 25%	Deionized Water (and) Citric Acid	Q.S. to 6.5-7.5



Prime, moisturize, protect in one step. The Natural Glow CC Cream leaves the skin soft and hydrated while protecting from the sun with SPF 15. Covers blemishes and imperfections for an all-day glow.





### 100% Natural **Structuring Agent**



#### SustOleo BA

**INCI: Brassica alcohol** 

Skin-feel: Smooth

**Sensory experience:** Soft texture

Benefit in formulation: Emulsion stabilizer and viscosity builder

Sustainability benefit: Readily biodegradable

Plant origin: Brassica

















# **Brassica Plant Creates Ideal Properties in a Fatty Alcohol**

**SustOleo™ BA** is derived from the *Brassica Napus* seed oil which belongs to the Genus *Brassica* containing a variety of nutrient rich plants including cauliflower, broccoli, and kale

	SustOleo™ BA (brassica alcohol)	Cetyl Alcohol	Stearyl Alcohol
Carbon Chain Length	C18-C22	C16	C18
Plant Source	Brassica	Typically palm	Coconut or palm
Melting point	55°C	45°C	57°C

#### Benefits of SustOleo™ BA

- Brassica oil's unique C18-C22 fatty acyl composition delivers emulsions with soft textures and improved stability
- Sustainable non-palm plant source













### **Gentle Exfoliating Cream Cleanser** (SC-1064)

	Trade Name	Ingredient (INCI)	(w/w)%
	Deionized Water	Deionized Water	66.80
	ProCondition <sup>™</sup> 22	Brassicamidopropyl Dimethylamine	2.00
	Aspartic Acid	Aspartic Acid	0.70
	Lexaine® C MB	Cocamidopropyl Betaine	5.00
	Spectrastat™	Caprylhydroxamic Acid (and) Caprylyl Glycol (and) Glycerin	1.00
	SustOleo <sup>™</sup> DCS	Diisooctyl Succinate	10.00
	SustOleo <sup>™</sup> BA	Brassica Alcohol	7.00
	SustOleo <sup>™</sup> GMS	Glyceryl Stearate	3.00
	Salicylic Acid	Salicylic Acid	0.50
	PhytoTrace <sup>™</sup> Lemon Verbena	Lippia Citriodora (Lemon Verbena) Leaf Extract (and) Glycerin (and) Water	1.00
	Florabeads Jojoba <sup>3</sup> (Purple Color)	Jojoba Esters	3.00

<sup>\*</sup>percent naturality is based on carbon content as outlined by the ISO standard

This creamy soft cleanser, exfoliates the outer levels of the skin to reveal a bright and rejuvenated complexion.

Simultaneously, it conditions the skin which preps it for the next steps in the routine.





### The Shampoo Bar (HC-1104)

Trade Name	Ingredient (INCI)	(w/w)%
AminoSensyl <sup>™</sup> HC	Brassica Alcohol (and) Brassicyl Valinate Esylate	10.00
SustOleo <sup>™</sup> BA	Brassica Alcohol	6.00
LexFeel <sup>™</sup> N5 MB	Diheptyl Succinate (and) Capryloyl Glycerin/Sebacic Acid Copolymer	4.50
Cocoa Butter	Theobroma Cacao (Cocoa) Seed Butter	1.20
Jojoba Oil	Simmondsia Chinensis (Jojoba) Seed Oil	0.50
Argan Oil	Argania Spinosa (Argan) Oil	0.40
Tapioca Natural 9096	Tapioca Starch	15.00
Bio-Terge® AS-90 Beads	Sodium (C14-16) Olefin Sulfonate	29.00
Hostapon® SCI 85 P	Sodium Cocoyl Isethionate	29.00
Lexgard <sup>®</sup> O	Caprylyl Glycol	1.00
Deionized Water	Water	2.40
Natural Rose & Black Currant Fragrance N17316	Fragrance	1.00
Tartrazine Acid Yellow 23 (1.00% Solution)	FD&C Yellow 5 (CI 19140)	0.50

<sup>\*</sup>percent naturality is based on carbon content as outlined by the ISO standard

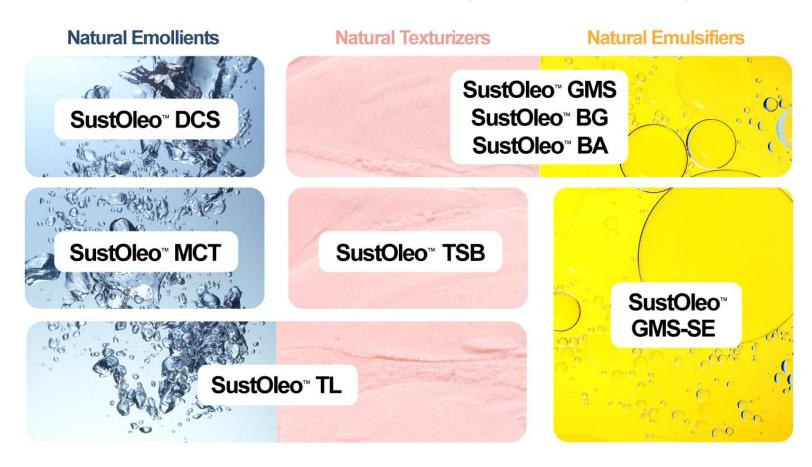
A sustainable take on a traditional shampoo, this highly concentrated bar format eliminates the need for plastic packaging. This shampoo is nonstripping and rehydrates the hair as it cleanses.





### A Collection of Sensory Enhancers From Biodiverse Feedstocks

Biodiverse feedstocks create *unique textures*, *positive consumer perception*, and improves supply chain *sustainability* 







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