

- eye cream ▪ O/W emulsion ▪ moisturizing ▪ energizing ▪ anti dark circles ▪ soft focus effect ▪
- lifting ▪ smooth skin feel ▪

PHASE	INGREDIENT	INCI	SUPPLIER	% ww
A	Deionised Water	Aqua		46.20
	Palmera® G995E	Glycerin	KLK Oleo	3.00
	Keltrol® CG-V	Xanthan Gum	CP Kelco	0.40
B	IMWITOR® 900K	Glyceryl Stearate	IOI Oleo	2.00
	IMWITOR® 375	Glyceryl Citrate/ Lactate/ Linoleate/ Oleate	IOI Oleo	3.00
	Huile Pepin de Framboise (Raspberry Seed Oil)	Rubus Idaeus Seed Oil	Prod'Hyg	3.00
	VEGELIGHT® 1820	C18-C21 Alkane	BioSynthis	5.50
	KahlWax 6290 Berry Wax	Rhus Verniciflua Peel Cera	Kahl	4.00
	LACTABASE® C14	Myristyl Lactate	Prod'Hyg	5.00
	DuoLux™ CM	Pullulan	Joyvo	3.00
C	Amaze™ Nordic Barley	Hordeum Vulgare Powder	Nouryon	8.00
D	dermosoft® Pentiol eco	Pentylene Glycol	Evonik Dr. Straetmans	4.00
E	Deionised Water	Aqua		5.00
	GENENCARE® OSMS MI	Inositol	IFF	1.00
F	Deionised Water	Aqua		5.00
	Synastol® TC	Terminalia Chebula Fruit Extract	Sytheon	0.50
G	Happy Fragrance N52514	Parfum	Carruba	0.40
	L-Arginine 10% Solution	L-Arginine	Ajinomoto	1.00
				100.00

PRODUCT FEATURES

Appearance: Off-white emulsion
 pH: 5.5.-6.0
 Viscosity: 20,000-40,000 mPas (Brookfield Helipath, spindle T93, speed 10 rpm, room temperature)
 Stability: Stable for more than 3 months at 4°C, 20°C and 40°C.

MANUFACTURING PROCEDURE

1. Heat water up to 75°C. Pre-dissolve Keltrol® CG-V in Palmera® G995E and add to water while stirring.
2. Mix all ingredients of phase B except DuoLux™ CM. Heat phase B separately up to 75°C and add DuoLux™ CM shortly before the next step.
3. Add phase B to phase A and stir shortly until homogenous. Homogenize for 2-3 minutes.
4. Cool down below 45°C while stirring.
5. Add phase C very slow to the batch while stirring or homogenize to avoid clusters formation. Avoid increasing the temperature >45°C so that Amaze™ Nordic Barley does not thicken.
6. Add phase D while stirring.
7. Pre-dissolve phase E in water at room temperature and add to batch while stirring.
8. Pre-dissolve phase F in warm water (45°C) and stir until completely dissolved. Add phase F to batch while stirring.
9. Add phase G one after the other while stirring.
10. Homogenize. Cool down to room temperature while stirring.

APPLICATION ADVICE

Apply at skin under your eyes and softly massage in. Avoid eye contact.

BIESTERFELD PRODUCTS

MATERIAL	BENEFIT	BENEFIT	BENEFIT	NOI ¹	PALM	VEGAN	COSMOS-CERTIFIED	COSMOS-CONFORM	NATRUE-CERTIFIED	NATRUE-CONFORM
Amaze™ Nordic Barley	Unmodified barley starch	Aesthetic modifier	Sebum absorption	1	Palm-free	Vegan	Yes	Yes	Yes	Yes
	Blures fine lines	Translucent coverage	Soft skin feel							
dermosoft® Pentiol eco	Multifunctional	Antimicrobial activity		1	Palm-free	Vegan	Yes	Yes	No	Yes
GENENCARE® OSMS MI	Natural osmolyte	NMF component	Deep moisturization	1	Palm-free	Vegan	Yes	Yes	Yes	Yes
	Energizing	Upcycled ingredient								
Happy Fragrance N52514	Fragrance			1	Palm-free		No		No	
Huile Pepin de Framboise (Raspberry Seed Oil)	Emollient	Antioxidant	Soothing	1						
	Restructuring									
IMWITOR® 375	Anionic O/W emulsifier	EO-free	Versatile viscosities and textures	1	Palm-free	Vegan	Yes	Yes	No	Yes
	Excellent compatibility	Soft and velvet skin feel								
IMWITOR® 900 K	Non-ionic O/W Co-emulsifier	Consistency enhancer		1	RSPO MB available	Vegan	Yes	Yes	No	Yes
KahlWax 6290 Berry Wax	Low melting soft wax	Consistency enhancer	Velvet, powdery skin feel	1	Palm-free	Vegan	No	Yes	No	Yes
Keltrol® CG-V	Stabilizer			1	Palm-free	Vegan	No	No	Yes	Yes
LACTABASE® C14	Texturizer	Low melting point	Fresh skin	1	RSPO MB available	Vegan	No	No	No	No
	Improved spreadability									
Palmera® G995E	Moisturizer			1	RSPO MB available	Vegan	Yes	Yes	No	No
DuoLux™ CM	Moisturizing film-former	Skin tightening	Lifting effect	1	Palm-free	Vegan	Yes	Yes	No	Yes
	Luxurious silky skin feel									
Synastol® TC	Anti-aging active	Collagen booster	Reduces under eye circles	1	Palm-free	Vegan	Yes	Yes		
	Evens skin tone	Reverses and inhibits glycation	Anti-blue light							
VEGELIGHT® 1820	Non-volatile natural alkane	Dimethicone (5cSt) replacement	Elegant skin feel	1	Palm-free	Vegan	Yes	Yes	No	No

¹ Calculation by including formulation water according to ISO 16128.