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(54) Title: SELF-FOAMING COSMETIC PRODUCT

(57) Abstract: A foaming cosmetic product is provided packaged in a non-aerosol mechanical dispenser. The dispenser includes a container for holding a liquid composition, a dispensing head with a housing enclosing a pump mechanism and a screen material in the flow path to convert liquid composition into a foam, and a diptube for delivering liquid from the container to the dispensing head. The cosmetic composition is an opaque creamy, relatively non-viscous fluid, the creamy appearance imparted by a latex with suspended polymer particles compatible with the foaming mechanism.



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SELF-FOAMING COSMETIC PRODUCT

The invention concerns a foaming cosmetic product based upon a cosmetic composition delivered through a non-aerosol  
5 dispenser, wherein the dispenser cooperates with the cosmetic composition to generate a mousse quality foam while concurrently imparting moisturization benefits to the skin.

Cosmetic compositions in mousse form have certain appeal to consumers. Foremost is the instant foam achieved by the  
10 mere pressing of a button. Aerosol dispensers employing propellants generally provide a satisfactory foam volume. Unfortunately, aerosol products are under attack for environmental reasons. Volatile organic compounds interfere with the earth's ozone layer and contribute to smog in  
15 metropolitan areas. Aerosol packages are also relatively costly to assemble. For all these reasons, attention has been recently directed at non-aerosol dispensers.

U.S. Patent 5,635,469 (Fowler et al.) discloses personal cleansing products comprising a foamable liquid composition  
20 and a foam-producing non-aerosol dispenser. The compositions include a surfactant, a water soluble cationic or nonionic polymer, a humectant, a water-insoluble emollient and water. The dispenser employs at least two screens through which the composition is blown to generate a  
25 foam.

U.S. Patent 5,364,031 (Taniguchi et al.) discloses a foam dispensing system having nozzles including a velocity decreasing structure. The average foam velocity through these structures is controlled to avoid exceeding a given

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value. Examples are provided of suitable cosmetic products for use with these systems.

U.S. Patent 6,030,931 (Vinski et al.) describes a non-aerosol pump foaming composition free of water insoluble emollients. Transparent systems achieve a luxurious foam generated through use of select amphoteric surfactants and densifying agents.

Delivery of the cosmetic compositions via non-aerosol dispensers has presented many challenges. Additives within these compositions can interfere with foam properties. Certain types of non-aerosol dispensers which operate with porous filters or meshed screens are not tolerant to particulate components or to even modestly viscous compositions.

For aesthetic and marketing reasons, formulators desire to impart a milky visual effect to the compositions. Milkiness is most often accomplished with titanium dioxide, mica or esters such as glycol distearate. The problem with these ingredients is that the inorganic substances generally clog screens which are necessary for generating the foaming effect. Higher molecular weight esters impart too much viscosity to be foamed by dual screen mousse generators. Other problems with non-aerosol generated foams is that they often lack a dense luxurious character and often do not provide a cushioned afterfeel.

Accordingly, it is an advantage of the present invention to provide a cosmetic product in mousse form based on a milky formulation.

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Another advantage of the present invention is to provide a cosmetic product in mousse form which is not subject to clogging within the dispensing mechanism.

5 Still another advantage of the present invention is to provide a cosmetic product in mousse form having a relatively low viscosity to achieve pumpability yet displaying an excellent cushioned afterfeel.

10 These and other advantages of the present will become more readily apparent from consideration of the summary and detailed description which follows.

A foaming cosmetic product is provided which includes:

(A) a non-aerosol dispenser having:

- (i) a container for storing a cleansing composition;
- 15 (ii) a dispensing head located on the container having a housing surrounding a pump mechanism and a foam-forming screen material;
- 20 (iii) a diptube communicating between the container and head functioning to fluidly deliver liquid cleansing composition between container and head and being upstream from the screen material; and

25 (B) the cleansing composition including:

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- 5 (i) from 0.01 to 10% by weight of the cleansing composition of a latex suspending from about 0.1% to about 90% by weight of the latex of a polymer insoluble in the composition; and
- (ii) from about 0.1 to about 10% by weight of the cleansing composition of at least one anionic surfactant.

10 Now it has been discovered that a creamy appearance can be imparted to the composition by means of a latex. Particles of polymers forming the latex were found not to clog screens of the dispenser nor to inhibit mousse formation or interfere with skin aesthetics of the product foam.

15 By the term "latex" is meant water or a fluid of essentially equivalent viscosity, suspending a water-insoluble polymer. Amounts of the latex may be present from 0.01 to 10%, preferably from 0.1 to 5%, optimally from 0.5 to 2% by weight of the cleansing composition. Amount of the water-insoluble polymer may range from 0.01 to 90%, preferably  
20 from 0.1 to 60%, optimally from 10 to 50% by weight of the latex.

Average diameters of the dispersed polymer may range from 0.001 micron to 120 micron, preferably from 0.01 micron to 1 micron, optimally from 0.1 micron to 0.5 micron.

25 Polymers of the latex include the sub categories of homo and copolymer. Moreover, the term "copolymer" includes polymers fashioned from 2 to 6 different monomers in block or random linkage.

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Illustrative of copolymers suitable for the latex emulsion are those formed from styrene, alpha-methylstyrene, divinylbenzene, acrylic acid, methacrylic acid, C<sub>1</sub>-C<sub>20</sub> esters of acrylic acid or methacrylic acid, acrylamide, methacrylamide, maleic acid, vinyl acetate, crotonic acid, vinyl neodecanoate and butenoic acid. Exemplative of carboxylate type copolymers are the styrene/alkyl acrylate and partially esterified polyacrylic and polymethacrylic salts and free acid forms. Among the foregoing materials are poly(butyl methacrylate), poly(methyl acrylate), poly(methyl methacrylate), poly(acrylic acid/C<sub>1</sub>-C<sub>20</sub> alkyl acrylate) and poly(methacrylic acid/C<sub>1</sub>-C<sub>20</sub> alkyl methacrylate). These copolymers may be prepared by polymerization of the respective monomers by traditional oil-in-water or water-in-oil emulsion polymerization techniques. Alternatively, a pseudo latex may be prepared by esterification of preformed polymer with C<sub>1</sub>-C<sub>20</sub> alkanol.

A variety of techniques well-known in the art can be used to prepare latexes of water-insoluble polymer particles. These include batch, semi-continuous and seeded emulsion polymerization. See the Encyclopedia of Polymer Science and Engineering, Volume 6, 1990.

Particularly preferred polymers for the present invention are styrene/acrylate latexes available from the Rohm & Haas Company sold under the trademark Acusol. The latexes are characterized by pH of about 2 to about 3, having approximately 40% solids in water, with particle size of about 0.1 to about 0.5 micron. Specific Acusol<sup>®</sup> polymers

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include Acusol<sup>®</sup> OP301 (styrene/acrylate) polymer, Acusol<sup>®</sup>  
OP302 (Styrene/Acrylate/Divinylbenzene Copolymer), Acusol<sup>®</sup>  
OP303 (Styrene/Acrylamide Copolymer), Acusol<sup>®</sup> OP305  
(Styrene/PEG-10 Maleate/Nonoxynol-10 Maleate/Acrylate  
5 Copolymer) and (Styrene/Acrylate/PEG-10 Dimaleate  
Copolymer).

Number average molecular weight for polymers according to  
the present invention may range from about 1,000 to about  
1,000,000, preferably from about 2,000 to about 500,000,  
10 optimally from about 5,000 to about 20,000.

A further component of the cleansing compositions according  
to the present invention is that of an anionic surfactant.  
Illustrative but not limiting examples include the following  
classes:

15 (1) Alkyl benzene sulfonates in which the alkyl  
group contains from 9 to 15 carbon atoms,  
preferably 11 to 14 carbon atoms in straight chain  
or branched chain configuration. Especially  
preferred is a linear alkyl benzene sulfonate  
20 containing about 12 carbon atoms in the alkyl  
chain.

(2) Alkyl sulfates obtained by sulfating an  
alcohol having 8 to 22 carbon atoms, preferably 12  
to 16 carbon atoms. The alkyl sulfates have the  
25 formula  $\text{ROSO}_3^- \text{M}^+$  where R is the C<sub>8-22</sub> alkyl group  
and M is a mono- and/or divalent cation.

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(3) Paraffin sulfonates having 8 to 22 carbon atoms, preferably 12 to 16 carbon atoms, in the alkyl moiety. These surfactants are commercially available as Hostapur SAS from Hoechst Celanese.

5 (4) Olefin sulfonates having 8 to 22 carbon atoms, preferably 12 to 16 carbon atoms. Most preferred is sodium C<sub>14</sub>-C<sub>16</sub> olefin sulfonate, available as Bioterge AS 40<sup>®</sup>

10 (5) Alkyl ether sulfates derived from an alcohol having 8 to 22 carbon atoms, preferably 12 to 16 carbon atoms, ethoxylated with less than 30, preferably less than 12, moles of ethylene oxide. Most preferred is sodium lauryl ether sulfate formed from 2 moles average ethoxylation,  
15 commercially available as Standopol ES-2<sup>®</sup>.

(6) Alkyl glyceryl ether sulfonates having 8 to 22 carbon atoms, preferably 12 to 16 carbon atoms, in the alkyl moiety.

20 (7) Fatty acid ester sulfonates of the formula:  
 $R^1CH(SO_3-M^+)CO_2R^2$

where R<sup>1</sup> is straight or branched alkyl from about C<sub>8</sub> to C<sub>18</sub>, preferably C<sub>12</sub> to C<sub>16</sub>, and R<sup>2</sup> is straight or branched alkyl from about C<sub>1</sub> to C<sub>6</sub>, preferably primarily C<sub>1</sub>, and M<sup>+</sup> represents a mono- or  
25 divalent cation.



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(8) Secondary alcohol sulfates having 6 to 18, preferably 8 to 16 carbon atoms.

5 (9) Fatty acyl isethionates having from 10 to 22 carbon atoms, with sodium cocoyl isethionate being preferred.

(10) Dialkyl sulfosuccinates wherein the alkyl groups range from 3 to 20 carbon atoms each.

10 (11) Alkanoyl sarcosinates corresponding to the formula  $RCON(CH_3)CH_2CH_2CO_2M$  wherein R is alkyl or alkenyl of about 10 to about 20 carbon atoms and M is a water-soluble cation such as ammonium, sodium, potassium and trialkanolammonium. Most preferred is sodium lauroyl sarcosinate.

15 Amounts of the anionic surfactant may range from 0.1 to 10%, preferably from 0.5 to 6%, optimally from 2 to 3% by weight of the cleansing composition. In instances where formulations contain more than one anionic surfactant, it is advantageous to limit the total amount of anionic surfactant to arrange from 0.1 to 20%, more preferably from 1 to 10% by  
20 weight of the cleansing composition.

Co-surfactants may also be present to aid in the foaming, detergency and mildness properties. Nonionic and amphoteric actives are the preferred co-surfactants. Suitable nonionic surfactants include C<sub>10</sub>-C<sub>20</sub> fatty alcohol or acid hydrophobes  
25 condensed with from 2 to 100 moles of ethylene oxide or propylene oxide per mole of hydrophobe; C<sub>2</sub>-C<sub>10</sub> alkyl phenols condensed with from 2 to 20 moles of alkylene oxides; mono-

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and di- fatty acid esters of ethylene glycol such as ethylene glycol distearate; fatty acid monoglycerides; sorbitan mono- and di- C<sub>8</sub>-C<sub>20</sub> fatty acids; and polyoxyethylene sorbitan available as Polysorbate 80 and Tween 80<sup>®</sup> as well as combinations of any of the above surfactants.

Other useful nonionic surfactants include alkyl polyglycosides, saccharide fatty amides (e.g. methyl gluconamides) as well as long chain tertiary amine oxides. Examples of the latter category are: dimethyldodecylamine oxide, oleyldi(2-hydroxyethyl)amine oxide, dimethyloctylamine oxide, dimethyldecylamine oxide, dimethyltetradecylamine oxide, di(2-hydroxyethyl)tetradecylamine oxide, 3-didodecoxy-2-hydroxypropyldi(3-hydroxypropyl)amine oxide, and dimethylhexadecylamine oxide.

Amounts of the nonionic surfactant may range if present from 0.1 to 40%, preferably from 0.5 to 10%, optimally from 1 to 5% by weight of the cleansing composition.

Amphoteric surfactants such as betaines may also be employed as co-actives along with the anionic surfactants. Suitable betaines may have the general formula  $RN^+(R^1)_2R^2COO^-$  wherein R is a hydrophobic moiety selected from the group consisting of alkyl groups containing from 10 to 22 carbon atoms, preferably from 12 to 18 carbon atoms; alkyl aryl and aryl alkyl groups containing 10 to 22 carbon atoms with a benzene ring being treated as equivalent to about 2 carbon atoms, and similar structures interrupted by amido or ether

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linkages; each R<sup>1</sup> is an alkyl group containing from 1 to 3 carbon atoms; and R<sup>2</sup> is an alkylene group containing from 1 to about 6 carbon atoms. Sulfobetaines such as cocoamidopropyl sultaine are also suitable.

5 Examples of preferred betaines are dodecyl dimethyl betaine, cetyl dimethyl betaine, dodecyl amidopropyldimethyl betaine, tetradecyldimethyl betaine, tetradecylamidopropyldimethyl betaine, and dodecyldimethylammonium hexanoate. Most preferred is cocoamidopropyl betaine available as  
10 Tegobetaine F<sup>®</sup> sold by Th. Goldschmidt AG of Germany. Amounts of the betaine may range from 0.05 to 15%, preferably from 0.5 to 10%, optimally from 2 to 8% by weight of the cleansing composition.

Particularly preferred amphoteric surfactants include the  
15 alkali, alkaline earth, ammonium and trialkanolammonium salts of cocoamphoacetate, cocoamphopropionate, cocoamphodipropionate and mixtures thereof. Most preferred is sodium cocoamphoacetate available as Miranol HMA from the Rhone Poulenc Corporation. Similar surfactants are also  
20 available as Amphotege<sup>®</sup> from Lonza Inc., Fair Lawn, N.J. While the sodium salt is preferred, other cations can also be employed including lithium, potassium, magnesium and calcium. Amounts of the amphoteric surfactant if present may range from 0.1 to 20%, preferably from 1 to 10%,  
25 optimally from 2 to 6% by weight of the cleansing composition. When more than one amphoteric surfactant is present, the total amount of amphoteric surfactant may usually range from 0.1 to 10%, preferably from 0.5 to 8%,

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optimally from 1 to 5% by weight of the cleansing composition.

Moisturizing ingredients may also be included in compositions of the present invention. Water soluble  
5 moisturizers such as polyhydric alcohol-type humectants are particularly preferred. Typical polyhydric alcohols include glycerol (also known as glycerin), polyalkylene glycols and more preferably alkylene polyols and their derivatives,  
including propylene glycol, dipropylene glycol,  
10 polypropylene glycol, polyethylene glycol and derivatives thereof, sorbitol, hydroxypropyl sorbitol, hexylene glycol, 1,3-butylene glycol, 1,2,6-hexanetriol, ethoxylated glycerol, propoxylated glycerol and mixtures thereof. For best results the humectant is preferably glycerin. The  
15 amount of humectant may range anywhere from 0.5 to 30%, preferably between 1 and 15% by weight of the cleansing composition.

Preservatives can desirably be incorporated into the cosmetic compositions of this invention to protect against  
20 the growth of potentially harmful microorganisms. Suitable traditional preservatives are EDTA salts and alkyl esters of para-hydroxybenzoic acid. Other preservatives which have more recently come into use include hydantoin derivatives, propionate salts, and a variety of quaternary ammonium  
25 compounds. Cosmetic chemists are familiar with appropriate preservatives and routinely choose them to satisfy the preservative challenge test and to provide product stability. Particularly preferred preservatives are iodopropynyl butyl carbamate, phenoxyethanol, methyl  
30 paraben, propyl paraben, imidazolidinyl urea, sodium

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dehydroacetate and benzyl alcohol. The preservatives should be selected having regard for the use of the composition and possible incompatibilities between the preservatives and other ingredients in the composition. Preservatives are preferably employed in amounts ranging from 0.01% to 2% by weight of the cleansing composition.

Minor adjunct ingredients may be present in the cosmetic compositions. Among them may be vitamins, colorants, fragrances and opacifiers. Each of these substances may range from 0.05 to 5%, preferably between 0.1 and 3% by weight of the cleansing composition.

Advantageously, the compositions of the invention may contain a foam densifying agent. Examples of this substance are waxy materials with a melting point greater than 20°C, preferably greater than 40°C. Illustrative are ethoxylated glyceride esters such as PEG 75 soy glycerides sold under the trademark Acconon S 75. Also useful are C<sub>8</sub>-C<sub>12</sub> acyl lactylates such as sodium lauroyl lactylate sold as Pationic 138 C<sup>®</sup> available from the Patterson Chemical Company.

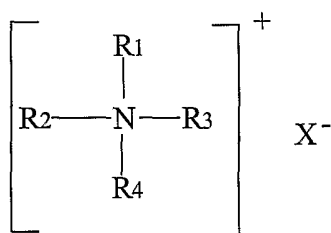
Amounts of these agents may range from 0.1 to 10%, preferably from 0.5 to 5%, optimally from 1 to 3% by weight of the cleansing composition.

Cationic conditioning agents in monomeric and polymeric type are also useful for purposes of this invention. Examples of the polymeric type include: cationic cellulose derivatives, cationic starches, copolymers of a diallyl quaternary ammonium salt and an acryl amide, quaternized vinylpyrrolidone, vinylimidazole polymers, polyglycol amine

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condensates, quaternized collagen polypeptide, polyethylene imine, cationized silicon polymer (e.g. Amodimethicone), cationic silicon polymers provided in a mixture with other components under the trademark Dow Corning 929 (cationized emulsion), copolymers of adipic acid and dimethylaminohydroxypropyl diethylenetriamine, cationic chitin derivatives, cationized guar gum (e.g. Jaguar C-B-S, Jaguar C-17, Jaguar C-16, etc. manufactured by the Celanese Company), quaternary ammonium salt polymers (e.g. Mirapol A-15, Mirapol AD-1, Mirapol AZ-1, etc., manufactured by the Miranol Division of the Rhone Poulenc Company). Most preferred is polyquaternium-11 available as Luviquat<sup>®</sup> PQ 11 sold by the BASF Corporation.

Examples of monomeric cationic conditioning agents are salts of the general structure:



wherein R<sup>1</sup> is selected from an alkyl group having from 12 to 22 carbon atoms, or aromatic, aryl or alkaryl groups having from 12 to 22 carbon atoms; R<sup>2</sup>, R<sup>3</sup>, and R<sup>4</sup> are independently selected from hydrogen, an alkyl group having from 1 to 22 carbon atoms, or aromatic, aryl or alkaryl groups having from 12 to 22 carbon atoms; and X<sup>-</sup> is an anion selected from chloride, bromide, iodide, acetate, phosphate, nitrate,

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sulfate, methyl sulfate, ethyl sulfate, tosylate, lactate, citrate, glycolate, and mixtures thereof. Additionally, the alkyl groups can also contain ether linkages, or hydroxy or amino group substituents (e.g., the alkyl groups can contain polyethylene glycol and polypropylene glycol moieties).  
5 Preferably the anion is phosphate, especially preferred is hydroxy ethyl cetyl dimonium phosphate available as Luviquat<sup>®</sup> Mono CP from the BASF Corporation.

Amino silicone quats may similarly be employed. Most  
10 preferred is Silquat AD designated by the CTFA as Silicone Quaternium 8, available from Siltech Inc.

Amounts of each cationic agent may range from 0.05 to 5%, preferably from 0.1 to 3%, optimally from 0.3 to 2.5% by weight of the cleansing composition.

15 Compositions of this invention are preferably opaque. By the term opaque is meant having less than 20% light transmittance of any wave length in the range of 400 to 700 nm through a sample 1 cm thick.

Compositions of this invention should also be of relatively  
20 low viscosity to be pumpable. Viscosity may range from 1 to 300 centipoise, preferably from 3 to 100 centipoise, optimally from 5 to 50 centipoise at 25°C. Measurement is via a Brookfield RVT Viscometer, Spindle No. 1, 100 rpm at 25°C.

25 Compositions of this invention may have a very broad pH range. Advantageously, the pH will be acidic with pH range

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from 2 to 6.8, preferably from 3 to 6, optimally from 4.5 to 6 for the cleansing composition.

An important element of cosmetic products according to this invention is a non-aerosol mechanical dispenser. The  
5 dispenser is generally characterized by a container for storing the composition (preferably a transparent container), a dispensing head defined by a housing containing a pump, and a diptube for transferring the composition from the container into the dispensing head.  
10 Foam is created by requiring the composition to pass through a screen material which may be a porous substance such as a sintered material, a wire (plastic or metal) gauze screen or similar structures.

Suitable dispensers are described in U.S. Patent 3,709,437  
15 (Wright), U.S. Patent 3,937,364 (Wright), U.S. Patent 4,022,351 (Wright), U.S. Patent 4,147,306 (Bennett), U.S. Patent 4,184,615 (Wright), U.S. Patent 4,598,862 (Rice), U.S. Patent 4,615,467 (Grogan et al.) and U.S. Patent 5,364,031 (Tamiguchi et al.). Most preferred however is a  
20 device sold by the Airspray International Corporation described in WO 97/13585 (Van der Heijden). All these patents are incorporated herein by reference. The Airspray device comprises a container for storing a cleansing composition and a dispensing head, the latter including at  
25 least a concentric air pump and liquid pump. Each of the pumps has a piston chamber with a piston displaceable therein and an inlet and discharge, and an operating component for operating the two pumps. The operating component is integral with one of the pistons and comprises  
30 an outflow channel with a dispensing opening. Shut-off



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mechanisms, rendering it possible to suck up air or liquid, respectively, and dispense them, are present in the inlet and discharge of the pumps. The air pump includes a double-acting shut-off device which can be operated actively by the  
5 operating component. The shut-off device prevents both the inlet of air to the air pump and discharge of air therefrom. The air piston is able to be moved freely at least over a small distance with respect to the operating component.

Except in the operating and comparative examples, or where  
10 otherwise explicitly indicated, all numbers in this description indicating amounts of material ought to be understood as modified by the word "about".

The term "comprising" is meant not to be limiting to any subsequently stated elements but rather to encompass non-  
15 specified elements of major or minor functional importance. In other words the listed steps, elements or options need not be exhaustive.

The following examples will more fully illustrate the embodiments of this invention. All parts, percentages and  
20 proportions referred to herein and in the appended claims are by weight unless otherwise indicated.

#### EXAMPLE 1

A foamable cosmetic product according to the present  
25 invention was prepared according to the formula of Table I.

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TABLE I

INGREDIENT	WEIGHT %
<b>PHASE A</b>	
Water	68.09
Paticonic <sup>®</sup> 138A (C) (Sodium Lauryl Lactylate)	0.50
DL-Panthenol	0.05
Glycerin	3.00
Acconon <sup>®</sup> S75 (PEG-75 Soy Glycerides)	1.00
<b>PHASE B</b>	
Sodium Lauryl Ether-3 Sulphate (30% Actives)	6.00
Sodium C <sub>14</sub> -C <sub>16</sub> Olefin Sulphonate (40% Active)	6.00
Cocoamidopropyl Betaine (30% Active)	6.00
Sodium Lauroamphoacetate (32% Active)	5.00
Polysorbate 80	1.00
Mackanate <sup>®</sup> DC-30 (Dimethicone Copolyol Sulfosuccinate-30% Active)	1.66
<b>PHASE C</b>	
Polysorbate 20	0.15
Fragrance	0.20
Glydant Plus <sup>®</sup>	0.20
Citric Acid	0.15
<b>PHASE D</b>	
Acusol <sup>®</sup> OP301	1.00

Ingredients of Phase A were charged to a reactor and heated at 60°C under moderate agitation. Temperature was lowered to 50°C whereupon ingredients listed under Phase B were singly added one after another allowing sufficient mixing time between each addition. Temperature was then lowered to 40°C whereupon the ingredients of Phase C were combined with those of Phase A/B previously formed. Lastly, temperature was lowered to 35°C and Acusol<sup>®</sup> OP301 was charged to the remainder of the mixing ingredients.

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The resultant cosmetic composition was packaged into an Airspray, double gauze screen dispenser pump package forming the delivery system.

## EXAMPLE 2

- 5 Another foaming cosmetic product according to the present invention has a formula as described in Table II.

TABLE II

INGREDIENT	WEIGHT %
<b>PHASE A</b>	
Water	74.59
Pationic <sup>®</sup> 138A (C) (Sodium Lauryl Lactylate)	0.50
DL-Panthenol	0.05
Glycerin	3.00
Acconon <sup>®</sup> S75 (PEG-75 Soy Glycerides)	1.00
<b>PHASE B</b>	
Sodium Lauryl Ether-3 Sulphate (30% Actives)	4.00
Sodium C <sub>14</sub> -C <sub>16</sub> Olefin Sulphonate (40% Active)	4.00
Cocoamidopropyl Betaine (30% Active)	4.00
Sodium Lauroamphoacetate (32% Active)	5.00
Plantereen <sup>®</sup> 2000 (Alkyl Polyglucoside)	1.00
Mackanate <sup>®</sup> DC-30 (Dimethicone Copolyol Sulfosuccinate-30% Active)	1.66
<b>PHASE C</b>	
Polysorbate 20	0.15
Fragrance	0.20
Glydant Plus <sup>®</sup>	0.20
Citric Acid	0.15
<b>PHASE D</b>	
Acusol <sup>®</sup> OP301	0.50

- 10 The composition in Table II is formulated in a manner similar to that found under Example 1. Likewise, the

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resultant product is placed in an Airspray pump as the dispensing package.

## EXAMPLE 3

Another foam producing cosmetic product according to the present invention has a foamable composition described under Table III.

TABLE III

INGREDIENT	% WEIGHT/WEIGHT
Lauryldimonium Hydroxypropyl Hydrolyzed Collagen	7.14
Hexylene Glycol	6.50
Decyl Polyglucose	6.00
Sodium Lauryl Ether-3 Sulphate (30% Active)	6.00
Laurodimonium Hydroxypropyl Oxyethyl Cellulose	5.67
Cocoamidopropyl Betaine (30% Active)	5.00
Glycerin	3.00
Sodium Isostearoyl Lactylate	1.00
Acusol <sup>®</sup> OP 302	1.00
Fragrance	0.35
Glydant Plus <sup>®</sup>	0.10
Tetrasodium EDTA	0.10
Water	Balance

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## EXAMPLE 4

Various potential opacifiers were evaluated for their performance characteristics. Table IV lists the base of composition into which were formulated the opacifiers.

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TABLE IV

INGREDIENT	WEIGHT %
Water	Balance
Pationic <sup>®</sup> 138C (Na lauroyl lactylate)	0.50
DL-Panthenol	0.05
Acconon <sup>®</sup> S75 (PEG-75 Soy Glycerides)	1.00
Glycerin	5.00
Sodium Lauryl Ether-3 Sulphate (30% Active)	6.00
Sodium C <sub>14</sub> -C <sub>16</sub> Olefin Sulphonate (40% Active)	6.00
Cocoamidopropyl Betaine (30% Active)	6.00
Sodium Lauroamphoacetate (32% Active)	8.00
Polysorbate 80	1.00
Dimethicone Copolyol Sulfosuccinate (Mackanate <sup>®</sup> DC-30)	1.66
Polysorbate 20	0.15
Glydant Plus <sup>®</sup>	0.10
Fragrance	0.20
Citric Acid	0.15
Opacifier	*

TABLE V

Opacifier	Weight (%)	Effect on Product	Stability
Styrene/Acrylate Copolymer (Acusol® OP301)	0.20	Good white/opaque appearance and creamy rich lather. No apparent drawbacks.	Stable
Styrene/Acrylamide Copolymer (Acusol® OP303)	0.20	Good white/opaque appearance and creamy rich lather. No apparent drawbacks.	Stable
Styrene/PEG-10 Maleate/Nonoxynol-10 Maleate/Acrylate Copolymer (Acusol® OP305)	0.20	Good white/opaque appearance and creamy rich lather. No apparent drawbacks.	Stable
Zinc Oxide	0.20	Imparted insufficient opacity to product.	Settled out overnight
Ultra Fine Silica	0.20	Imparted insufficient opacity to product.	Settled out overnight
Ultra Fine Silica	6.18	Good white/opaque appearance. Clogged screen of pump.	Settled out overnight
Silica	0.20	Imparted insufficient opacity to product.	Settled out overnight
Silica	2.22	Clogged screen of pump.	Settled out overnight
Water Dispersible Titanium Dioxide	0.20	Left slight white stain on sink and countertop.	Settled out overnight
Water Dispersible Titanium Dioxide	1.65	Left white stain on sink and countertop.	Settled out overnight

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Inorganic opacifiers such as zinc oxide, silica and titanium dioxide were relatively ineffective at low concentrations (i.e. 0.2%) to impart sufficient opacity to the base composition. Levels of these materials which did  
5 sufficiently opacify were unstable in the system and/or clogged the pump screen. By contrast, the Acusol<sup>®</sup> latexes performed well. Opacity and phase stability were both good. Screens were not clogged and a creamy, rich lather was able to be generated.

CLAIMS

1. A foaming cosmetic product comprising:

(A) a non-aerosol dispenser comprising:

5 (i) a container for storing a cleansing composition;

(ii) a dispenser head located on the container having a housing surrounding a pump mechanism and a foam-forming screen material;

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(iii) a diptube communicating between the container and head functioning to fluidly deliver liquid cleansing composition between container and head and being upstream from the screen material; and

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(B) the cleansing composition comprising:

(i) from 0.01 to 10% by weight of the cleansing composition of a latex suspending from 0.1% to 90% by weight of the latex of a polymer insoluble in the composition; and

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(ii) from 0.1 to 10% by weight of the cleansing composition of at least one anionic surfactant.

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2. The product according to claim 1 wherein the screen material is a wire gauze.
3. The product according to claim 2 wherein a second wire gauze is placed down stream from a first wire gauze, the  
5 cosmetic composition being required to traverse both the first and second wire gauze to achieve a foam.
4. The product according to claim 1 wherein the screen material is a sintered material.
5. The product according to any of the preceding claims  
10 wherein the polymer is formed from a monomer selected from styrene, alpha-methylstyrene, divinylbenzene, acrylic acid, methacrylic acid, C<sub>1</sub>-C<sub>20</sub> esters of acrylic acid or methacrylic acid, acrylamide, methacrylamide, maleic acid, vinyl acetate, crotonic acid, vinyl  
15 neodecanoate and butenoic acid, and mixtures thereof.
6. The product according to any of the preceding claims wherein the polymer is selected from Styrene/Acrylate Copolymer, Styrene/Acrylate/Divinylbenzene Copolymer, Styrene/PEG-10 Maleate/Nonoxynol-10 Maleate/Acrylate  
20 Copolymer, Styrene/Acrylamide Copolymer and Styrene/Acrylate/PEG-10 Dimaleate Copolymer.
7. The product according to claim 6 wherein the polymer is a styrene/acrylate copolymer.
8. The product according to any of the preceding claims  
25 wherein the latex is present in an amount from 0.1 to 5% by weight of the cleansing composition.

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9. The product according to any of the preceding claims wherein the pH ranges from 2 to 6.8.
10. The product according to any of the preceding claims wherein all anionic surfactants are present in total  
5 amount from 0.1 to 20% by weight of the cleansing composition.