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(57) **Abrégé/Abstract:**

A surfactant free soap bar comprising soap, 0.1 to 2.5% by weight free fatty acid, 3 to 7% by weight talc, and 0.1 to 5% glycerin. The talc can be a macrocrystalline talc having  $D_{90} \geq 40 \mu\text{m}$  and optionally  $D_{50} \geq 20 \mu\text{m}$  or  $D_{10} \geq 5 \mu\text{m}$ . The combination provides increased skin feel and leaves skin looking less dry.

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(57) Abstract: A surfactant free soap bar comprising soap, 0.1 to 2.5% by weight free fatty acid, 3 to 7% by weight talc, and 0.1 to 5% glycerin. The talc can be a macrocrystalline talc having  $D_{90} \geq 40 \mu\text{m}$  and optionally  $D_{50} \geq 20 \mu\text{m}$  or  $D_{10} \geq 5 \mu\text{m}$ . The combination provides increased skin feel and leaves skin looking less dry.

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## SOAP BAR

### FIELD OF THE INVENTION

[0001] The present invention relates to soap bars.

### BACKGROUND OF THE INVENTION

[0002] Soap bars contain soap made from salts of fatty acids. Soap bars are used for cleansing skin. When using soap bars, there is a desire for the soap to provide a desired skin feel and not dry the skin. It would be desirable to provide a soap bar that can leave skin not looking dry and looking moisturized.

### BRIEF SUMMARY OF THE INVENTION

[0003] A surfactant free soap bar comprising soap, free fatty acid in an amount of 0.1 to 2.5% by weight of the bar, macrocrystalline talc in an amount of 3 to 7% by weight of the bar, and glycerin in an amount of 0.1 to 5% by weight of the bar. The soap bar can also be used in a method to cleanse skin by cleansing with the soap bar. Also a use of a soap bar comprising 0.1 to 2.5% free fatty acid by weight of the bar, 3 to 7% macrocrystalline talc by weight of the bar, and 0.1 to 5% glycerin by weight of the bar for reducing dryness on skin or for increasing fragrance perception.

[0004] Further areas of applicability of the present invention will become apparent from the detailed description provided hereinafter. It should be understood that the detailed description and specific examples, while indicating the preferred embodiment of the invention, are intended for purposes of illustration only and are not intended to limit the scope of the invention.

### DETAILED DESCRIPTION OF THE INVENTION

[0005] The following description of the preferred embodiment(s) is merely exemplary in nature and is in no way intended to limit the invention, its application, or uses.

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[0006] The term surfactant free means that there is less than 0.5% by weight of anionic, nonionic, amphoteric, and zwitterionic surfactants total in the soap bar. While soap is an anionic surfactant, the term soap is not included in the exclusion of anionic surfactants. Also, the term surfactant free can also exclude cationic surfactants that are not present to provide conditioning or antibacterial effect. Some cationic surfactants can condition skin or provide an antibacterial effect. These types of materials can be included in the soap bar. In other embodiments, there is

less than 0.4, less than 0.3, less than 0.2, less than 0.1, less than 0.05, less than 0.01, or no surfactant in the soap bar.

[0007] The soap can be made from typical fatty acids, such as C<sub>12</sub>-C<sub>20</sub> fatty acids. Typical fatty acids used for soaps include, myristic acid, lauric acid, palmitic acid, stearic acids, and other fatty acids. Sources of fatty acids include coconut oil, palm oil, palm kernel oil, tallow, avocado, canola, corn, cottonseed, olive, hi-oleic sunflower, mid-oleic sunflower, sunflower, palm stearin, palm kernel olein, safflower, and babassu oils. The fatty acids can be neutralized with any base to form a soap. Typical bases include, but are not limited to, sodium hydroxide, potassium hydroxide, and triethanolamine.

[0008] The soap bar includes free fatty acid, which is present in acid form. The free fatty acids can be any of the above fatty acids that are used to make soap. The free fatty acid is present in the soap bar in an amount of 0.1 to 2.5% by weight of the bar. In other embodiments, the amount of free fatty acid is 0.1 to 2%, 0.1 to 1.5%, 0.1 to 1%, 0.5 to 2%, 0.5 to 1%, 1.2% or 1% by weight of the bar.

[0009] The soap bar includes talc. The talc is present in the soap bar in an amount of 3 to 7% by weight of the bar. In other embodiments, the amount of talc is 4 to 6%, 4.5 to 5.5% or 5% by weight of the bar. In certain embodiments, the talc is a macrocrystalline talc, which has large particle sizes. In certain embodiments, the talc has D<sub>90</sub>≥40μm, optionally D<sub>90</sub>≥50μm or D<sub>90</sub>≥60μm. In other embodiments, the talc has D<sub>50</sub>≥20μm, optionally D<sub>50</sub>≥25μm. In another embodiment, the talc has D<sub>10</sub>≥5μm. In another embodiment, the talc has D<sub>90</sub>≥50μm and D<sub>50</sub>≥20μm, optionally D<sub>90</sub>≥60μm.

[0010] The soap bar also includes glycerin. The glycerin is present in an amount of 0.1 to 5% by weight of the soap bar. In other embodiments, glycerin is present in an amount of 0.1 to 3%, 0.1 to 2%, 0.1 to 1.5%, 0.1 to 1%, 0.5 to 2%, 0.5 to 1.5%, 0.7%, 1%, or 1.4% by weight of the bar.

[0011] Optionally, the soap bar can contain any other materials that can be added to soap bars. Examples include, but are not limited to, fillers, fragrances, colorants, pH agents, antibacterial actives, preservatives, deodorant actives, emollients, moisturizers, vitamins, and exfoliating agents.

[0012] The soap bar can leave skin feeling and looking more moisturized and less dry. Also, the perception of fragrance can be increased using the combination of free fatty acid, talc, and glycerin in the soap bar.

[0013] Examples

[0014] The following soap bars are prepared.

| Material        | Example 1<br>(wt. %) | Comparative<br>(wt. %) |
|-----------------|----------------------|------------------------|
| Free fatty acid | 2                    | 5                      |
| Talc            | 5                    | 5                      |
| Glycerin        | 2                    | 2                      |
| Soap and minors | Q.S.                 | Q.S.                   |

Note, the same talc is used in both bars. The talc is the macrocrystalline talc.

[0015] Ten panelists wash one forearm with Example 1 and the other forearm with the comparative soap bar. Immediately after washing, the panelists are asked which soap was preferred. Seven out of ten preferred Example 1 with 2 weight % fatty acid compared to the 5 weight % fatty acid soap bars.

[0016] The following soap bars are prepared.

| Material        | Example 2<br>(wt. %) | Comparative<br>(wt. %) |
|-----------------|----------------------|------------------------|
| Free fatty acid | 2                    | 2                      |
| Talc            | 5                    | 5                      |
| Glycerin        | 2                    | 2                      |
| Soap and minors | Q.S.                 | Q.S.                   |

Note, Example 2 uses the the macrocrystalline talc, and the comparative uses a standard talc that is not macrocrystalline.

[0017] Ten panelists wash one forearm with Example 2 and the other forearm with the comparative soap bar. Immediately after washing, the panelists are asked which soap was preferred. Eight out of ten preferred Example 2 with the macrocrystalline talc.

[0018] As used throughout, ranges are used as shorthand for describing each and every value that is within the range. Any value within the range can be selected as the terminus of the range. In the event of a conflict in a definition in the present disclosure and that of a cited reference, the present disclosure controls.

[0019] Unless otherwise specified, all percentages and amounts expressed herein and elsewhere in the specification should be understood to refer to percentages by weight. The amounts given are based on the active weight of the material.

CLAIMS:

1. A surfactant free soap bar comprising:
  - a) soap,
  - b) free fatty acid in an amount of 0.1 to 2.5% by weight of the bar,
  - c) macrocrystalline talc in an amount of 3 to 7% by weight of the bar, and
  - d) glycerin in an amount of 0.1 to 5% by weight of the bar.
2. The soap bar of claim 1, wherein the free fatty acid is present in an amount of 0.1 to 2% by weight of the bar.
3. The soap bar of claim 1 or 2, wherein the free fatty acid is present in an amount of 0.1 to 1.5%, 0.1 to 1%, 0.5 to 2%, 0.5 to 1% or 1% by weight of the bar.
4. The soap bar of any one of claims 1-3, wherein the talc is present in an amount of 4 to 6% by weight of the bar.
5. The soap bar of any one of claims 1-4, wherein the talc is present in an amount of 4.5 to 5.5% or 5% by weight of the bar.
6. The soap bar of any one of claims 1-5, wherein the glycerin is present in an amount of 0.1 to 3% by weight of the bar.
7. The soap bar of any one of claims 1-6, wherein the glycerin is present in an amount of 0.1 to 2%, 0.1 to 1.5%, 0.1 to 1%, 0.5 to 2%, 0.5 to 1.5%, 0.7%, 1%, or 1.4% by weight of the bar.
8. The soap bar of any one of claims 1-7, wherein the talc has  $D_{90} \geq 40 \mu\text{m}$ .
9. The soap bar of any one of claims 1-8, wherein the talc has  $D_{90} \geq 50 \mu\text{m}$  or  $D_{90} \geq 60 \mu\text{m}$ .
10. The soap bar of any one of claims 1-9, wherein the talc has  $D_{50} \geq 20 \mu\text{m}$ .
11. The soap bar of any one of claims 1-10, wherein the talc has  $D_{50} \geq 25 \mu\text{m}$ .
12. The soap bar of any one of claims 1-11, wherein the talc has  $D_{10} \geq 5 \mu\text{m}$ .
13. The soap bar of any one of claims 1-12, wherein the talc has  $D_{90} \geq 50 \mu\text{m}$  and  $D_{50} \geq 20 \mu\text{m}$ .
14. The soap bar of any one of claims 1-13, wherein the talc has  $D_{90} \geq 60 \mu\text{m}$ .

15. The soap bar of any one of claims 1-14, which comprises one of:
  - e) 0.7% by weight glycerin, 1.2% by weight free fatty acid, and 5% by weight talc,
  - f) 4.5% by weight glycerin, 1% by weight free fatty acid, and 5% by weight talc,
  - g) 1.4% by weight glycerin, 1.2% by weight free fatty acid, and 5% by weight talc, or
  - h) 1% by weight glycerin, 1% by weight free fatty acid, and 5% by weight talc.
16. A method for cleansing skin comprising cleansing skin with the soap bar of any one of claims 1-15.
17. Use of a soap bar comprising 0.1 to 2.5% free fatty acid by weight of the bar, 3 to 7% macrocrystalline talc by weight of the bar, and 0.1 to 5% glycerin by weight of the bar for reducing dryness on skin or for increasing fragrance perception.
18. The use of claim 17, for reducing dryness in skin.
19. The use of claim 17, for increasing fragrance perception.