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(54) **Title:** MASCARA COMPOSITIONS WITH ENHANCED DEPTH OF COLOR

(57) **Abstract:** Mascara compositions having enhanced depth of color are provided that maintain flexibility qualities. Mascaras emulsion compositions comprise an at least one glutamic acid gellant, a low opacity wax composition, at least one pigment, a non-aqueous phase, and an aqueous phase. Other mascara compositions comprise an anhydrous vehicle, a glutamic acid gellant, a low opacity wax composition, and a pigment.



MASCARA COMPOSITIONS WITH ENHANCED DEPTH OF COLOR

RELATED APPLICATIONS

[001] This application claims priority benefit to U.S. Provisional Patent Application Serial Nos. 61/789,975 and 61/790,104, both filed on March 15, 2013, the entirety of both of which is herein incorporated by reference for all purposes.

FIELD OF INVENTION

[002] The present invention relates to a cosmetic composition such as mascara. More specifically, the invention relates to the use of glutamic acid derivatives in anhydrous mascara compositions and mascara emulsion compositions to enhance the depth of color as applied to the eyelashes.

BACKGROUND OF THE INVENTION

[003] Mascaras are generally used by women to accentuate their lashes – that is, impart color and/or aesthetic effects to eyelashes. In particular, consumers look to mascaras to darken, lengthen, thicken, and curl their lashes. Most mascara compositions contain waxes as a means to obtain all of these attributes.

[004] However, waxes have certain undesirable properties when used in a mascara composition. First, waxes are typically opaque solids. Mascaras containing such waxes exhibit more muted colors or require additional amounts of pigments to achieve the same color effect, thus, impairing the mascara's ability to provide the dark coloring desired by consumers. Wax based mascaras make lashes dry and brittle, easily smudge and flake, make the eyelashes clump and stick together, and often feel heavy, sticky and stiff on the lashes. Mascara containing a reduced level of waxes would lessen these characteristics and improve the overall organoleptics of the mascara.

[005] Accordingly, mascara compositions that impart a richer, more lustrous appearance than conventional mascaras and that provide depth of color (deep dark coloring), while maintaining or improving any of the other desired attributes of mascara are needed. It would further be desirable to have mascara that has the

visual appearance of lengthening and thickening eyelashes while imparting a dramatic color effect.

[006] U.S. Patent No. 6,214,329 to Brieva *et al.* discloses the use of organic, non-polymeric gelling agents with or without waxes in pigmented emulsions (mascaras) to achieve a viscosity of 4,000 to 2,000,000 centipoise at 25° C.

[007] Patent Publication No. WO 2011112804 to Bui *et al.* discloses cosmetic compositions, including mascaras, incorporating (a) a low molecular mass N-acyl glutamic acid diamide having a straight-chain alkyl group; (b) a low molecular mass N-acyl glutamic acid diamide having a branched-chain alkyl group; (c) at least one gel-promoting solvent; (d) at least one film former; (e) at least one volatile solvent capable of solubilizing the film former; and (f) at least one colorant; and (g) a polyorganosiloxane-containing polymer, wherein the composition has a hardness value ranging from about 30 to about 300g, a melting point of about 500° C or higher, and does not require use of wax as a structuring agent.

[008] U.S. Publication No. 2009/0280077 to Yoshida *et al.* discusses amino acid, polyamide resins, and various monoesters gelling agents when used individually in maintaining the usability and stability of cosmetic compositions. Yoshida discloses the combination of the above gelling agents to enhance the usability and stability of cosmetic compositions.

[009] U.S. Publication No. 2011/0150793 to Do *et al.* discloses an anhydrous solid, a semi-solid, or a viscous gel cosmetic composition that is clear or transparent. Do discloses that the cosmetic composition incorporates a mixture of at least two amino acid-based gelatinizing agents, a non-ionic unsaturated fatty alcohol which reduces the dissolution of the gelatinizing agent to allow processing at or below 100° C, an alkyl dimethicone, and an oil and/or polymer component.

[010] U.S. Publication No. 2011/0182834 to Do *et al.* discloses an anhydrous solid, a semi-solid, or a viscous gel cosmetic composition that is clear or translucent. Do discloses that the cosmetic composition incorporates a mixture of at least two amino acid-based gelatinizing agents, a polyamide resin, a non-ionic unsaturated fatty alcohol which reduces the dissolution of the gelatinizing agent to allow

processing at or below 115° C, an alkyl dimethicone, and an oil and/or polymer component.

[011] U.S. Publication No. 20120164093 discloses the use of glutamide compounds and ethanol to stabilize and thicken water-in-oil emulsions.

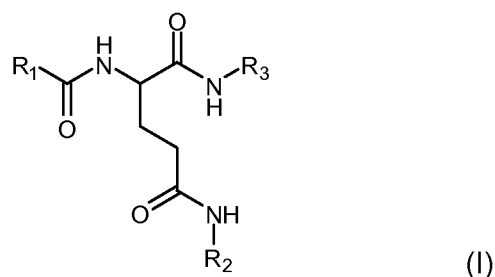
[012] However, the above-noted literature does not disclose a liquid or viscous liquid mascara emulsion with enhanced depth of color and flexibility.

SUMMARY OF THE INVENTION

[013] In one embodiment, the current invention relates to a mascara emulsion comprising a non-aqueous phase, an aqueous phase, at least one glutamide based gellant, and at least one pigment. In a further embodiment, the mascara emulsion composition may include a low opacity wax component having a ΔL value less than 8. The mascara emulsions exhibit enhanced depth of color and flexibility post-application to eyelashes without impairing the volumizing and lengthening effects of the mascara.

[014] In another embodiment, the current invention relates to an anhydrous mascara composition comprising an anhydrous vehicle, at least one glutamide based gellant, at least one pigment, and a low opacity wax component having a ΔL of less than 8. The composition exhibits enhanced depth of color and flexibility while still maintaining the volumizing and lengthening attributes desired of a mascara.

[015] In some embodiments of the invention, the glutamide based gellant has the structure according to formula (I):



[016] wherein, R1, R2 and R3 are each independently selected from branched, straight chain, or cyclic alkyl groups having from three to 20 carbon atoms. In further

embodiment, R₁ is selected from branched, straight chain alkyl groups having from five to 16 carbon atoms, and R₂ and R₃ are independently straight chain alkyl groups having from three to six carbon atoms. In yet another embodiment, R₁ is selected from branched, straight chain alkyl groups having from five to 16 carbon atoms, and R₂ and R₃ are each n-butyl groups.

[017] In another embodiment, R₁ is selected from branched, straight chain alkyl groups having from five to 16 carbon atoms, and R₂ and R₃ are independently straight chain alkyl groups having from three to six carbon atoms. In a further embodiment, R₁ is selected from branched, straight chain alkyl groups having from five to 16 carbon atoms, and R₂ and R₃ are each n-butyl groups.

[018] The glutamide based gellant may be Dibutyl Lauroyl Glutamide, Dibutyl Ethylhexanoyl glutamide, or Dibutyl Lauroyl Glutamide and Dibutyl Ethylhexanoyl glutamide. In all the previous embodiments, the glutamide based gellant may be present in an amount of from about 0.5% to about 10.0% by weight, or, in further embodiments, may be present in an amount of from about 0.5% to about 5.0% by weight, 3 to 8%, from 4 to 6% by weight, or from 2.0% to 5.0% by weight.

[019] A mascara in accordance with the previous embodiments, may not contain a white pigment in one embodiment, and, in a further embodiment, may not contain titanium dioxide. The mascara compositions, in further embodiments, may have iron oxide (black) and carbon black as a pigment. In yet another embodiment of the previously noted mascaras, the composition provides a black color when applied to an eyelash. In a further embodiments the composition may have L* value of 20 or less. In other embodiments the L* value is less than 15, or less than 12.5, or less than 10, or less than 7.5, as measured in accordance with the protocol of Example 1.

[020] The mascara compositions, in additional embodiments, may include a polyamide resin, and in further embodiments the polyamide resin may be Ethylenediamine hydrogenated dimer Dilinoleate Copolymer Bis-Di-C14-18 Alkyl Amide .

[021] In yet a further embodiment, the mascara compositions may incorporate a low opacity filler component. In another embodiment the invention relates to such mascara compositions further containing a low opacity filler component having a ΔL

of less than 8. In yet another embodiment the invention relates to such mascara compositions wherein the low opacity wax component in aggregate combination with the low opacity filler component has a ΔL of less than 8. The low opacity filler component may be barium sulfate, solid glass microspheres, talc Italian, and/or combinations thereof in certain embodiments.

[022] In one embodiment, the mascara compositions of the current invention may have L^* value of less than 20. In a further embodiment, the mascara compositions may have a hardness value of less than about 15 g. In yet a further embodiment, the mascara compositions may have a viscosity of about 250,000 cps to 2,000,000 cps.

[023] In a further embodiment, the low opacity wax composition may include carnauba wax, beeswax, Ozokerite, Kahlwax 7307, and a silicone wax, such as Silwax 5022. In a further embodiment, the low opacity wax composition of the mascara compositions may comprise less than 25% by weight of the mascara compositions.

[024] When the mascara composition is a mascara emulsion, the non-aqueous phase may be a silicone oil. In an additional embodiment, the non-aqueous phase of the mascara composition, when in the form of an emulsion, comprises about 20% to 60% by weight of the mascara composition. In yet a further embodiment, the aqueous phase may be about 20% to 50% by weight of the composition.

[025] Any mascara compositions of the invention may be substantially free of an alkyl dimethicone.

[026] In another embodiment, the current invention relates to a method for coloring eyelashes comprising applying to the eyelashes any of the above-noted embodiments of a mascara composition. In a further embodiment of the method, the mascara compositions may impart color, such as black color, to the lashes. In an additional embodiment, the mascara compositions impart high chroma to the lashes.

[027] These and other aspects of the present invention will become apparent to those skilled in the art according to the present description, including the claims.

DETAILED DESCRIPTION

[028] The present invention provides mascara emulsion compositions and anhydrous mascara compositions exhibiting a greater depth of color and enhanced flexibility when deposited on eyelashes.

[029] In some embodiments, the mascara composition of the current invention includes (a) one or more glutamide based gellants, (b) one or more pigments, (c) a non-aqueous phase, (d) an aqueous phase, (e) optionally a low opacity wax component, and (f) optionally a low opacity filler component. The current invention provides for a more transparent cosmetic base for the mascara composition, the base comprising, in the form of an emulsion, the gellants (a), the non-aqueous phase (c), and the aqueous phase (d) (collectively the “cosmetic base” or “base”), and not including constituents such as the wax component (e) and the filler component (f). The cosmetic base is achievable as a consequence of providing a substantially transparent, as hereinafter defined, gel base, defined as the gellant (a) incorporated into the non-aqueous phase (c). This gel base provides structure, yet retains clarity and moreover, allows superior clarity to the mascara emulsion. Accordingly, a heightened depth of the color is obtained from the pigments, as this cosmetic base enhances the color, such as by enhancing the darkening provided by the mascara upon application.

[030] In other embodiments, the mascara compositions are anhydrous mascara compositions that comprise (a) one or more gellants derived from the amino acid glutamic acid, (b) one or more low opacity waxes (the “low opacity wax component”), (c) one or more pigments, (d) an anhydrous vehicle, and optionally one or more low opacity fillers (the “low opacity filler component”). The mascaras of the current invention provide a substantially transparent, as hereinafter defined, cosmetic base defined as the stated gellants incorporated into the anhydrous vehicle. This cosmetic base provides structure, yet retains clarity. As used herein anhydrous means that the compositions and vehicle of the invention are substantially water free. “Substantially water free” means that the composition contains 2% or less, especially 1% or less, in particular 0.5% or less water. Such amounts of water may be present solely in the anhydrous vehicle. In other embodiments the compositions are free of water by which is meant that no water is intentionally added to the composition other

than trace amounts of water that may be associated with the various components as impurities or absorbed into the composition from the environment.

[031] The waxes of the low opacity wax component, when present, further structure the mascara and provide volumizing and lengthening of the eyelash, and are selected, as set forth herein, so that the clarity of the cosmetic base and the gel base are minimally affected. Accordingly, a heightened depth of the color is obtained from the pigments, as this cosmetic base enhances the darkening provided by the mascara upon application. Further, if incorporated, the low opacity wax component in the cosmetic base would provide volumizing and lengthening effects, while retaining suitable flexibility as a consequence of the reduced wax levels. In further embodiments, the mascara composition of the current invention may also include polyamide resins, such as ethylenediamine/hydrogenated dimer dilinoleate alkyl amide, as further structuring agents, and/or low opacity fillers, and/or low refractive index fillers, as hereinafter described.

[032] It has been found that the above-noted mascaras provide a deeper, darker color, increased depth of color, and enhanced flexibility when applied to eyelashes without impairing the ability of the mascara to add volume and/or length to the eyelashes.

[033] As used herein, the term "consisting essentially of" is intended to limit the invention to the specified materials or steps and those materials or steps that do not materially affect the basic and novel characteristics of the claimed invention, for example, loss of transparency and translucency, as understood from a reading of this specification.

[034] The terms "a" and "an", as used herein and in the appended claims, mean "one or more" unless otherwise indicated herein.

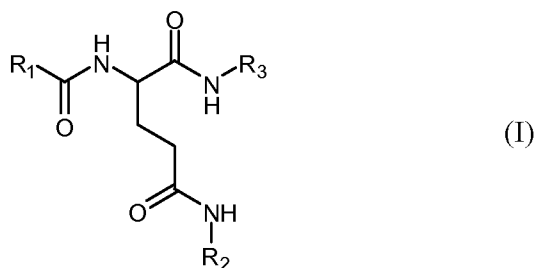
[035] It should be noted that unless indicated to the contrary, as used herein, percent (%) is % by weight, based on the total weight of the composition.

[036] As noted above, in some embodiments, the mascara compositions of the current invention include (a) one or more glutamide based gellants; (b) one or more pigments; (c) a non-aqueous phase; and (d) an aqueous phase disclosed in further

detail below. In other embodiments, the mascara compositions of the current invention include (a) one or more gellants based on the amino acid glutamic acid; (b) one or more low opacity waxes; (c) a pigment; and (d) an anhydrous composition disclosed in further detail below.

[037] A. Gellants

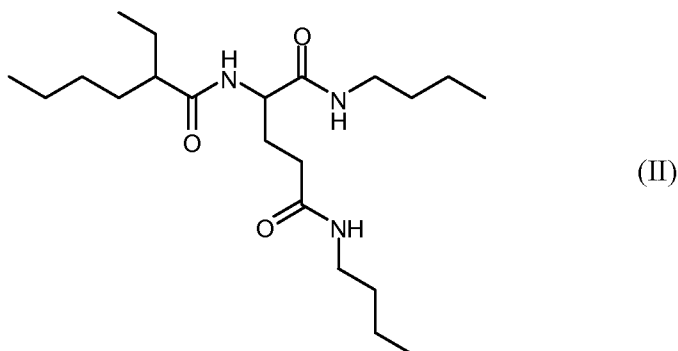
[038] The glutamide based gellants used within the cosmetic composition of the current invention will have the structure according to formula (I):



[039] wherein, R_1 , R_2 and R_3 are C_1 - C_{20} hydrocarbon moieties which may be straight chained, branched, or cyclic and which may comprise one or more heteroatoms selected from oxygen, nitrogen, and sulfur. R_1 , R_2 and R_3 are independently selected at each occurrence and therefore may be the same or different. Preferably, at least one of R_1 , R_2 and R_3 is a C_5 - C_{20} hydrocarbon moiety and more preferred still, R_1 is a C_6 - C_{20} hydrocarbon moiety.

[040] Typically, each of R_1 , R_2 and R_3 are independently selected from branched, straight chain, or cyclic alkyl groups having from three to 20 carbon atoms. R_1 , R_2 and R_3 may, for example, each be independently selected from methyl, ethyl, propyl (e.g., n-propyl or isopropyl), butyl (e.g., n-butyl, isobutyl, tert-butyl), pentyl (e.g., n-pentyl, isopentyl, neopentyl, cyclopentyl), hexyl, heptyl, octyl, nonyl, decyl, undecyl, dodecyl, tridecyl, tetradecyl, pentadecyl, etc. In one embodiment, R_1 is selected from branched or straight chain alkyl groups having from five to 16 carbon atoms and R_2 and R_3 are independently straight chain alkyl groups having from three to six carbon atoms, namely propyl, butyl, pentyl, or hexyl. Preferably, R_1 is selected from branched or straight chain alkyl groups having from five to 16 carbon atoms, and R_2 and R_3 are each n-butyl groups.

[041] In one embodiment, R_1 is a straight chain undecyl group and the compound of formula (I) is Dibutyl Lauroyl Glutamide. In another implementation, R_1 is a branched heptyl group, more specifically a 1-ethylpentyl group, and the compound of formula (I) is Dibutyl Ethylhexanoyl Glutamide, having the structure of formula (II):



As specific product names, GP-1 as dibutyl lauroyl glutamide and EB-21 as dibutyl ethylhexanoyl glutamide (both manufactured by AJINOMOTO CO., INC.) *etc.*, are mentioned.

[042] A glutamide compound “consisting essentially of” dibutyl ethylhexanoyl glutamide is intended to mean that the presence of additional glutamide compounds in amounts which would measurably affect the stability and/or viscosity of the fluid are excluded.

[043] The gellants used in the mascara composition may include either dibutyl lauryl glutamide or dibutyl ethylhexanoyl glutamide, in certain embodiments the composition may include dibutyl lauroyl glutamide, and in further embodiments the composition includes both dibutyl lauryl glutamide and dibutyl ethylhexanoyl glutamide. The gellants will typically be present in an amount sufficient to stabilize the emulsion composition or to structure the composition. The gellants will typically be present in an amount of greater than 0.5% to about 8.0% by weight, of the composition, or from about 1.0 to about 10.0% by weight, or in an amount of from about 0.75% to about 7.0% by weight, or in an amount from about 1.0% to about 6.0% by weight, or in an amount of from about 2.0% to about 5.0%, or in an amount of from about 2.0% to about 9.0% by weight, or from about 3.0% to about 7.0% by weight, or from about 4.0% to about 5.0% by weight. In specific embodiments, the compositions contain 0.7%, 0.8%, 0.9%, 1.0%, 1.25%, 1.5%, 2.0%, 2.5%, 3.0%,

3.5%, 4.0%, 4.5%, 5.0%, 5.5%, 6.0%, 6.5%, and 7% of a glutamide gellant, a major portion of which is dibutyl lauroyl glutamide. "A major portion of which" in this context means that, in various embodiments, greater than 50% by weight of the glutamide gellant comprises dibutyl lauroyl glutamide, with the remainder being, preferably, dibutyl ethylhexanoyl glutamide.

[044] B. Pigments

[045] For purposes of the current invention, "pigments" shall be defined as organic pigments, inorganic pigments, lakes, pearlescent pigments, and or combinations thereof. Typically the compositions will include pigments to impart a desired color or effect. Mascaras of the current invention may include black including various shades as well as additional known colors for mascaras. In certain, embodiments, the color white may be excluded from the colors of mascara available.

[046] Examples of pigments are inorganic pigments, organic pigments, and/or lakes. Exemplary inorganic pigments include, but are not limited to, metal oxides and metal hydroxides such as magnesium oxide, magnesium hydroxide, calcium oxide, calcium hydroxides, aluminum oxide, aluminum hydroxide, iron oxides (α - Fe_2O_3 , γ - Fe_2O_3 , Fe_3O_4 , FeO), red iron oxide, yellow iron oxide, black iron oxide, iron hydroxides, titanium dioxide, titanium lower oxides, zirconium oxides, chromium oxides, chromium hydroxides, manganese oxides, cobalt oxides, cerium oxides, nickel oxides and zinc oxides as well as composite oxides and composite hydroxides such as iron titanate, cobalt titanate and cobalt aluminate. Non-metal oxides also contemplated to be suitable are alumina and silica, ultramarine blue (i.e., sodium aluminum silicate containing sulfur), Prussian blue, manganese violet, bismuth oxychloride, talc, mica, sericite, magnesium carbonate, calcium carbonate, magnesium silicate, aluminum magnesium silicate, silica, titanated mica, iron oxide titanated mica, bismuth oxychloride, and the like. Organic pigments can include, but are not limited to, at least one of carbon black, carmine, phthalocyanine blue and green pigment, diarylide yellow and orange pigments, and azo-type red and yellow pigments such as toluidine red, litho red, naphthol red and brown pigments, and combinations thereof.

[047] Lakes generally refer to a colorant prepared from a water-soluble organic dye, (e.g., D&C or FD&C) which has been precipitated onto an insoluble reactive or absorptive substratum or diluent. The term "D&C" as used herein means drug and cosmetic colorants that are approved for use in drugs and cosmetics by the FDA. The term "FD&C" as used herein means food, drug, and cosmetic colorants which are approved for use in foods, drugs, and cosmetics by the FDA. Certified D&C and FD&C colorants suitable for precipitation onto the insoluble reactive or absorptive stratum of lakes are listed in 21 C.F.R. § 74.101 *et seq.* and include the FD&C colors Blue 1, Blue 2, Green 3, Orange B, Citrus Red 2, Red 3, Red 4, Red 40, Yellow 5, Yellow 6, Blue 1, Blue 2, Orange B, Citrus Red 2, and the D&C colors Blue 4, Blue 9, Green 5, Green 6, Green 8, Orange 4, Orange 5, Orange 10, Orange 11, Red 6, Red 7, Red 17, Red 21, Red 22, Red 27, Red 28, Red 30, Red 31, Red 33, Red 34, Red 36, Red 39, Violet 2, Yellow 7, Yellow 8, Yellow 10, Yellow 11, Blue 4, Blue 6, Green 5, Green 6, Green 8, Orange 4, Orange 5, Orange 10, Orange 11, and so on. Suitable lakes include, without limitation, those of red dyes from the monoazo, disazo, fluoran, xanthene, or indigoid families, such as Red 4, 6, 7, 17, 21, 22, 27, 28, 30, 31, 33, 34, 36, and Red 40; lakes of yellow pyrazole, monoazo, fluoran, xanthene, quinoline, dyes or salt thereof, such as Yellow 5, 6, 7, 8, 10, and 11; lakes of violet dyes including those from the anthroquinone family, such as Violet 2, as well as lakes of orange dyes, including Orange 4, 5, 10, 11, and the like. Suitable lakes of D&C and FD&C dyes are defined in 21 C.F.R. § 82.51.

[048] The pigments may be optionally surface treated to, for example, make the particles more hydrophobic or more dispersible in a vehicle. The surface of the particles may, for example, be covalently or ionically bound to an organic molecule or silicon-based molecule or may be absorbed thereto, or the particle may be physically coated with a layer of material. The surface treatment compound may be attached to the particle through any suitable coupling agent, linker group, or functional group (e.g., silane, ester, ether, etc). The compound may comprise a hydrophobic portion which may be selected from, for example, alkyl, aryl, allyl, vinyl, alkyl-aryl, aryl-alkyl, organosilicone, di-organosilicone, dimethicones, methicones, polyurethanes, silicone-polyurethanes, and fluoro- or perfluoro-derivatives thereof. Other hydrophobic modifiers include, but are not limited, lauroyl lysine, Isopropyl Titanium Triisostearate (ITT), ITT and Dimethicone (ITT/Dimethicone) cross-

polymers, ITT and Amino Acid, ITT/Triethoxycaprylylsilane Crosspolymer, waxes (e.g., carnauba), fatty acids (e.g., stearates), HDI/Trimethylol Hexylactone Crosspolymer, PEG-8 Methyl Ether Triethoxysilane, aloe, jojoba ester, lecithin, perfluoroalcohol phosphate, and Magnesium Myristate (MM). In other embodiments, the pigments or particulates may be surface treated with galactoarabinan or glyceryl rosinat. In another embodiment, the pigments or particulates may be surface treated with Disodium Stearoyl Glutamate (and) Aluminum Dimyristate (and) Triethoxycaprylylsilane.

[049] In addition to the foregoing, the compositions according to the invention may comprise additional pigments, and/or pearlescents. Inorganic pigments include without limitation titanium dioxide, zinc oxide, iron oxides, chromium oxide, ferric blue, mica, bismuth oxychloride, and titinated mica; organic pigments include barium, strontium, calcium or aluminium lakes, ultramarines, and carbon black. In certain, embodiments mascaras of the current invention exclude titanium dioxide.

[050] The pigments may be surface modified with, for example, fluoropolymers, to adjust one or more characteristics of the colorant as described in, for example, U.S. Patent Nos. 6,471,950, 5,482,547, and 4,832,944, the contents of which are hereby incorporated by reference. Suitable pearling pigments include without limitation bismuth oxychloride, guanine and titanium composite materials containing, as a titanium component, titanium dioxide, titanium lower oxides or titanium oxynitride, as disclosed in U.S. Patent No. 5,340,569, the contents of which are hereby incorporated by reference. Other suitable pearlescent materials typically are pigments or layers of titanium dioxide on a substrate such as mica, polyethylene terephthalate, bismuth oxychloride, aluminum oxide, calcium borosilicate, synthetic flourophlogopite (synthetic mica), silica, acrylates copolymer, methyl methacrylate, and the like. Interference or pearl pigments may also be included. These are typically comprised of micas layered with about 50 to 300 nm films of TiO_2 , Fe_2O_3 , or Cr_2O_3 or the like. These include white nacreous materials, such as mica covered with titanium oxide or covered with bismuth oxychloride; and colored nacreous materials, such as titanium mica with iron oxides, titanium mica with ferric blue or chromium oxide, titanium mica with an organic pigment of the aforementioned type.

[051] The pearlescent pigments can be chosen from white pearlescent pigments, such as mica covered with titanium or with bismuth oxychloride, colored pearlescent pigments, such as titanium oxide-coated mica with iron oxides, titanium oxide-coated mica with in particular ferric blue or chromium oxide, or titanium oxide-coated mica with an organic pigment of the abovementioned type, and pearlescent pigments based on bismuth oxychloride. Commercially available pearlescent pigments suitable for the current invention include, but are not limited to, MicaMira (Sandream Enterprises), SynMira (Sandream Enterprises), GlassMira (Sandream Enterprises), Xirona (EMD Performance Chemicals), Timiron (EMD Performance Chemicals), Colorna (EMD Performance Chemicals), Ronastar (EMD Performance Chemicals), RonaFlair (EMD Performance Chemicals), Reflecks (BASF), Duochrome (BASF), and Chione (BASF).

[052] Preferred pigments include Iron Oxides, Black Oxide of Iron, Brown Iron Oxide, Iron Oxide Red 10-34-PC-2045, Pigment Black 11, Pigment Brown 6, Pigment Brown 7, Pigment Red 101, Pigment Red 102, Pigment Yellow 42, Pigment Yellow 43, Red Iron Oxide, Synthetic Iron Oxide, Yellow Iron Oxide, or carbon black. In those embodiments where carbon black is used as a pigment all or a portion thereof may be dispersed in a suitable synthetic wax. The mascara compositions herein are particularly useful in providing an enhanced depth of a dark color to the eyelashes, especially a more pronounced black color to the eyelashes, especially a color having a tristimulus L^* value less than about 20, 15 or less, 12.5 or less, 10 or less, or 7.5 or less, as measured using a Konica Minolta CM-2600d Spectrophotometer.

[053] The aggregate amount of all such additional pigments is not particularly restricted. Typically, additional pigments and/or colorants may comprise from about 0.1% to about 15% of the total composition, from about 1% to about 12% by weight of the composition, or from about 3% to about 10% by weight of the composition. In certain embodiments, the composition will contain 1%, 2.5%, 5%, 7.5%, 10%, 12.5%, or 15% pigments. In embodiments incorporating carbon black as a pigment, the amount of carbon black incorporated may be about 0.005% to about 0.025%, about 0.1% to about 5%, about 0.5% to about 4%, and about 1% to about 3%. When the mascara composition is a mascara emulsion, the pigments are added to

the phase in which they are most compatible. For example pigments that have a hydrophobic treatment would be incorporated into the lipophilic phase, while pigments having a hydrophilic treatment would be in the aqueous phase. Pigments with silicone coatings would be incorporated into the silicone phase of a silicone-water emulsion.

[054] C. Emulsion

[055] The mascara composition may also comprise an emulsion. Non-limiting examples of suitable emulsions include water-in-oil emulsions, oil-in-water emulsions, silicone-in-water emulsions, water-in-silicone emulsions, wax-in-water emulsions, water-oil-water triple emulsions or the like having the appearance of a cream, gel or microemulsions. The emulsion may include an emulsifier, such as a nonionic, anionic or amphoteric surfactant.

[056] The aqueous phase of the emulsion in one embodiment has one or more organic compounds, including humectants (such as butylene glycol, propylene glycol, Methyl gluceth-20, and glycerin); other water-dispersible or water-soluble components including thickeners such as veegum or hydroxyalkyl cellulose; gelling agents, such as high MW polyacrylic acid, i.e. Carbopol 934; and mixtures thereof. In one embodiment, the aqueous phase may include a film forming polymer, for example an acrylate copolymer. In one embodiment, an acrylates copolymer is characterized as having a viscosity of about 25 cps in a 30% aqueous solution. The emulsion may have one or more emulsifiers capable of emulsifying the various components present in the composition.

[057] The compounds suitable for use in the oil phase include without limitation, vegetable oils; esters including emollient esters, such as octyl palmitate, isopropyl myristate and isopropyl palmitate; ethers such as dicapryl ether; fatty alcohols such as cetyl alcohol, stearyl alcohol and behenyl alcohol; isoparaffins such as isooctane, isododecane and isohexadecane; silicone oils such as dimethicones, cyclic silicones, and polysiloxanes; hydrocarbon oils such as mineral oil, petrolatum, isoeicosane and polyisobutene; and the like. Suitable hydrophobic hydrocarbon oils may be saturated or unsaturated, have an aliphatic character and be straight or branched chained or

contain alicyclic or aromatic rings. The oil-containing phase may be composed of a singular oil or mixtures of different oils.

[058] In one embodiment, the oil phase will include an amount of octyldodecanol sufficient to solubilize the amino acid gellants. In one embodiment, the oil phase will include a film forming polymer (e.g., VP hexadecene copolymer). The film former may act to reduce smudging.

[059] Hydrocarbon oils including those having 6-20 carbon atoms may be utilized, and in one embodiment they may have 10-16 carbon atoms. Representative hydrocarbons include decane, dodecane, tetradecane, tridecane, and C₈₋₂₀ isoparaffins. Paraffinic hydrocarbons are available from Exxon under the ISOPARS trademark, and from the Permethyl Corporation. In addition, C₈₋₂₀ paraffinic hydrocarbons such as C₁₂ isoparaffin (isododecane) manufactured by the Permethyl Corporation having the tradename Permethyl 99A™ are also contemplated to be suitable. Various commercially available C₁₆ isoparaffins, such as isohexadecane (having the tradename Permethyl®) are also suitable. Examples of volatile hydrocarbons include polydecenes such as isododecane and isodecane, including for example, Permethyl-99A (Presperse Inc.) and the C₇-C₈ through C₁₂-C₁₅ isoparaffins such as the Isopar Series available from Exxon Chemicals. A representative hydrocarbon solvent is isododecane.

[060] Non-limiting emulsifiers include emulsifying waxes, emulsifying polyhydric alcohols, polyether polyols, polyethers, mono- or di-ester of polyols, ethylene glycol mono-stearates, glycerin mono-stearates, glycerin di-stearates, silicone-containing emulsifiers, soya sterols, fatty alcohols such as cetyl alcohol, acrylates, fatty acids such as stearic acid, fatty acid salts, and mixtures thereof. Emulsifiers may include soya sterol, cetyl alcohol, stearic acid, emulsifying wax, acrylates, silicone containing emulsifiers and mixtures thereof. Other specific emulsifiers that can be used in the composition of the present invention include, but are not limited to, one or more of the following: C₁₀₋₃₀ alkyl acrylate crosspolymer; Dimethicone PEG-7 isostearate, acrylamide copolymer; mineral oil; sorbitan esters; polyglyceryl-3-diisostearate; sorbitan monostearate, sorbitan tristearate, sorbitan sesquioleate, sorbitan monooleate; glycerol esters such as glycerol monostearate and glycerol monooleate; polyoxyethylene phenols such as polyoxyethylene octyl phenol and polyoxyethylene

nonyl phenol; polyoxyethylene ethers such as polyoxyethylene cetyl ether and polyoxyethylene stearyl ether; polyoxyethylene glycol esters; polyoxyethylene sorbitan esters; dimethicone copolyols; polyglyceryl esters such as polyglyceryl-3-diisostearate; glyceryl laurate; Steareth-2, Steareth-10, and Steareth-20, to name a few. Additional emulsifiers are provided in the INCI Ingredient Dictionary and Handbook 11th Edition 2006, the disclosure of which is hereby incorporated by reference in its entirety.

[061] These emulsifiers typically will be present in the composition in an amount from about 0.001% to about 10% by weight, in particular in an amount from about 0.01% to about 5% by weight, and in one embodiment, from about 0.1% to about 3% by weight.

[062] The oil phase may comprise one or more volatile and/or non-volatile silicone oils. Volatile silicones include cyclic and linear volatile dimethylsiloxane silicones. In one embodiment, the volatile silicones may include cyclodimethicones, including tetramer (D₄), pentamer (D₅), and hexamer (D₆) cyclomethicones, or mixtures thereof. Particular mention may be made of the volatile cyclomethicone-hexamethyl cyclotrisiloxane, octamethyl-cyclotetrasiloxane, and decamethyl-cyclopentasiloxane. Suitable dimethicones are available from Dow Corning under the name Dow Corning 200® Fluid and have viscosities ranging from 0.65 to 600,000 centistokes or higher. Suitable non-polar, volatile liquid silicone oils are disclosed in U.S. Pat. No. 4,781,917, herein incorporated by reference in its entirety. Additional volatile silicones materials are described in Todd et al., "Volatile Silicone Fluids for Cosmetics", Cosmetics and Toiletries, 91:27-32 (1976), herein incorporated by reference in its entirety. Linear volatile silicones generally have a viscosity of less than about 5 centistokes at 25° C., whereas the cyclic silicones have viscosities of less than about 10 centistokes at 25° C. Examples of volatile silicones of varying viscosities include Dow Corning 200, Dow Corning 244, Dow Corning 245, Dow Corning 344, and Dow Corning 345, (Dow Corning Corp.); SF-1204 and SF-1202 Silicone Fluids (G.E. Silicones), GE 7207 and 7158 (General Electric Co.); and SWS-03314 (SWS Silicones Corp.). Linear, volatile silicones include low molecular weight polydimethylsiloxane compounds such as hexamethyldisiloxane,

octamethyltrisiloxane, decamethyltetrasiloxane, and dodecamethylpentasiloxane, to name a few.

[063] Non-volatile silicone oils will typically comprise polyalkylsiloxanes, polyarylsiloxanes, polyalkylarylsiloxanes, or mixtures thereof. Polydimethylsiloxanes are non-volatile silicone oils. The non-volatile silicone oils will typically have a viscosity from about 10 to about 60,000 centistokes at 25° C., in one embodiment between about 10 and about 10,000 centistokes, and in one embodiment still between about 10 and about 500 centistokes; and a boiling point greater than 250° C. at atmospheric pressure. Non limiting examples include dimethyl polysiloxane (dimethicone), phenyl trimethicone, and diphenyldimethicone. The volatile and non-volatile silicone oils may optionally be substituted with various functional groups such as alkyl, aryl, amine groups, vinyl, hydroxyl, haloalkyl groups, alkylaryl groups, and acrylate groups, to name a few.

[064] The water-in-silicone emulsion may be emulsified with a nonionic surfactant (emulsifier) such as, for example, polydiorganosiloxane-polyoxyalkylene block copolymers, including those described in U.S. Pat. No. 4,122,029, the disclosure of which is hereby incorporated by reference in its entirety. These emulsifiers generally comprise a polydiorganosiloxane backbone, typically polydimethylsiloxane, having side chains comprising $-(EO)_m-$ and/or $-(PO)_n-$ groups, where EO is ethyleneoxy and PO is 1,2-propyleneoxy, the side chains being typically capped or terminated with hydrogen or lower alkyl groups (e.g., C₁₋₆, typically C₁₋₃). Other suitable water-in-silicone emulsifiers are disclosed in U.S. Pat. No. 6,685,952, the disclosure of which is hereby incorporated by reference herein. Commercially available water-in-silicone emulsifiers include those available from Dow Corning under the trade designations 3225C and 5225C FORMULATION AID; SILICONE SF-1528 available from General Electric; ABIL EM 90 and EM 97, available from Goldschmidt Chemical Corporation (Hopewell, Va.); and the SILWET series of emulsifiers sold by OSI Specialties (Danbury, Conn.).

[065] Examples of water-in-silicone emulsifiers include, but are not limited to, dimethicone PEG 10/15 crosspolymer, dimethicone copolyol, cetyl dimethicone copolyol, PEG-15 lauryl dimethicone crosspolymer, laurylmethicone crosspolymer, cyclomethicone and dimethicone copolyol, dimethicone copolyol (and) caprylic/capric

triglycerides, polyglyceryl-4 isostearate (and) cetyl dimethicone copolyol (and) hexyl laurate, and dimethicone copolyol (and) cyclopentasiloxane. In one embodiment examples of water-in-silicone emulsifiers include, without limitation, PEG/PPG-18/18 dimethicone (trade name 5225C, Dow Corning), PEG/PPG-19/19 dimethicone (trade name BY25-337, Dow Corning), Cetyl PEG/PPG-10/1 dimethicone (trade name Abil EM-90, Goldschmidt Chemical Corporation), PEG-12 dimethicone (trade name SF 1288, General Electric), lauryl PEG/PPG-18/18 methicone (trade name 5200 FORMULATION AID, Dow Corning), PEG-12 dimethicone crosspolymer (trade name 9010 and 9011 silicone elastomer blend, Dow Corning), PEG-10 dimethicone crosspolymer (trade name KSG-20, Shin-Etsu), dimethicone PEG-10/15 crosspolymer (trade name KSG-210, Shin-Etsu), and dimethicone PEG-7 isostearate.

[066] The emulsifiers typically will be present in the composition in an amount effective to disperse the discontinuous phase into the continuous phase, typically from about 0.001% to about 10% by weight, in another embodiment in an amount from about 0.01% to about 5% by weight, and in a further embodiment in an amount below 1% by weight.

[067] The aqueous phase of the emulsion may include one or more volatile solvents, including lower alcohols, such as ethanol, isopropanol, and the like. The volatile solvent may also be a cosmetically acceptable ester such as butyl acetate or ethyl acetate; ketones such as acetone or ethyl methyl ketone; or the like. The volatile solvents are generally present in an amount of 25% or less by weight of the composition. In other embodiments the volatile solvent is present in an amount of less than 15%, less than 10%, or less than 5% by weight of the composition. In another embodiment the compositions do not contain a volatile solvent.

[068] The non-aqueous phase will typically comprise from about 10% to about 90%, about 30% to about 80%, or from about 50% to about 70% by weight, based on the total weight of the emulsion, and the aqueous phase will typically comprise from about 10% to about 90%, about 30% to about 80%, or from about 40% to about 70% by weight of the total emulsion. In one embodiment of the invention the mascara composition is a water-in-silicone emulsion in which the aqueous phase is from about 20% to about 60% by weight of the total composition and the non-aqueous

silicone phase is from about 40% to 80% by weight of the total composition. In one embodiment of the invention the mascara composition is a water-in-oil or oil-in-water emulsion in which the aqueous phase is about 60% by weight of the total composition and the non-aqueous oil phase is about 40% by weight of the total composition.

[069] D. Anhydrous Vehicle

[070] Mascara compositions comprising an anhydrous vehicle include without limitation, vegetable oils; esters including emollient esters, such as octyl palmitate, isopropyl myristate and isopropyl palmitate; ethers such as dicapryl ether; fatty alcohols such as cetyl alcohol, stearyl alcohol octyldodecanol and behenyl alcohol; isoparaffins such as isooctane, isododecane and isohexadecane; silicone oils such as dimethicones, cyclic silicones, and polysiloxanes; hydrocarbon oils such as mineral oil, petrolatum, isoeicosane and polyisobutene; and the like. Suitable hydrophobic hydrocarbon oils may be saturated or unsaturated, have an aliphatic character and be straight or branched chained or contain alicyclic or aromatic rings.

[071] Hydrocarbon oils including those having 6-20 carbon atoms may be utilized, and in one embodiment they may have 10-16 carbon atoms. Representative hydrocarbons include decane, dodecane, tetradecane, tridecane, and C₈₋₂₀ isoparaffins. Paraffinic hydrocarbons are available from Exxon under the ISOPARS trademark, and from the Permethyl Corporation. In addition, C₈₋₂₀ paraffinic hydrocarbons such as C₁₂ isoparaffin (isododecane) manufactured by the Permethyl Corporation having the tradename Permethyl 99A™ are also contemplated to be suitable. Various commercially available C₁₆ isoparaffins, such as isohexadecane (having the tradename Permethyl®) are also suitable. Examples of volatile hydrocarbons include polydecenes such as isododecane and isodecane, including for example, Permethyl-99A (Presperse Inc.) and the C₇-C₈ through C₁₂-C₁₅ isoparaffins such as the Isopar series available from Exxon Chemicals. A representative hydrocarbon solvent is isododecane.

[072] The oil phase may comprise one or more volatile and/or non-volatile silicone oils. Volatile silicones include cyclic and linear volatile dimethylsiloxane silicones. In one embodiment, the volatile silicones may include cyclodimethicones, including

tetramer (D₄), pentamer (D₅), and hexamer (D₆) cyclomethicones, or mixtures thereof. Particular mention may be made of the volatile cyclomethicone-hexamethyl cyclotrisiloxane, octamethyl-cyclotetrasiloxane, and decamethyl-cyclopentasiloxane. Suitable dimethicones are available from Dow Corning under the name Dow Corning 200® Fluid and have viscosities ranging from 0.65 to 600,000 centistokes or higher. Suitable non-polar, volatile liquid silicone oils are disclosed in U.S. Pat. No. 4,781,917, herein incorporated by reference in its entirety. Additional volatile silicones materials are described in Todd et al., "Volatile Silicone Fluids for Cosmetics", Cosmetics and Toiletries, 91:27-32 (1976), herein incorporated by reference in its entirety. Linear volatile silicones generally have a viscosity of less than about 5 centistokes at 25° C., whereas the cyclic silicones have viscosities of less than about 10 centistokes at 25° C. Examples of volatile silicones of varying viscosities include Dow Corning 200, Dow Corning 244, Dow Corning 245, Dow Corning 344, and Dow Corning 345, (Dow Corning Corp.); SF-1204 and SF-1202 Silicone Fluids (G.E. Silicones), GE 7207 and 7158 (General Electric Co.); and SWS-03314 (SWS Silicones Corp.). Linear, volatile silicones include low molecular weight polydimethylsiloxane compounds such as hexamethyldisiloxane, octamethyltrisiloxane, decamethyltetrasiloxane, and dodecamethylpentasiloxane, to name a few.

[073] Non-volatile silicone oils will typically comprise polyalkylsiloxanes, polyarylsiloxanes, polyalkylarylsiloxanes, or mixtures thereof. Polydimethylsiloxanes are non-volatile silicone oils. The non-volatile silicone oils will typically have a viscosity from about 10 to about 60,000 centistokes at 25° C, in one embodiment between about 10 and about 10,000 centistokes, and in one embodiment still between about 10 and about 500 centistokes; and a boiling point greater than 250° C. at atmospheric pressure. Non limiting examples include dimethyl polysiloxane (dimethicone), phenyl trimethicone, and diphenyldimethicone. The volatile and non-volatile silicone oils may optionally be substituted with various functional groups such as alkyl, aryl, amine groups, vinyl, hydroxyl, haloalkyl groups, alkylaryl groups, and acrylate groups, to name a few.

[074] The anhydrous vehicle may comprise a non-ionic unsaturated fatty alcohol which can dissolve the glutamide based gellants. One or more of the non-ionic

unsaturated fatty alcohols useful for dissolution includes but is not limited to a non-ionic mono- or poly-unsaturated fatty alcohol. Non-limiting examples of useful non-ionic unsaturated fatty alcohols of the disclosure include oleyl alcohols, octyldodecanols, 2-butyloctanals, 2-hexyldecanols, and 2-undecylpentadecanols. A particular embodiment is directed to oleyl alcohol. Oleyl alcohol examples include, but are not limited to octadecenol.. The non-ionic unsaturated fatty alcohol of the inventive composition is present in an amount from about 0.1% to about 30% by weight of the total composition. Other embodiments are directed to an amount of about 15% to about 30%, and further, about 16% to about 25.5% by weight of the total composition. The anhydrous vehicle will comprise up to 75% of the composition, typically about 10% to about 60%, usually about 20% to about 50%, and especially about 25% to about 40% by weight of the mascara composition

[075] The mascara compositions herein are particularly useful in providing an enhanced depth of a dark color to the eyelashes, especially, for example, a more pronounced black color to the eyelashes. The overall opacity of the cosmetic base of the mascara composition of the current invention is sufficiently low to permit the desired enhancement in the depth of color, i.e., to provide the deep dark color consumers prefer. In the $L^* a^* b^*$ color space (also known as CIELAB), L^* indicates lightness and a^* and b^* are the color directions. L^* is measured from 0 (black) to 100 (white). When the inventive formulations are dark or especially black, the black pigments in the formulations have increased light absorption and decreased light reflection, that is, a decreased L^* value (i.e., a more intense black). In one embodiment, the mascara composition has a tristimulus L^* value of less than 20. In other embodiments L^* is 15 or less, 12.5 or less, 10 or less, or 7.5 or less, as measured using a Konica Minolta CM-2600d Spectrophotometer. L^* is measured by measuring L^* values on a drawdown film (as hereinafter described) of mascara on a black Leneta card using a Konica Minolta CM-2600d hand-held spectrophotometer.

[076] The mascara compositions of the current invention may have a consistency of a liquid and/or viscous liquid. The hardness of the mascara may be measured by penetrating a probe into the composition. In particular, a texture analyzer (for example TA-XT2i from Rheo) equipped with a 2 mm needle probe may be used. The texture analyzer may be set to: Measurement Mode: Force in Compression;

Test Speed: 1.0 mm/s; Distance: 5 mm; and Trigger Force: 5 g. Under these conditions it was determined that the mascara compositions of the current invention required a penetrating force of less than about 15 g and in other embodiments the penetrating force may be less than about 10 g.

[077] Additionally, the compositions of the current invention should exhibit a viscosity between about 250,000 centipoise and about 2,000,000 centipoise, in another embodiment between about 500,000 centipoise and about 1,750,000 centipoise; and about 750,000 centipoise and about 1,500,000 centipoise. The viscosity of the composition may be determined by using a Brookfield DV-E viscometer rotating at 4 rpms with a T-bar E spindle.

[078] In certain embodiments of the current invention, the mascara composition is substantially free of alkyl dimethicone. "Substantially free," in this context means that there is less than about 1%, in some embodiments less than 0.5%, in further embodiments less than 0.05%, and in yet further embodiments 0% of alkyl dimethicone. In other embodiments, the compositions include alkyl dimethicone (e.g., stearyl dimethicone). In one embodiment, the amount of alkyl dimethicone (e.g., stearyl dimethicone) is between about 1% and about 5% by weight, or between about 1.5% and about 3.5% by weight.

[079] In another embodiment of the current invention, the mascaras of the current invention may further incorporate a low opacity wax component to enhance their volumizing capabilities. Waxes useful in the mascara of the present invention may include natural, mineral, or synthetic waxes exhibiting low opacity, *i.e.*, a ΔL value of less than 8 as determined by the procedure set forth in Example 1 below. Waxes suitable for use in the current composition will exhibit a ΔL value that is less than 8 individually and/or in combination. In other embodiments the ΔL value of the waxes, singly or in combination, is 6 or less, or 4 or less, or 2 or less, or 1 or less. For clarity, in certain embodiments the wax component can be a combination of one or more individually waxes having a ΔL less than 8 with one or more waxes individually having a ΔL 8 or greater that in aggregate so long as the combination of waxes (*i.e.*, the wax component) exhibits a ΔL less than 8. In one embodiment the wax component does not contain an individual wax having a ΔL value of 8 or greater. In other embodiments the wax component does not contain more than 15%, or more

than 10%, or more than 5% of a wax whose ΔL value is 8 or greater by weight of the wax component. Suitable low opacity waxes include, but are not limited to, carnauba wax, beeswax, bleached beeswax, ozokerite, Kahlwax 7307, Silwax CRM2, Silwax 5022, low opacity variants and combinations thereof. In one embodiment, the low opacity wax comprises a silicone wax. In another embodiment, the low opacity wax consists predominantly of a silicone wax. In a further embodiment, the silicone wax comprises the major wax component of the composition.

[080] ΔL is measured by measuring L^* values on a drawdown film of mascara on a black Leneta card using a hand-held spectrophotometer (e.g., a Konica Minolta CM-2600d spectrophotometer). The drawdown film is obtained by applying 3 mL of the sample (i.e., in the case of an emulsion, the non-aqueous phase or the gel base into which wax(es) or filler(s) have been incorporated, as the case may be, otherwise the cosmetic base or the cosmetic base into which wax(es) or filler(s) have been incorporated, as the case may be) to obtain a test film on the Leneta card that is about 75 microns in thickness and allowed to dry for 2 hours. The Leneta card itself is the standard for the color black in the tristimulus color measurement method, and by definition has an L value of zero. Thus, the $\Delta L_{\text{gel base}}$ would be the L value associated with the gel base minus zero. As used herein the term "substantially transparent" as applied to the gel base means a $\Delta L_{\text{gel base}}$ that is 10 or less. Preferably, this value is less than 10, typically less 7.5 or less, and especially between about 1 to 6, or between essentially zero to 6. The low opacity wax component and the low opacity filler component is provided in the cosmetic base (e.g., gel base) such that $L_{\text{wax and/or filler}}$ minus $L_{\text{gel base}}$ is less than 8, i.e., ΔL is less than 8, where $L_{\text{wax and/or filler}}$ is the L value of the cosmetic (e.g., gel) base to which wax(es) and/or filler(s) have been incorporated.

[081] In particular, Applicants have determined wax components that impart the desire volume and lengthening to the mascara without adversely impacting the composition's greater depth of color. These waxes may be individually present in the combination of waxes in the following weight percentages: carnauba waxes may be present in about 1 to 40%, about 5 to 35%, about 10 to 30%, or about 15 to 25%; Kahlwax 7307 wax may be present in about 1 to 40%, about 5 to 35%, about 10 to 30%, or about 15 to 25%; beeswax may be present in about 1 to 30%, about 2.5 to

20%, about 5 to 15, or about 7.5 to 12.5%; Ozokerite wax may be present in about 0.1 to 15%, about 1 to 10%, or about 1.5 to 5%; and Silwax 5022 may be present in about 0.1-15%, about 1-10%, or about 1.5-5%. In a further embodiment, the wax component may be comprised of carnauba wax in about 1-20%, Kahlwax 7307 wax in about 1-10%, beeswax in about 1-10%; Ozokerite in about 1-10%, and Silwax in about 1-10%.

[082] The low opacity wax component may be present in the mascara of the current invention in an amount less than 25%. In other embodiments, the wax component is present in an amount of 1 to 20%, 2.5 to 15%, or 5 to 10% by weight of the mascara composition. In a particular embodiment, the compositions may contain 1%, 5%, 10%, 15%, 16%, 17%, 18%, 19%, 20%, 21%, 22%, 23%, 24%, and 24.5% of the low opacity wax component.

[083] In an additional embodiment of the current invention, a polyamide resin may provide additional structural integrity to the gel base. Polyamide resins are high molecular weight polymers which feature amide linkages along the molecular chain. These polymers contain monomers of amides joined by peptide bonds. They can occur both naturally and artificially. Such polymers are made through step growth polymerization or solid phase synthesis. In some cases, examples of polyamide resins are nylons and aramids. Due to their extreme durability and strength, polyamide resins are typically utilized in textiles, plastics and various automotive applications. In the composition of the present invention the polyamide resin also provides a degree of gloss or shine to the composition and adhesion to the target substrate.

[084] While the polyamide resin Ethylenediamine Hydrogenated Dimer Dilinoleate Copolymer Bis-Di-C14-18 Alkyl Amide is currently preferred, the invention is not limited to this polyamide resin. One skilled in the art will be able to select suitable polyamide resins and many suitable polymers are disclosed in the CTFA Handbook, 12th Ed. 2008, the disclosure of which is hereby incorporated by reference. These include, without limitation, Polyamide-1, Polyamide-2, Polyamide-3, Ethylenediamine/Dimer Tallate Copolymer Bis-Hydrogenated Tallow Amide, Ethylenediamine/Stearyl Dimer Dilinoleate Copolymer, Ethylenediamine/Stearyl Dimer Tallate Copolymer, etc.

[085] A particular embodiment of the present disclosure is directed to a polyamide resin, or a combination of compatible polyamide resins, in an amount ranging from about 0.1% to about 25% by weight of the total composition, about 5% to about 20% by weight, and about 7% to about 15%. A particularly preferred polyamide resin is Ethylenediamine Hydrogenated Dimer Dilinoleate Copolymer Bis-Di -C14-18 Alkyl Amide.

[086] In yet a further embodiment of the mascara compositions of the current invention, various low opacity fillers (the low opacity filler component) determined in accordance with the method denoted in Example 1 below, may be incorporated to enhance the dry time and volume of the composition. Fillers suitable for use in the current composition will exhibit a ΔL value that is less than 8 individually and/or in combination. In other embodiments the ΔL value of the fillers, singly or in combination, is 6 or less, or 4 or less, or 2 or less, or 1 or less. For clarity, in certain embodiments the filler component can be a combination of one or more individual fillers having a ΔL value of less than 8 with one or more waxes individually having a ΔL value of 8 or greater that in aggregate so long as the combination of fillers (i.e., the filler component) exhibits a ΔL value of less than 8. In one embodiment the filler component does not contain an individual filler having a ΔL value of 8 or greater. In other embodiments the filler component does not contain more than 15%, or more than 10%, or more than 5% of a filler whose ΔL value is 8 or greater, by weight of the filler component. Suitable fillers having a ΔL value of less than 8 may include, but are not limited to, barium sulfate (e.g., Blanc Fixe XR-HN from Sachtleben Chemie), sericite (e.g., Sericite PHN from Horie Kako), nylon powder, extra fine (e.g., Orgasol 2002 Exd Nat Cos from Arkema or Anbybes from SH Energy & Chemicals), talc Italian (e.g., Supra H USP from Luzenac America), solid glass microspheres (e.g., Prizmalite™ P2011 SL from Prizmalite Industries, Inc.), and combinations thereof. In particular, in certain embodiments solid glass microspheres may be used as inventors have noted that the use of the spheres provides enhanced depth of color and may provide a cumulative and/or synergistic enhancement in depth of color when used in conjunction with the inventive mascara of the current invention.

[087] The aggregate amount of the filler component is not particularly restricted. Typically, the filler component, if present, will collectively comprise from about 0.1%

to about 10% of the total composition, about 0.5% to about 7% by weight of the composition, or about 1% to about 5% by weight of the composition. In certain embodiments the compositions will contain 0.75%, 1.0%, 2.0%, 3.0%, 4.0%, 5.0%, or 7.5% of the filler component.

[088] The mascara composition may also contain additional materials such as at least one film-forming agent. The film-forming polymer improves the wear of the composition, and can confer transfer-resistance to the make-up product. The film-forming agent may be any which is cosmetically acceptable for use around the eye. Examples include polymers such as polyethylene polymers, PVP, copolymers of PVP, ethylene vinyl acetate, dimethicone gum, C1-C6 alkyl (meth)acrylate polymer, polyacrylates, polymethacrylates, cellulose polymers, and resins such as trimethylsiloxysilicate. The film former is used in an amount of from about 0.1% to about 50%, more preferably from about 1 to about 30%. The compositions may comprise about 0.1% to about 50%, about 0.5% to about 40%, about 1% to about 30%, about 2% to about 30%, about 1% to about 20%, about 2% to about 20%, about 2% to about 15%, about 2% to about 10%, about 2% to about 5%, about 5% to about 20%, about 10% to about 20%, about 15% to about 20%, about 10% to about 40%, about 15% to about 35%, or about 20% to about 30%, relative to the total weight of the composition, of one or more film-forming polymers.

[089] The composition may comprise additional anhydrous compounds including without limitation, vegetable oils; esters such as octyl palmitate, isopropyl myristate, and isopropyl palmitate; ethers such as dicapryl ether; fatty alcohols such as cetyl alcohol, stearyl alcohol and behenyl alcohol; isoparaffins such as isooctane, isododecane, and isohexadecane; silicone oils such as dimethicones, cyclic silicones, and polysiloxanes; hydrocarbon oils such as mineral oil, petrolatum, isoeicosane and polyisobutene; and the like. Suitable hydrophobic hydrocarbon oils may be saturated or unsaturated, have an aliphatic character and be straight or branched chained or contain alicyclic or aromatic rings. The anhydrous vehicle may be composed of a singular oil or mixtures of different oils.

[090] Hydrocarbon oils including those having 6-20 carbon atoms may be utilized, in one embodiment having more preferably 10-16 carbon atoms. Representative hydrocarbons include decane, dodecane, tetradecane, tridecane, and C₈₋₂₀

isoparaffins. Paraffinic hydrocarbons are available from Exxon under the ISOPARS trademark, and from the Permethyl Corporation. In addition, C₈₋₂₀ paraffinic hydrocarbons such as C₁₂ isoparaffin (isododecane) manufactured by the Permethyl Corporation having the tradename Permethyl 99A™ are also contemplated to be suitable. Various commercially available C₁₆ isoparaffins, such as isohexadecane (having the tradename Permethyl®) are also suitable. Examples of preferred volatile hydrocarbons include polydecenes such as isododecane and isodecane, including for example, Permethyl-99A (Presperse Inc.) and the C₇-C₈ through C₁₂-C₁₅ isoparaffins such as the Isopar Series available from Exxon Chemicals. A representative hydrocarbon solvent is isododecane.

[091] The anhydrous vehicle may comprise one or more volatile and/or non-volatile silicone oils. Volatile silicones include cyclic and linear volatile dimethylsiloxane silicones. In one embodiment, the volatile silicones may include cyclodimethicones, including tetramer (D4), pentamer (D5), and hexamer (D6) cyclomethicones, or mixtures thereof. Particular mention may be made of the volatile cyclomethicone-hexamethyl cyclotrisiloxane, octamethyl-cyclotetrasiloxane, and decamethyl-cyclopentasiloxane. Suitable dimethicones are available from Dow Corning under the name Dow Corning 200® Fluid and have viscosities ranging from 0.65 to 600,000 centistokes or higher. Suitable non-polar, volatile liquid silicone oils are disclosed in U.S. Pat. No. 4,781,917, herein incorporated by reference in its entirety. Additional volatile silicone materials are described in Todd et al., "Volatile Silicone Fluids for Cosmetics", Cosmetics and Toiletries, 91:27-32 (1976), herein incorporated by reference in its entirety. Linear volatile silicones generally have a viscosity of less than about 5 centistokes at 25° C., whereas the cyclic silicones have viscosities of less than about 10 centistokes at 25° C. Examples of volatile silicones of varying viscosities include Dow Corning 200, Dow Corning 244, Dow Corning 245, Dow Corning 344, and Dow Corning 345, (Dow Corning Corp.); SF-1204 and SF-1202 Silicone Fluids (G.E. Silicones), GE 7207 and 7158 (General Electric Co.); and SWS-03314 (SWS Silicones Corp.). Linear, volatile silicones include low molecular weight polydimethylsiloxane compounds such as hexamethyldisiloxane, octamethyltrisiloxane, decamethyltetrasiloxane, and dodecamethylpentasiloxane.

[092] Non-volatile silicone oils will typically comprise polyalkylsiloxanes, polyarylsiloxanes, polyalkylarylsiloxanes, or mixtures thereof. Polydimethylsiloxanes are preferred non-volatile silicone oils. The non-volatile silicone oils will typically have a viscosity from about 10 to about 60,000 centistokes at 25° C., preferably between about 10 and about 10,000 centistokes, and more preferred still between about 10 and about 500 centistokes; and a boiling point greater than 250° C. at atmospheric pressure. Non-limiting examples include dimethyl polysiloxane (dimethicone), phenyl trimethicone, and diphenyldimethicone. The volatile and non-volatile silicone oils may optionally be substituted with various functional groups such as alkyl, aryl, amine groups, vinyl, hydroxyl, haloalkyl groups, alkylaryl groups, and acrylate groups, to name a few.

[093] Viscosifying agents such as gellants may also be used. Examples include bentone, triglycerides, aluminum stearate, C18-C36 acid glycol esters, glyceryl tribehenate, glycerol monostearate, alginates, carbomers, celluloses, gums, carageenans, starches or silicates.

[094] Compounds commonly used in the cosmetic arts for preventing or reducing fungal, bacterial, or microorganismal growth are also added to the composition of the disclosure. By including these compounds, the shelf life of the composition is lengthened. These anti-fungal and anti-microorganisms include but are not limited to methyl paraben, butyl paraben, sodium dehydroacetate, *etc.* The amounts of these ingredients that may be used within the inventive composition effectively reduce fungal, bacterial, and/or microorganismal growth without negatively affecting the components of the inventive composition or its desired effects.

[095] The compositions of the invention may optionally comprise other active and inactive ingredients typically associated with the intended cosmetic or personal care products. Suitable other ingredients include, but are not limited to, amino acids, antioxidants, conditioners, chelating agents, colorants, emollients, emulsifiers, excipients, fillers, fragrances, gelling agents, humectants, minerals, moisturizers, photostabilizing agents (*e.g.*, UV absorbers), sunscreens, preservatives, stabilizers, staining agents, surfactants, viscosity and/or rheology modifiers, vitamins, waxes and mixtures thereof. Collectively, all such additional components will typically comprise less than about 5% by weight of the composition.

[096] All ingredients useful herein may be categorized or described by their postulated mode of action. However, it is to be understood that the ingredients can, in some instances, provide more than one cosmetic and/or therapeutic benefit or operate via more than one mode of action. Therefore, classifications herein are made for the sake of convenience and are not intended to limit an ingredient to the particularly stated application or applications listed.

[097] Needless to say, the composition of the invention should be cosmetically or dermatologically acceptable, i.e., it should contain a non-toxic physiologically acceptable medium and should be able to be applied to the eyelashes of human beings. For the purposes of the invention, the expression "cosmetically acceptable" means a composition of pleasant appearance, odor, feel and taste.

[098] A person skilled in the art will take care to select the optional additives and/or the amount thereof such that the advantageous properties of the composition according to the invention are not, or are not substantially, adversely affected by the envisaged addition. It is further understood that the other cosmetic ingredients and adjuvants introduced into the composition must be of a kind and quantity that are not detrimental to the advantageous effect which is sought herein according to the invention.

[099] The following examples describe specific aspects of the mascara of the present invention to illustrate the invention and provide a description for those skilled in the art. The Examples should not be construed as limiting the invention as the examples merely provide specific methodology useful in the understanding and practice of the invention and its various aspects.

EXAMPLES

[0100] EXAMPLE 1: Opacity Test Method

[0101] The opacity of fillers and waxes, and therefore their impact on the depth of color in a mascara composition of the current invention was determined as follows. A cosmetic base in accordance with the invention as set forth in Table 1 below was prepared for use as a negative control and used to determine the suitability of various waxes and fillers.

Table 1

<u>Cosmetic Base</u>	
Dibutyl Ethylhexanoyl Glutamide	1.19%
Dibutyl Lauroyl Glutamide	1.785%
Ethylenediamine/Hydrogenated Dimer Dilinoleate Alkyl Amide	19.05%
Octyldodecanol	77.975%

[0102] Various gels incorporating waxes and fillers to be evaluated were prepared by replacing 10% of the octyldodecanol in the gelbase. Once prepared, each sample was drawn down (3 mL) on black Leneta cards and allowed to dry for 2 hours. Once dried, five L*, a*, b* readings were calculated per sample using a Konica Minolta CM-2600d spectrophotometer and the data averages were calculated. Any wax or filler having a ΔL , in the aggregate, greater than 8 was considered opaque and would interfere with the depth of color within the mascara of the current invention.

Table 2: Waxes and Fillers

Waxes	ΔL
Paraffin Wax	13.06
Paraffin Wax High Penetration	12.75
Carnauba Wax	-0.578
Beeswax	0.608
Beeswax Bleached	1.026
Ozokerite	-0.346
Kahlwax 7307	0.37
Silwax CR M2	-0.742
Silwax 5022	-0.712
Fillers	ΔL
Barium Sulfate	1.16
Prizmalite™ microspheres	2.05
POMP 605	8.39
Sericite	7.99

Talc Italian	1.30
Nylon Powder	16.19

[0103] Example 2: Exemplary Mascara Formulation

[0104] A. A mascara emulsion composition according to the current invention is provided in Table 3.

Table 3

INCI name/description	Wt. %
OIL PHASE	
Cyclomethicone	20-60
PEG-12 Dimethicone	1-10
Silicone Fluid	1-10
Film Former	1-10
Glutamide based gellant	1-10
Butylene Glycol	5-15
Pigment	5-15
Preservative	0.1-1.5
WATER PHASE	
Water	20-50

Film Former	1-5
Chelating agent	0.1-1
Total:	100.00

[0105] The mascara composition is prepared by heating the cyclomethicone, PEG-12 Dimethicone, silicone fluid, and film former to 85° C while milling on Silverson L4RT-Q Laboratory Mixer. Once solution is at 85° C the glutamide based gellant and butylene glycol are pre-heated and added. Then pigments and preservatives are slowly added until fully dispersed. The water is then pre-heated and added to batch and milled. The batch is then cooled.

[0106] B. Mascara emulsion

[0107] A further formulation for a mascara of the current invention is set forth in Table 4 below.

Table 4

INCI name/description	%
OIL PHASE	
Cyclomethicone	32
PEG-12 Dimethicone	2.2
Silicone Fluid	2.2
Acrylates/dimethicone copolymer	1.6

Dibutyl lauroyl glutamide	3.3
Butylene Glycol	11
Black Iron Oxide	8.2
Phenoxyethanol	0.6
WATER PHASE	
Water	36.9
Acrylates Copolymer	1.5
EDTA	0.5
Total:	100.00

[0108] C. Mascara emulsion

[0109] Example 3: Additional Exemplary Mascara Formulation

[0110] A. An anhydrous mascara composition according to the current invention is provided in Table 5 below.

Table 5.

INCI name/description	%
Octyldodecanol	Qs
Amino Acid Gellant(s)	1-6

Ethylenediamine/hydrogenated dimer dilinoleate alkyl amide	1-15
C9-C11 Isoparaffin	1-15
Wax Blend Combo	<25
Fillers	1-10
Pigments	1-15
Film Former	5-25
Total:	100.00

[0111] The mascara composition is prepared by heating the octyldodecanol to 115° C while milling on Silverson L4RT-Q Laboratory Mixer. Once octyldodecanol is at 115° C the amino acid gellant is added and milled until the solution is clear and then Ethylenediamine/Hydrogenated Dimer Dilinoleate is slowly added until fully dispersed. The remaining ingredients are then added and mixed into the resulting composition.

[0112] B. Mascara

[0113] Another exemplary mascara composition is provided below in Table 6.

Table 6

Ingredient	Percentage
Phase A	
Octyldodecanol	22
Phase B	
Dibutyl Ethylhexanol Glutamide	1.2
Dibutyl Lauroyl Glutamide	1.8

Ethylenediamine/Hydrogenated Dimer Dilinoleate	11.4
Phase C	
C9-11 Isoparaffin	11.6
Phase D	
Wax Blend (Carnauba wax 32%, Kahlwax-7307 32%, Beeswax 20%, Ozokerite-170D 8%, Silwax 5022 8%)	20
Phase E	
Prizmalite Microspheres	2.5
Talc Italian	2.5
Phase F	
D&C Black No. 2/Synthetic Wax-Dispersion	2
Iron Oxide Black:	8
Ferric Blue	0.5
Phase G	
Acrylates Copolymer/Isododecane	16.5

[0114] The mascara composition is prepared by heating the octyldodecanol to 115° C while milling on Silverson L4RT-Q Laboratory Mixer. Once octyldodecanol is at 115° C the amino acid gellant is added and milled until the solution is clear and then Ethylenediamine/Hydrogenated Dimer Dilinoleate Alkyl Amide is slowly added until fully dispersed. The remaining ingredients are then added and mixed into the resulting composition.

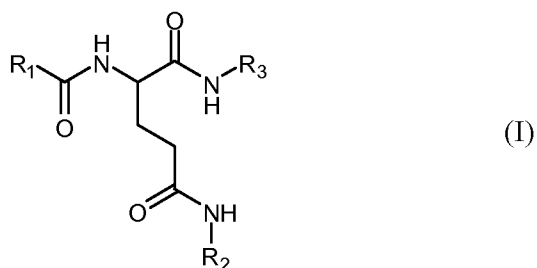
[0115] The invention described and claimed herein is not to be limited in scope by the specific embodiments herein disclosed since these embodiments are intended as illustrations of several aspects of the invention. Any equivalent embodiments are intended to be within the scope of this invention. Indeed, various modifications of the invention in addition to those shown and described therein will become apparent to those skilled in the art from the foregoing description. Such modifications are also

intended to fall within the scope of the appended claims. All publications cited herein are incorporated by reference in their entirety.

CLAIMS

What is claimed is:

1. An emulsion mascara composition comprising a non-aqueous phase, an aqueous phase, at least one glutamide based gellant, and at least one pigment.
2. The emulsion mascara composition of claim 1, further comprising a low opacity wax component having a ΔL value as measured in example 1 of less than 8.
3. The emulsion mascara composition of claim 1 or 2, wherein the glutamide based gellant has the structure according to formula (I):

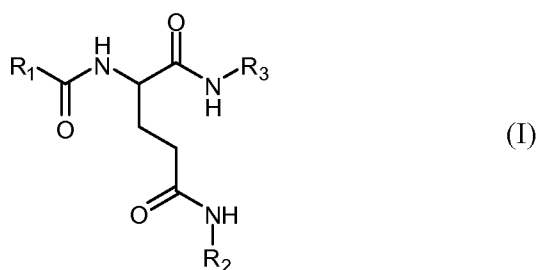


wherein, R_1 , R_2 and R_3 are each independently selected from branched, straight chain, or cyclic alkyl groups having from three to 20 carbon atoms.

4. The emulsion mascara composition according to claim 3, wherein R_1 is selected from branched, straight chain alkyl groups having from five to 16 carbon atoms, and R_2 and R_3 are independently straight chain alkyl groups having from three to six carbon atoms.
5. The emulsion mascara composition according to claim 6, wherein R_1 is selected from branched, straight chain alkyl groups having from five to 16 carbon atoms, and R_2 and R_3 are each n-butyl groups.
6. The emulsion mascara composition according to any of the preceding claims, wherein the glutamide based gellant is Dibutyl Lauroyl Glutamide.
7. The emulsion mascara composition according to any of the preceding claims, wherein said glutamide based gellant is Dibutyl Ethylhexanoyl glutamide.

8. The emulsion mascara composition according to any of the preceding claims, wherein the glutamide based gellant is comprised of Dibutyl Lauroyl Glutamide and Dibutyl Ethylhexanoyl glutamide.
9. The emulsion mascara composition according to any of the preceding claims wherein said glutamide based gellant is present in an amount of from about 1.0 % to about 10.0% by weight.
10. The emulsion mascara composition according to any of the preceding claims, wherein said glutamide based gellant is present in an amount of from about 3.0 % to about 7.0% by weight.
11. The emulsion mascara composition according to any of the preceding claims, wherein said pigment is not a white pigment.
12. The emulsion mascara composition according to any of the preceding claims, wherein said pigment is not titanium dioxide.
13. The emulsion mascara composition according to any of the preceding claims, wherein the pigment comprises iron oxide (black) and carbon black.
14. The emulsion mascara composition according to any of the preceding claims, wherein the composition provides a black color when applied to an eyelash
15. The emulsion mascara composition according to any of the preceding claims, further comprised of a polyamide resin.
16. The emulsion mascara composition according to claim 13, wherein the polyamide resin is Ethylenediamine hydrogenated dimer Dilinoleate Copolymer Bis-Di-C₁₄₋₁₈ Alkyl Amide.
17. The emulsion mascara composition according to any of the preceding claims, further comprised of a low opacity filler component having a ΔL value as measured in example 1 of less than 8.
18. The emulsion mascara composition according to claim 15, wherein the low opacity filler component comprises barium sulfate, solid glass microspheres, talc Italian, and/or combinations thereof.

19. The emulsion mascara composition according to claim 18, wherein the filler component comprises solid glass microspheres
20. The emulsion mascara composition according to any of the preceding claims, wherein the composition has a L* value of less than 20.
21. The emulsion mascara composition according to any of the preceding claims, wherein the composition has a hardness value of less than about 15 g.
22. The emulsion mascara composition according to claim 1, where in the composition has a viscosity of about 250,000 cps to 2,000,000 cps.
23. The emulsion composition of any of the preceding claims, wherein the low opacity wax component comprises less than 25% by weight of the composition.
24. The emulsion composition of any of the preceding claims, wherein the non-aqueous phase is a silicone oil.
25. The emulsion composition of any of the preceding claims, wherein the non-aqueous phase comprises about 20% to 60% by weight of the composition.
26. The emulsion composition of any of the preceding claims, wherein the aqueous phase comprises about 20% to 50% by weight of the composition.
27. The emulsion mascara composition according to any of the preceding claims, wherein the composition is substantially free of an alkyl dimethicone.
28. A method for coloring eyelashes comprising applying to the eyelashes an emulsion mascara composition according to any of claims 1-27.
29. The method for coloring eyelashes according to claim 28, wherein the color imparted to the eyelashes is black.
30. An anhydrous mascara composition comprising an anhydrous vehicle, at least one glutamide based gellant, at least one pigment, and a low opacity wax component having a ΔL of less than 8.
31. The anhydrous mascara composition of claim 30 wherein the glutamide based gellant has the structure according to formula (I):



wherein, R_1 , R_2 and R_3 are each independently selected from branched, straight chain, or cyclic alkyl groups having from three to 20 carbon atoms.

32. The anhydrous mascara composition according to claim 31, wherein R_1 is selected from branched and/or straight chain alkyl groups having from five to 16 carbon atoms, and R_2 and R_3 are independently straight chain alkyl groups having from three to six carbon atoms.

33. The anhydrous mascara composition according to claim 32, wherein R_1 is selected from branched or straight chain alkyl groups having from five to 16 carbon atoms, and R_2 and R_3 are each n-butyl groups.

34. The anhydrous mascara composition according to claim 33 wherein the glutamide based gellant is Dibutyl Lauroyl Glutamide.

35. The anhydrous mascara composition according to claim 34, wherein said glutamide based gellant is Dibutyl Ethylhexanoyl glutamide.

36. The anhydrous mascara composition according to claim 31, 32, or 33, wherein the glutamide based gellant is comprised of Dibutyl Lauroyl Glutamide and Dibutyl Ethylhexanoyl glutamide.

37. The anhydrous mascara composition according to any of claims 30-36, wherein said glutamide based gellant is present in an amount of from about 1.0 % to about 6.0% by weight.

38. The anhydrous mascara composition according to any of claims 30-37, wherein said glutamide based gellant is present in an amount of from about 2.0 % to about 5.0% by weight.

39. The anhydrous mascara composition according to any of claims 30-38, wherein said pigment is not a white pigment.
40. The anhydrous mascara composition according to any of claims 30-39, wherein said pigment is not titanium dioxide.
41. The anhydrous mascara composition according to any of claims 30-40, wherein the pigment comprises iron oxide (black) and carbon black.
42. The anhydrous mascara composition according to any of claims 30-41, wherein the composition provides a black color when applied to an eyelash.
43. The anhydrous mascara composition according to any of claims 30-42, further comprised of a polyamide resin.
44. The anhydrous mascara composition according to claim 43, wherein the polyamide resin is Ethylenediamine Hydrogenated Dimer Dilinoleate Copolymer Bis-Di-C₁₄₋₁₈ Alkyl Amide.
45. The anhydrous mascara composition according to any of claims 30-44, further comprised of a low opacity filler component.
46. The anhydrous mascara composition according to claim 45, wherein the low opacity filler component comprises one or more of barium sulfate, sericite, nylon powder, solid glass microspheres, and talc Italian.
47. The anhydrous mascara composition according to claim 46, wherein the filler component comprises solid glass microspheres.
48. The anhydrous mascara composition according to any of claims 30-47, wherein the composition has a L* value of less than 20.
49. The anhydrous mascara composition according to any of claims 30-48, wherein the composition has a hardness of less than about 15 g.
50. The anhydrous mascara composition according to according to any of claims 30-49, where in the composition has a viscosity of about 250,000 cps to 2,000,000 cps.

51. The composition of any of claims 30-50, wherein the low opacity wax component comprises <25% by weight of the composition.
52. The composition of any of claims 30-51, wherein the low opacity wax component comprises 1 to 20% by weight of the composition.
53. The anhydrous mascara composition according to any of claims 30-52, wherein the composition is substantially free of an alkyl dimethicone.
54. A method for coloring eyelashes comprising applying to the eyelashes a composition according to any of claims 30-53.
55. The method for coloring eyelashes according to claim 54, wherein the color imparted to the eyelashes is black.

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US 14/27609

A. CLASSIFICATION OF SUBJECT MATTER IPC(8) - A61Q 1/10; A61K 8/00 (2014.01) USPC - 424/70.7; 424/70.1 According to International Patent Classification (IPC) or to both national classification and IPC		
B. FIELDS SEARCHED Minimum documentation searched (classification system followed by classification symbols) IPC(8) - A61Q 1/10; A61K 8/00 (2014.01) USPC - 424/70.7; 424/70.1 Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched USPC: 514/616 (search terms below) Electronic data base consulted during the international search (name of data base and, where practicable, search terms used) PatBase (AU BE BR CA CH CN DE DK EP ES FI FR GB IN JP KR SE TH TW US WO), Free Patents Online, Google Web search terms: emulsion mascara glutamide gellant organogelator pigment dye color colour Dibutyl Lauroyl Glutamide Dibutyl Ethylhexanoyl Glutamide		
C. DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X — Y	US 6,214,329 B1 (Brieva et al.) 10 April 2001 (10.04.2001), col 1, ln 44-46; col 1, ln 64 to col 2, ln 3; col 2, ln 46-50; col 3, ln 66 to col 4, ln 23; col 5, ln 23-36	1, 3-5, 22 2
Y	US 2010/0162941 A1 (Lentz et al.) 1 July 2010 (01.07.2010), para [0093], [0100]	2, 30-36
Y	US 2011/0182834 A1 (Do et al.) 28 July 2011 (28.07.2011), para [0022], [0023], [0026], [0032], [0050], [0051], [0067], [0074]	30-36
A	US 2006/0110345 A1 (Lu et al.) 25 May 2006 (25.05.2006), para [0015], [0035], [0203], [0225], [0316], [0324], [0610]	1-5, 30-36
A	US 2004/0170586 A1 (Ferrari et al.) 2 September 2004 (02.09.2004), para [0015], [0033], [0335], [0339], [0447], [0453], [0545]	1-5, 30-36
☐ Further documents are listed in the continuation of Box C. ☐		
* Special categories of cited documents: "A" document defining the general state of the art which is not considered to be of particular relevance "E" earlier application or patent but published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art "&" document member of the same patent family		
Date of the actual completion of the international search 27 June 2014 (27.06.2014)		Date of mailing of the international search report 21 JUL 2014
Name and mailing address of the ISA/US Mail Stop PCT, Attn: ISA/US, Commissioner for Patents P.O. Box 1450, Alexandria, Virginia 22313-1450 Facsimile No. 571-273-3201		Authorized officer: Lee W. Young PCT Helpdesk: 571-272-4300 PCT OSP: 571-272-7774

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US 14/27609

Box No. II Observations where certain claims were found unsearchable (Continuation of item 2 of first sheet)

This international search report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:
because they relate to subject matter not required to be searched by this Authority, namely:
2. ☐ Claims Nos.:
because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:
3. ☒ Claims Nos.: 6-21, 23-29 and 37-55
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box No. III Observations where unity of invention is lacking (Continuation of item 3 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

1. ☐ As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying additional fees, this Authority did not invite payment of additional fees.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims for which fees were paid, specifically claims Nos.:
4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

- ☐ The additional search fees were accompanied by the applicant's protest and, where applicable, the payment of a protest fee.
- ☐ The additional search fees were accompanied by the applicant's protest but the applicable protest fee was not paid within the time limit specified in the invitation.
- ☐ No protest accompanied the payment of additional search fees.