CLAIMS:

1. A wet wipe comprising a fibrous sheet material and an aqueous-based formulation which comprises:

a.) from about 10 to about 50 weight percent witch hazel;

b.) from about 0.01 to about 2 weight percent of at least one emulsifier; and

c.) from about 0.01 to about 0.20 weight percent of at least one emollient;

wherein the weight percent is based on a total weight of said formulation;

wherein the at least one emulsifier in the formulation is a botanical butter; and

wherein the aqueous-based formulation is prepared by a process comprising the steps of:

a.) preparing a side-phase by

i) melting the at least one emulsifier at 50 degrees C in a side-phase mixing vessel;

ii) adding the at least one emollient to the side-phase mixing vessel; and

iii) mixing the at least one emulsifier and the at least one emollient in the side-phase mixing vessel; and

b.) mixing the side-phase to a main batch at about 25 degrees C with vigorous mixing.

2. The wet wipe according to claim 1 wherein the at least one emollient in the formulation is vitamin E acetate.

3. The wet wipe according to claim 1 or claim 2 wherein the at least one emulsifier in the formulation is an ethoxylated shea butter.

4. The wet wipe according to any one of claims 1 through 3 wherein said fibrous sheet material comprises a nonwoven material.

5. The wet wipe according to any one of claims 1 through 4 wherein said wet wipe comprises from about 10 to about 90 weight percent of said formulation based on a dry weight of said wet wipe.

6. The wet wipe according to any one of claims 1 through 5 wherein said wet wipe comprises from about 4:1 formulation to wipe based on dry weight of said wet wipe.

7. The wet wipe according to any one of claims 1 through 6 wherein the formulation comprises a ratio of at least one emulsifier to at least one emollient of about 10:1.

8. The wet wipe according to claim 3 wherein the formulation comprises about 1.5 weight percent ethoxylated shea butter, wherein the weight percent is based on a total weight of said formulation.

9. The wet wipe according to any one of claims 1 through 8 wherein the formulation comprises at least one surfactant.

10. The wet wipe according to claim 9 wherein the at least one surfactant is capryl/capramidopropyl betaine.

11. The wet wipe according to any one of claims 1 through 10 wherein the formulation further comprises from about 0.1 to about 0.5 weight percent based on a total weight of said formulation of at least one antimicrobial preservative.

12. The wet wipe according to claim 11 wherein the antimicrobial preservative comprises diazolidinyl urea, propylparaben, and methylparaben.

13. The wet wipe according to any one of claims 1 through 12 wherein the formulation has a pH of from about 5 to about 7.

14. The wet wipe according to any one of claims 1 through 13 wherein said formulation further comprises from about 0.01 to about 10 weight percent glycerin based on a total weight of said formulation.

15. The wet wipe according to any one of claims 1 through 14 wherein said formulation further comprises from about 0.01 to about 0.5 weight percent botanical extracts based on a total weight of said formulation.

16. The wet wipe according to any one of claims 1 through 15 wherein the formulation comprises about 20 weight percent witch hazel based on a total weight of said formulation.

17. A wet wipe comprising a fibrous sheet material and an aqueous-based formulation which comprises:

a.) about 50 weight percent witch hazel;

b.) about 9 weight percent glycerin;

c.) about 5 weight percent propylene glycol;

d.) about 1.5 weight percent ethoxylated shea butter;

e.) about 0.2 weight percent cucumber extract;

f.) about 0.2 weight percent chamomile extract;

g.) about 0.2 weight percent diazolidinyl urea;

h.) about 0.2 weight percent fragrance;

i.) about 0.2 weight percent methylparaben;

j.) about 0.1 weight percent capramidopropyl betaine;

k.) about 0.1 weight percent aloe vera;

l.) about 0.1 weight percent vitamin E acetate;

m.) about 0.09 weight percent citric acid;

n.) about 0.09 weight percent sodium citrate;

o.) about 0.05 weight percent edetate disodium;

p.) about 0.05 weight percent propylparaben; and

q.) about 33 weight percent added purified water;

based on a total weight of said formulation,

wherein the aqueous-based formulation is prepared by a process comprising the steps of:

a.) preparing a side-phase by

i) melting the ethoxylated shea butter at 50 degrees C in a side-phase mixing vessel;

ii) adding the vitamin E acetate to the side-phase mixing vessel; and

iii) mixing the ethoxylated shea butter and the vitamin E acetate in the side-phase mixing vessel;

b.) mixing the side-phase to a main batch at about 25 degrees C with vigorous mixing, wherein the main batch comprises witch hazel, glycerin, cucumber extract, chamomile extract, diazolidinyl urea, capramidopropyl betaine, aloe vera, citric acid, sodium citrate, edetate disodium, and added purified water;

c.) preparing a propylene glycol preservative phase by mixing propylene glycol, methylparaben, propylparaben, and fragrance;

d.) adding the propylene glycol preservative phase of step c.) to the mixture of step b.) comprising the main batch and the side-phase; and

e.) mixing the formulation at about 25 degrees C for approximately 15 minutes.

18. A wet wipe comprising a fibrous sheet material and an aqueous-based formulation which comprises:

a.) about 20 weight percent witch hazel;

b.) about 9 weight percent glycerin;

c.) about 5 weight percent propylene glycol;

d.) about 1.5 weight percent ethoxylated shea butter;

e.) about 0.2 weight percent cucumber extract;

f.) about 0.2 weight percent chamomile extract;

g.) about 0.2 weight percent diazolidinyl urea;

h.) about 0.2 weight percent fragrance;

i.) about 0.2 weight percent methylparaben;

j.) about 0.1 weight percent capramidopropyl betaine;

k.) about 0.1 weight percent aloe vera;

l.) about 0.1 weight percent vitamin E acetate;

m.) about 0.09 weight percent citric acid;

n.) about 0.09 weight percent sodium citrate;

o.) about 0.05 weight percent edetate disodium;

p.) about 0.05 weight percent propylparaben; and

q.) about 63 weight percent added purified water;

based on a total weight of said formulation,

wherein the aqueous-based formulation is prepared by a process comprising the steps of:

a.) preparing a side-phase by

i) melting the ethoxylated shea butter at 50 degrees C in a side-phase mixing vessel;

ii) adding the vitamin E acetate to the side-phase mixing vessel; and

iii) mixing the ethoxylated shea butter and the vitamin E acetate in the side-phase mixing vessel;

b.) mixing the side-phase to a main batch at about 25 degrees C with vigorous mixing, wherein the main batch comprises witch hazel, glycerin, cucumber

extract, chamomile extract, diazolidinyl urea, capramidopropyl betaine, aloe vera, citric acid, sodium citrate, edetate disodium, and added purified water;

c.) preparing a propylene glycol preservative phase by mixing propylene glycol, methylparaben, propylparaben, and fragrance;

d.) adding the propylene glycol preservative phase of step c.) to the mixture of step b.) comprising the main batch and the side-phase; and

e.) mixing the formulation at about 25 degrees C for approximately 15 minutes.

19. A method of manufacturing the aqueous-based formulation as defined in any one of claims 1 through 16, for use in a wet wipe, comprising the steps of:

a.) preparing a side-phase by

i) melting the at least one emulsifier at 50 degrees C in a side-phase mixing vessel;

ii) adding the at least one emollient to the side-phase mixing vessel; and

iii) mixing the at least one emulsifier and the at least one emollient in the side-phase mixing vessel; and

b.) mixing the side-phase to a main batch at about 25 degrees C with vigorous mixing.

20. A method of manufacturing the aqueous-based formulation as defined in claim 17 or claim 18, for use in a wet wipe, comprising the steps of:

a.) preparing a side-phase by

i) melting the ethoxylated shea butter at 50 degrees C in a side-phase mixing vessel;

ii) adding the vitamin E acetate to the side-phase mixing vessel; and

iii) mixing the ethoxylated shea butter and the vitamin E acetate in the side-phase mixing vessel;

b.) mixing the side-phase to a main batch at about 25 degrees C with vigorous mixing, wherein the main batch comprises witch hazel, glycerin, cucumber extract, chamomile extract, diazolidinyl urea, capramidopropyl betaine, aloe vera, citric acid, sodium citrate, edetate disodium, and added purified water;

c.) preparing a propylene glycol preservative phase by mixing propylene glycol, methylparaben, propylparaben, and fragrance;

d.) adding the propylene glycol preservative phase of step c.) to the mixture of step b.) comprising the main batch and the side-phase; and

e.) mixing the formulation at about 25 degrees C for approximately 15 minutes.