SUMMARY

In one aspect, there is provided ~~the use of~~ a hand cleanser formulation, ~~as a hand cleanser,~~ the formulation comprising: a gel; and lipophilic polymeric particles selected from the group consisting of a polymer of norbornane, a polymer of norbornene, a polymer of norbordiene, and a polymer of a derivative of norbornane, norbornene or norbordiene, wherein said derivative of norbornane, norbornene or norbordiene is one in which a hydrogen atom of one or more C-H bonds of norbornane, norbornene or norbordiene is substituted with a hydrocarbyl group; ~~or lipophilic particles comprising cellulose acetate; or lipophilic particles comprising aggregates of fumed silica~~, the particles being suspended in the gel and present in a concentration from about 0.1 % w/w to about 99% w/w of the formulation, wherein: the gel comprises at least one non-Newtonian thickener present in an amount sufficient to provide the formulation with a yield value of at least 30 dynes/cm^2 (3 Pa); the formulation is optionally free of lipophilic solvent; and the formulation is optionally free of surfactant.

In another ~~aspect~~embodiment, there is provided a skin cleansing formulation, comprising: a gel; and lipophilic particles comprising cellulose acetate; orlipophilic particles comprising aggregates of fumed silica, the particles being suspended in the gel and present in a concentration from about 0.1 % w/w to about 99% w/w of the formulation, wherein: the gel comprises at least one non-Newtonian thickener present in an amount sufficient to provide the formulation with a yield value of at least 30 dynes/cm^2 (3 Pa); the formulation is optionally free of lipophilic solvent; and the formulation is optionally free of surfactant.

In another ~~aspect~~ embodiment there is provided the formulation as disclosed above for use as a hand cleanser.

Also provided herein are skin cleansing formulations particularly useful for cleaning heavy duty oil/dirt from skin based on lipophilic particles as a hydrophobic stain-removing agent for the replacement of all or part of the surfactants and solvents normally involved in greasy stain-removing heavy duty skin cleansers.

An embodiment of a skin cleansing formulation is a gel in which lipophilic polymeric particles are suspended. The particles are present in a concentration from about 0.1 % w/w to about 99% w/w of the formulation, and the gel comprises at least

one non-Newtonian thickener present in an amount sufficient to provide the formulation with a yield value of at least 30 dynes/cm^2.

In embodiments, the formulation is free of lipophilic solvents and/or is free of surfactants.

A non-Newtonian thickener can be any one or more of acrylates/C10-30 alkyl acrylate crosspolymer, carbomer, xanthan gum, guar gum, quaternised guar gum, alginate, bentonite, and is typically present in a concentration totalling from about 0.01 to about 10% w/w of the formulation.

The polymer particles are often present in the formulation in a range from about 0.5 to about 20% w/w of the formulation, for example, or range from about 1 to about 10% w/w of the formulation.

While lipohilic particles may themselves act as scrubbing particles, a formulation may additionally include other scrubbing particles in a concentration from about 0.1 to about 95% w/w, more likely in a concentration from about 0.5 to about 20% w/w, or from about 1 to about 10% w/w of the formulation. Such scrubbing particles can be any one or any combination of vegetable based, organic based and mineral based scrubbing agents, such as, for example, vegetable based particles e.g., one or more of ground cornmeal, ground fruit stones, ground walnuts, or other organic based scrubbing particles such as wood dust, polyethylene and/or polypropylene, or mineral based scrubbing particles such as pumice and/or ground shellfish.

One or more preservatives having bacteriostatic and/or fungistatic properties can be included in a formulation.

THEREFORE WHAT IS CLAIMED IS:

1. A hand cleanser formulation comprising:

a gel; and

lipophilic polymeric particles selected from the group consisting of a polymer of a norbornane, a polymer of a norbornene, a polymer of a norbornadiene, or a polymer of a derivative of norbornane, norbornene or norbornadiene, wherein said derivative of norbornane, norbornene or norbornadiene is one in which a hydrogen atom of one or more C-H bonds of norbornane, norbornene or norbornadiene is substituted with a hydrocarbyl group;

the particles being suspended in the gel and present in a concentration from about 0.1 % w/w to about 99% w/w of the formulation,

wherein:

the gel comprises at least one non-Newtonian thickener present in an amount sufficient to provide the formulation with a yield value of at least 30 dynes/cm^2 (3 Pa);

the formulation is optionally free of lipophilic solvent; and

the formulation is optionally free of surfactant.

2. The formulation according to claim 1, wherein the at least one non-Newtonian thickener is any one or combination of acrylates/C10-30 alkyl acrylate crosspolymer, carbomer, xanthan gum, guar gum, quaternised guar gum, alginate, bentonite, in a concentration of from about 0.01 to about 10% w/w of the formulation.

3. The formulation according to claim 1 or 2, wherein the non-Newtonian thickener is present in a range from about 0.1 to about 5% w/w of the formulation.

4. The formulation according to claim 1, 2 or 3, wherein the polymer particles are present in the formulation in a range from about 0.5 to about 20% w/w of the formulation.

5. The formulation according to claim 4, wherein the polymer particles are present in the formulation in a range from about 1 to about 10% w/w of the formulation.

6. The formulation according to any one of claims 1 to 5, further comprising scrubbing particles in a concentration from about 0.1 to about 95% w/w of the formulation.

7. The formulation according to claim 6, wherein the scrubbing particles are present in a concentration from about 0.5 to about 20% w/w of the formulation.

8. The formulation according to claim 7, wherein the scrubbing particles are present in a concentration from about 1 to about 10% w/w of the formulation.

9. The formulation according to any one of claims 6 to 8, wherein said scrubbing particles are any one or any combination of vegetable based, organic based and mineral based scrubbing agents.

10. The formulation according to claim 9, wherein said vegetable based scrubbing particles include any of ground cornmeal, ground fruit stones, ground walnuts, wherein said organic based scrubbing particles include any of wood dust, polyethylene and polypropylene, and wherein said mineral based scrubbing particles include any of pumice and ground shellfish.

11. The formulation according to any one of claims 1 to 10, further comprising at least one preservative having bacteriostatic and fungistatic properties.

12. The formulation according to claim 11, wherein the at least one preservative is any one or a combination of benzoic acid, benzyl alcohol, bromo-nitro-propanediol,

chloroxylenol, diazolidinyl urea, dehydroacetic acid, dichloro-benzyl alcohol, imadazolidinyl urea, iodopropynylbutyl carbamate, methyl-chloro-isothiazolinone and methyl-isothiazolinone, paraben methyl and/or ethyl and/or butyl and/or isobutyl, phenoxyethanol, poly(hexa-methylene biguanide)-hydrochloride, propionic acid, sodium hydroxymethyl glycinate and sorbic acid.

13. The formulation according to any one of claims 1 to 12, further comprising at least one chelating agent.

14. The formulation according to claim 13, wherein the at least one chelating agent is any one or combination of sodium tripolyphosphate, ethylenediaminetetraacetic acid (EDTA), diethylenetriaminepentaacetic acid (DTPA), N-(hydroxyethyl)-ethylenediami- netriacetic acid (HEDTA), 2-hydroxyethyliminodiacetic acid (HEIDA), aminobenzoic acid, iminodisuccinic acid, polyaspartic acid, gluconic acid, and salts thereof, in a concentration of from 0.01 to 5% w/w of the formulation.

15. The formulation according to claim 14, wherein the at least one chelating agent is present from about 0.1 to about 0.5% w/w of the formulation.

16. The formulation according to any one of claims 1 to 15, further comprising at least one skin conditioner, the at least one skin conditioner being any one or a combination of one or more allantoin, quaternised polymers or gums (polyquaterniums, dihydroxypropyl PEG-5 linoleammonium chloride, guar hydroxypropyltrimonium chloride, behentrimonium chloride).

17. The formulation according to claim 16, wherein said at least one skin conditioner is present in a concentration from about 0.01 to about 10% w/w of the formulation.

18. The formulation according to claim 17, wherein said at least one skin conditioner is present in a concentration from about 0.1 to about 5% w/w of the formulation.

19. The formulation according to any one of claims 1 to 18, the formulation further comprising at least one hydrotrope.

20. The formulation according to any one of claims 1 to 18, the formulation further comprising at least one hydrotrope that is any one or a combination of sodium xylene sulfonate, ammonium xylene sulfonate, calcium xylene sulfonate, potassium xylene sulfonate, sodium toluene sulfonate, ammonium toluene sulfonate, sodium cumene sulfonate, ammonium cumene sulfonate, phosphate polyether ester, alkyldiphenyloxide disulfonate, present in a concentration of from about 0.01 to about 10% w/w.

21. The formulation according to claim 20, wherein the at least one hydrotrope is present in a concentration from about 0.1 to about 5% w/w of the formulation.

22. The formulation according to any one of claims 1 to 21, the formulation further comprising any one or a combination of colouring dyes, pigments and perfumes.

23. The formulation according to any one of claims 1 to 22, wherein said lipophilic particles have a size in a range from about 10 to about 3000 µm.

24. The formulation according to claim 23, wherein said lipophilic particles are microparticles having a size in a range from about 50 µm to about 1000 µm.

25. The formulation according to claim 23, wherein said lipophilic particles have an average size in the range of from 50 µm to 2000 µm.

26. The formulation according to claim 25, wherein said lipophilic particles are microparticles having an average size in the range of from 50 µm to 900 µm.

27. The formulation according to claim 26, wherein said microparticles have an average size in the range of from 100 µm to 700 µm.

28. The formulation according to claim 27, wherein said microparticles have an average size in the range of from 200 µm to 600 µm.

29. The formulation according to any one of claims 1 to 28, wherein said formulation is substantially free of lipophilic solvent.

30. The formulation according to any one of claims 1 to 29, wherein said formulation is substantially free of surfactant.

31. The formulation according to any one of claims 1 to 30, wherein said formulation is substantially free of water.

32. The formulation according to any one of claims 1 to 30, the formulation further comprising water.

33. The formulation according to claim 32, wherein the water is present in amount of from about 0% to about 85% w/w of the formulation.

34. The formulation according to claim 32 or 33, the formulation further comprising at least one pH-adjuster and wherein the formulation has a pH between about 4 and about 9.

35. The formulation according to claim 34, wherein the formulation has a pH between about 5 and about pH 7.

36. The formulation according to claim 34 or 35, wherein the pH-adjuster is an acidic or alkaline pH-adjuster and is any one or a combination of citric acid, phosphoric acid, lactic acid, tartaric acid, sodium hydroxide, potash, aminomethyl propanol, and triethanolamine.

37. The formulation according to claim 1, wherein said the polymer of a norbornane, norbornene or norbornadiene is a homopolymer.

38. The formulation according to claim 1, wherein said polymer of norbornane, norbornene or norbornadiene is poly(norbornene).

THEREFORE WHAT IS CLAIMED IS:

1. Use of a formulation as a hand cleanser, the formulation comprising:

a gel; and

lipophilic polymeric particles selected from the group consisting of a polymer of a norbornane, a polymer of a norbornene, a polymer of a norbornadiene, and a polymer of a derivative of norbornane, norbornene or norbornadiene, wherein a said derivative of norbornane, norbornene or norbornadiene is one in which a hydrogen atom of one or more C−H bonds of norbornane, norbornene or norbornadiene is substituted with a hydrocarbyl group; or

lipophilic particles comprising cellulose acetate; or

lipophilic particles comprising aggregates of fumed silica,

the particles being suspended in the gel and present in a concentration from about 0.1 % w/w to about 99% w/w of the formulation,

wherein:

the gel comprises at least one non-Newtonian thickener present in an amount sufficient to provide the formulation with a yield value of at least 30 dynes/cm^2 (3 Pa);

the formulation is optionally free of lipophilic solvent; and

the formulation is optionally free of surfactant.

2. Use according to claim 1, wherein the at least one non-Newtonian thickener is any one or combination of acrylates/C10-30 alkyl acrylate crosspolymer, carbomer, xanthan gum, guar gum, quaternised guar gum, alginate, bentonite, in a concentration of from about 0.01 to about 10% w/w of the formulation.

3. Use according to claim 1 or 2, wherein the non-Newtonian thickener is present in a range from about 0.1 to about 5% w/w of the formulation.

4. Use according to claim 1, 2 or 3, wherein the polymer particles are present in the formulation in a range from about 0.5 to about 20% w/w of the formulation.

5. Use according to claim 4, wherein the polymer particles are present in the formulation in a range from about 1 to about 10% w/w of the formulation.

6. Use according to any one of claims 1 to 5, further comprising scrubbing particles in a concentration from about 0.1 to about 95% w/w of the formulation.

7. Use according to claim 6, wherein the scrubbing particles are present in a concentration from about 0.5 to about 20% w/w of the formulation.

8. Use according to claim 7, wherein the scrubbing particles are present in a concentration from about 1 to about 10% w/w of the formulation.

9. Use according to any one of claims 6 to 8, wherein said scrubbing particles are any one or any combination of vegetable based, organic based and mineral based scrubbing agents.

10. Use according to claim 9, wherein said vegetable based scrubbing particles include any of ground cornmeal, ground fruit stones, ground walnuts, wherein said organic based scrubbing particles include any of wood dust, polyethylene and polypropylene, and wherein said mineral based scrubbing particles include any of pumice and ground shellfish.

11. Use according to any one of claims 1 to 10, further comprising at least one preservative having bacteriostatic and fongistatic properties.

12. Use according to claim 11, wherein the at least one preservative is any one or a combination of benzoic acid, benzyl alcohol, bromo-nitro-propanediol, chloroxylenol, diazolidinyl urea, dehydroacetic acid, dichloro-benzyl alcohol, imadazolidinyl urea, iodopropynylbutyl carbamate, methyl-chloro-isothiazolinone and methyl-isothiazolinone, paraben methyl and/or ethyl and/or butyl and/or isobutyl, phenoxyethanol, poly(hexa-methylene biguanide)-hydrochloride, propionic acid, sodium hydroxymethyl glycinate and sorbic acid.

13. Use according to any one of claims 1 to 12, further comprising at least one chelating agent.

14. Use according to claim 13, wherein the at least one chelating agent is any one or combination of sodium tripolyphosphate, ethylenediaminetetraacetic acid (EDTA), diethylenetriaminepentaacetic acid (DTPA), N-(hydroxyethyl)-ethylenediaminetriacetic acid (HEDTA), 2-hydroxyethyliminodiacetic acid (HEIDA), aminobenzoic

acid, iminodisuccinic acid, polyaspartic acid, gluconic acid, and salts thereof, in a concentration of from 0.01 to 5% w/w of the formulation.

15. Use according to claim 14, wherein the at least one chelating agent is present from about 0.1 to about 0.5% w/w of the formulation.

16. Use according to any one of claims 1 to 15, further comprising at least one skin conditioner, the at least one skin condition being any one or a combination of allantoin, quaternised polymers or gums (polyquaterniums, dihydroxypropyl PEG-5 linoleammonium chloride, guar hydroxypropyltrimonium chloride, behentrimonium chloride).

17. Use according to claim 16, wherein said at least one skin conditioner is present in a concentration from about 0.01 to about 10% w/w of the formulation.

18. Use according to claim 17, wherein said at least one skin conditioner is present in a concentration from about 0.1 to about 5% w/w of the formulation.

19. Use according to any one of claims 1 to 18, the formulation further comprising at least one hydrotrope.

20. Use according to any one of claims 1 to 18, the formulation further comprising at least one hydrotrope that is any one or a combination of sodium xylene sulfonate, ammonium xylene sulfonate, calcium xylene sulfonate, potassium xylene sulfonate, sodium toluene sulfonate, ammonium toluene sulfonate, sodium cumene sulfonate, ammonium cumene sulfonate, phosphate polyether ester, alkyldiphenyloxide disulfonate, present in a concentration of from about 0.01 to about 10% w/w.

21. Use according to claim 20, wherein the at least one hydrotrope is present in a concentration from about 0.1 to about 5% w/w of the formulation.

22. Use according to any one of claims 1 to 21, the formulation further comprising any one or a combination of colouring dyes, pigments and perfumes.

23. Use according to any one of claims 1 to 22, wherein said lipophilic particles have a size in a range from about 10 to about 3000 µm.

24. Use according to claim 23, wherein said lipophilic particles are microparticles having a size in a range from about 50 µm to about 1000 µm.

25. Use according to claim 23 or 24, wherein said lipophilic particles have an average size in the range of from 50 µm to 2000 µm.

26. Use according to claim 25, wherein said lipophilic particles are microparticles having an average size in the range of from 50 µm to 900 µm.

27. Use according to claim 26, wherein said microparticles have an average size in the range of from 100 µm to 700 µm.

28. Use according to claim 27, wherein said microparticles have an average size in the range of from 200 µm to 600 µm.

29. Use according to any one of claims 1 to 28, wherein said formulation is substantially free of lipophilic solvent.

30. Use according to any one of claims 1 to 29, wherein said formulation is substantially free of surfactant.

31. Use according to any one of claims 1 to 30, wherein said formulation is substantially free of water.

32. Use according to any one of claims 1 to 30, the formulation further comprising water.

33. Use according to claim 32, wherein the water is present in amount of from about 0% to about 85% w/w of the formulation.

34. Use according to claim 32 or 33, the formulation further comprising at least one pH-adjuster and wherein the formulation has a pH between about 4 and about 9.

35. Use according to claim 34, wherein the formulation has a pH between about 5 and about pH 7.

36. Use according to claim 34 or 35, wherein the pH-adjuster is an acidic or alkaline pH-adjuster and is any one or a combination of citric acid, phosphoric acid, lactic acid, tartaric acid, sodium hydroxide, potash, aminomethyl propanol, and triethanolamine.

37. Use according to any one of claims 1 to 36, wherein said lipophilic particle comprises said polymer of a norbornane, norbornene, norbornadiene, or said derivative of norbornane, norbornene or norbornadiene.

38. Use according to claim 37, wherein said polymer of a norbornane, norbornene or norbornadiene is a homopolymer.

39. Use according to claim 38, wherein said polymer of norbornane, norbornene or norbornadiene is poly(norbornene).

40. Use according to any one of claims 1 to 36, wherein said lipophilic particles comprise cellulose acetate.

41. Use according to claim 40, wherein said lipophilic particles further comprise aggregates of fumed silica, or a combination of any of the foregoing.

42. Use according to any one of claims 1 to 36, wherein said lipophilic particles comprise aggregates of fumed silica.

43. Use according to any one of claims 41 to 39 and 42, wherein said lipophilic particles further comprise cellulose acetate.

44. Use of any one of claims 1 to 43, wherein said use is as a heavy duty cleanser.

45. A skin cleansing formulation, comprising:

a gel; and

lipophilic particles comprising cellulose acetate; or

lipophilic particles comprising aggregates of fumed silica,

the particles being suspended in the gel and present in a concentration from about 0.1 % w/w to about 99% w/w of the formulation,

wherein:

the gel comprises at least one non-Newtonian thickener present in an amount sufficient to provide the formulation with a yield value of at least 30 dynes/cm^2 (3 Pa);

the formulation is optionally free of lipophilic solvent; and

the formulation is optionally free of surfactant.

46. The formulation according to claim 45, wherein the at least one non-Newtonian thickener is any one or combination of acrylates/C10-30 alkyl acrylate crosspolymer, carbomer, xanthan gum, guar gum, quaternised guar gum, alginate, bentonite, in a concentration of from about 0.01 to about 10% w/w of the formulation.

47. The formulation according to claim 45 or 46, wherein the non-Newtonian thickener is present in a range from about 0.1 to about 5% w/w of the formulation.

48. The formulation according to claim 45, 46 or 47, wherein the polymer particles are present in the formulation in a range from about 0.5 to about 20% w/w of the formulation.

49. The formulation according to claim 48, wherein the polymer particles are present in the formulation in a range from about 1 to about 10% w/w of the formulation.

50. The formulation according to any one of claims 45 to 49, further comprising scrubbing particles in a concentration from about 0.1 to about 95% w/w of the formulation.

51. The formulation according to claim 50, wherein the scrubbing particles are present in a concentration from about 0.5 to about 20% w/w of the formulation.

52. The formulation according to claim 51, wherein the scrubbing particles are present in a concentration from about 1 to about 10% w/w of the formulation.

53. The formulation according to any one of claims 50 to 52, wherein said scrubbing particles are any one or any combination of vegetable based, organic based and mineral based scrubbing agents.

54. The formulation according to claim 53, wherein said vegetable based scrubbing particles include any of ground cornmeal, ground fruit stones, ground walnuts, wherein said organic based scrubbing particles include any of wood dust, polyethylene and polypropylene, and wherein said mineral based scrubbing particles include any of pumice and ground shellfish.

55. The formulation according to any one of claims 45 to 54, further comprising at least one preservative having bacteriostatic and fongistatic properties.

56. The formulation according to claim 55, wherein the at least one preservative is any one or a combination of benzoic acid, benzyl alcohol, bromo-nitro-propanediol, chloroxylenol, diazolidinyl urea, dehydroacetic acid, dichloro-benzyl alcohol, imadazolidinyl urea, iodopropynylbutyl carbamate, methyl-chloro-isothiazolinone and methyl-isothiazolinone, paraben methyl and/or ethyl and/or butyl and/or isobutyl,

phenoxyethanol, poly(hexa-methylene biguanide)-hydrochloride, propionic acid, sodium hydroxymethyl glycinate and sorbic acid.

57. The formulation according to any one of claims 45 to 56, further comprising at least one chelating agent.

58. The formulation according to claim 57, wherein the at least one chelating agent is any one or combination of sodium tripolyphosphate, ethylenediaminetetraacetic acid (EDTA), diethylenetriaminepentaacetic acid (DTPA), N-(hydroxyethyl)-ethylenediami- netriacetic acid (HEDTA), 2-hydroxyethyliminodiacetic acid (HEIDA), aminobenzoic acid, iminodisuccinic acid, polyaspartic acid, gluconic acid, and salts thereof, in a concentration of from 0.01 to 5% w/w of the formulation.

59. The formulation according to claim 58, wherein the at least one chelating agent is present from about 0.1 to about 0.5% w/w of the formulation.

60. The formulation according to any one of claims 45 to 59, further comprising at least one skin conditioner, the at leaset one skin condition being any one or a combination of allantoin, quaternised polymers or gums (polyquaterniums, dihydroxypropyl PEG-5 linoleammonium chloride, guar hydroxypropyltrimonium chloride, behentrimonium chloride).

61. The formulation according to claim 60, wherein said at least one skin conditioner is present in a concentration from about 0.01 to about 10% w/w of the formulation.

62. The formulation according to claim 61 wherein said at least one skin conditioner is present in a concentration from about 0.1 to about 5% w/w of the formulation.

63. The formulation according to any one of claims 45 to 62, further comprising at least one hydrotrope.

64. The formulation according to any one of claims 45 to 62, further comprising at least one hydrotrope that is any one or a combination of sodium xylene sulfonate, ammonium xylene sulfonate, calcium xylene sulfonate, potassium xylene sulfonate, sodium toluene sulfonate, ammonium toluene sulfonate, sodium cumene sulfonate, ammonium cumene sulfonate, phosphate polyether ester, alkyldiphenyloxide disulfonate, present in a concentration of from about 0.01 to about 10% w/w.

65. The formulation according to claim 64, wherein the at least one hydrotrope is present in a concentration from about 0.1 to about 5% w/w of the formulation.

66. The formulation according to any one of claims 45 to 65, further comprising any one or a combination of colouring dyes, pigments and perfumes.

67. The formulation according to any one of claims 45 to 66, wherein said lipophilic particles have a size in a range from about 10 to about 3000 µm.

68. The formulation according to claim 67, wherein said lipophilic particles are microparticles having a size in a range from about 50 µm to about 1000 µm.

69. The formulation according to claim 67 or 68, wherein said lipophilic particles have an average size in the range of from 50 µm to 2000 µm.

70. The formulation according to claim 69, wherein said lipophilic particles are microparticles having an average size in the range of from 50 µm to 900 µm.

71. The formulation according to claim 70, wherein said microparticles have an average size in the range of from 100 µm to 700 µm.

72. The formulation according to claim 71, wherein said microparticles have an average size in the range of from 200 µm to 600 µm.

73. The formulation according to any one of claims 45 to 72, wherein said formulation is substantially free of lipophilic solvent.

74. The formulation according to any one of claims 45 to 73, wherein said formulation is substantially free of surfactant.

75. The formulation according to any one of claims 45 to 74, wherein said formulation is substantially free of water.

76. The formulation according to any one of claims 45 to 74, further comprising water.

77. The formulation according to claim 76, wherein the water is present in amount of from about 0% to about 85% w/w of the formulation.

78. The formulation according to claim 76 or 77, further comprising at least one pH-adjuster and wherein the formulation has a pH between about 4 and about 9.

79. The formulation according to claim 78, wherein the formulation has a pH between about 5 and about pH 7.

80. The formulation according to claim 78 or 79 wherein the pH-adjuster is an acidic or alkaline pH-adjuster and is any one or a combination of citric acid, phosphoric acid, lactic acid, tartaric acid, sodium hydroxide, potash, aminomethyl propanol, and triethanolamine.

81. The formulation according to any one of claims 45 to 80, wherein said lipophilic particles comprise cellulose acetate.

82. The formulation according to any one of claims 45 to 80, wherein said lipophilic particles comprise aggregates of fumed silica.

83. The formulation according to any one of claims 45 to 82, wherein the lipophilic particles further comprise: a polymer of a norbornane, norbornene, norbornadiene, or a derivative of norbornane, norbornene or norbornadiene, wherein a said derivative of norbornane, norbornene or norbornadiene is one in which a hydrogen atom of one or more C–H bonds of norbornane, norbornene or norbornadiene is substituted with a hydrocarbyl group.

84. The formulation according to claim 83, wherein said polymer of a norbornane, norbornene or norbornadiene is a homopolymer.

85. The formulation according to claim 84 wherein said polymer of norbornane, norbornene or norbornadiene is poly(norbornene).

86. The formulation according to any one of claims 45 to 85, wherein said formulation is substantially free of lipophilic solvent.

87. The formulation according to any one of claims 45 to 86, wherein said formulation is substantially free of surfactant.

88. The formulation as defined by any one of claims 45 to 88, for use as a hand cleanser.

89. The formulation of claim 88, wherein the hand cleanser is a heavy duty cleanser.