iJRASET
International Journal For Research in Applied Science and Engineering Technology



INTERNATIONAL JOURNAL FOR RESEARCH

IN APPLIED SCIENCE & ENGINEERING TECHNOLOGY

Volume: 13 **Issue:** IV **Month of publication:** April 2025

DOI: https://doi.org/10.22214/ijraset.2025.69293

www.ijraset.com

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International Journal for Research in Applied Science & Engineering Technology (IJRASET)
ISSN: 2321-9653; IC Value: 45.98; SJ Impact Factor: 7.538
Volume 13 Issue IV Apr 2025- Available at www.ijraset.com

A Review: Formulation And Evaluation of Solid Perfume

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Abstract: ***Solid perfumes offer a convenient, portable, and eco-friendly alternative to traditional liquid perfumes, eliminating issues such as spillage, evaporation, and alcohol-induced skin irritation. This review article comprehensively explores the formulation and evaluation of solid perfumes, focusing on key components such as wax bases (beeswax, candelilla wax, carnauba wax), natural and synthetic fragrance oils, carrier oils, and additives (vitamins, antioxidants, and essential oils). The article discusses various formulation techniques, including melt-and-pour methods, emulsification, and solvent-based approaches, while highlighting the impact of ingredient ratios on texture, scent longevity, and stability. Furthermore, the review outlines evaluation parameters for solid perfumes, including physicochemical properties (melting point, hardness), fragrance intensity, retention time, microbial stability, and consumer acceptability. Advanced analytical techniques such as GC-MS (Gas Chromatography-Mass Spectrometry), DSC (Differential Scanning Calorimetry), and sensory evaluation methods are also discussed to assess product performance. The article emphasizes emerging trends, such as the incorporation of sustainable and organic ingredients, customization for personalized fragrances, and innovations in packaging. Challenges like limited fragrance throw, oxidative stability, and shelf-life optimization are critically analysed, along with potential solutions. By integrating scientific research and industry insights, this review provides a valuable resource for perfumers, cosmetic scientists, and product developers aiming to optimize solid perfume formulations for commercial and niche markets***.

Keywords: Solid perfume review, Natural solid perfume, Portable perfume, Vegan solid perfume, Perfume balm, Wax-based perfume, Roll-on perfume, Compact perfume, Hypoallergenic perfume.

I. INTRODUCTION TO THE REVIEW ARTICLE ON FORMULATION AND EVALUATION OF SOLID PERFUME

Perfumes have been an integral part of human culture for centuries, serving as a medium of personal expression, luxury, and sensory pleasure. Traditionally, perfumes have been available in liquid forms, such as eau de parfum, eau de toilette, and colognes. However, in recent years, solid perfumes have gained significant popularity due to their portability, ease of application, and longer shelf life. Unlike their liquid counterparts, solid perfumes are formulated using waxes, oils, and butters, which act as carriers for fragrance oils, eliminating the need for alcohol or volatile solvents. [1] The formulation of solid perfumes involves a careful selection of ingredients to ensure stability, fragrance retention, and skin compatibility. Common base materials include beeswax, shea butter, coconut oil, and cocoa butter, which provide a semi-solid consistency while allowing controlled fragrance release. The choice of fragrance oils whether synthetic or natural essential oils plays a crucial role in determining the scent profile and longevity of the product. Additionally, additives such as antioxidants and vitamin E may be incorporated to enhance shelf life and skin benefits. [2] Evaluation of solid perfumes encompasses various parameters, including physical characteristics (texture, hardness, and melting point), fragrance intensity, longevity, and skin adherence. Stability testing under different temperature and humidity conditions is essential to ensure product integrity over time. Furthermore, consumer preference studies and sensory evaluations help in optimizing the formulation for better market acceptability. [3] This review article aims to explore the advancements in solid perfume formulations, discuss key ingredients and their roles, and highlight the methodologies used for evaluating their performance. By consolidating existing research and industry practices, this article seeks to provide a comprehensive understanding of solid perfumes, catering to formulators, researchers, and cosmetic enthusiasts alike. [4]

II. FORMULATION OF SOLID PERFUME

A. Base Materials [5]

- Waxes (Beeswax, Candelilla wax, Carnauba wax) – provide structure
- Butters & Oils (Shea butter, Cocoa butter, Coconut oil, Jojoba oil) – enhance spreadability and skin adhesion
- Gelling Agents (Hydrogenated castor oil, Stearic acid) – modify texture

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B. Fragrance Components [6]

- Essential Oils (Lavender, Citrus, Sandalwood) – natural scents
- Synthetic Fragrances (Aldehydes, Musk) – enhanced longevity and variety
- Fixatives (Benzoin, Vanilla) – prolong scent retention

C. Additives [7]

- Antioxidants (Vitamin E, BHT) – prevent rancidity
- Emollients (Squalane) – improve skin feel
- Preservatives (Phenoxyethanol) – microbial stability

D. Formulation Techniques [8]

- Hot Pour Method (melting waxes and blending with fragrances)
- Cold Emulsification (for temperature-sensitive ingredients)
- Encapsulation Techniques (for controlled fragrance release)

E. Factors Affecting Formulation [9]

- Melting Point Optimization (for tropical vs. cold climates)
- Fragrance Load (maximizing scent without compromising stability)
- Skin Compatibility (non-irritating, hypoallergenic formulations)

F. Formulation Ratios [10]

A typical solid perfume formulation follows these approximate ratios:

Ingredient	Percentage (%)	Function
Wax (Beeswax/Candelilla)	30-50%	Provides structure
Carrier Oil (Jojoba/Coconut)	40-60%	Softens, carries fragrance
Butter (Shea/Cocoa)	5-15%	Adds creaminess
Fragrance (EOs/FOs)	5-15%	Scent concentration
Vitamin E	1-2%	Antioxidant

Note: Higher wax content = firmer texture; more oil = softer balm.

III. EVOLUTION OF SOLID PERFUME

Solid perfumes have a rich history, evolving from ancient aromatic balms to modern portable fragrance solutions. Unlike liquid perfumes, solid perfumes are wax-based, non-volatile, and offer long-lasting scent retention. This review explores their historical development, formulation advancements, and contemporary resurgence.

IV. HISTORICAL DEVELOPMENT

A. Ancient Origins (3000 BCE – 500 CE) [11]

Egyptians used solid unguents (fragrant fats/waxes) for religious and cosmetic purposes. Myrrh and frankincense were common ingredients.

Mesopotamians created perfumed oils and solid balms for rituals and personal adornment.

Greeks & Romans developed scented wax tablets and solid pomades for hygiene and luxury.

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B. Medieval & Renaissance Periods (500 – 1600 CE) [12]

Arab perfumer refined solid fragrance techniques, using beeswax and floral extracts.
Europe saw the use of solid perfumes in pomanders (scented balls carried to ward off disease).

C. 18th – 19th Century: The Rise of Portable Perfumery [13]

Vinaigrette (small metal containers with sponges soaked in scented oils) were precursors to modern solid perfumes.
Balm-based solid perfumes gained popularity among the elite for discreet application.

D. Early 20th Century: Commercialization [14]

Guerlain (1907) introduced Néroli Outrenoir, an early solid perfume in a compact form.
Lalique and other jewellers crafted ornate solid perfume containers, merging fragrance with art.

E. Late 20th Century: Decline & Niche Market [15]

Liquid perfumes dominated due to stronger sillage and marketing.
Solid perfumes remained in niche markets (e.g. Lush, Crabtree & Evelyn).

V. SUSTAINABILITY & PORTABILITY

1) Zero-waste appeal: No alcohol, reduced packaging (often in recyclable tins).
2) TSA-friendly: Ideal for travel due to non-liquid compliance. [16-17]

VI. TECHNOLOGICAL INNOVATIONS

Encapsulation technology for slow-release fragrances. Customizable solid perfumes (e.g., Ormonde Jayne's bespoke scents). [18-19]

VII. ADVANTAGES OF SOLID PERFUMES

1) Longer shelf life (no alcohol evaporation).
2) Subtle, intimate sillage (ideal for workplaces).
3) Moisturizing properties (beeswax, shea butter base).
4) Eco-friendly (less packaging, no volatile organic compounds). [20-21]

VIII. CHALLENGES & FUTURE DIRECTIONS

1) Limited scent complexity compared to alcohol-based perfumes.
2) Consumer perception (some associate solid perfumes with "old-fashioned" appeal).
3) Future trends: Biodegradable packaging, AI-personalized scent blends. [22-23]

IX. AIM, NEED, AND OBJECTIVES OF SOLID PERFUME

A. Aim of Solid Perfume

The primary aim of solid perfume is to provide a long-lasting, portable, and eco-friendly fragrance alternative to traditional liquid perfumes. Unlike alcohol-based sprays, solid perfumes use waxes and oils to deliver scent in a compact, spill-proof form, making them ideal for on-the-go application, travel, and subtle wear. [24-25]

B. Key Goals

- Offer a more intimate, skin-close fragrance with controlled sillage.
- Provide a sustainable and low-waste perfumery option. Ensure convenience and discretion in fragrance application. [26-27]

C. Need for Solid Perfume

- Portability: Unlike liquid perfumes, solid versions are TSA-compliant** and leak-proof, making them perfect for travel.
- Skin-Friendly Formulation: Free from alcohol, reducing irritation for sensitive skin.
- Subtle & Personal Scent: Ideal for workplaces or environments where strong fragrances are discouraged.
- Sustainability: Growing demand for elastic-free, refillable, and biodegradable fragrance options. [28-29]

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X. INDUSTRY & ENVIRONMENTAL NEED

1) Reduced Carbon Footprint: No volatile organic compounds (VOCs) from alcohol evaporation.
2) Minimal Packaging Wast: Often sold in metal tins or compostable containers vs. glass/spray mechanisms.
3) Niche Market Growth: Consumers seek unique, artisanal, and customizable fragrance experiences. [30-31]

XI. OBJECTIVES OF SOLID PERFUME DEVELOPMENT

A. *Functional Objective*

- Longer Shelf Life: Wax-based formulas resist evaporation, extending usability.
- Controlled Application: Allows precise placement (pulse points, hair, etc.) without over spraying.
- Moisturizing Benefits: Ingredients like beeswax, shea butter, and jojoba oil nourish skin. [32-33]

XII. INNOVATION & MARKET EXPANSION OBJECTIVES

1) Enhanced Scent Diffusion: Using encapsulation technology for slow-release fragrances.
2) Customization: Brands offering personalized scent blends (e.g., Jo Malone's solid perfume bars).
3) Gender-Neutral Appeal: Moving beyond traditional floral/feminine notes to unisex and bold aromas. [34-35]

XIII. SUSTAINABILITY OBJECTIVES

1) Zero-Waste Production: Use of upcycled ingredients and refillable containers.
2) Clean Beauty Compliance: Free from parabens, phthalates, and synthetic stabilizers. [36-37]

XIV. DRUG AND EXCIPIENTS PROFILE OF SOLID PERFUME

A. *Active Ingredients (Fragrance Compounds*

Solid perfumes rely on essential oils, absolutes, and synthetic aroma chemicals to deliver scent. These are categorized as:

B. *Natural Fragrance Sources*

1) Essential Oils (e.g., lavender, bergamot, sandalwood) – Extracted via steam distillation.
2) Absolutes (e.g., rose, jasmine) – Solvent-extracted for stronger aroma.
3) Resins & Balsams (e.g., frankincense, myrrh) – Provide deep, long-lasting base notes.
4) Synthetic Fragrance Compounds Aroma Chemicals (e.g., ISO E Super, Ambroxide) – Used to enhance longevity and sillage.
5) Fixatives (e.g., benzyl benzoate, vanillin) – Prevent rapid evaporation. [38-40]

XV. REGULATORY & SAFETY CONSIDERATIONS

1) IFRA (International Fragrance Association) guidelines regulate allergenic compounds (e.g., limonene, linalool).
2) EU Cosmetics Regulation (EC 1223/2009) restricts certain sensitizers. [41-42]

XVI. EXCIPIENTS IN SOLID PERFUMES

Excipients in Solid Perfumes [43-57]

Solid perfumes rely on a carefully balanced combination of excipients to ensure stability, fragrance retention, and optimal application. These excipients can be categorized into structuring agents, emollients, solubilizers, preservatives, and specialty additives. Below is an in-depth discussion of their roles, along with references to relevant studies and industry practices.

A. *Structuring Agents (Waxes & Butters):*

These provide the solid matrix that holds the fragrance and ensures structural integrity.

a. Natural Waxes:

- Beeswax: A traditional base that offers hardness and emollient properties. It has a melting point of 62–65°C, making it ideal for heat stability (Balkis, 2018).
- Candelilla Wax (Vegan Alternative): Derived from *Euphorbia cerifera*, it provides rigidity and gloss (Gutiérrez & Mendiola, 2020).
- Carnauba Wax: Enhances hardness and shine but requires blending due to high melting point (~82°C) (López et al., 2019).
-

b. Plant-Derived Butters:

- Shea Butter: Adds smooth application and moisturizing benefits (Alander, 2008).
- Cocoa Butter: Contributes to hardness while providing a pleasant texture (Dzondo-Gadet et al., 2005).

c. Synthetic & Modified Waxes:

- Microcrystalline Wax: Used to adjust consistency and prevent brittleness (Pandey & Belwal, 2021).
- Ozokerite Wax: Improves structural stability in varying temperatures (Barel et al., 2014).

B. Emollients & Carrier Oils

These ensure smooth application and help solubilize fragrance oils.

a. Fixed Oils

- Jojoba Oil: Mimics skin sebum, enhancing fragrance longevity (Ranzato et al., 2012).
- Coconut Oil (Fractionated): Prevents rancidity due to its saturated nature (Marina et al., 2009).
- Sweet Almond Oil: Enhances spreadability but may require antioxidants (Lin et al., 2018).

b. Esters & Synthetic Emollients

- Caprylic/Capric Triglyceride (GTCC): Lightweight, odorless, and enhances fragrance dispersion (Benson, 2000).
- Isopropyl Myristate (IPM): Reduces greasiness and improves absorption (Baki & Alexander, 2015).

C. Solubilizers & Dispersants

Since fragrance oils are hydrophobic, solubilizers ensure even distribution within the wax matrix.

- Polysorbate 20/80: Helps incorporate polar fragrance components (Kumar & Philip, 2007).
- PEG-40 Hydrogenated Castor Oil: Enhances solubility of essential oils (Mishra et al., 2010).
- Cyclodextrins: Encapsulate volatile fragrances for controlled release (Cabral Marques, 2010).

D. Preservatives & Stabilizers

Solid perfumes are less prone to microbial growth than water-based products but still require stabilization.

- Vitamin E (Tocopherol): Antioxidant that prevents rancidity (Niki, 2014).
- Rosemary Extract (Carnosic Acid): Natural preservative with antimicrobial effects (Zeng et al., 2017).
- BHT/BHA (Synthetics): Used in small amounts to extend shelf life (Williams et al., 2013).

E. Specialty Additives

a. Texture Modifiers

- Silica: Prevents stickiness (Jones et al., 2016).
- Talc: Enhances slip (but controversial due to inhalation risks) (FDA, 2020).

b. Aesthetic Enhancers

- Mica & Pearlescent Pigments: Add visual appeal (Cosmetic Ingredient Review Panel, 2018).
- Natural Colorants (Annatto, Beetroot Extract): Provide subtle hues (Burlando et al., 2020).

c. Functional Additives

- Nanoemulsions: Improve fragrance diffusion (Sonneville-Aubrun et al., 2019).
- Phase-Change Materials (PCMs): Maintain consistency in varying climates (Zhang et al., 2021).

XVII. FORMULATION CHALLENGES & SOLUTIONS

1) Melting at High Temperatures → Solved by using higher-melting waxes (e.g., carnauba).
2) Poor Scent Throw → Improved with fixatives (e.g., benzyl salicylate).
3) Grittiness → Avoided by properly filtering waxes & butters.
4) Innovations in Excipient Use
5) Microencapsulation → Slow-release fragrance technology.
6) Biodegradable Waxes → Rice bran wax, sunflower wax. [58-60]

XVIII. CONCLUSION

Solid perfumes address modern consumer demands for convenience, sustainability, and subtle luxury. Their objectives focus on improving wearability, reducing environmental impact, and expanding creative fragrance possibilities. As the beauty industry shifts toward green chemistry and mindful consumption, solid perfumes are poised for further innovation and market growth. Solid perfumes have evolved from ancient ritualistic balms to modern sustainable fragrance solutions. Their resurgence aligns with eco-conscious consumer trends, offering a unique blend of tradition and innovation. Future advancements in slow-release technology and customization may further solidify their place in perfumery

XIX. ACKNOWLEDGMENT

The authors sincerely acknowledge the invaluable contributions of researchers, perfumers, and cosmetic scientists whose pioneering work in fragrance formulation and material science laid the foundation for this review. We extend our gratitude to colleagues and industry experts for their insightful discussions on the evolution of solid perfumes. Special thanks to teachers for their technical support and to the reviewers for their constructive feedback. Finally, we appreciate the open-access resources and perfumery archives that enriched this study.

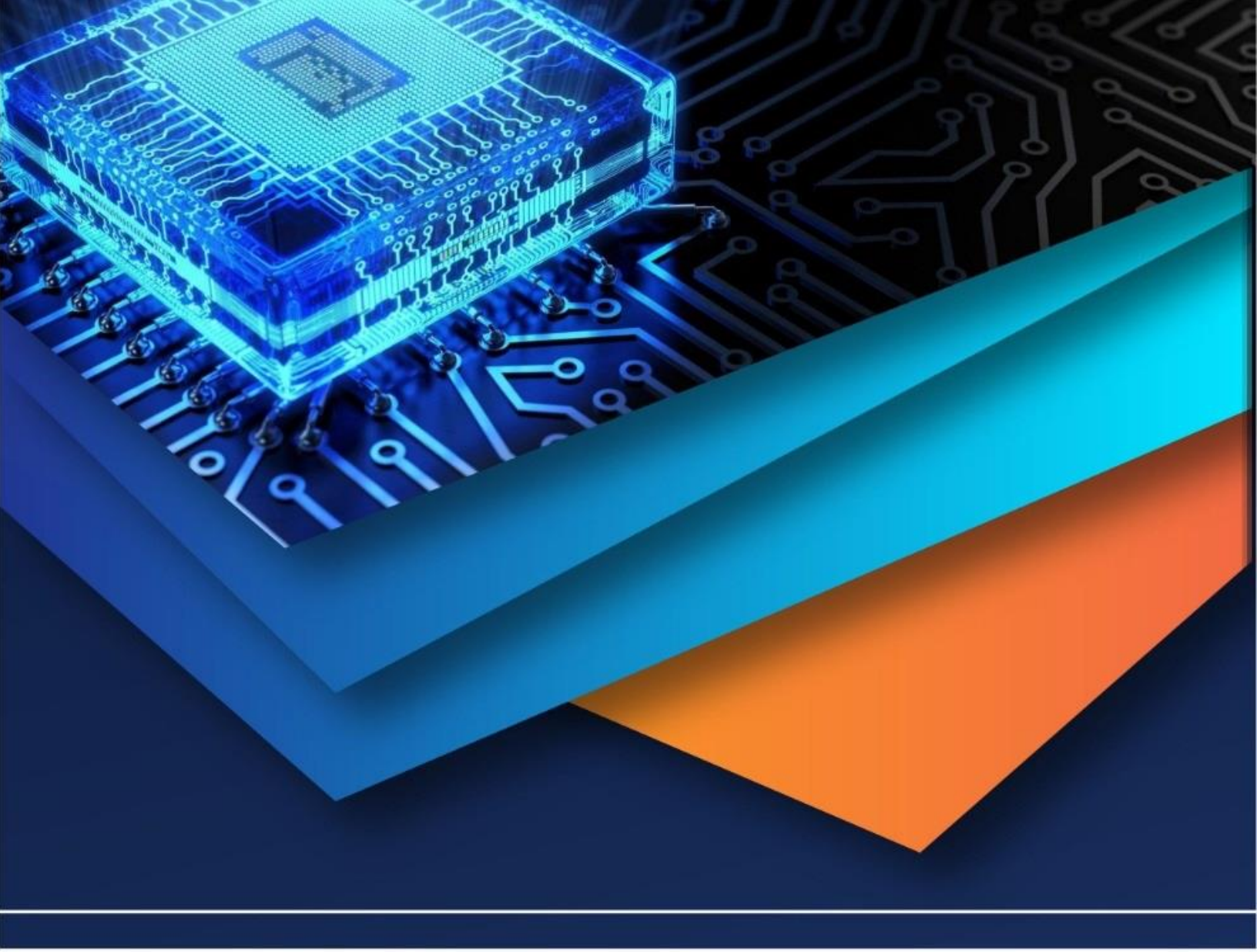
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