

## Solubility Values for OrcoSolve MC Series™

**Orcosolve MC™** solvent soluble metal complex dyes are applicable to the inks and coating industries including wood stains, foil, leather, hot-stamp & bake applications, and plastics. These dyes offer superior heat stability and lightfastness in addition to solubility in many organic solvent systems. In addition to this standard product line we also offer many other specialty solvent dyes as well as custom formulated blends.

| Dye Name                         | Color Index | Ethanol | Methanol | n-Pro panol | Iso pro panol | n- Butanol | Toluene | Dowanol PM | Benzyl Alcohol | Acetone | Methyl Ethyl Ketone (MEK) | Cyclohexanone | Dicetrone Alcohol | Ethyl Cellulose | Butyl Cellulose | Ethyl Acetate | n-Butyl Acetate | Cellulose Acetate | Propylene Glycol |
|----------------------------------|-------------|---------|----------|-------------|---------------|------------|---------|------------|----------------|---------|---------------------------|---------------|-------------------|-----------------|-----------------|---------------|-----------------|-------------------|------------------|
| <b>Orcosolve Black RE-MC</b>     | SBk 27      | 450     | 100      | 110         | 30            | 40         | tr      | 100        | 560            | 450     | 300                       | 500           | 450               | 450             | 450             | 150           | 200             | 350               | 270              |
| <b>Orcosolve Black CNL-MC</b>    | SBk 28      |         |          | 50          | 100           |            | 30      | 200        |                |         | 400                       |               |                   |                 |                 | 20            |                 |                   |                  |
| <b>Orcosolve Black RL-MC</b>     | SBk 29      | 400     | 50       | 100         | 70            | 40         | tr      | 100        | 460            | 400     | 300                       | 390           | 400               | 400             | 400             | 100           | 220             | 360               | 220              |
| <b>OrcoSolve Blue 2GN-MC</b>     | SB 70       | 40      | 100      | 500         | 500           | 220        | 80      | 500        | 500            | 230     | 140                       | 390           | 350               | 500             | 280             | 10            | 80              | 20                | 200              |
| <b>OrcoSolve Green BYS-MC</b>    | SG -        | 45      | 100      | 150         | 150           | 80         | 40      | 300        | 260            | 340     | 320                       | 200           | 350               | 450             | 300             | 10            | 40              | 20                | 190              |
| <b>OrcoSolve Orange RE-MC</b>    | SO 54       | 40      | 40       | 170         | 110           | 150        | tr      | 100        | 170            | 450     | 400                       | 400           | 200               | 150             | 100             | 10            | 20              | 240               | <10              |
| <b>OrcoSolve Orange G-MC</b>     | SO 56       | 150     | 320      | 60          | 80            | 90         | tr      | 300        | 170            | 170     | 100                       | 400           | 200               | 500             | 300             | 150           | 40              | 90                | 240              |
| <b>OrcoSolve Orange RL-MC</b>    | SO 58       | 200     | 20       | <10         | 170           | tr         | tr      | 100        | 80             | 400     | 100                       | <10           | 400               | 400             | 400             | 100           | 100             | 220               | 220              |
| <b>OrcoSolve Orange RLN-MC</b>   | SO 62       | 300     |          | 50          | 100           |            | 50      | 200        |                |         | 500                       |               |                   |                 |                 | 50            |                 |                   |                  |
| <b>OrcoSolve Orange R-MC</b>     | SO 99       | 150     | 150      | 180         | 140           | 180        | tr      | 150        | 180            | 450     | 400                       | 400           | 400               | 400             | 300             | 100           | 10              | 300               | 60               |
| <b>OrcoSolve Fire Red GLS-MC</b> | SR 89       | 20      | 130      | 20          | <10           | 20         | tr      | 100        | 190            | 400     | 150                       | 180           | 400               | 350             | 350             | 20            | tr              | 180               | 60               |
| <b>OrcoSolve Fire Red G-MC</b>   | SR 119      | 20      | 40       | 40          | <10           | 160        | tr      | 100        | 190            | 200     | 100                       | 540           | 200               | 200             | 200             | 20            | 10              | 200               | ins              |
| <b>OrcoSolve Red B-MC</b>        | SR 122      | 150     | 220      | 170         | <10           | 180        | tr      | 400        | 180            | 400     | 400                       | 340           | 400               | 400             | 200             | 100           | 150             | 280               | 250              |
| <b>OrcoSolve Red 2BL-MC</b>      | SR 132      | 100     | 380      | 130         | 100           | 280        | tr      | 100        | 230            | 400     | 300                       | 390           | 400               | 350             | 350             | 50            | 40              | 300               | 270              |
| <b>OrcoSolve Pink 6BLS-MC</b>    | SR 127      | 50      | 300      | 80          | 25            | 20         | <10     | 20         | 600            | <10     | <10                       | 1000          | 100               | 100             | 50              | <10           | <10             | <10               | <10              |
| <b>OrcoSolve Fire Red BL-MC</b>  | SR 160      | 500     | 500      | 80          | 60            | 160        | tr      | 500        | 180            | 390     | 500                       | 500           | 400               | 500             | 0               | <100          | tr              | 90                | 120              |
| <b>OrcoSolve Yellow GL-MC</b>    | SY 90       | 50      | 100      | <20         | <10           | 20         | tr      | 100        | 50             | 400     | 480                       | <10           | 400               | 400             | 400             | 10            | tr              | 15                | 180              |
| <b>OrcoSolve Yellow 2GN-MC</b>   | SY 82       | 100     | 140      | <10         | 150           | 30         | 50      | 100        | 50             | 400     | 300                       | 100           | 400               | 400             | 400             | 250           | 10              | 25                | <10              |
| <b>OrcoSolve Brown 2RL-MC</b>    | SBrn 43     | 130     | 110      | <10         | <10           | 100        | 150     | 330        | 200            | 350     | 500                       | 330           | 420               | 500             | 500             | 200           | 170             | 380               | 290              |