

How to Continuous-Steam Dye Cotton Using **Orco** Reactive **BF-Series™** Dyes

1. Properly prescour goods. If the substrate being processed is rayon, do not exceed a pH of 9 as it will cause saponification of the fiber.
2. Pad goods through dye bath at room temperature containing:

 *X*gr/L(oz/gal) **BF-Series™** reactive dye properly prepared
 2-5oz/gal(15-38gr/L) **Orco Antimigrant ALG™**(5% Solution)
 0.1-0.3 oz/gal(.75-2.25 g/L) **Orconol CHSA Conc™**
3. Dry goods @ 230°F-250°F(110°C-120°C) for 2 minutes.
4. Pad goods through alkali bath at room temperature containing:

 2.5-5.0 oz/gal(20-40 ml/L) Caustic Soda (38° Be')
 33 oz/gal(250 gram/L) Glauber's salt
 1.33 oz/gal (10 gr/L) **Orcotol MN Powder™**
 0-2.5 oz/gal(0-20 gr/L) Sodium Carbonate.
5. Steam @ 225 °F(110°C) for 20-30 seconds.
6. Wash excess or unfixed dye by cold rinsing, then a warm neutralizing rinse @ 120°F(50°C) using acetic acid and a thorough hot rinse.
7. Soap at boil using 0.25 oz/gal(2gr/L) **Orcopon KP™**
8. Warm rinse, then a final cold rinse.