

## How to Exhaust Dye Nylon Using **Orcoset™** Dyes

**Orcoset™** dyes are a specialty line of modified Reactive and 1:2 metal complex dyes with similar dyeing characteristics for wool and nylon offering exceptional fastness. Advantages include high wetfastness, reproducibility, minimum wool fiber degradation, and easy application.

### Prescour

Prescouring of the nylon is necessary in order to remove any impurities in the goods otherwise an unlevel dyeing would result.

Run goods in bath containing 2.0% on weight of goods(owg) **Orconol CHSA Conc™** at 100°-110°F for 15 minutes followed by a warm rinse.

### Dyeing – General Exhaust Method

- Enter goods in bath at 110°F containing:
  - 0.5 - 1.0% owg
  - 1.0 - 1.5 % owg
  - 1.5 - 4.0%% owg
  - 0.13-0.27 oz/gal(1.0 - 2.0 g/L)
- Circulate for 15 minutes.
- Slowly add pre-dissolved **Orcoset™** dyes with circulation and slowly raise temperature to 210°-265°F(100° - 130°C) at a rate of 2°- 3°F per minute and hold as follows:
  - 45 minutes @ 210°F(100°C)
  - 30 minutes @ 250°F(120°C)
  - 20 minutes @ 265°F(130°C)
- Cool back to 165°F(74°C) and rinse.
- After-fix using **Orcofix MN™** if necessary.

**Orco Penetrant 120™**  
**Orcogal SET™**  
Glacial Acetic Acid to pH of 5.5  
Sodium Acetate