

## How to Exhaust Dye Wool 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 wool 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 140°-160°F for 20 minutes.

### Dyeing – General Exhaust Method

- Enter goods in bath at 110°F containing:
  - 0.5 - 1.0% owg      **Orco Penetrant 120™**
  - 1.0 – 1.5 % owg      **Orcogal SET™**
  - 1.5 – 4.0%% owg      Glacial Acetic Acid to pH of 4.5
  - 5.0 % owg      Sodium Acetate
- Circulate for 15 minutes.
- Slowly add pre-dissolved **Orcoset™** dyes with circulation and slowly raise temperature to 160°-170°F(71° – 77°C) at a rate of 2°- 3°F per minute.
- Maintain temperature for 20 minutes.
- Raise temperature to 210°F(99°) at a rate of 2°- 3°F per minute.
- Maintain temperature for 25-45 minutes.
- Cool back to 165°F(74°C) and re-acidify with Formic Acid if necessary.
- Dye adds should only be made after cooling the bath back to 165°F(74°C).

### Shade Leveling

- This leveling procedure will pull the shade back approximately 15 – 20%. A thorough rinse should be performed prior to any re-dye. Use the same chemicals and amounts listed in the dyeing procedure(without any dye) and bring to 210°F and run for 30 minutes. Cool back to 160° and re-acidify with Formic Acid before re-dyeing.