

How to High-Temperature Pressure Dye Polyester Using **Orcocilacron™** Dyes

High-temperature / pressure dyeing of homopolymer polyester calls for medium-to-high energy **Orcocilacron™** disperse dyes and an optional small amount of dye carrier for further swelling of the polyester fiber and also to aid as a leveling agent.

- Prepare and pre-scour goods.
- Enter goods in bath at 120°F(49°C) containing:
 - Acetic Acid to a pH of 5.5 – 6.0
 - 1.0% **Orco Penetrant 120™** on weight of goods(owg)
 - 1.0 % owg **Orco Polylev B-400™**
 - 1.0 - 3.0% owg **Orco Dye Carrier LO™**
 - **Orco Dye Carrier LO™** is recommended when dyeing temperatures are < 240°F. The amount of carrier depends on the temperature of the dyeing. Pressure-dyeing temperature ranges from 212°-265°F(100°-130°C). Because of the structure of the fabric and/or abrasion that can exist in dyeing machines such as jets, a lower temperature such as 230°F(110°C) may be required.
 - X% owg **Orcocilacron™** dyes – use proper disperse dye preparation procedure
- Circulate for 10 minutes.
- Raise temperature to dyeing temperature and run for 45-90 minutes, depending on depth of shade.
- Cool back to 180°F(82°C) and sample.
- If shading is necessary, add pre-dissolved shading disperse dye, raise to dyeing temperature, and run for additional 30 minutes.
- Cool back to 120°F(49°C) slowly while rinsing.
- After-scour(after-clear) with:
 - 2 – 4% owg **Orco Synclear P-D™** at a temperature of 140°F(60°C) and run for 15 -20 minutes.
 - Drop bath and rinse well.