

How to One-Bath Bleach & Dye Cellulosics using **Orcolitefast™** and **Orcomine™** Dyes

- Prepare and pre-scour goods as necessary.
- Enter goods into dyebath set at 100°F(38°C) with 0.5% on weight of goods(owg) and circulate for 10 minutes.
- Add the following chemicals and run for 15 minutes at 100F(38C):
 - 3-4 % Hydrogen Peroxide 35% on weight of bath(owb)
 - 1.0-1.5 % owb Sodium silicate
 - 0.25-0.5 % owb Caustic Soda 50% (less than pH of 9 if processing rayon)
 - 0.5-1.0 % owg **Orcoterge ALK-N Conc™**
 - 0.25% owb Peroxide Stabilizer
- Add properly prepared **Orcolitefast™** or **Orcomine™** direct dyes and run for 10 minutes.
- Slowly raise temperature to 205°F(96°C) and run for one hour.
- Add 1-10 g/L, dependent on depth of shade, of Glauber's Salt 20 minutes after reaching 205°F and then again after another 20 minutes for exhaustion of the dye. More salt additions might be necessary for darker shades. If levelness is a problem, the number of salt additions may be increased with the proportional decrease amount of salt.
- Cool back to 120°F(49°C).
- A cold "salt-rinse" might be necessary to help minimize dye wash-off/migration.
- Rinse cold until clear.
- After-fix if necessary using **Orcofix EC™**, **Orcofix F-NF™**, or **Orcofix DS™** depending on your requirements.