

## How to Continuous/Steam Dye Cotton Using Orco Reactive R-Series™ Dyes

1. Prepare and prescour cotton goods.
2. Pad goods through dye bath at room temperature containing:

X gr/L(oz/gal)	<b>R-Series™</b> reactive dye properly prepared
2-5oz/gal(15-38gr/L)	<b>Orco Antimigrant ALG™</b> (5% Solution)
0.1-0.3 oz/gal(.75-2.25 g/L)	<b>Orconol CHSA Conc™</b>
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 )	<b>Orcotol MN Powder™</b>
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 off by cold rinsing, then a warm neutralizing rinse @ 120°F(50°C) using acetic acid.
7. Thoroughly hot rinse and soap at boil using 0.25 oz/gal(2gr/L) **Orcopon KP™**.
8. Warm rinse, then a final cold rinse.