How to Dye Acetate/Rayon Blends with Orcocil™ and Orco Reactive R- or BF-Series™ Reactive Dyes using a Two-Bath Dyeing Process

- Care should be exercised when selecting Orcocil™ dyes for certain applications due to the limitations of gas-fade properties of some dyes.
- Do not exceed a pH of 9 in any process involving rayon as it will cause saponification of the fiber.

**Dyeing of Rayon**

1. Circulate goods at 120°F(49°C) in following chemical bath:
   - 1 % owg Orcol CHSA Conc™
   - Common Salt - refer to chart below
   - x % owg Orco Reactive™ Dye properly prepared
   - Soda Ash - refer to chart below
<table>
<thead>
<tr>
<th>Liquor Ratio</th>
<th>% owg Dye</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>0.0-0.5</td>
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<tr>
<td>8:1 to 12:1</td>
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<tr>
<td>Common Salt (G/L)</td>
<td>15</td>
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<tr>
<td>Soda Ash (G/L)</td>
<td>4</td>
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<tr>
<td>Less than 8:1</td>
<td></td>
</tr>
<tr>
<td>Common Salt (G/L)</td>
<td>10</td>
</tr>
<tr>
<td>Soda Ash (G/L)</td>
<td>5</td>
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</tbody>
</table>

2. Raise temperature slowly to 140°F(60°C) and hold.
3. At 140°F(60°C) add Soda Ash. This should be added pre-diluted and in thirds over a 20-minute period to ensure levelness. Dyeing time can range from 45-90 minutes depending on depth of shade.
4. Cool back/overflow to 110°F(43°C)
5. Rinse in 0.13 oz/gal(1.0 g/L) of Acetic acid 56% for 15 minutes.
6. Cool back to 90°F(32°C), drop bath, and refill.
7. Raise temperature to 210°F(99°C) and soap off for 15 minutes with 0.25 % owg Orcopon KP™.
8. Drop bath, refill and hot rinse for 10 minutes.
9. Drop bath, refill and cold rinse for 10 minutes.
10. Refill for subsequent dyeing of acetate with disperse dyes.
**Dyeing of Acetate**

**Orcocil Dyes on Acetate**

1. Circulate goods at 110-120°F (43-49°C) for 10-15 minutes in a bath containing 0.50-1.0% owg Orcoterge 35-C™. Adjust pH if necessary to 5.5-6.0.
2. Add Orcocil™ dyes properly prepared.
3. Hold at this temperature for 50-60 minutes.
4. Cool back to 140°F (60°C), drop bath, and rinse.