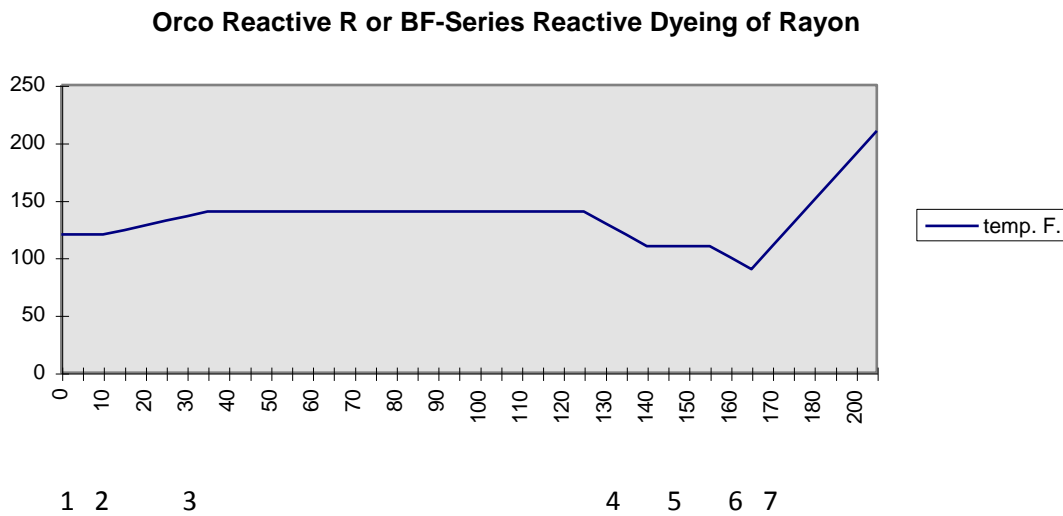


How to Dye Acetate/Rayon Blends with Orcocil™ and Orco Reactive R- or BF-Series™ Reactive Dyes using a Two-Bath Dyeing Process



- 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.

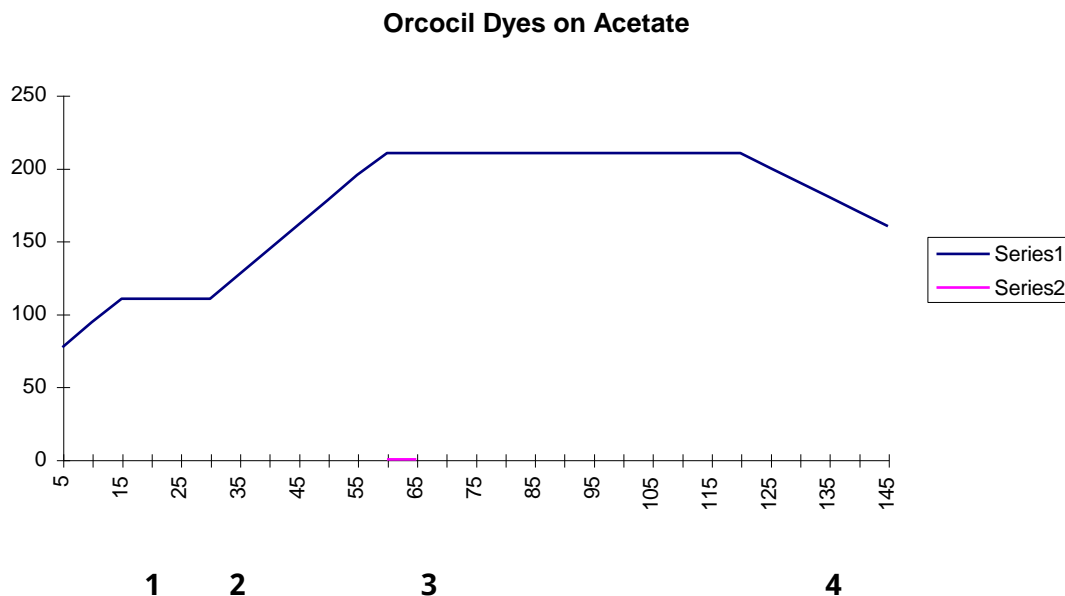
Dyeing of Rayon

1. Circulate goods at 120°F(49°C) in following chemical bath:
 - 1 % owg **Orconol CHSA Conc™**
 - Common Salt - refer to chart below
 - x % owg **Orco Reactive™** Dye properly prepared
 - Soda Ash - refer to chart below

<u>Liquor Ratio</u>	<u>% owg Dye</u>					
	0.0-0.5	0.5-1.0	1.0-2.0	2.0-3.0	3.0-4.0	4.0-+
8:1 to 12:1						
Common Salt (G/L)	15	25	40	50	50	50
Soda Ash (G/L)	4	5	6	7	9	12
Less than 8:1						
Common Salt (G/L)	10	20	30	35	45	45
Soda Ash (G/L)	5	6	7	9	11	13

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



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.