

How to Dye Acetate/Rayon Blends with Orcocil™ and Orco™ Direct Dyes using a Jig Dyeing Process

1. Care should be exercised when selecting **Orcocil™** dyes for certain applications due to the limitations of gas-fade properties of some dyes.
2. Do not exceed a pH of 9 in any process involving rayon as it will cause saponification of the fiber.
3. Prepare goods as necessary.
4. In a dyebath at 100°F(38°C) add:
 - 1 % owg **Orcoterge 35-C™**
5. Adjust pH to 6.5-7.0 and run two ends then begin adding **Orcocil™** Disperse dyes and **Orco™** Direct dyes properly prepared.
6. Raise the temperature to 130°F(54°C) and run two ends.
7. Raise the temperature to 150°F(66°C) and run two ends.
8. Slowly raise temperature to 160-200°F(71-93°C) while adding 20-30% Glauber's salt on weight of rayon and run two ends. The salt should be added in three equal portions over the remainder of the dyeing time to promote direct dye exhaustion. More dyeing time may be required for deeper shades and is also dependent on the construction of the fabric. The luster of the acetate will decrease with the increase of dyeing temperature. If luster is not desired, an initial boil of the fabric for 15 minutes before the dyeing will degrade the luster. It is important to keep in mind that the dyeing of fiber requires energy which is related to the amount of time and temperature. The shorter the end is the less amount of time for each end and therefore overall dyeing time is less. This procedure assumes one end requires a minimum of 15 minutes.
9. Cool slowly to 90°F(32°C) and cold *salt-rinse* for two ends to help minimize wash-off of the direct dyes.
10. Drop bath and cold rinse for four ends.
11. Add fixative **Orcofix EC™** or **Orcofix F-NF™** if necessary.