

How to Dye Polyester/Cellulosic Blends with Disperse and Direct Dyes using a One-bath/Two Step Jet or Package Dyeing Process

1. Prepare goods as necessary.
2. If the substrate being processed is rayon, do not exceed a pH of 9 as it will cause saponification of the fiber.
3. Prepare bath at 120 F(49°C) containing 1-2% owf **Orcoterge 35-C™** and 1-2% owf Monosodium Phosphate(MSP) for a neutral pH.
4. Circulate bath for 15 minutes.
5. Add pre-dispersed **Orcocilacron™** Disperse dyes properly prepared. It is recommended that high-energy disperse dyes are used in a procedure where temperatures attained are between 250-275°F(120-135°C)[5]. Run for 10 minutes.
6. Raise temperature slowly to 265°F(130°C at a rate of 2°F/minute).
7. Hold for 30-45 minutes.
8. Cool to 160°F(71°C).
9. Check shade and adjust if necessary.
10. Add predissolved **Orcolitefast™** Direct dye solution.
11. Circulate for 10 minutes.
12. Raise temperature slowly at 2°F/minute to 210°F(99°C).
13. Add 30-40% owf Glauber's salt evenly over 30 minutes.
14. Run for 45 minutes and cool to 160°F(71°C).
15. Sample and adjust shade if necessary.
16. Rinse warm.
17. Rinse cold.
18. After-treat if necessary.