

How to Dye Polyester/Nylon Blends with Orcocilacron™ Disperse and Orco™ Acid Dyes using a One-Bath Process

This is a general one-bath procedure, for cross or union-dyeing, using **Orcocilacron™** Disperse and **Orco™** acid dyes on Polyester/Nylon blends. Acid dye classes that are applicable for this procedure are **Orco Milling™**, **Orco Nylosol™**, and **Orcolan Neutral™**.

1. Prepare goods as necessary.
2. In a bath at 110°F(43°C), add:
 - 0.5-1.0 % owg **Orcoterge 35-C™**
 - 6 % owg Glauber's Salt
 - X % owg **Orcocilacron™** Disperse dyes properly prepared
3. Circulate for 10 minutes and then add:
 - Y % owg **Orco™** Acid dyes properly prepared
4. Slowly raise temperature to 170°F(77°C) and add:
 - 3 % owg **Orco Dye Carrier LO™**
5. Raise to the boil and run for 1-1 ½ hours depending on the depth of shade.
6. Cool to 170°F(77°C), sample, and shade if necessary. If so, raise to the boil and run an additional 30 minutes.
7. Hot wash at 170-180°F(77-82°C) to remove dye carrier. Do not allow the temperature to drop below 160°F(71°C) until all carrier is removed.
8. After-scour in fresh bath at 180°F(82°C) for 30 minutes with:
 - 0.5 % owg **Orcoterge 35-C™**
 - 0.5 % owg Acetic Acid
9. Cool to 170°F(77°C), drop bath, and rinse well.