/ COMPATIBILITY WITH BIOMASS-BASED SULFUR DYES

FiberColors®
Creating a new, colorful life from wool waste

FiberColors® is an award-winning range of high-performance sulfur dyes synthesized from wool waste. The palette offers warm shades for entire collections and can be applied across multiple processes including exhaust or continuous dyeing, denim coloration, and textile printing for cellulosic and wool fibers.

DIRESUL® FIBER-TEAK
synthesized using 100% wool waste-based raw material

DIRESUL® FIBER-OCHRE
synthesized using 50% wool waste-based raw material

DIRESUL® FIBER-MAROON
synthesized using 50% wool waste-based raw material

DIRESUL® FIBER-SLATE
synthesized using 50% wool waste-based raw material

DIRESUL® FIBER-GRAPHITE
synthesized using 50% wool waste-based raw material

EarthColors®
Creating a new and colorful life for agricultural and herbal waste

EarthColors® is a patented, award-winning range of high-performance dyes synthesized from upcycled, non-edible agricultural and herbal industry waste. This palette of natural shades are suitable for cellulosic based fibres such as cotton, viscose, linen, bamboo and kapok.

DIRESUL® EARTH-OAK
manufactured using 100% ALMOND SHELLS from the food industry

DIRESUL® EARTH-COTTON
manufactured using 100% COTTON PLANT residues from the cotton industry

DIRESUL® EARTH-SAND
manufactured using 90% BITTER ORANGE residues from the herbal industry

DIRESUL® EARTH-CLAY
manufactured using 90% BEET residues from the food industry

DIRESUL® EARTH-FOREST
manufactured using 90% SAW PALMETTO residues from the herbal industry

DIRESUL® EARTH-STONE
manufactured using 70% SAW PALMETTO residues from the herbal industry

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InOneGO / Unique All-In-One Continuous Process for DIRESUL® RDT Dyes



InOneGO

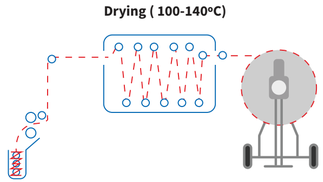
Unique All-In-One Continuous Process for DIRESUL® RDT Dyes

Transform your production with a highly efficient, water-free Pad-Dry application for Stenter or Thermosol machines. This tailormade process delivers exceptional resource savings while expanding your design possibilities across diverse fabrics and end-markets.

- **Significant Resource Savings**
  Designed to reduce water and energy use, processing time and associated process emissions compared with a conventional benchmark dyeing process.
- **Zero Fabric Washing**
  Features a completely water-free application process in fabric form.
- **Ultimate Fabric Versatility**
  Ideal for cellulosics (wovens like canvas/twills and knits).
- **Broad Market Appeal**
  Perfect for Denim, Fashion Wear or Home Textiles.
- **Consistent wash down looks**
  Vintage-inspired aesthetics with reproducible wash-down performance.
- **High Performance**
  Ensures good overall fastness properties, especially after wash-down, with the option to add performance finishes in a second step.
- **Biomass-Based Dye Compatibility**
  Seamlessly integrates with biomass-based sulfur dyes like Archroma's EarthColors® and FiberColors®.

/ APPLICATION PROCESS AND RECIPE

Dyeing



Dyeing Recipe

X g/l	DIRESUL® RDT liq
15 g/l	APPRETAN® N92100 liq
2 g/l	NaOH 50%
2 g/l	LEONIL® EHC liq C
2 g/l	DEKOL® SN liq/2005 liq c
20g/l	CERALUBE® SVN liq

Padding at Room temperature

- Pad and Dry, with no additional oxidation step.
- Low or no additional reducing agent required in the recipes.
- Low concentration of NaOH required.
- Color fixation system based on affinity and a binder.
- Polyethylene softener included in the recipe for stitching.

By incorporating an additional step, optional finishing agents from ALBAFIX®, ALBAFLOW®, OPTIFIX®, AND CERALUBE® ranges are available for enhancing fixation during wash-down processes and improve fastness properties.

Great shade selection to obtain natural/earthy tones, including special blues and dark blacks.

- DIRESUL® Olive Yellow RDT-Y liq
- DIRESUL® Orange RDT-3G liq
- DIRESUL® Olive RDT-B 150 liq
- DIRESUL® Olive RDT-BW 150 liq
- DIRESUL® Brown RDT-ZS 150 liq
- DIRESUL® Brown RDT-ZN liq
- DIRESUL® Brown RDT-ZFW liq
- DIRESUL® Brown RDT-R liq
- DIRESUL® Indiblue RDT-R liq
- DIRESUL® Indiblue RDT-G liq
- DIRESUL® Indinavy RDT-B liq
- DIRESUL® Smart Denim Blue liq
- DIRESUL® Night Blue liq
- DIRESUL® Blue Black RDT-2B liq
- DIRESUL® Black RDT-K liq

Casual Wear InOneGO



Knit sweater, consciously dyed with Archroma's **DIRESUL® Indiblue RDT-G liq**. using the **InOneGO** process
Powered by Moda 21- Portugal-.

/ EXAMPLE OF InOneGO WOVEN FABRIC

75 g/l DIRESUL®OLIVE RDT-B 150 liq.



1 ORIGINAL FABRIC | 2 ORIGINAL DYEING | 3 ENZYMATIC WASH DOWN

/ CASE STUDY
STENTER MACHINE, 100% COTTON JACQUARD WOVEN FABRIC



COMPARED TO BENCHMARK COLD PAD BATCH REACTIVE DYE + PIGMENT DYE TOP

InOneGO saves

PROCESS TIME	WATER
-81%	-97%

ENERGY	CO_2 EMISSIONS
-65%	-75%

*Powered by Lameirinho-Portugal.

*According to Archroma's One-Way calculator tool.