(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization
International Bureau

(43) International Publication Date
25 April 2002 (25.04.2002)

PCT

(10) International Publication Number
WO 02/33163 A1

(51) International Patent Classification[7]: D06P 5/00, B08B 7/00

(21) International Application Number: PCT/US01/32551

(22) International Filing Date: 18 October 2001 (18.10.2001)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:
60/241,262 18 October 2000 (18.10.2000) US
09/729,566 4 December 2000 (04.12.2000) US

(71) Applicant *(for all designated States except US)*: **NORTH CAROLINA STATE UNIVERSITY** [US/US]; 2401 Research Drive, Suite 1122, Campus Box 8210, Raleigh, NC 27695-8210 (US).

(72) Inventors; and
(75) Inventors/Applicants *(for US only)*: **SMITH, Carl, Brent** [US/US]; 2610 Glen Burnie Drive, Raleigh, NC 27607 (US). **HENDRIX, Walter, A.** [US/US]; 10717 East Bridgefort Road, Raleigh, NC 27606 (US). **BUTCHER, Donald, L.** [US/US]; 2031 Hodge Road, Knightdale, NC 27545 (US).

(74) Agent: **TAYLOR, Arles, A., Jr.**; Jenkins & Wilson, P.A., Suite 1400, University Tower, 3100 Tower Boulevard, Durham, NC 27707 (US).

(81) Designated States *(national)*: AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZW.

(84) Designated States *(regional)*: ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

Published:
— *with international search report*
— *before the expiration of the time limit for amending the claims and to be republished in the event of receipt of amendments*

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

WO 02/33163 A1

(54) **Title:** PROCESS FOR TREATING TEXTILE SUBSTRATES

(57) **Abstract:** A process for treating a textile substrate, the process including the steps of providing a textile substrate; providing a treatment bath; entraining a transport material in the treatment bath wherein the transport material further comprises a treatment material dissolved or suspended therein and wherein the transport material is substantially immiscible with the treatment bath; and contacting the textile substrate with the transport material in the treatment bath to thereby treat the textile substrate with the treatment material in the transport material.

Description

PROCESS FOR TREATING TEXTILE SUBSTRATES

Cross Reference to Related Applications

This application is based on and claims priority to U.S. provisional patent application serial number 60/241,262, filed October 18, 2000, and to U.S. patent application serial number 09/729,566, filed December 4, 2000, both of which are herein incorporated by reference in their entirety.

Technical Field

The present invention relates generally a process for treating textile substrates, and more particularly to a process for treating a textile substrate in treatment bath having a transport material entrained therein, the transport material having a treatment material dissolved, dispersed or suspended therein. In a preferred embodiment, the process comprises treating a textile substrate in supercritical fluid carbon dioxide (SCF-CO_2).

Background Art

It will be appreciated by those having ordinary skill in the art that conventional aqueous dyeing processes for textile substrates generally provide for effective dyeing, but possess many economic and environmental drawbacks. Particularly, aqueous dye baths that include organic dyes and co-solvents must be disposed of according to arduous environmental standards. Compliance with environmental regulations and process heating requirements thus drive up the costs of aqueous textile dyeing to both industry and the consuming public alike. Accordingly, there is a substantial need in the art for an alternative dyeing process wherein such problems are avoided.

One alternative to aqueous dyeing that has been proposed in the art is the dyeing of textile substrates in a supercritical fluid. Particularly, textile dyeing processes using supercritical fluid carbon dioxide (SCF-CO_2) have been explored.

However, those in the art who have attempted to treat textile substrates in SCF-CO_2 have encountered a variety of problems. These problems include, but are not limited to, "crocking" (i.e. tendency of a dye to smudge when a dyed article is touched) of a dye on a dyed textile article; unwanted deposition of the dye onto the article and/or onto the dyeing apparatus during process termination; difficulty in characterizing solubility of the dyes in SCF-CO_2; insolubility of many dyes and other treatment materials in CO_2; difficulty introducing the dyes into the SCF-CO_2 flow; difficulty in preparing the dyes for introduction into the dyeing process; high pressure and temperature requirements for solubility; and trimer (cyclic oligomer) extraction from polyester at high temperature. These problems are exacerbated when attempts to extrapolate from a laboratory process to a plant-suitable process are made.

Poulakis et al., *Chemiefasern/Textilindustrie*, Vol. 43-93, Feb. 1991, pages 142-147 discuss the phase dynamics of supercritical carbon dioxide. An experimental section describing an apparatus and process for dyeing polyester in supercritical carbon dioxide in a laboratory setting is also presented. Thus, this reference only generally describes the dyeing of polyester with supercritical carbon dioxide in the laboratory setting and is therefore believed to be limited in practical application.

U.S. Patent No. 5,199,956 issued to Schlenker et al. on April 6, 1993 describes a process for dyeing hydrophobic textile substrate with disperse dyes by heating the disperse dyes and textile substrate in SCF-CO_2 with an azo dye having a variety of chemical structures. The patent thus attempts to provide an improved SCF-CO_2 dyeing process by providing a variety of dyes for use in such a process.

U.S. Patent No. 5,250,078 issued to Saus et al. on October 5, 1993 describes a process for dyeing hydrophobic textile substrate with disperse dyes by heating the disperse dyes and textile substrate in SCF-CO_2 under a pressure of 73 to 400 bar at a temperature in the range from 80°C to 300°C. Then the pressure and temperature are lowered to below the critical pressure and the critical temperature, wherein the pressure reduction is carried out in a plurality of steps.

U.S. Patent No. 5,578,088 issued to Schrell et al. on November 26, 1996 describes a process for dyeing cellulose fibers or a mixture of cellulose and polyester fibers, wherein the fiber material is first modified by reacting the fibers with one or more compounds containing amino groups, with a fiber-reactive disperse dyestuff in SCF-CO_2 at a temperature of 70-210°C and a CO_2 pressure of 30-400 bar. Specific examples of the compounds containing amino groups are also disclosed. Thus, this patent attempts to provide level and deep dyeings by chemically altering the fibers prior to dyeing in SCF-CO_2.

U.S. Patent No. 5,298,032 issued to Schlenker et al. on March 29, 1994 describes a process for dyeing cellulosic textile substrate, wherein the textile substrate is pretreated with an auxiliary composition that promotes dye uptake subsequent to dyeing, under pressure and at a temperature of at least 90°C with a disperse dye from SCF-CO_2. The auxiliary composition is described as being preferably polyethylene glycol. Thus, this patent attempts to provide improved SCF-CO_2 dyeing by pretreating the material to be dyed.

Despite extensive research into SCF-CO_2 textile treatment processes, there remains room for improvement in the development of a process for treating a textile substrate with a textile treatment material. A process for treating a textile substrate would be particularly desirable in a plant-scale application of an SCF-CO_2 textile treatment process. Therefore, the development of such a process meets a long-felt and significant need in the art.

Summary of the Invention

A process for treating a textile substrate is disclosed. The process comprises providing a textile substrate; providing a treatment bath; entraining a transport material in the treatment bath wherein the transport material further comprises a treatment material dissolved, dispersed or suspended therein and wherein the transport material is substantially immiscible with the treatment bath; and contacting the textile substrate with the transport material in the treatment bath to thereby treat the textile substrate with the treatment material in the transport material. In a preferred embodiment, the process comprises treating a textile substrate in supercritical fluid carbon dioxide (SCF-CO_2).

Accordingly, it is an object of the present invention to provide a novel process for treating a textile substrate. This object is achieved in whole or in part by the present invention.

An object of the invention having been stated hereinabove, other objects will be evident as the description proceeds, when taken in connection with the accompanying Drawings and Laboratory Examples as best described hereinbelow.

Brief Description of the Drawings

Figure 1A-1B is a detailed schematic of a system suitable for use in the textile treatment process of the present invention;

Figure 2 is a detailed perspective view of a system suitable for use in the textile treatment process of the present invention;

Figure 3 is a schematic of an alternative embodiment of a system suitable for use in the textile treatment process of the present invention;

Figure 4 is a schematic of another alternative embodiment of a system suitable for use in the textile treatment process of the present invention;

Figure 5 is a schematic of a system for introducing textile treatment materials into a textile treatment system in accordance with a process of the present invention;

Figure 6 is a schematic of a system for introducing textile treatment materials into a textile treatment system in accordance with a process of the present invention; and

Figure 7 is a schematic of a textile treatment system suitable for use in a process of the present invention, wherein the system includes a treatment material preparation subsystem and a dyeing/treament subsystem.

Detailed Description of the Invention

A process for treating a textile substrate is disclosed. The process comprises providing a textile substrate; providing a treatment bath; entraining a transport material in the treatment bath wherein the transport material further comprises a treatment material dissolved, dispersed or suspended therein and wherein the transport material is substantially immiscible with the treatment bath; and contacting the textile substrate with the transport material in the treatment bath to thereby treat the textile substrate with the treatment material in the transport material.

The process of the present invention can further comprise an optional drying step. Optionally, the drying step can be accomplished using a conventional apparatus or system, such as dielectric drying (radio-frequency or microwave), a centrifugal system or other thermal or mechanical/thermal system. Preferably, however, drying is accomplished by a process step, such as by circulating fresh treatment bath (i.e. having substantially no transport material entrained therein) through the textile substrate to remove excess transport material (e.g. water) present in the textile substrate. Optionally, bath temperature can be increased to enhance the drying step.

In a preferred embodiment, the transport material comprises water and the treatment bath comprises near-critical liquid CO_2 or SCF-CO_2. More preferably, the water is present in the near-critical liquid CO_2 or SCF-CO_2 treatment bath in a trace amount. Thus, a major advantage of a preferred embodiment of the present inventive process is that it eliminates virtually all water usage and attendant waste treatment required in conventional textile dyeing processes. The process also has great advantage in that the present inventive process can easily apply dyes of very low affinity, normally not suitable for batch/exhaust dyeing.

I. Process of the Present Invention

In the process of the present invention, the treatment bath can comprise any fluid that is (1) inert with respect to the dye, transport material and textile substrate and (2) has physical properties (density, viscosity, etc.) sufficient to entrain and transport finely distributed droplets or agglomerations of dye- or chemical-laden transport material. Near-critical liquid CO_2 or SCF-CO_2 represent preferred embodiments of such a fluid that is safe, economical and environmentally acceptable. Nitrogen, hexane and propane are additional examples. High-density fluids are preferred.

By the term "high-density" (for the non-aqueous bath liquid) it is meant sufficient to entrain, propel and inhibit settling of the droplets of transport material. The required magnitude of the density of the bath liquid can depend on the velocity of the bath liquid; the viscosity of the bath liquid; the density of the entrained transport material droplets; the size of the entrained transport material droplets; the design of the treatment machine; and on combinations of any of these characteristics.

In a preferred embodiment, the process uses small amounts (trace amounts) of a transport material that is substantially immiscible in the treatment bath. By the term "substantially immiscible" it is meant that the transport material and the treatment bath do not mix to form a solution, i.e., they are substantially insoluble in each other and usually exist in separate phases when mixed. Representative combinations thus included hydrophobic and hydrophilic materials, polar and non-polar materials and/or aqueous and non-aqueous materials. For example, the transport material can comprise an aqueous material (e.g., water), while the treatment bath comprises a non-aqueous material (e.g., SCF-CO_2).

Additionally, the term "transport material" is meant to refer to a material that (1) acts as a solvent, as a dispersing agent or as a suspending agent for the dye or other treatment materials; (2) is capable of wetting the textile substrate; and (3) is a liquid under the treatment conditions. Table 1 contrasts the action of conventional carriers that are used in conventional dyeing processes with that of a transport material of the present invention.

Table 1

Carrier vs. Transport Material

Feature	Carrier	Transport Material
Entrainment	Emulsion of oil-type material in water. Carriers are substantially non-functional in SCF-CO_2. Neither the carrier-active material (e.g. 1,2,4 trichlorobenzene (TCB)), nor the emulsifier systems (e.g. ethoxylated nonyl phenol) are suitable for SCF-CO_2 use.	Entrained droplets of water-type material in SCF-CO_2. No emulsifier is involved. The treatment bath is not an emulsion; rather, the treatment bath comprises entrained droplets.
Dye interaction	Carriers do not dissolve non-ionic dyes within the emulsified droplets.	Treatment material (e.g. dye) is dissolved, dispersed or suspended in the entrained droplets; however, the treatment material is sparingly soluble in the SCF-CO_2.
Persistence	Carriers produce persistent effects in fibers. For example, polyester can be treated with carrier (1,2,4 TCB) then washed thoroughly so that no trace of the carrier remains. Then the fiber can be dyed and will respond as if carrier were still present in the bath.	Once removed, the transport material (e.g. aqueous transport material) preferably has no permanent effect.
Glass transition of fibers	Carriers reduce the glass transition temperature of fibers, and produce permanent morphological changes.	Cotton and wool have no glass transition temperature. They decompose upon heating (or burns)—they do not

		melt or undergo a glass transition. Therefore, carriers would have no function with respect to cotton, wool, silk or similar fibers
Action	Carriers act in the fiber. A polyester fiber placed in a dye bath containing fiber will absorb essentially all of the carrier-active material. The action of the carrier is done by the absorbed material in the fiber.	The transport material acts in the bath to deliver the treatment material to the textile substrate as entrainment of treatment material-laden droplets.
Continuous phase	The continuous phase is aqueous, i.e. a conventional aqueous treatment (e.g. dyeing) bath.	The continuous phase is preferably non-aqueous.

A preferred transport material comprises water or comprises an aqueous solution, an aqueous dispersion, an aqueous emulsification, and/or an aqueous suspension, such as: water/alcohol, water/reducing or oxidizing agent, water/buffer (for pH control), water/salt, or water/surfactant, wherein the surfactant is soluble in water and preferably not soluble in SCF-CO_2. Though less preferred, other transport materials include, but are not limited to: alcohols, poly-alcohols, fluorocarbons, chlorocarbons, hydrocarbons, amines, esters and amides.

Any dyes, chemicals or other textile treatment materials can be used in the process of the present invention so long as the dyes or chemicals are (1) soluble in the transport material and (2) capable of dyeing or treating the textile substrate. An example is the use of direct dyes to dye cotton in SCF-CO_2 with water as the transport material. Another example is the dyeing of wool in SCF-CO_2 with acid dyes, using water as the transport material. The transport material can be conveniently introduced by using it to prewet the textile substrate, but can also be introduced by injection into the treatment bath, along with or separately from the dye or treatment chemical, at a preferred point in the process, i.e., with respect to location and time.

Dyes that can be used to carry out the present invention include, but are not limited to, acid, basic, azo (mono, di, poly), carbonyl, sulfur, methine, and triarylcarbonium dyes. The dyes can be anionic (acid including non-metallized acid, mordant, direct, reactive), cationic (brilliant color with good color fastness), direct (substantive character without mordants), dispersive (very low solubility in dyebath, substantive toward hydrophobics), and azoid (azo containing small molecule permeation followed by a reaction to form a larger substantive dye) dyes.

Materials that can be dyed by the process of the present invention include, but are not limited to, fiber, yarns and fabrics formed from polyester, nylon, acrylic fibers, acetate (particularly cellulose acetate), triacetate, silk, rayon, cotton and wool, including blends thereof such as cotton/polyester blends, as well as leather. In particular, textile substrates are treated by the process, and encompass a large number of materials. Such substrates are those formed from textile fibers and precursors and include, for example, fabrics, garments, upholstery, carpets, tents, canvas, leather, clean room suits, parachutes, yarns, fibers, threads, footwear, silks, and the other water sensitive fabrics. Articles (e.g., ties, dresses, blouses, shirts, and the like) formed of silk or acetate can also be treated via the process of the present invention.

In one embodiment, the process of the present invention pertains to the treatment of hydrophilic fibers, including natural fibers (e.g., cotton, wool and silk) in a non-aqueous fluid treatment bath (e.g., supercritical fluid carbon dioxide, SCF-CO_2) with textile dyes and other textile treatment materials. The treatment is accomplished by entraining dye- or chemical-laden transport materials in an inert treatment bath in a manner that delivers the dye- or chemical-laden transport materials to the textile substrate to be dyed or treated.

The amount of transport material employed in the process of the present invention can vary in accordance with the textile substrate and the treatment conditions, among other variables. For example, the amount of transport material includes the amount that is sorbed by the textile substrate as well as the amount of transport material that is free to circulate and to form entrained droplets in the system. Different fibers and different forms of textile substrates (e.g. yarn package, fabric, etc) will sorb different amounts of water. Wool will absorb most, cotton a little less. Nylon and acrylic will absorb less than cotton and wool. And polyester will absorb almost none. Representative amounts of transport material (e.g. water) are disclosed in the Laboratory Examples presented below.

Thus, the term "trace amount" comprises an amount of transport material needed to result in enough entrainment to accomplish the treatment process plus any additional transport material needed directly in the treatment process. For example, some additional amount of transport material (e.g. water), beyond entrainment needs, can be employed to "swell" fibers such as cellulosics (e.g. cotton) so that they can be treated, but there would be no such need in the case of treating polyester. The amount of free transport material is preferably equal to or less than the weight of the textile substrate being dyed, but will also depend on the particular dye or other treatment material being applied.

The terms "supercritical fluid carbon dioxide" or "SCF-CO_2" are meant to refer to CO_2 under conditions of pressure and temperature which are above the critical pressure (P_c = about 73 atm) and temperature (T_c = about 31°C). In this state the CO_2 has approximately the viscosity of the corresponding gas and a density that is intermediate between the density of the liquid and gas states.

The terms "near-critical liquid carbon dioxide" or "NCL-CO_2" are meant to refer to liquid CO_2 under conditions of pressure and temperature that are near the critical pressure (P_c = about 73 atm) and temperature (T_c = about 31°C).

The term "textile treatment material" means any material that functions to change, modify, brighten, add color, remove color, or otherwise treat a textile substrate. Examples comprise UV inhibitors, lubricants, whitening agents, brightening agents and dyes. Representative fluorescent whitening agents are described in U.S. Patent No. 5,269,815, herein incorporated by reference in its entirety. The treatment material is, of course, not restricted to those listed herein; rather, any textile treatment material compatible with the treatment process is provided in accordance with the present invention.

Representative treatment materials also include but are not limited to antimicrobial agents (e.g., algaecides, bacteriocides, biocides, fungicides, germicides, mildewcides, preservatives); antimigrants (fixing agents for dyes); antioxidants; antistatic agents; bleaching agents; bleaching assistants (stabilizers and catalysts); catalysts; lubricants (coning and winding); crease-resisting finishing agents (anticreasing agents, durable press agents); desizing agents (enzymes); detergents; dye fixing agents; flame retardants; gas fading inhibitors (antifume agents, atmospheric protective agents); fumigants (insecticides and insect repellents); leveling agents; oil repellents; oxidizing agents; penetrating agents (rewetting agents, wetting agents); polymers (resins); reducing agents; retarding agents; scouring agents; soaps; softeners; soil release/stain resistant finishes; souring agents; stripping agents; surfactants; ultraviolet absorbers/light stabilizers; water repellents; waxes; whitening finishes; fluorescent finishes; and combinations of any of the foregoing.

Preferably, the process of the present invention is free of a surfactant that is soluble in the treatment bath, e.g., a surfactant that is soluble in SCF-CO_2. Representative embodiments of such surfactants are disclosed in U.S. Patent No. 6,010,542 issued to DeYoung et al. on January 4, 2000. However, optionally, the transport material can further comprise a surfactant that is substantially insoluble in the treatment bath, but that is soluble in the transport material, e.g., a surfactant that is soluble in water but sparingly soluble in SCF-CO_2.

The term "dye" is meant to refer to any material that imparts a color to a textile substrate. Preferred dyes comprise water-soluble and water-dispersible dyes, and many representative dyes are identified in the Colour Index, an art-recognized reference manual.

The term "hydrophilic textile fiber" " is meant to refer to any textile fiber comprising a hydrophilic material. More particularly, it is meant to refer to natural and synthetic hydrophilic fibers that are suitable for use in textile substrates such as yarns, fabrics, or other textile substrate as would be appreciated by one having ordinary skill in the art. Preferred examples of hydrophilic materials include cellulosic materials (e.g. cotton, cellulose acetate), wool, silk, nylon and acrylic.

The term "hydrophobic textile fiber" is meant to refer to any textile fiber comprising a hydrophobic material. More particularly, it is meant to refer to hydrophobic polymers that are suitable for use in textile substrates such as yarns, fibers, fabrics, or other textile substrate as would be appreciated by one having ordinary skill in the art. Preferred examples of hydrophobic polymers include linear aromatic polyesters made from terephathalic acid and glycols; from polycarbonates; and/or from fibers based on polyvinyl chloride, polypropylene or polyamide. A most preferred example comprises 150 denier/34 filament type 56 trilobal texturized yarn (polyester fibers) such as that sold under the registered trademark DACRON® Type 54,64 (filaments) and 107W (spun/staple)(E.I. Du Pont De Nemours and Co.). Glass transition temperatures of preferred hydrophobic polymers, such as the listed polyesters, typically fall over a range of about 55°C to about 65°C in SCF-CO_2.

The term "sparingly soluble", when used in referring to a solute, means that the solute is not readily dissolved in a particular solvent at the temperature and pressure of the solvent. Thus, the solute tends to fail to dissolve in the solvent, or alternatively, to precipitate from the solvent, when the solute is "sparingly soluble" in the solvent at a particular temperature and pressure.

The term "crocking", when used to describe a dyed article, means that the dye exhibits a transfer from dyed material to other surfaces when rubbed or contacted by the other surfaces.

Following long-standing patent law convention, the terms "a" and "an" mean "one or more" when used in this application, including the claims.

II. Representative Textile Treatment Systems

Any machine that has a suitable mechanical configuration can be used in the practice of the process of the present invention. For instance, in each of the Examples presented below, a package dyeing SCF-CO_2 system was employed. A representative embodiment of such a system is disclosed in U.S. Patent No. 6,048,369, issued April 11, 2000 to Smith, et al., herein incorporated by reference in its entirety. Other representative systems are disclosed in U.S. Patent Nos. 5,298,032; 5,518,088; and 6,010,542; and the contents of each of these patents are incorporated herein by reference in their entirety.

Referring now to Figs. 1A, 1B and 2, a system suitable for use in the practice of the process of the present invention is referred to generally as **10**. In the following detailed description, the parts of system **10** that are primarily involved in the process of the present invention are described. Additionally, a legend describing other parts of system **10** is provided in Table 2 below. For convenience, system **10** is referred to as an SCF-CO_2 dyeing system; however, system **10** can be adapted for use with any treatment material and any treatment bath.

TABLE 2

LEGEND FOR Figs. 1A, 1B AND 2

Item No.	Name
10	Supercritical CO_2 Treatment System
12	CO_2 Supply Cylinder
14	Line Section
16	Pressure Regulating Valve

18	Pressure Indicator
20	Pressure Alarm
22	Pressure Relief Valve
24	Needle Valve
26	Condenser (Shell-in-Tube Heat Exchanger)
28	Chiller
30	Turbine Flow Meter
32	Temperature Element (Indicator)
34	System Pressurization Pump (Positive Displacement)
36	Pressure Control Valve
38	Static Mixer
40	Electric Preheater
42	Temperature Alarm
44	Over-Temperature Switch
46	Needle Valve
50	Co-Solvent Pump (Positive Displacement)
52	Needle Valve
54	Needle Valve
56	Check Valve
58	Rupture Disk
60	Temperature Element (Indicator)
62	Temperature Controller
64	Needle Valve
66	Needle Valve
68	Check Valve
70	Dye-Add Vessel
71	Dye-Add Vessel Jacket
72	Temperature Element (Indicator)
74	Temperature Alarm
76	Temperature Controller
78	Control Valve (Temperature-Controlled)
80	Control Valve (Temperature-Controlled)

82	Control Valve (Temperature-Controlled)
84	Control Valve (Temperature-Controlled)
86	Rupture Disk
88	Pressure Indicator
90	Pressure Alarm
91	Line Section
92	Ball Valve (2-Way)
93	Ball Valve
94	Ball Valve (2-Way)
96	Sight Glass
98	Circulation Pump (Centrifugal)
100	Rupture Disk
102	Ball Valve (2-Way)
104	Ball Valve (2-Way)
106	Dyeing Vessel
107	Dyeing Vessel Jacket
108	Line Section
109	Needle Valve
110	Pressure Indicator
114	Ball Valve (2-Way)
116	Ball Valve (2-Way)
118	Coriolis Flow Meter
120	Ball Valve (3-Way)
122	Temperature Element (Indicator)
124	Temperature Alarm
126	Temperature Controller
128	Pressure Indicator
130	Pressure Alarm
132	Control Valve (Temperature-Controlled)
134	Control Valve (Temperature-Controlled)
136	Control Valve (Temperature-Controlled)
138	Control Valve (Temperature-Controlled)

140	Rupture Disk
142	Needle Valve
144	Needle Valve
146	Line Section
148	Needle Valve
150	Temperature Element (Indicator)
152	Needle Valve
154	Pressure Control Valve
156	Separator Vessel
158	Pressure Indicator
160	Pressure Alarm
162	Temperature Element (Indicator)
164	Rupture Disk
166	Pressure Control Valve
168	Needle Valve
170	Needle Valve
172	Filter
174	Filter
176	Pressure Relief Valve
178	Check Valve
180	Line Section
182	Check Valve
184	Line Section

Referring particularly to Figures 1A, 1B and 2, operation and control of the SCF-CO_2 dyeing system **10** optionally encompasses three distinct equipment subsystems. The subsystems include filling and pressurization subsystem **A**, dyeing subsystem **B**, and venting subsystem **C**. Carbon dioxide is introduced into system **10** via CO_2 supply cylinder **12**. Preferably, supply cylinder **12** contains liquid carbon dioxide. Thus, liquid CO_2 enters the filling and pressurization subsystem **A** from the supply cylinder **12** through line section **14** and regulating valve **16** and is cooled in condenser **26** by a water/glycol solution supplied by chiller **28**. The CO_2 is cooled to assure that it remains in a liquid state and at a pressure sufficiently low to prevent cavitation of system pressurization pump **34**.

Continuing with Figures 1A, 1B and 2, turbine flow meter **30** measures the amount of liquid CO_2 charged to dyeing system **10**. Pump **34** increases the pressure of the liquid CO_2 to a value above the critical pressure of CO_2 but less than the operating pressure for the dyeing system, typically ranging from about 1000 psig to greater that about 4000 psig, depending of the particular textile substrate being dyed or otherwise treated. A side-stream of water/glycol solution from chiller **28** provides cooling for pump **34**. Control valve **36** allows pump **34** to run continuously by opening to bypass liquid CO_2 back to the suction side of pump **34** once the system pressure set point has been reached. This valve closes if the system pressure falls below the set point that causes additional liquid CO_2 to enter the dyeing subsystem **B**. Optionally, the transport material can be injected into the liquid CO_2 stream by pump **50** at the discharge of pump **34** and mixed in by static mixer **38**.

Continuing with Figs. 1 and 2, liquid CO_2 leaving mixer **38** enters electrical pre-heater **40** where its temperature is increased. Heated and pressurized CO_2 can enter the dyeing subsystem **B** through needle valve **66** and into dye-add vessel **70**; through needle valve **64** and into dyeing vessel **106**; or through both of these paths. Typically, dyeing subsystem **B** is filled and pressurized simultaneously through both the dye-add and dyeing vessels **70** and **106**, respectively.

Once a sufficient quantity of liquid CO_2 has been charged to dyeing subsystem B to achieve the operating density, typically a value in the range of 0 to about 0.75 g/cm^3, preferably about 0.2 to about 0.7 g/cm^3, more preferably to about 0.25 to 0.50 g/cm^3, circulation pump **98** is activated. Optionally, system **10** is configured so that circulation pump **98** first drives the flow of liquid CO_2 through the dyeing vessel **106**, which contains a textile substrate that has been wetted out with transport material. Contacting of the liquid CO_2 flow with the textile substrate that has been wetted out with transport material entrains the transport material into the liquid CO_2 flow.

Once circulation is started, heating of subsystem **B** is initiated by opening control valves **78** and **84** to supply steam to and remove condensate, respectively, from the heating/cooling jacket **71** on dye-add vessel **70**. Similarly, control valves **132** and **136** are opened to supply steam to and remove condensate from, respectively, the heating/cooling jacket **107** on dyeing vessel **106**. Commercial practice would utilize a heat exchanger in the circulation loop to provide for heating of the CO_2 rather than relying on heating through the vessel jackets **71** and **107**. Heating is continued until the system passes the critical temperature of CO_2 and reaches the operating, or dyeing, temperature, typically ranging from about ambient (e.g., 22°C - 25°C) to about 130°C, preferably ranging from about 25°C to about 100°C, more preferably ranging from about 40°C to about 95°C.

Continuing with Figures 1A, 1B and 2, SCF-CO_2 leaving circulation pump **98** passes through sight glass **96** and is diverted, by closing ball valve **94** and opening ball valve **93**, through dye-add vessel **70** where dye is dissolved and/or suspended in the transport material. Transport material-laden SCF-CO_2 passes out of the dye-add vessel **70** through ball valve **92** and flow meter **118** to ball valve **120**. Ball valve **120** is a three-way valve that diverts the SCF-CO_2 flow to the inside or outside of the package loaded in dyeing vessel **106** depending on the direction in which it is set. If ball valve **120** is set to divert flow in the direction of ball valve **104**, and ball valve **104** is open and ball valve **102** is closed, then all of the SCF-CO_2 flow proceeds to the inside of the dye spindle (not shown in Figs. 1A, 1B and 2). The flow continues from the inside to the outside of the dye spindle, from the inside to the outside of the dye tube (not shown in Figs. 1A, 1B and 2) on which the textile yarn package is wound and out through the textile yarn package to the interior of dyeing vessel **106**. The SCF-CO_2 flow passes out of dyeing vessel **106**, through open ball valves **114** and **116** to the suction of pump **98**, completing a circuit for inside-to-outside dyeing of the yarn package.

If ball valve **120** is set to divert flow in the direction of ball valve **114**, and ball valve **114** is open and ball valve **116** is closed, then all of the SCF-CO_2 flow proceeds to the interior of dyeing vessel **106** and the outside of the textile yarn package. The flow passes through the textile yarn package, continues from the outside to the inside of the dye tube on which the yarn is wound and then passes from the outside to the inside of the dye spindle. The SCF-CO_2 flow exits the interior of the dye spindle and passes through open ball valves **104** and **102** to the suction of pump **98**, which completes a circuit for outside-to-inside dyeing of the textile yarn package.

The SCF-CO_2 flow having treatment material-laden transport material entrained therein is held at values ranging from values of 1 gallon per minute (GPM)/lb of textile or less, to values greater than 15 GPM/lb of textile. The treatment bath flow is periodically switched between the inside-to-outside(I-O) circuit and the outside-to-inside (O-I) circuit to promote uniformity of dyeing of the textile yarn; e.g., 6 min./2 min. I-O/O-I, 6 min./4 min. I-O/O-I, 5 min./5 min. I-O/O-I, etc. This dyeing process is continued with system **10** held at the dyeing temperature, usually about ambient temperature to about 130°C, and preferably about 40°C to 95°C, until the treatment material in the transport material is exhausted onto the textile substrate to produce an even distribution, typically around 30 minutes.

Continuing with reference to Fig. 1A, 1B and 2, venting is initiated by opening needle valve **109** to provide a flow path from the dyeing vessel **106** to control valve **154**. Control valve **154** is opened to set the pressure in dyeing subsystem **B** and control valve **166** is opened to set the pressure in separator vessel **156**. By adjusting control valves **154** and **166** appropriately, the pressure in the dyeing vessel **106** is reduced at a controlled rate. Dye-add vessel **70** is isolated during venting to prevent any additional dye remaining in dye-add vessel **70** from going into solution in the transport material that is entrained in the SCF-CO_2. Isolation of dye-add vessel **70** is accomplished by closing ball valves **92** and **93** while opening ball valve **94** to maintain a circulation loop for the dyeing vessel.

During venting SCF-CO_2 flows from dyeing subsystem **B** through control valve **154** and into separator vessel **156** of venting subsystem **C**. In separator vessel **156** the pressure is sufficiently low so that the CO_2 is in the gaseous phase and any contaminants, and the treatment material solids collect in separator vessel **156** and gaseous CO_2 exits through control valve **166**. Once the gaseous CO_2 passes through control valve **156** it can be vented to atmosphere by opening needle valve **168**. The gaseous CO_2 can also be recycled to filling and pressurization subsystem A by keeping needle valve **168** closed so that the gaseous CO_2 passes through filters **172** and **174**. Filters **172** and **174** collect any minute amounts of solids that can have escaped separator vessel **156** with the gaseous CO_2 flow. The gaseous CO_2 exiting filters **172** and **174** passes through check valve **178** and enters filling and pressurization subsystem **A** for re-use in system **10**.

Referring now to Fig. 3, an alternative system **10'** for use in the SCF-CO_2 dyeing process of the present invention is depicted schematically. Generally, however, system **10'** works in a similar manner as system **10** described above and as depicted in Figs. 1 and 2. System **10'** includes a CO_2 cylinder **12'**, from which CO_2 flows through check valve **16'** to a cooling unit **26'**. CO_2 is cooled and pressurized within cooler **26'** and then is pumped, using positive displacement pump **34'**, into dye injection vessel **70'**. Prior to introduction of CO_2 into vessel **70'**, a dyestuff is placed within vessel **70'**. In dye injection vessel **70'**, the treatment material, i.e., the dyestuff, is dissolved and/or suspended into the transport material, which is preferably water or an aqueous solution. Thus, when CO_2 is introduced into vessel **70'** the dye-laden transport material is entrained within the SCF-CO_2 flow.

Continuing with Fig. 3, the action of pump **34'** drives the SCF-CO_2 that has dye-laden transport material entrained therein out of dye injection vessel **70'** through a hand valve **64'** and a check valve **182'** into a dyeing vessel **106'** that contains the textile substrate to be dyed. Dyeing vessel **106'** is pressurized and heated to SCF dyeing conditions prior to the introduction of the SCF-CO_2 that has dye-laden transport material entrained therein. Steam and/or cooling water are introduced to jacket **107'** of dyeing vessel

106' via valves **132'** and **134'**, respectively. Thus, appropriate temperatures for dyeing are achieved in vessel **106'**. During and after dyeing, any condensate resulting from the introduction of steam through valve **132'** is exported through vent **136'** and any water introduced via valve **134'** is exported through drain **138'**.

Continuing with Fig. 3, during dyeing, the SCF-CO_2 flow that has dye-laden transport material entrained therein is circulated into and out of vessel **106'** via circulation pump **98'**, valves **104'** and **114'**, and 3-way valve **120'** in a manner analogous to that described above for system **10**, valves **104** and **114**, and 3-way valve **120**. Flow meter **118'** is placed in system **10'** between circulation pump **98'** and 3-way valve **120'** so that the flow rate of SCF-CO_2 can be monitored. Dyeing is thus facilitated by the circulation subsystem. Further, the action of circulation pump **98'** maintains system flow during the treatment process.

Continuing with particular reference to Fig. 3, after a predetermined time, preferably when substantially exhaustion of the treatment material in the transport material onto the textile substrate is observed, SCF-CO_2 is removed from dyeing vessel 106' and flows through back pressure regulator **154'**. At this point, the pressure of the process is reduced and CO_2 within the system is introduced into separator vessel **156'**. Any contaminants, likely a small amount, are removed from the CO_2 in separator vessel **156'**. CO_2 then can be vented through vent **170'**. Alternatively, CO_2 can be recycled back into system **10'** via check valve **178'**.

Referring now to Fig. 4, another alternative embodiment of a suitable system for use in the process of the instant invention is described. System **10"** includes CO_2 cylinder **12"**. CO_2 flows from cylinder **12"** through check valve **16"** into subcooler **26"**. The temperature of the CO_2 is reduced within subcooler **26"** to assure that is remains in a liquid state and at a pressure sufficiently low to prevent cavitation of positive displacement pump **34"**. The positive displacement pump **34"** then drives the CO_2 through hand valve **64"**, then through a check valve **182"**, into dyeing vessel **106"**. Dyeing vessel **106"** includes the textile fibers to be dyed. In dye injection vessel **70'**, the treatment material, i.e., the dyestuff, is dissolved and/or suspended into the transport material, which is preferably water or an aqueous solution.

Continuing with particular reference to Fig. 4, dyeing vessel **106"** is pressurized and heated to produce CO_2 at SCF temperature and pressure. SCF-CO_2 is then exported from vessel **106"** using circulation pump **98"** and valves **104"** and **114"** in a manner analogous to that described above for system **10** and valves **104** and **114**. SCF-CO_2 is introduced via valve **92"** into a dye injection vessel **70"** containing a suitable dye. The dye is dissolved and/or suspended in the transport material in dye injection vessel **70"**, and the transport material is entrained in the SCF-CO_2 in dye injection vessel **70"**. Circulation pump **98"** drives the SCF-CO_2 that has the dye-laden transport material entrained therein from vessel **70"** through flow meter **118"** and 3-way valve **120"** back into dyeing vessel **106"** wherein dyeing of the textile fibers is accomplished. During dyeing, steam and/or cooling water are introduced to jacket **107"** of dyeing vessel **106"** via valves **132"** and **134"**, respectively. Thus, appropriate temperatures for dye dissolution and dyeing are achieved in vessel **106"**. During and after dyeing, any condensate resulting from the introduction of steam through valve **132"** is exported through vent **136"** and any water introduced via valve **134"** is exported through drain **138"**.

Continuing with Fig. 4, after a predetermined time, preferably when substantially complete exhaustion of the treatment material in the transport material onto the textile substrate is observed, the SCF-CO_2 dye bath is removed from vessel **106"** to back pressure regulator **154"**. The pressure of the process is then reduced using regulator **154"** and the resulting CO_2 phase is then introduced into separator vessel **156"**. In separator vessel **156"** the pressure is further reduced so that any contaminants, likely a small amount, are deposited within separator vessel **156"** and the resulting contaminant-free CO_2 gas is removed from separator vessel **156"**. Particularly, the contaminant-free CO_2 gas can be vented using vent **170"** or can be recycled back into system **10"** via check valve **178"**. An aspect of the efficiency of the process of this invention is thus demonstrated.

The present invention also provides a treatment material introduction system to facilitate introduction of a textile treatment material, such as a dye, into a textile treatment process. Preferably, the treatment material is dissolved, dispersed and/or suspended in the transport material when it contacts the treatment bath used in the treatment process.

Referring again to the drawings, a representative embodiment of a textile treatment material introduction system of the present invention is generally designated **200** in Figure 5. Referring to Figure 5, system **200** introduces textile treatment materials dissolved and/or suspended in transport material into a textile treatment system **220**, which preferably comprises a SCF-CO_2 textile treatment system such as that described in detail above. System **200** comprises dye-add or preparation vessel **202**, positive-displacement metering pump **204**, line section **206**, control valves **210** and **214**, and return line **218**. Treatment system **220** comprises a treatment vessel **222**, a circulation loop **224** and a circulation pump **226**.

Continuing with reference to Figure 5, a textile treatment material is placed in preparation vessel **202**, which is equipped with a stirring device **228** capable of thoroughly mixing the contents of vessel **202**. Stirring device **228** comprises a motor-driven fan, but can also comprise a motor-driven shaft, a rotatably mounted shaft, or any other suitable stirring device as would be apparent to one of ordinary skill in the art after reviewing the disclosure of the present invention. Other stirring devices include a fan, propeller or paddle that is magnetically coupled to a motor rather than coupled to the motor by a solid shaft. Such devices, and equivalents thereof, thus comprise “stirring means” and “mixing means” as used herein and in the claims.

Continuing with reference to Figure 5, in operation the preparation vessel **202** of system **200** is charged with transport material and treatment material and sealed. The amount of transport material initially charged depends on the transport material concentration desired at the introduction conditions. If a surfactant or dispersing agent, each of which is also soluble in the transport material is to be used, it is charged along with the textile treatment material, or introduced with a metering pump (not shown in Figure 5) into the preparation vessel **202** at some point in the textile treatment material preparation process. The contents of the preparation vessel **202** are then heated with mixing to the introduction conditions, which can optionally, but are not required to, encompass a pressure that is near the textile treatment system pressure.

Introduction system **200**, and particularly preparation vessel **202**, can be isolated from treatment system **220** when the solution or suspension of textile treatment material is prepared in the transport material. Control valves **210** and **214** are used to isolate preparation vessel **202** and thus can be opened and closed for reversibly isolating preparation vessel **202**. Any other suitable structure, such as other valves, piping or couplings, as would be apparent to one of ordinary skill in the art after reviewing the disclosure of the present invention can also be used to isolate, preferably to reversibly isolate, preparation vessel **202**. Such devices and structures, and equivalents thereof, thus comprise "isolation means" as used herein and in the claims.

During introduction of treatment material laden transport material, introduction system **200** can be operated in several different modes. In one mode, introduction is accomplished with closed valve **214** so that only treatment material laden transport material is introduced into the treatment system through open valve **210**. That is, vessel **202** is emptied of treatment material laden transport material without any other type of communication with the treatment system. In a second mode, treatment material laden transport material is mixed with SCF-CO_2 in vessel **202**. In this case, a mixture of SCF-CO_2 and treatment material laden transport material is prepared for introduction into the treatment system. Introduction of this mixture can be with valve **214** closed or open. If valve **214** is closed during the introduction process, vessel **202** is emptied of the mixture of SCF-CO_2 and treatment material laden transport material through open valve **210**, without any other type of communication with the treatment system. If valve **214** is open during the introduction process, vessel **202** is replenished with a mixture of SCF-CO_2 and transport material while a mixture of SCF-CO_2 and treatment material laden transport material is introduced into the treatment system through open valve **210**. This last operating mode might be used in the case that the amount of transport material is insufficient to instantaneously dissolve all of the treatment material resident in vessel **202**. In this case, the stream of SCF-CO_2 entering vessel **202** through open valve **214** would contain transport material exhausted of treatment material and, thereby, ready to dissolve or suspend more treatment material.

Continuing with reference to Figure 5, positive-displacement metering pump **204** introduces the textile treatment material-laden transport material (or mixture of SCF-CO_2 and treatment material-laden transport material) into the circulation loop **224** of treatment system **220** using an introducing rate profile that is consistent with producing uniformly-treated textile substrates in minimum processing time. In a preferred embodiment, pump **204** shown in Figure 5 comprises a positive displacement pump with a reciprocating piston. Other representative pumps include a syringe type pump employing a mechanical piston and a syringe type pump employing an inert fluid as a piston. Thus, devices such as pumps, nozzles, injectors, combinations thereof, and other devices as would be apparent to one of ordinary skill in the art after reviewing the disclosure of the present invention, and equivalents thereof, comprise "introducing means" as used herein and in the claims.

Mixing of the preparation vessel **202** is continued throughout the introduction cycle via mechanical stirring with stirring device **228**. Introducing of the textile treatment material-laden transport material (or mixture of SCF-CO_2 and treatment material-laden transport material) occurs at an introduction point **230** in the circulation loop **224** where fluid shear is very high. It is also preferred that introduction point **230** lie relatively near the dyeing/treatment vessel in order to avoid possible recombination of the droplets of the transport material before interaction with the textile substrate; this point could be before or after circulation pump **224** as long as pump **224** is sufficiently close to the dyeing/treatment vessel to avoid droplet recombination. For example, point **230** can lie before or after circulation pump **224** or in a mixing zone that contains static mixing elements (not shown in Figure 5) in order to facilitate mixing with the treatment medium (e.g. SCF-CO_2) flowing in circulation loop **224** of treatment system **220**. The term "high fluid shear" refers to a turbulent flow or a flow with high rate of momentum transfer. Preferably, the term "high fluid shear" refers to a flow having a Reynolds number greater than 2300, and more preferably, greater than 5000.

Referring now to Figure 6, an alternative embodiment of the textile treatment material introduction system **200** shown in Figure 5 is disclosed and generally designated **300**. In alternative embodiment **300**, treatment materials are introduced in transport material into textile treatment system **302**, which preferably comprises a SCF-CO_2 textile treatment system as described hereinabove. System **302** comprises dye-add or preparation vessel **304**, positive-displacement metering pump **306**, line section **308**, control valves **314** and **316**, and return line **320**. Treatment system **302** comprises a treatment vessel **322**, a circulation loop **324** and a circulation pump **326**.

Textile treatment material is placed in the preparation vessel **304** of system **300**. Preparation vessel **304** is equipped with a mixing loop **328** as shown in Figure 3. Thus, mixing of the preparation vessel **304** is continued throughout the introducing cycle via fluid circulation (demonstrated by arrows in Figure 3) by circulation pump **330** through mixing loop **328**. Such devices and structures, and equivalents thereof, thus comprise "circulation means" and "mixing means" as used herein and in the claims. Other aspects of alternative embodiment **300** function as described above, including the introduction of treatment material at high fluid shear introduction point **332**.

Referring now to Figure 7, yet another embodiment of a textile treatment system for use in a process of the present invention is generally referenced at **400**. System **400** comprises a treatment material preparation subsystem **402** and a dyeing/treatment subsystem **404**. Preparation subsystem **402** further comprises an injection pump **406**; a preparation vessel **410** with a mixer **414**; line sections **408** and **416**; and an atomizing nozzle **420**. Dyeing/treatment subsystem **404** further comprises a bath preparation vessel **422**; a treatment vessel **426**; line sections **428**, **432**, **438**, **440** and **446**; centrifugal separator **430**; and circulation pump **436**.

Continuing with Fig. 7, a transport material is introduced into treatment material preparation subsystem **402** via injection pump **406**. The transport material travels through line section **408** to treatment material preparation vessel **410**, where a treatment material **412** is dissolved, dispersed and/or suspended in the transport material. The dissolving, dispersing and/or suspending of treatment material **412** is facilitated by the action of mixer **414**. Treatment material-laden transport material **418** then travels through line section **416** to atomizing nozzle **420**. The treatment material-laden transport material **418** coming from preparation vessel **410** is added in the form of suitably small droplets to bath preparation vessel **422** via atomizing nozzle **420** and the action of injection pump **406**.

Continuing with Fig. 7, a dyeing/treatment bath **424** is prepared by passing bath fluid (flow represented by arrow **448**) through bath preparation vessel **420**. Dyeing/treatment bath **424** then passes on to dyeing/treatment vessel **426**, which holds the textile substrate to be dyed or treated. After exiting dyeing/treatment vessel **426**, dyeing/treatment bath **424** passes into a centrifugal separator **430** via line section **428**. In centrifugal separator **430**, the transport material is separated from the bath fluid by centrifugation, as indicated by arrows **442**. As indicated by flow arrows **434**, bath fluid that is substantially free of transport material leaves centrifugal separator **430** via line section **432** and is circulated by circulation pump **436** through line section **438** back to preparation vessel **422**. Indeed, circulation pump **436** drives the flow of bath fluid and transport material for the dyeing/treatment process as a whole. As indicated by flow arrow **444**, the transport material is returned to injection pump **406** via line section **446** and subsequently is reintroduced into vessel **410**. As described above, the treatment material-laden transport material (represented by flow arrow **418**) coming from preparation vessel **410** is added in the form of suitably small droplets to bath preparation vessel **422** via atomizing nozzle **420** and the action of injection pump **406**. In this way, a continuous flow of properly prepared dyeing/treatment bath **424** is provided to dyeing/treatment vessel **426** and to the dyeing process as a whole.

In the system embodiment presented in Fig. 7, bath preparation vessel **422** is integrated within dyeing/treatment subsystem **404**. In order to faciliate uniform dyeing or treatment of the textile substrate, the droplet size for the entrained transport material is preferably very small, on the order a few microns or less. A very small droplet size provides intimate, vigorous contact of the transport material containing the dye or treatment chemical with the textile substrate. This process parameter plays a large role in applications where the dyeing/treatment bath must pass through the micron size pore spaces between individual yarns and fibers; e.g., in the dyeing or treatment of yarn packages.

In the system embodiment presented in Fig. 7, atomizing nozzle **420** produces small droplets of dye-laden or treatment material-laden transport material, but other techniques and devices for accomplishing this operation are also provided in accordance with the present invention. For example, a sub-stream of "clean" bath fluid can be removed from the main stream of this fluid before it enters bath preparation vessel **422**. The substream is then reintroduced along with dye-laden or treatment material-laden transport material into bath preparation vessel **422** using a mixing nozzle. That is, bath fluid and dye-laden or treatment material-laden transport material are atomized together into the main bath flow using a mixing nozzle.

In another approach, atomizing nozzle **420** is replaced by a sparging device with numerous, very small sparging holes; e.g., the sparging media can be sintered metal with micron sized pores. In this case, the dye-laden or treatment material-laden transport material is forced through the sparging device, thereby creating small droplets of dye-laden or treatment material-laden transport material that mix with the bath fluid. In yet another approach, the transport material and bath fluid are mixed together in bath preparation vessel **422** using vigorous agitation, such as that generated by a high-speed stirrer or high-speed flow through turbulence-producing devices such as baffles. The examples discussed here are meant to be illustrative only, and not limiting. Indeed, any device that introduces very small droplets into the inert, non-aqueous bath fluid can be utilized.

In the system embodiment presented in Fig. 7, it is preferred that dyeing/treatment vessel **426** has a design that is particular to the textile fiber being processed as well as to the form of the textile substrate. For example, equipment that is used in treating natural fibers such as cotton, silk and wool generally varies from that used to treat synthetic fibers such as polyester and nylon. Systems to dye or treat yarn, fabric or garments can also vary, and in some cases, can be substantially different. Examples of such differences include, but are not limited to, multiple ports into dyeing/treatment vessel **426** for dyeing/treatment bath entry, mechanical movement of the textile substrate being treated, and/or a piping and valve system capable of accomplishing flow reversal. In each case, uniform contact of dyeing/treatment bath **424** with the textile substrate is provided.

Continuing with Fig. 7, as dyeing/treatment bath **424** passes through and exits dyeing/treatment vessel **426** droplets of transport material suspended in the bath fluid could interact to form larger droplets. Eventually the droplet size could be too large to assure rapid and uniform dying/treatment of the textile substrate. For this reason, it is preferred for some textile substrates that the transport material is separated from the bath fluid and reintroduced into bath preparation vessel **422** in fine droplet form, as discussed above.

In the system embodiment presented in Fig. 7, centrifugal separator **430** removes the transport material from the fluid, but other techniques and devices for accomplishing this operation are provided in accordance with the present invention. For example, a settling chamber can be employed. This device is a large tank in which the fluid velocity slows sufficiently to allow entrained transport material to settle by gravity. Since the density of the transport material might be 2-3 times that of the bath fluid, such a device can provide the desired separation. The efficiency of a settling chamber would likely be improved by adding baffles or other solid surfaces to further slow the flow of the transport material and cause agglomeration, so that separation by gravity is enhanced.

Another potential separation method is filtration. Because the viscosity of the transport material is likely much greater than that of the bath fluid, the bath fluid will be expected to pass through the filter while the transport material collects on the upstream side. In this case, the "clean" bath fluid from downstream of the filter is sent to bath preparation vessel **422**, while the transport material from upstream of the filter is siphoned off for reintroduction in bath preparation vessel **422**. The examples discussed here are meant to be illustrative only, and not to be limiting. Any device that can efficiently separate the transport material from the bath fluid can be utilized.

In the system embodiment presented in Fig. 7, the transport material can be initially introduced into treatment material preparation subsystem **402** by a variety of techniques and devices. For example, since the textile substrate is preferably initially wetted-out with the transport material, the substrate can be provided with enough excess of transport material to meet the droplet entrainment needs. Alternatively, the amount of transport material needed for proper droplet entrainment can be introduced along with treatment material **412** into treatment material preparation vessel **410**. In yet another alternative, the transport material is injected into dyeing/treatment bath **424** at some convenient point in the process with respect to both time and location. The examples discussed here are meant to be illustrative only, and non-limiting, Thus, any device that efficiently dissolves, disperses or suspends a dye or another treatment material in a suitable amount of transport material can be utilized.

Once dyeing/treatment is complete, partial or complete removal of excess transport material from the textile substrate can optionally be accomplished by continuing the dyeing/treatment bath flow while ceasing reintroduction of the transport material. This process step allows a "clean" bath flow to "strip" excess transport material from the textile substrate to thereby "dry" the textile substrate. Increasing the temperature of the bath can serve to improve the speed and efficiency of the drying step. In the case that this step is not sufficient for complete removal of excess transport material, it can be augmented by conventional mechanical and/or thermal methods either within the dyeing/treatment vessel or in another piece of process equipment. That is, drying of the textile substrate can be performed via centrifuging, vacuum extraction, dielectric heating or convection heating either in situ or in external equipment. The dyeing/treatment process is completed by depressurizing the dyeing/treatment system to a recovery system where a separator removes any trace contaminants from the CO_2 before sending it to storage.

III. Laboratory Examples

The following Laboratory Examples have been included to illustrate preferred modes of the invention. Certain aspects of the following Laboratory Examples are described in terms of techniques and procedures found or contemplated by the present inventors to work well in the practice of the invention. These Laboratory Examples are exemplified through the use of standard laboratory practices of the inventors. In light of the present disclosure and the general level of skill in the art, those of skill will appreciate that the following Laboratory Examples are intended to be exemplary only and that numerous changes, modifications and alterations can be employed without departing from the spirit and scope of the invention.

To summarize, the Laboratory Examples indicate that acid dyes on nylon; basic dyes on acrylic; direct dyes on cotton, Arnel, silk, viscose rayon; disperse dyes on polyester; finishes on any substrate (softener, antistatic, lubricants, etc); preparation (scouring, bleaching chemistry); and disperse/direct dye combinations on polyester/cotton blends and other blends like nylon/cotton (popular in knit underwear fabrics) can be employed in the process of the present invention.

In each of the following Laboratory Examples, a package dyeing SCF-CO_2 system was employed. A representative embodiment of such a system is disclosed in U. S. Patent No. 6,048,369, issued April 11, 2000 to Smith, et al., herein incorporated by reference in its entirety. Other representative systems are disclosed in U.S. Patent Nos. 5,298,032; 5,518,088; and 6,010,542; and the contents of each of these patents are incorporated herein by reference in their entirety. In each of the following Laboratory Examples, CO_2 density was about 0.6 g/mL, flow was about 7 gallons bath fluid/lb substrate/minute; and temperature was about 80-100°C (usually 90°C). Pressure ranged from about 1,500 to about 5,000 psi, and preferably ranged from about 3,000 to about 4,000 psi. Thus, pressure can vary and can be optionally lowered.

Laboratory Example 1

Dyeing of Cotton

Yarn:	Cotton(not prepared, unfinished)
Package Density:	0.5 g/cc (approx.)
Dye:	C.I. Direct Blue 78
Weight of Yarn:	450 g (approx.)
Weight of Dye:	10 g
% o.w.g.:	2.2 %

Nominal Dyeing Conditions:

CO_2 Density: 0.6 g/cc

Temperature: 40 - 83°C

Volume Flow Rate: 7 gallons per minute (gpm)

Unit Volume Flow Rate: 7 gal/min-lb

Flow Reversal: 5 min Inside-to-outside (I-O) Flow
5 min Outside-to-inside (O-I) Flow

Dyeing Procedure: Wet out yarn package thoroughly; load package and dye into SCF-CO_2 dyeing machine; fill machine to CO_2 density of about 0.6 g/cc at ambient temperature; circulate at about 7 gpm volume flow rate with 5 min./5 min. I-O/O-I flow reversal pattern; heat to 80°C; circulate at 80°C for 30 minutes; depressurize.

Results: A dark blue colorfast dyeing was obtained; a stocking was knitted from the dyed yarn and evaluated for shade depth and crocking; the stocking had a color matching Munsell designation 2.5 PB 2/6; a dry crocking of grade 4-5 and a wet crocking of grade 3-4 were obtained for the stocking (AATCC Standard Test Method #8); the tensile strength and elongation of the dyed yarn were measured by the Single Strand Method (ASTM D2256-97) and found to be comparable to values for a sample of undyed yarn, i.e. undyed: T.S. = 68 g, % Elongation = 3.93; dyed: T.S. = 553 g, % Elongation = 4.69.

The observed data fell within normal parameters for this dye on unprepared, "unfinished" cotton (unfinished means that the cotton had not yet received any resin treatment for shrinkage control, etc.). The approach of this Example is equally applicable to "prepared" cotton that has been scoured and/or bleached.

Laboratory Example 2

Dyeing of Wool

Package:	Cotton (served to hold fabric for dying)
Fabric:	Worsted Wool (woven, natural state; unscoured, unbleached)
Dye:	C.I. Acid Red 360
Weight of Fabric:	40 g (est.)
Weight of Dye:	2 g
% o.w.g.:	5 %

Nominal Dyeing Conditions:

CO2 Density: 0.7 g/cc

Temperature: 75°C

Volume Flow Rate: 7 gpm

Flow Reversal: Outside-to-inside (O-I) flow over entire cycle

Dyeing Procedure: Wet out yarn package; wet wool fabric swatches; wrap and secure fabric swatches to outside of yarn package; load dye and package with swatches into SCF-CO_2 dyeing machine; fill machine to CO_2 density of about 0.7 g/cc at ambient temperature; circulate O-I at about 7 gpm volume flow rate and heat to 80°C; circulate at 80°C for 30 minutes; depressurize.

Results: A dark red colorfast dyeing was obtained; the dyed fabric was evaluated for shade depth and crocking; the fabric had a color matching Munsell designation 2.5 R 2/8; wet and dry crocking were both of grade 4 determined by AATCC Standard Test Method #8; the breaking strength and elongation of the dyed fabric were measured (Fabric Grab/Strip Test, ASTM D5034/5035) and compared to values determined for a sample of undyed fabric; the results are shown in Table 3 below.

Table 3

Fabric	Direction	Breaking Strength (g)	Elongation (%)
Undyed Wool	warp	33.8	18.6
Dyed Wool	warp	34.7	22.3
Undyed Wool	fill	17.0	11.7
Dyed Wool	fill	16.4	19.3

All of the above results are considered normal for the noted dye on wool in its natural state.

In the wool dyeings, two runs were performed, one with and one without surfactant to help the wetting. This is an optional step, and it appeared to contribute to levelness. The approach of this Example is equally applicable to "prepared" wool that has been scoured and/or bleached.

Laboratory Example 3

Dyeing of Nylon

Package: Polyester (serves to hold fabric for dying)

Fabric: Nylon 6,6 (woven)

Dye: C.I. Acid Red 360

Weight of Fabric: 40 g (est.)

Weight of Dye: 2 g

% o.w.g.: 5 %

Nominal Dyeing Conditions:

CO2 Density: 0.65 g/cc

Temperature: 100°C

Volume Flow Rate: 7 gpm

Flow Reversal: Outside-to-inside (O-I) flow over entire cycle

Dyeing Procedure: Wet out polyester yarn package thoroughly; wet nylon fabric swatches; wrap and secure swatches to outside of yarn package; load dye and package with swatches into SCF-CO_2 dyeing machine; fill machine to CO_2 density of about 0.65 g/cc at ambient temperature; circulate O-I at maximum volume flow rate and heat to 100°C; circulate 30 minutes; depressurize.

Results: A dark red colorfast dyeing was obtained; the dyed fabric was evaluated for shade depth and crocking; the stocking had a color matching Munsell designation 5 R 2/8; wet and dry crocking were both of grade 4 determined by AATCC Standard Test Method #8; the breaking strength and elongation of the dyed fabric were measured (Fabric Grab/Strip Test, ASTM D5034/5035) and compared to values determined for a sample of undyed fabric; the results are shown in Table 4 below.

Table 4

Fabric	Direction	Breaking Strength (g)	Elongation (%)
Undyed Nylon	warp	122.5	35.4
Dyed Nylon	warp	119.0	52.7
Undyed Nylon	fill	49.5	29.4
Dyed Nylon	fill	58.1	32.8

All of these data fall with normal parameters for this dye on nylon. The approach of this Example is equally applicable to "prepared" nylon that has been scoured and/or bleached.

Laboratory Example 4

Dyeing of Orlon 75 Acrylic

Package: Polyester (serves to hold fabric for dying)

Fabric: Acrylic(ORLON®75)

Dye: C.I. Basic Blue 38

Weight of Fabric: 40g (est.)

Weight of Dye: 2g

% o.w.g.: 5%

Nominal Dyeing Conditions:

CO2 Density: 0.65 g/cc

Temperature: 100°C

Volume Flow Rate: 7 gpm

Flow Reversal: Outside-to-inside (O-I) flow over entire cycle

Dyeing Procedure: Wet out polyester yarn package thoroughly; wet acrylic fabric swatches; wrap and secure swatches to outside of yarn package; load dye and package with swatches into SCF-CO_2 dyeing machine; fill machine to CO_2 density of about 0.65 g/cc at ambient temperature; circulate O-I at maximum volume flow rate and heat to 100°C; circulate 30 minutes; depressurize.

Results: A dark red colorfast dyeing was obtained; the dyed fabric was evaluated for shade depth and crocking; the stocking had a color matching Munsell designation 2.5 PB 3/8; wet and dry crocking were both of grade 5 determined by AATCC Standard Test Method #8; the breaking strength and elongation of the dyed fabric were measured (Fabric Grab/Strip Test, ASTM D5034/5035) and compared to values determined for a sample of undyed fabric; the results are shown in Table 5 below.

Table 5

Fabric	Direction	Breaking Strength [g]	Elongation (%)
Undyed Acrylic	warp	91.1	34.2
Dyed Acrylic	warp	83.7	43.3
Undyed Acrylic	fill	68.8	33.7
Dyed Acrylic	fill	71.2	40.3

All of the above results are considered normal for this dye on acrylic fabric.

Laboratory Example 5

Dyeing of Polyester

This Example pertains to the dyeing of polyester with a disperse dye. The polyester comprises DACRON®54, DACRON®64 and DACRON®107W fibers (E. I. du Pont de Nemours & Co., Wilmington, Delaware).

Package:	polyester (filament)
Package Density:	0.5 g/cc (approx.)
Dye:	C.I. Disperse Blue 56 (paste)
Weight of Yarn:	450g (est.)
Weight of Dye:	4g
% o.w.g.:	0.89%

Nominal Dyeing Conditions:

CO_2 Density: 0.6 g/cc

Temperature: 100°C

Volume Flow Rate: 15 gpm

Unit Volume Flow Rate: 15 gal/min-lb

Flow Reversal: 5 min inside-to-outside (I-O) flow, 5min outside-to-inside (O-I) flow

Dyeing Procedure: Wet out yarn package thoroughly; load dye and package into SCF-CO_2 dyeing machine; fill machine to CO_2 density of about 0.6 g/cc at ambient temperature; circulate at about 15 gpm volume flow rate with 5 min./5 min. I-O/O-I flow reversal pattern; heat to 100°C; circulate at 100°C for 30 minutes; depressurize.

Results: A dark blue colorfast dyeing was obtained; a stocking was knitted from the dyed yarn; no apparent crocking was noted for the dyeing; quantitative evaluation of shade depth and crocking was not performed; the tensile strength of the dyed yarn was measured by the Single Strand Method (ASTM D2256-97) and found to be comparable to that for a sample of undyed yarn; Undyed yarn T.S. = 132 g; Dyed yarn T.S. = 127 g; all of these results are considered normal for the trial dye on filament polyester yarn.

Laboratory Example 6

Dyeing of a Blended Textile Substrate

Package: Polyester/Cotton (50/50 Blend)

Package Density: 0.4 g/cc (approx.)

Dye: C.I. Disperse Blue 56 (paste), C.I. Direct Blue 78

Weight of Yarn: 225 g (est.)

Weight of Dye: 5 g (Total of equal amounts of the two dyes)

% o.w.g.: 2.22%

Nominal Dyeing Conditions:

CO2 Density: 0.33 g/cc

Temperature: 100°C

Volume Flow Rate: 7 gpm

Unit Volume Flow Rate: 7 gal/min-lb

Flow Reversal: 5 min inside-to-outside (I-O) flow, 5 min outside-to-inside (O-I) flow

Dyeing Procedure: Wet out yarn package thoroughly; load dye and package into SCF-CO_2 dyeing machine; fill machine to CO_2 density of about 0.6 g/cc at ambient temperature; circulate at 7 gpm volume flow rate with 5 min./5 min. I-O/O-I flow reversal pattern; heat to 100°C; circulate at 100°C for 30 minutes; depressurize.

Results: A dark blue colorfast dyeing was obtained; a stocking was knitted from the dyed yarn and evaluated for shade depth and crocking; the shade depth of the stocking was found to correspond to approximately a 3% dyeing based on reflectance measurements; a dry crocking of grade 4-5 and wet crocking of grade 4 were obtained for the stocking using AATCC Standard Test Method #8; the tensile strength of the dyed yarn was measured by the Single Strand Method (ASTM D2256-97) and found to be comparable to that for a sample of undyed yarn; Undyed yarn T.S. = 67 g; Dyed yarn T.S. = 72 g; all of these results are considered normal for this dye combination on polyester/cotton yarn.

Laboratory Example 7

Treatment of a Textile Substrate with Softener

This Example pertains to the treatment of a 100 percent cotton twill textile substrate with a softener. The purpose of the softener is to make the textile substrate feel slicker and softer, and to increase the tearing strength of the textile substrate.

Package: Cotton(serves to hold fabric for application of softener)
Fabric: Cotton (bleached)
Cotton (unbleached)
Softener: Cationic (5 parts) and HDPE (5 parts) mixed in water (10 parts)

Weight of Fabric: 40 g (est.)
Weight of Softener: 5 g
% o.w.g.: 12.5%

Nominal Treatment Conditions:

CO_2 Density: 0.3 g/cc
Temperature: 50°C
Volume Flow Rate: 15 gpm
Flow Reversal: Outside-to-inside (O-I) flow over entire cycle

Treatment Procedure: Wet out cotton yarn package thoroughly; wet cotton fabric swatches; wrap and secure swatches to outside of yarn package; load softener and package with swatches into SCF-CO_2 dyeing machine; fill machine to CO_2 density of about 0.3 g/cc at ambient temperature; circulate outside-to-inside at circulate at about 160 gpm volume flow rate; heat to 50°C; circulate at 50°C for 30 minutes; isolate treatment vessel and depressurize.

Results: The treated fabric felt slicker and softer relative to cotton that had not been treated with softener; the tearing strength of the treated fabric was measured and found to be 6.3 pounds; the tearing strength of an untreated fabric sample was measure and found to be 4.4 pounds; therefore, the addition of softener resulted in a tearing strength increase of 43%; these results are considered normal for this softener on cotton fabric.

It will be understood that various details of the invention can be changed without departing from the scope of the invention. Furthermore, the foregoing description is for the purpose of illustration only, and not for the purpose of limitation—the invention being defined by the claims.

CLAIMS

What is claimed is:

1. A process for treating a textile substrate, the process comprising:

(a) providing a textile substrate;

(b) providing a treatment bath;

(c) entraining a transport material in the treatment bath wherein the transport material further comprises a treatment material dissolved or suspended therein and wherein the transport material is substantially immiscible with the treatment bath; and

(d) contacting the textile substrate with the transport material in the treatment bath to thereby treat the textile substrate with the treatment material in the transport material.

2. The process of claim 1, wherein the textile substrate comprises a hydrophilic fiber, a hydrophobic fiber, or a blend thereof.

3. The process of claim 2, wherein the hydrophilic fiber comprises a cellulosic fiber, a silk fiber, a wool fiber or a blend thereof.

4. The process of claim 3, wherein the cellulosic fiber is a cotton fiber.

5. The process of claim 1, wherein the treatment bath comprises near critical liquid carbon dioxide, supercritical fluid carbon dioxide or combination thereof.

6. The process of claim 1, wherein the transport material comprises water.

7. The process of claim 1, wherein the transport material is present in a trace amount.

8. The process of claim 1, wherein the treatment material comprises a dye, a bleach, an optical brightener, a softener, an anti-static agent, a lubricant, a scouring agent, a sizing agent, an ultraviolet stabilizing agent, an antimicrobial agent, or combinations thereof.

9. The process of claim 1, wherein the treatment bath is free of a surfactant that is soluble in the treatment bath.

10. The process of claim 1, further comprising drying the textile substrate by removing the transport material from the textile substrate.

11. The process of claim 10, wherein the step of drying the textile substrate further comprises circulating the treatment bath through the textile substrate to re-entrain the transport material in the treatment bath, thereby removing transport material from the textile substrate.

12. A process for treating a textile substrate in a near critical or supercritical fluid carbon dioxide treatment bath, the process comprising:

(a) providing a textile substrate;

(b) providing a treatment bath comprising near critical liquid carbon dioxide, supercritical fluid carbon dioxide or combinations thereof;

(c) entraining a transport material in the treatment bath wherein the transport material further comprises a treatment material dissolved or suspended therein and wherein the transport material is substantially immiscible with the treatment bath; and

(d) contacting the textile substrate with the transport material in the treatment bath to thereby treat the textile substrate with the treatment material dissolved or suspended in the transport material.

13. The process of claim 12, wherein the textile substrate comprises a hydrophilic fiber, a hydrophobic fiber, or a blend thereof.

14. The process of claim 13, wherein the hydrophilic fiber comprises a cellulosic fiber, a silk fiber, a wool fiber or a blend thereof.

15. The process of claim 14, wherein the cellulosic fiber is a cotton fiber.

16. The process of claim 12, wherein the transport material comprises water.

17. The process of claim 12, wherein the transport material is present in a trace amount.

18. The process of claim 12, wherein the treatment material comprises a dye, a bleach, an optical brightener, a softener, an anti-static

agent, a lubricant, a scouring agent, a sizing agent, an ultraviolet stabilizing agent, an antimicrobial agent, or blends thereof.

19. The process of claim 12, wherein the treatment bath is free of a surfactant that is soluble in the treatment bath.

20. The process of claim 12, further comprising drying the textile substrate by removing the transport material from the textile substrate.

21. The process of claim 20, wherein the step of drying the textile substrate further comprises circulating the treatment bath through the textile substrate to re-entrain the transport material in the treatment bath, thereby removing transport material from the textile substrate.

22. A process for treating a hydrophilic textile substrate in a near critical or supercritical fluid carbon dioxide treatment bath, the process comprising:

(a) providing a hydrophilic textile substrate;

(b) providing a treatment bath comprising near critical fluid carbon dioxide, supercritical fluid carbon dioxide or blends thereof;

(c) entraining a transport material in the treatment bath wherein the transport material further comprises a treatment material dissolved or suspended therein and wherein the transport material is substantially immiscible with the treatment bath; and

(d) contacting the textile substrate with the transport material in the treatment bath to thereby treat the textile substrate with the treatment material dissolved or suspended in the transport material.

23. The process of claim 22, wherein the hydrophilic fiber comprises a cellulosic fiber, a silk fiber, a wool fiber or blends thereof.

24. The process of claim 23, wherein the cellulosic fiber is a cotton fiber.

25. The process of claim 22, wherein the transport material comprises water.

26. The process of claim 22, wherein the transport material is present in a trace amount.

27. The process of claim 22, wherein the treatment material comprises a dye, a bleach, an optical brightener, a softener, an anti-static agent, a lubricant, a scouring agent, a sizing agent, an ultraviolet stabilizing agent, an antimicrobial agent, or blends thereof.

28. The process of claim 22, wherein the treatment bath is free of a surfactant that is soluble in the treatment bath.

29. The process of claim 22, further comprising drying the textile substrate by removing the transport material from the textile substrate.

30. The process of claim 29, wherein the step of drying the textile substrate further comprises circulating the treatment bath through the textile substrate to re-entrain the transport material in the treatment bath, thereby removing transport material from the textile substrate.

31. A process for treating a hydrophobic textile substrate in a near critical or supercritical fluid carbon dioxide treatment bath, the process comprising:

(a) providing a hydrophobic textile substrate;

(b) providing a treatment bath comprising near critical liquid carbon dioxide, supercritical fluid carbon dioxide or combinations thereof;

(c) entraining a transport material in the treatment bath wherein the transport material further comprises a treatment material dissolved or suspended therein and wherein the transport material is substantially immiscible with the treatment bath; and

(d) contacting the hydrophobic textile substrate with the transport material in the treatment bath to thereby treat the textile substrate with the treatment material dissolved or suspended in the transport material.

32. The process of claim 31, wherein the transport material comprises water.

33. The process of claim 31, wherein the treatment material comprises a dye, a bleach, an optical brightener, a softener, an anti-static agent, a lubricant, a scouring agent, a sizing agent, an ultraviolet stabilizing

agent, an antimicrobial agent, or combinations thereof.

34. The process of claim 31, wherein the treatment bath is free of a surfactant that is soluble in the treatment bath.

35. The process of claim 31, further comprising drying the textile substrate by removing the transport material from the textile substrate.

36. The process of claim 35, wherein the step of drying the textile substrate further comprises circulating the treatment bath through the textile substrate to re-entrain the transport material in the treatment bath, thereby removing transport material from the textile substrate.

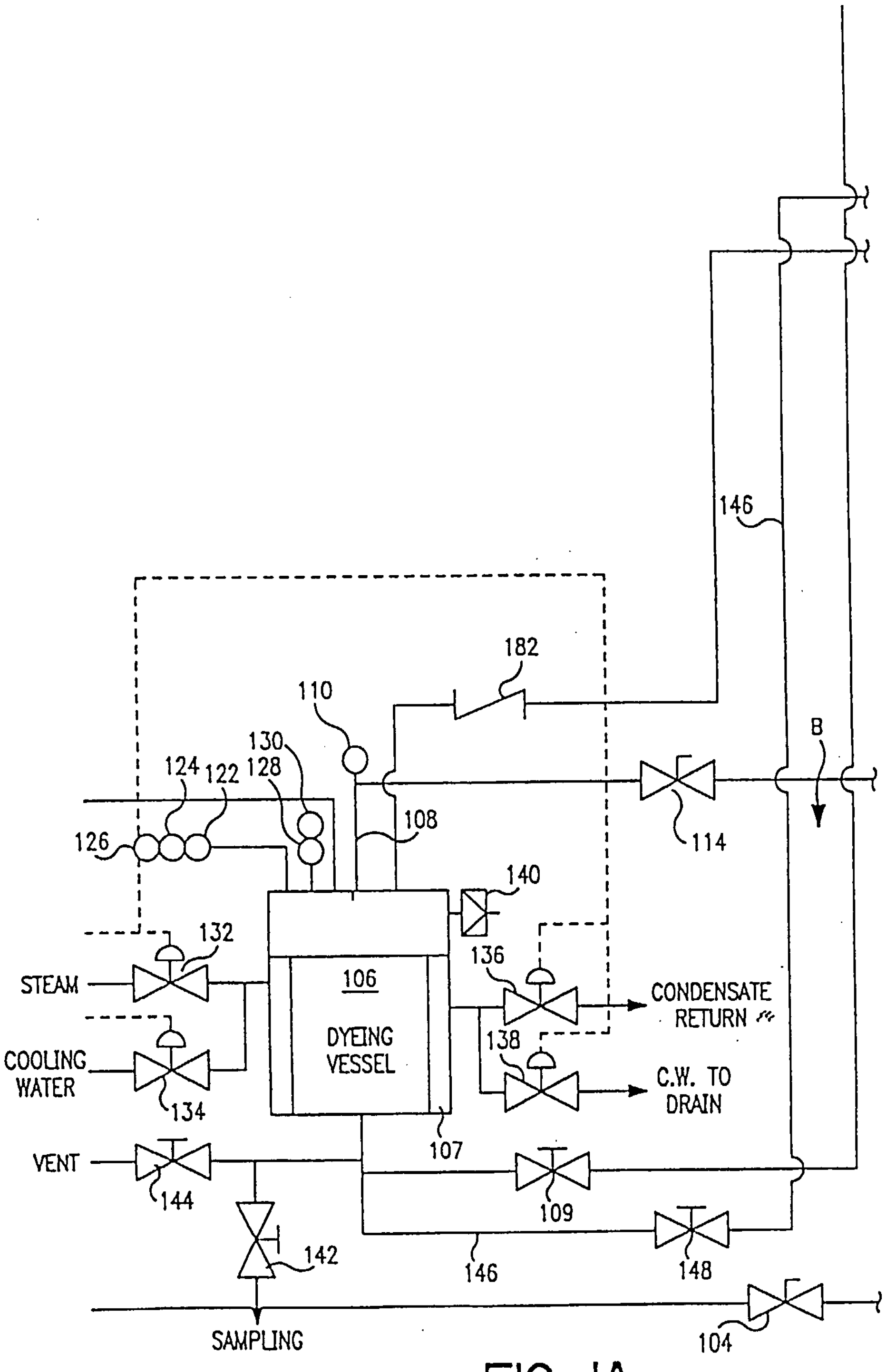
146
182
110
B
130
124
122
128
126
108
114
140
132
136
106
STEAM
DYEING
VESSEL
CONDENSATE
RETURN
138
COOLING
WATER
C.W. TO
DRAIN
134
107
VENT
109
144
148
142
146
104
SAMPLING

FIG. 1A

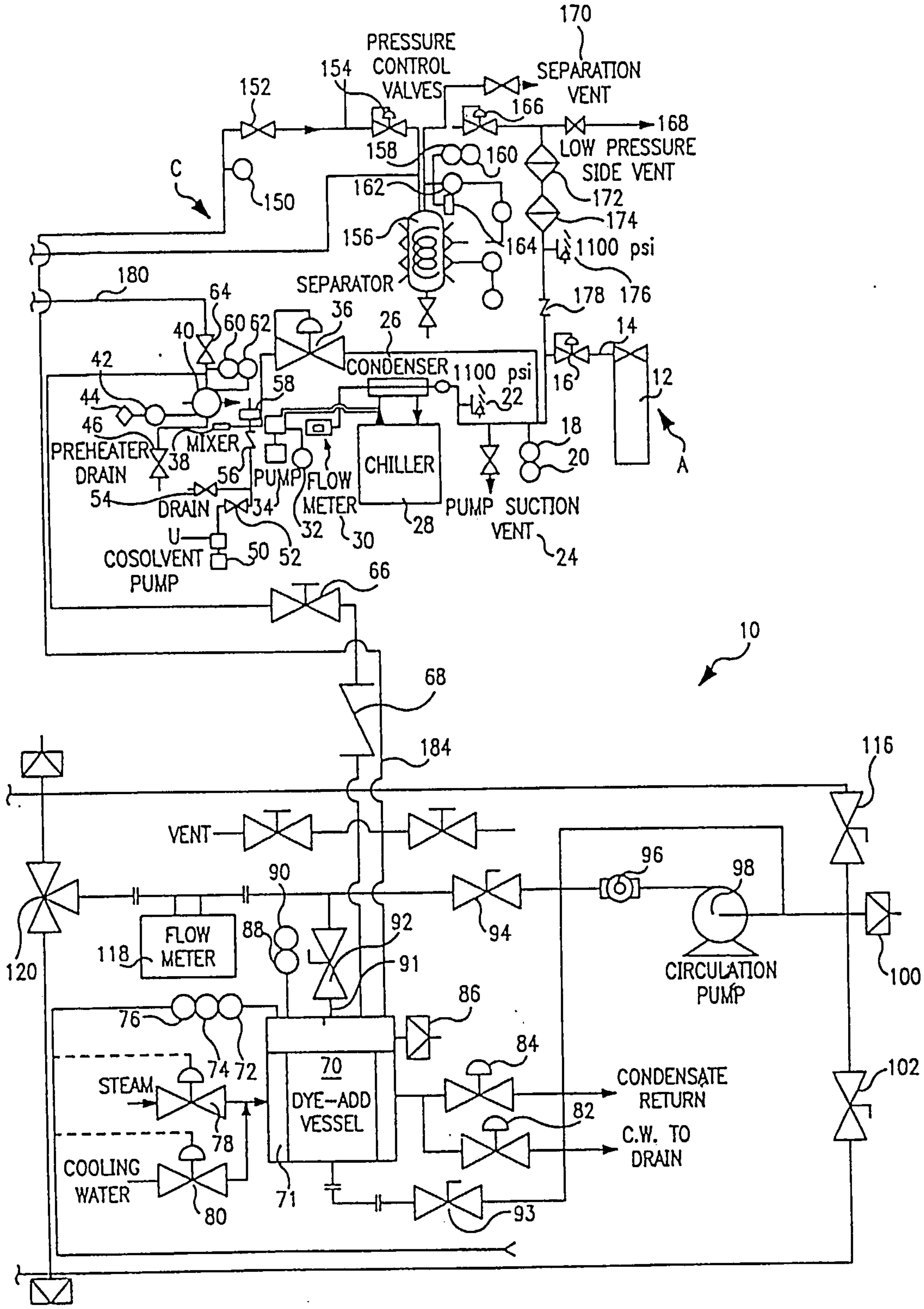
170
PRESSURE CONTROL VALVES
SEPARATION VENT
154
152
166
168
158
160
LOW PRESSURE SIDE VENT
C
162
150
172
174
156
164
1100 psi
180
SEPARATOR
178
176
64
36
26
14
40
60
62
42
CONDENSER
1100 psi
12
58
16
44
22
46
MIXER
18
PREHEATER
38
CHILLER
20
DRAIN
56
PUMP
FLOW METER
A
54
DRAIN
34
28
PUMP SUCTION VENT
32
30
24
COSOLVENT PUMP
50
52
66
10
68
184
116
VENT
96
90
98
88
92
94
FLOW METER
118
91
120
CIRCULATION PUMP
100
76
86
84
74
72
70
DYE-ADD VESSEL
CONDENSATE RETURN
STEAM
102
78
82
C.W. TO DRAIN
COOLING WATER
80
71
93

FIG. 1B

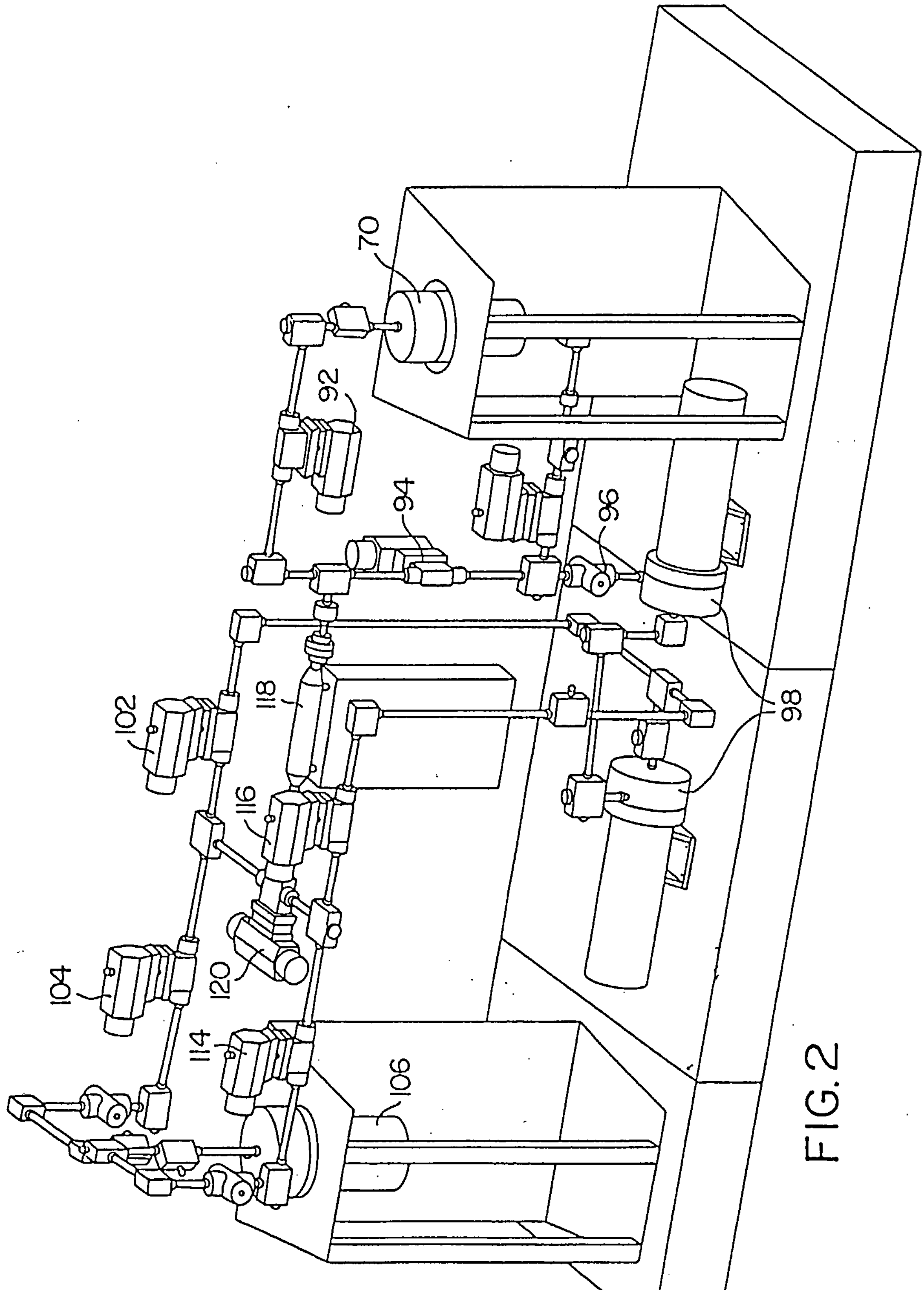

FIG.2

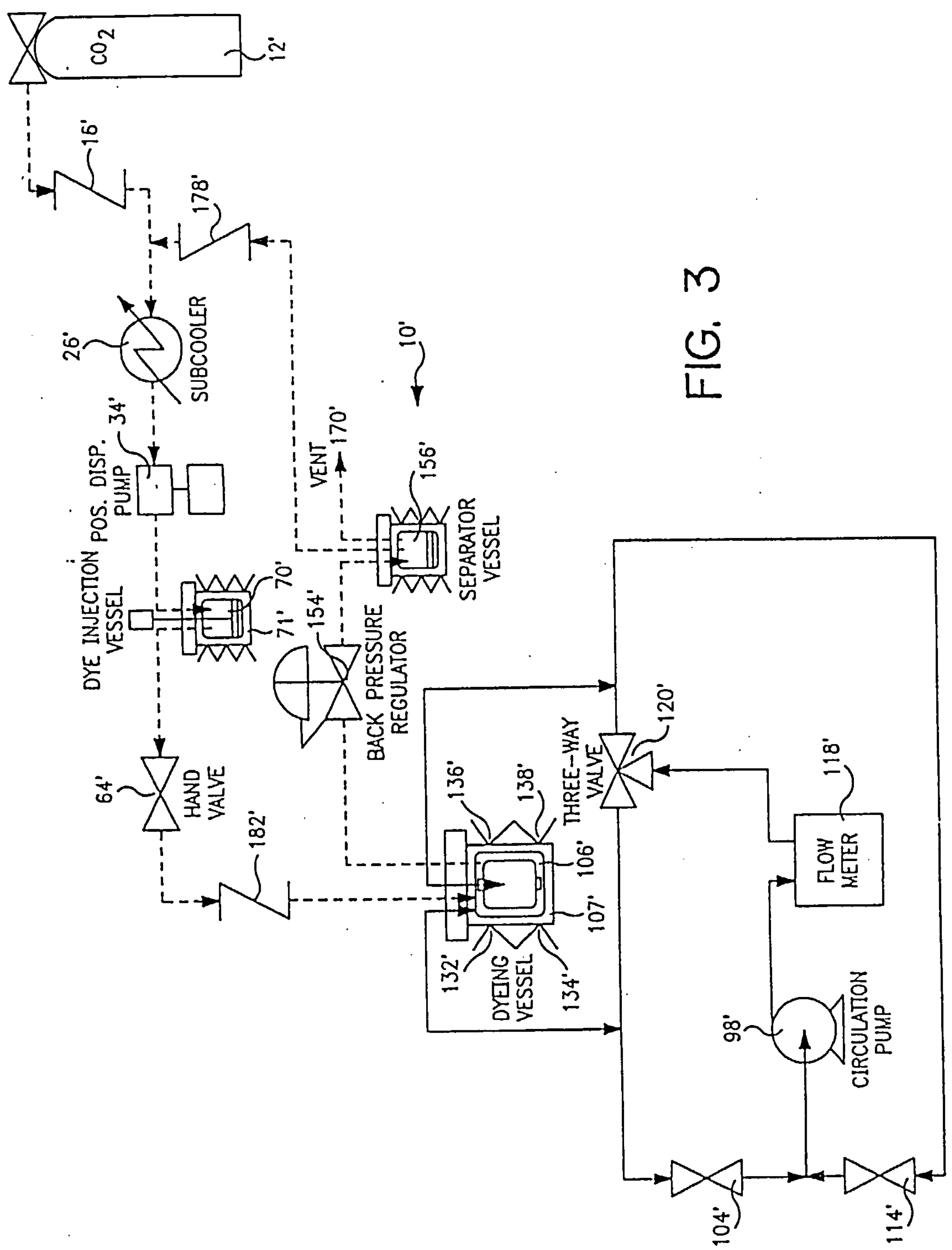
CO_2
12'
16'
178'
SUBCOOLER
26'
POS. DISP. PUMP
34'
VENT
170'
10'
156'
SEPARATOR VESSEL
DYE INJECTION VESSEL
70'
71'
154'
BACK PRESSURE REGULATOR
HAND VALVE
64'
182'
136'
138'
THREE-WAY VALVE
120'
118'
FLOW METER
106'
107'
132'
DYEING VESSEL
134'
98'
CIRCULATION PUMP
104'
114'

FIG. 3

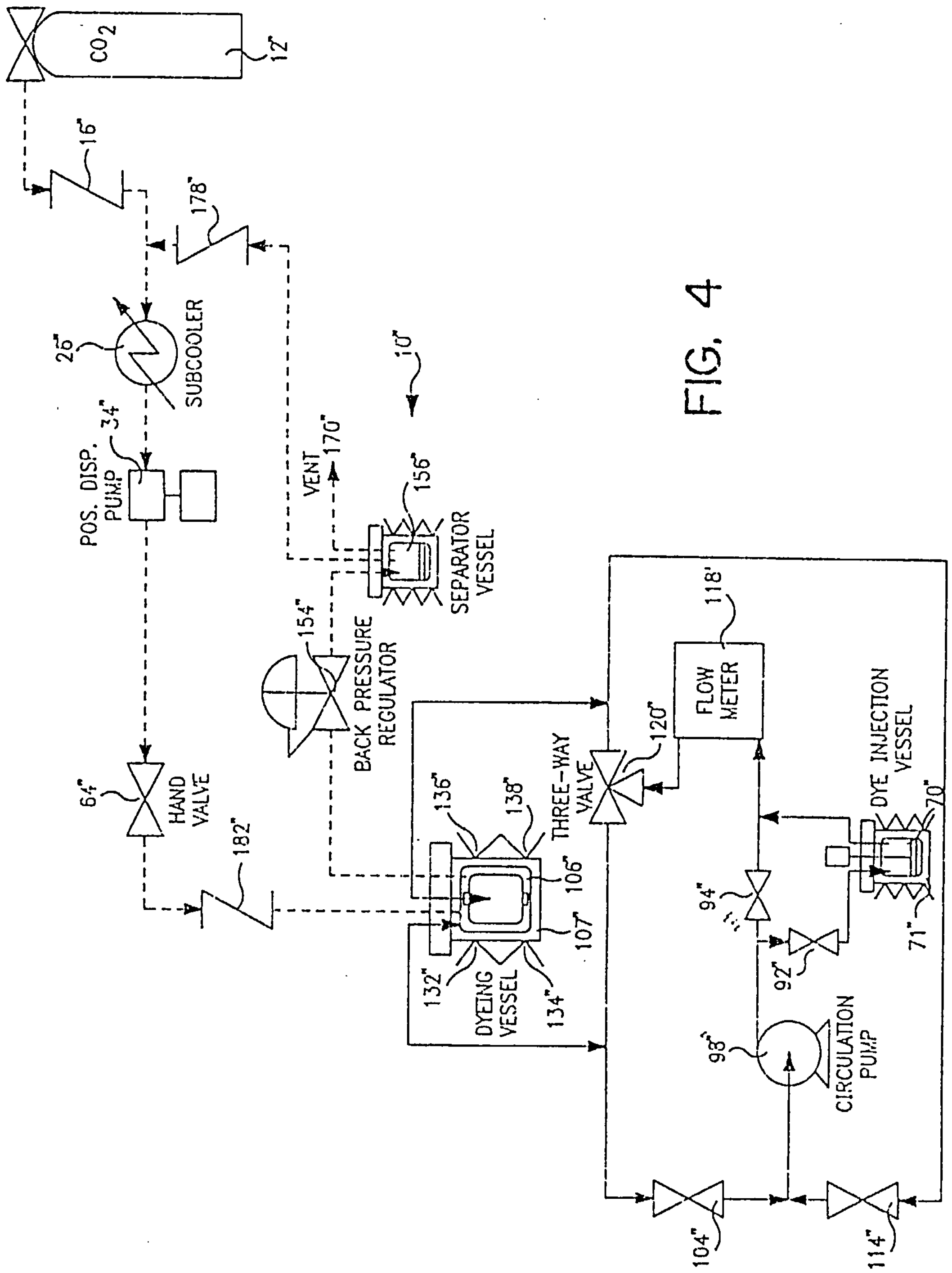
CO2
12"
16"
178"
26"
SUBCOOLER
POS. DISP. PUMP
34"
VENT
170"
10"
156"
SEPARATOR VESSEL
154"
BACK PRESSURE REGULATOR
118'
FLOW METER
120"
THREE-WAY VALVE
64"
HAND VALVE
182"
136"
138"
106"
107"
132"
DYEING VESSEL
134"
94"
92"
DYE INJECTION VESSEL
70"
71"
98"
CIRCULATION PUMP
104"
114"

FIG. 4

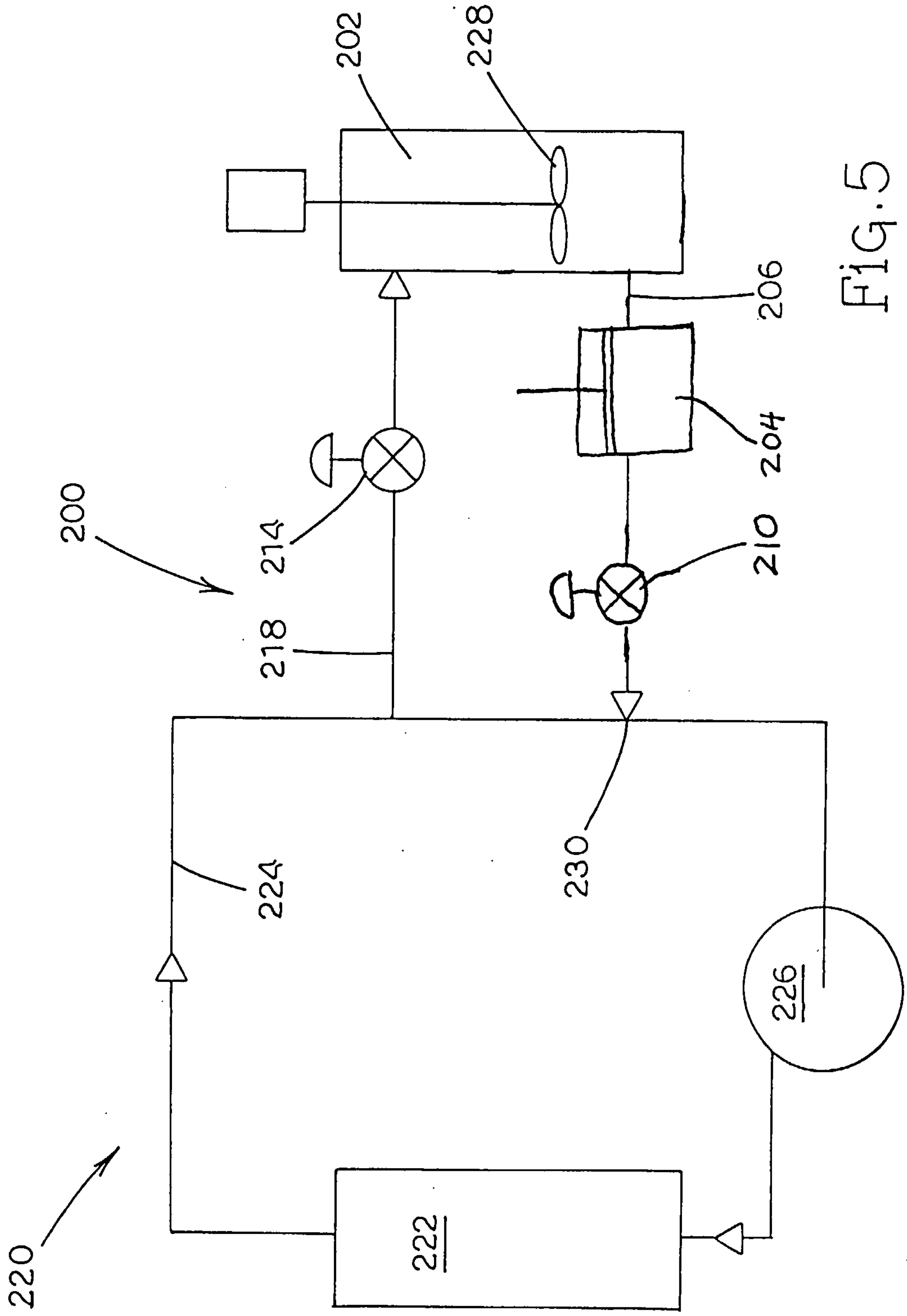

FIG. 5

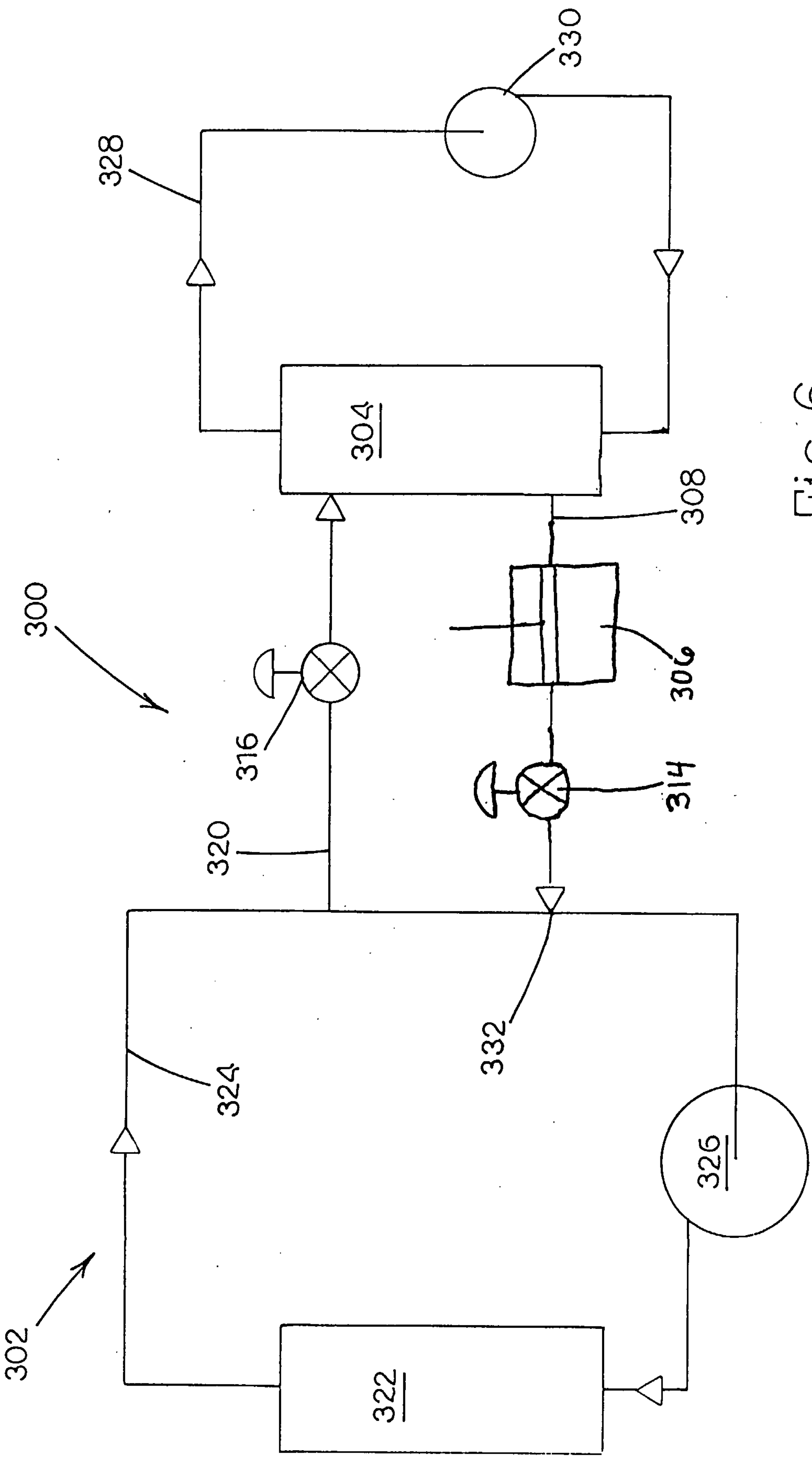

FIG.6

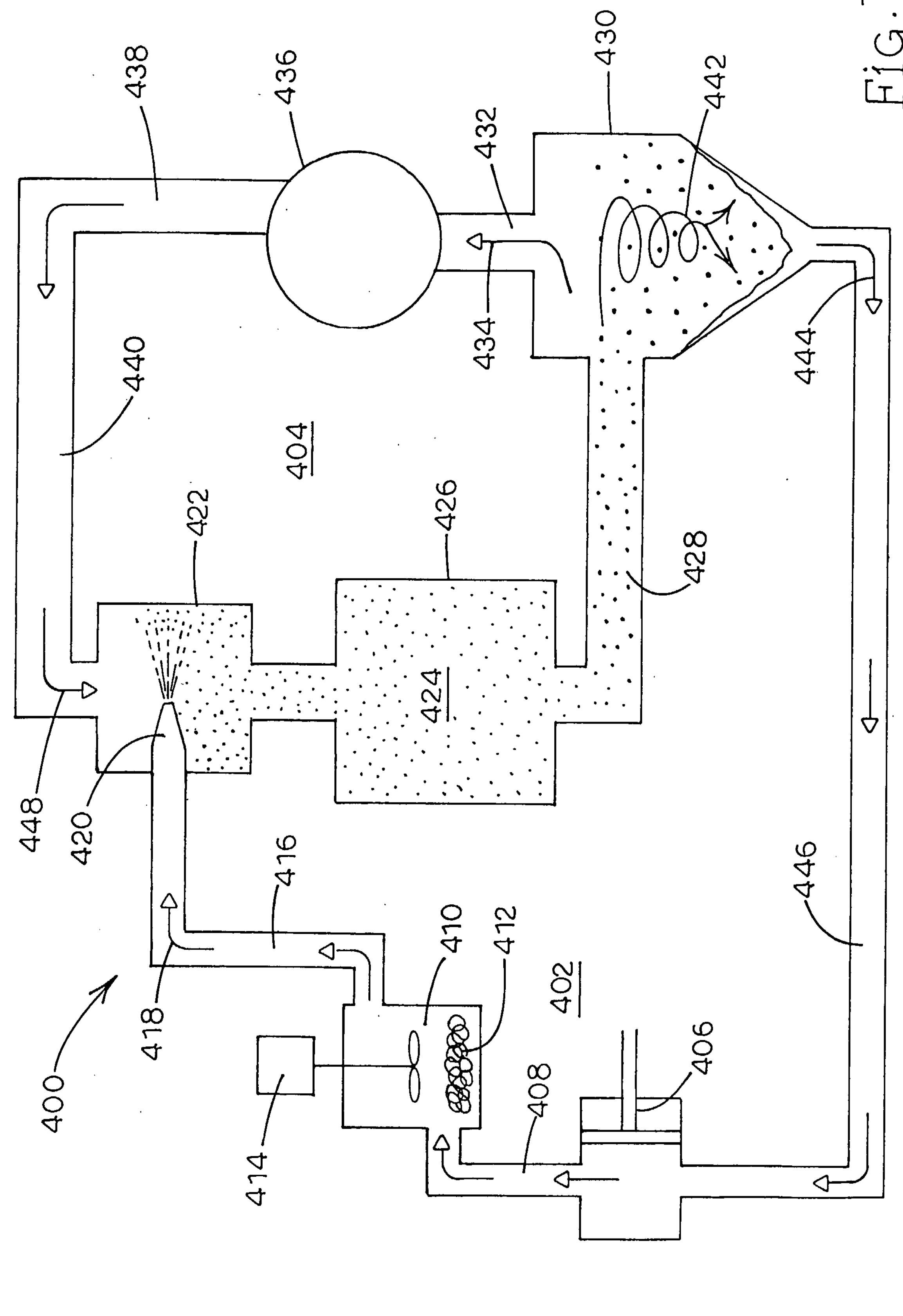
400
402
404
406
408
410
412
414
416
418
420
422
424
426
428
430
432
434
436
438
440
442
444
446
448

FIG. 7

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US01/32551

A. CLASSIFICATION OF SUBJECT MATTER
IPC(7) : D06P, 5/00; B08B, 7/00;
US CL : 8/107, 137, 139, 142, 404, 474, 475, 495, 916; 134/42
According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
U.S. : 8/107, 137, 139, 142, 404, 474, 475, 495, 916; 134/42

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X --- Y	US 6,010,542 A (DEYOUNG et al) 04 January 2000, column 7, lines 27-35, 45, 51, 53, 55 and column 8, lines 11, 12, 23 and 24.	1-8 and 10-36 ---------- 9
Y	US 5,676,705 A (JURELLER et al) 14 October 1997, column 1, lines 45-52.	9

☐ Further documents are listed in the continuation of Box C. ☐ See patent family annex.

* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier application or patent published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search 22 February 2002 (22.02.2002)	Date of mailing of the international search report 14 MAR 2002
Name and mailing address of the ISA/US Commissioner of Patents and Trademarks Box PCT Washington, D.C. 20231 Facsimile No. (703)305-3230	Authorized officer Yogendra Gupta Jean Proctor Paralegal Specialist Telephone No. 703 308-0661

Form PCT/ISA/210 (second sheet) (July 1998)