THE INTEGRA® PROGRAM

ANDERSON CHEMICAL COMPANY
325 South Davis
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www.theintegraprogram.com

GUIDELINE WASHING PARAMETERS

OPERATION	TEST REQUIRED	GUIDELINES	
Flush	None		
Break or Wash	Active Alkalinity	Delicate Light Medium Heavy Very Heavy	0 ppm 300-500 ppm 500-800 ppm 1000-2000 ppm 2000-3000 ppm
Flush	Active Alkalinity	Each flush reduces the alkalinity by 1/2	
Chlorine Bleach	pH and Temperature	140°-150°F. 130°-140°F. 120°-130°F. 110°-120°F.	10.2 - 10.8 pH 9.5 - 10.2 pH 9.0 - 9.5 pH 8.5 - 9.0 pH
Oxygen Bleaching	pH for oxygen bleaching temperature	Greater than a pH of 11.0 160°-°180F.	
Chlorine Bleach Usage	PPM Bleach Available Chlorine	Sample taken at the beginning: Light Medium Heavy Very Heavy	 100 ppm 100-150 ppm 150-200 ppm 200-400 ppm
		Titration at the end of the bleach operation should be 20-50 ppm above tap water.	
Oxygen Bleach Usage	PPM Bleach	Sample taken at the beginning: Light Medium Heavy Very Heavy	 50-100 ppm 100-300 ppm 300-400 ppm 600 ppm
Rinses	Active Alkalinity Available Chlorine	Each rinse reduces the alkalinity by 1/2	
Last Rinse	Chlorine level Use of antichlor Total Alkalinity	Equal to below tap Zero chlorine < 50 ppm above tap water	
Sour	Final Fabric pH	Bed linen Personal Towels Table linen Incontinent diapers Iron removal	6.0-6.5 6.0-6.5 5.5-6.5 5.5-6.0 / 4.5-5.5 for starch 5.5-6.0 5.0-5.5
Extracted Fabric	Test for residual chlorine Test for residual iron	Equal to tap water or less Pink is okay, red to red-orange is excessive	
Supply Water	Hardness Iron	Water softener recommended when over 5-6 grains. Greater than 0.20 ppm causes discoloration.	

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