DESCRIPTION
OAK DRAW 730 is a moderate-duty synthetic, metalforming lubricant.

APPLICATION
OAK DRAW 730 is used to draw, stamp, rollform, bend, and knurl non-ferrous and ferrous metals.

FEATURES & BENEFITS

LUBRICITY:
Exceptional film strength and friction reducing properties to maximize part coverage and formability. Superior tool and die life.

CLEANLINESS:
Contains detergents, which keeps the press, and tooling clean. Oil-free product. Deposited film is dry to touch dependent on concentration.

OPERATOR-FRIENDLY:
Forms transparent solution when mixed with water. Outstanding tramp oil rejection properties to prevent solution rancidity and extended sump life.

CORROSION CONTROL:
Excellent corrosion resistance on ferrous metals and safe on non-ferrous alloys.

STABILITY:
Non-foaming for recirculating systems.
**RECOMMENDED STARTING DILUTIONS**

OAK DRAW 730 is to be mixed with water. Typically dilutions are from 5 to 20% and are dependent upon the type of metal, gauge of metal, process involved and method of lubricant application. Add no other materials to the concentrate or mix unless approved by your CIMCOOL® District Manager. Always add concentrate to water. Fluid may be more difficult to mix when water temperature is below 55 F (13 C).

- Dilution Range: 5% - 20% (1:20 to 1:5)

**CONCENTRATION**

BCG Titration, Total Alkalinity, CIMCHEK™ Test Strip or Refractometer can be used.

The Refractometer Factor is 2.2.

Multiply the scale reading obtained on your CIMCOOL® Refractometer by this factor to obtain the mix concentration in percent. Calibrate the refractometer so that it reads 0.0 with water before testing the sample mix. Remove gross contaminants from the sample mixes before testing. A refractometer is only recommended for use in checking the concentration on afresh charge.

**TYPICAL PHYSICAL AND CHEMICAL PROPERTIES**

- Physical State: Liquid
- Appearance and Odor: Clear/Faint
- Solubility in Water: 100% miscible
- Weight, lb/gal, 60°F (15.6°C): 9.0
- Flash Point/Sp. Gr./Boiling Point: See MSDS
- pH, concentrate: 8.9
- Total Chlorine/Chlorides, wt%: 0/0
- pH, 10% dilution: 8.8
- Total Chlorine/Chlorides, wt%: 0/0
- Total Sulfur, wt%: Negligible
- Silicone: Yes

**HANDLING AND STORAGE**

If frozen, product separates. Thaw completely at room temperature and stir prior to use. Inside storage is recommended.

**SAFETY DATA SHEET**

Available at [www.cimcool.com](http://www.cimcool.com)

For additional information refer to its OSHA MSDS, website or contact your local CIMCOOL TECHNICAL SPECIALIST OR DISTRICT MANAGER, or you may contact CIMCOOL® Technical Services at 1-513-458-8199.

*Limitation of Liability: Under no circumstances, shall we or any affiliate of ours have any liability whatsoever for loss of use, or for any indirect or consequential damages. Minor formulation changes or normal variations in the manufacture of this product may cause slight variances in the data presented on this sheet.*