DESCRIPTION
OAK DRAW 740 is a moderate to heavy-duty synthetic, metalforming lubricant.

APPLICATION
OAK DRAW 740 is recommended for spinning, drawing, stamping, roll forming, bending and knurling for non-ferrous and ferrous metals. It is especially suited for “soft metals” such as aluminum, copper and copper alloys.

FEATURES & BENEFITS

LUBRICITY:
Polymeric emulsion exhibits excellent lubricity and load carrying capacity providing superior tool and die life.

CLEANLINESS:
Contains detergents, which keeps the press, and tooling clean. Outstanding tramp oil rejection properties to prevent solution rancidity and extended sump life.

OPERATOR-FRIENDLY:
Product is biodegradable, oil free and contains no chlorine or sulfur.

CORROSION CONTROL:
Excellent corrosion resistance on ferrous metals and safe on non-ferrous and exotic alloys.
RECOMMENDED STARTING DILUTIONS
OAK DRAW 740 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 TBD. 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 a fresh charge.

TYPICAL PHYSICAL AND CHEMICAL PROPERTIES

Physical State: Liquid  Appearance and Odor: Viscous/Bland
Solubility in Water: 100% miscible  Weight, lb/gal, 60°F (15.6°C): 8.68
Flash Point/Sp. Gr./Boiling Point: See MSDS  pH, 10% dilution: 8.8
Total Chlorine/Chlorides, wt%: 0/0  Total Sulfur, wt%: 0
Silicone: None

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

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.