DESCRIPTION
OAK DRAW 777B is a heavy-duty, synthetic drawing and stamping lubricant.

APPLICATION
OAK DRAW 777B is used to draw, stamp, roll form, and bend ferrous and non-ferrous metals. It is especially suited for soft metals such as aluminum.

The product forms a transparent solution with exceptional film strength and friction-reducing properties when added to water.

FEATURES & BENEFITS

LUBRICITY:
OAK DRAW 777B contains a lubricity package that offers superior tool and die life.

CLEANLINESS:
OAK DRAW 777B contains detergents, which keeps the press, and tooling clean.

EASY TO APPLY:
Easily mixed and can be applied by spray, flood, or drip. The film strength of the product allows for total part coverage providing enhanced formability.

CORROSION CONTROL:
OAK DRAW 777B has good corrosion control for in process protection for the tooling, machine tool.

MICROBIAL CONTROL:
Good microbial inhibition to prevent rancidity and extend sump life.

LOW FOAMING:
The product is fortified with additives to minimize foam.
RECOMMENDED STARTING DILUTIONS

OAK DRAW 777B 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 2.4. 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 an afresh charge.

TYPICAL PHYSICAL AND CHEMICAL PROPERTIES

Physical State: Liquid
Solubility in Water: 100% miscible
Flash Point/Sp. Gr./Boiling Point: See MSDS
Total Chlorine/Chlorides, wt%: 0.16/<50ppm
Silicone: Yes

Appearance and Odor: Clear/Chemical
Weight, lb/gal, 60°F (15.6°C): 8.81
pH Concentrate: 9.2
Total Sulfur, wt%: 0

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.

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