OAK KOOL EX 10-01
METALWORKING FLUID

DESCRIPTION
OAK KOOL EX 10-01 is an economical semi-synthetic metalworking fluid, derived from reclaimed raw materials.

APPLICATION
OAK KOOL EX 10-01 is a low cost, general duty machining and grinding fluid, which can be used on a wide variety of metals. Good on ferrous metals and most aluminum alloys. It should not be used on magnesium alloys.

For use in light to medium duty machining and grinding applications, such as milling, drilling, turning and surface grinding.

FEATURES & BENEFITS

EXCEPTIONALLY MILD:
A good choice for individual machine applications where mixes tend to become more concentrated than recommended.

CLEANLINESS:
The oily residue keeps machine tools and workpiece materials clean.

MICROBIAL CONTROL:
OAK KOOL EX 10-01 has good rancidity control if product concentration is properly controlled.

ECONOMICAL:
OAK KOOL EX 10-01 is one of the lowest priced semi-synthetics available and offers good savings potential if properly maintained and in systems that may require frequent changes due to process controls.

RESIDUE:
Product residues are light, very soft and non-tacky.
RECOMMENDED STARTING DILUTIONS
OAK KOOL EX 10-01 is to be mixed with water for use. Always add concentrate to water. Fluid may be more difficult to mix when water temperature is below 55 F. Add no other materials to the concentrate or mix unless approved by your CIMCOOL® District Manager.

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<tr>
<th>Material</th>
<th>Concentration</th>
<th>Dilution</th>
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<tbody>
<tr>
<td>Aluminum</td>
<td>5% - 10%</td>
<td>1:20 to 1:10</td>
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<tr>
<td>Steel</td>
<td>8% - 10%</td>
<td>1:13 to 1:10</td>
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CONCENTRATION
Non-solvent Titration, Total Alkalinity, or Refractometer can be used.

The Refractometer Factor is 1.5. 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.

TYPICAL PHYSICAL AND CHEMICAL PROPERTIES
Physical State: Liquid
Solubility in water: 100% miscible
Viscosity (SUS) @ 100°F: 250
pH Concentrate: 9.5
Total Chlorine/Chloride, wt%: 0.3/<100ppm
Silicones: Yes

Appearance and Odor: Blue, Hazy/Chemical
Weight, lb/gal, 60°F (15.6 °C): 8.5
Flash Point /Sp.Gr./Boiling Point: SEE MSDS
pH Mix 5%, Typical Operating: 8.9
Total Sulfur, wt%: 0.2

HANDLING and STORAGE
If frozen, thaw completely at room temperature before using. Inside storage is recommended.

This concentrate may show signs of separation within two months of manufacturing. It should be stirred before using. This product is “made to order” and is not returnable.

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. This product will have naturally occurring formulation and raw material variations in the manufacture of this product that will result in some variances in the data presented on this sheet. The values are presented as “typical” and are for comparison only.