



YOUR METALWORKING FLUID SOLUTIONS FOR SOLUTIONS

OAKFLO[®] DSO 650CF-AFC

PREMIUM SOLUBLE OIL, METALWORKING FLUID CONCENTRATE

<p>APPLICATIONS</p>	<p>OAKFLO[®] DSO 650CF-AFC is a chlorine-free premium soluble oil, recommended for high fluid pressure and high volume flow applications where minimization of foam is critical for part quality and machine operations. It can be used for machining operations including turning, drilling, tapping, reaming, gear cutting and broaching.</p> <p>Metals: Carbon Steels, High Speed Steels, Cast Steels, Alloy Steels, Tool Steels, Stainless Steels, Cast Iron, Aluminum, Most Non-Ferrous Metals.</p> <p>Duty Range: For heavy-duty operations.</p>										
<p>FEATURES & BENEFITS</p>	<p>OAK SIGNATURE[®] - AFC Fluids provide “Advanced Foam Control” through the combination of product design, raw material selection and innovative antifoam technology. These fluids are the result of years of experience that have identified creative methods to prevent, control and reduce foam, even when fluids are used in high pressure delivery systems including through the tool systems. This expertise is only available in OAK SIGNATURE[®] - AFC Fluids.</p> <div data-bbox="711 1171 1187 1549" data-label="Figure"> <p>High Pressure Foam Test 600 psi @ 5% in 50 ppm water OAKFLO[®] DSO 650CF - AFC</p> <table border="1"> <thead> <tr> <th>Product</th> <th>Maximum Foam Generated (%)</th> </tr> </thead> <tbody> <tr> <td>Competitor A</td> <td>~85%</td> </tr> <tr> <td>Competitor B</td> <td>~110%</td> </tr> <tr> <td>Competitor C</td> <td>~85%</td> </tr> <tr> <td>OAKFLO[®] DSO 650CF-AFC</td> <td>~35%</td> </tr> </tbody> </table> </div> <p>EXCELLENT LUBRICITY – Contains mineral oil for physical lubricity. Also contains lubricants for heavy-duty operations. Provides excellent tool life and surface finishes.</p> <p>EXCELLENT RANCIDITY CONTROL – Maintains control of bacteria and mold, resulting in extended fluid life.</p> <p>EXCELLENT CORROSION CONTROL – Contains ferrous and non-ferrous corrosion on parts and machine components.</p> <p>MACHINE FRIENDLY – Cleaner machines and work areas create a more pleasant work environment. Residue can be removed with water or alkaline cleaners.</p> <p>ECONOMICAL – Wide application on metals and operations. Minimizes requirements for storage, mixing, charging, makeup and maintenance.</p>	Product	Maximum Foam Generated (%)	Competitor A	~85%	Competitor B	~110%	Competitor C	~85%	OAKFLO [®] DSO 650CF-AFC	~35%
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<p>RECOMMENDED STARTING DILUTIONS</p>	<p>FOR INDUSTRIAL USE ONLY Recommended Starting Dilution: 5% (1:20) Typical Operating Range: 5%- 10% (1:20 to 1:10) For concentrations outside this range contact CIMCOOL® Technical Service.</p> <p>OAKFLO® DSS 650CF-AFC is to be mixed with water for use (add concentrate to water).</p> <p>Add no other substances to the concentrate or mix unless approved by CIMCOOL® Technical Services. Not recommended for use with magnesium or alloyed magnesium.</p> <p>For concentration analysis, use: Total Alkalinity Titration Procedure, Non-Solvent Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.</p>
<p>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</p>	<p>Physical state: Liquid Appearance and odor: Hazy/ Chemical Colors available: Undyed Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 7.8 Specific gravity, (H₂O = 1): 0.94 Boiling point, °F (°C): 212 (100) Flash point, COC, °F (°C): 345 (174) Fire point, COC, °F (°C): 355 (179) Freezing point (or pour point), °F, (°C): <0 (<-18) If frozen product separates. Thaw completely at room temperature and stir prior to use. pH, concentrate: NA pH, 5.0% mix, typical operating conditions: 8.9 Total chlorine/chloride, wt%, calculated: 0.0/<50 ppm Total sulfur, wt%, calculated: 0.24 Dicyclohexylamine: None</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR: 1.0 Multiply the scale reading obtained on your OAK SIGNATURE® 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.</p>	
<p>SAFETY DATA SHEET Available at www.cimcool.com For additional information refer to its OSHA MSDS, website or contact your local OAK SIGNATURE SPECIALIST OR DISTRICT MANAGER, or you may contact CIMCOOL® Technical Services at 1-513-458-8199</p> <p>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.</p> <p style="text-align: center;">3000 Disney Street Cincinnati, Ohio 45209 1-513-458-8199 Fax: 1-513-458-817</p> <p style="text-align: right;">PC B20143 8/14/2012</p>	

