



# YOUR METALWORKING FLUID SOLUTIONS FOR SOLUTIONS

## OAKFLO<sup>®</sup> DSO 5800

SOLUBLE OIL, METALWORKING FLUID CONCENTRATE

<b>APPLICATIONS</b>	<p><b>OAKFLO<sup>®</sup> DSO 5800</b> is a heavy –duty soluble oil, metalworking fluid designed for moderate to severe-duty machining operations on aluminum.</p> <p><b>Metals:</b> Aluminum Alloys (2024, 6061, 7050, 7075), Cast Aluminum Alloys (380, 390), Cast Iron, Nodular Iron, Carbon Steels, Stainless Steels, Titanium, Other Exotic Alloys</p> <p><b>Duty Range:</b> For moderate to severe-duty operations</p>
<b>FEATURES &amp; BENEFITS</b>	<p><b>OAKFLO<sup>®</sup> DSO 5800</b> blends synthetically modified, vegetable oils with the aluminum lubricating capabilities of premium soluble oils to deliver excellent lubricity in aluminum machining.</p> <p><b>EXCELLENT LUBRICITY</b> – Provides a tenacious lubricant film that enhances hydrodynamic lubricity, preventing galling and metal buildup on the tools. Taps stay clean and free from buildup. High silicon aluminums cut cleanly with reduced tool wear.</p> <p><b>REDUCES MANUFACTURING COSTS</b> – Increases tool life in critical operations, such as drilling, reaming and tapping, allowing extended production runs between tool changes.</p> <p><b>EXCELLENT SURFACE FINISHES</b> – Has lubricants that bind to the metal surface and form a barrier between the tool and the cut chip leading to bright and unmarred surface finishes.</p> <p><b>EXCELLENT CORROSION CONTROL</b> – Non-staining on aluminum. Provides corrosion control for ferrous metals and machine parts.</p> <p><b>OPERATOR FRIENDLY</b> – Mild to skin – Easy to mix.</p>

<p><b>RECOMMENDED STARTING DILUTIONS</b></p>	<p><b>FOR INDUSTRIAL USE ONLY</b>  <b>Use between 7.0% (1:14) and 12% (1:8.5) for moderate to severe-duty machining operations on aluminum.</b></p> <p><b>OAKFLO® DSO 5800</b> is to be mixed with water for use. Add concentrate to water and stir or circulate to insure thorough mixing.</p> <p>Add no other substances to the concentrate or mix unless approved by Oak Signature Technical Services. Not recommended for use with magnesium or alloyed magnesium.</p> <p><b>For concentration analysis, use</b> the Total Alkalinity Titration Procedure, Non-solvent Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.</p>
<p><b>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</b></p>	<p><b>Physical state:</b> Liquid  <b>Appearance and odor:</b> Slightly Hazy/ Chemical  <b>Colors available:</b> Undyed  <b>Solubility in water:</b> 100% Miscible  <b>Weight, lb/gal, 60°F (15.6°C):</b> 7.75  <b>Specific gravity, (H<sub>2</sub>O = 1):</b> 0.9288  <b>Boiling point, °F (°C):</b> NA  <b>Flash point, COC, °F (°C):</b> 300 (149)  <b>Fire point, COC, °F (°C):</b> 325 (163)  <b>Freezing point (or pour point), °F, (°C):</b> &lt;0 (-18)          If frozen, thaw completely at room temperature.  <b>pH, concentrate:</b> NA  <b>pH, 5.0% mix, typical operating conditions:</b> 8.4  <b>Total chlorine/chloride, wt%, calculated:</b> 0.0/&lt;50 ppm  <b>Total sulfur, wt%, calculated:</b> 0.27  <b>Silicone:</b> No</p>
<p><b>PACKAGING</b></p>	<p><b>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</b></p>
<p><b>REFRACTOMETER FACTOR:</b> 0.9          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.          This product is to be used within six months of its manufacture date indicated by the lot number on the container label.</p>	
<p><b>SAFETY DATA SHEET</b>          Available at <a href="http://www.cimcool.com">www.cimcool.com</a>          For additional information refer to its OSHA MSDS, website or contact your local OAK SIGNATURE SPECIALIST OR DISTRICT MANAGER, or you may contact OAK SIGNATURE® Technical Services at 1-513-458-8199</p> <p><b>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.</b></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 B20053    8/10/2012</p>	

