



# YOUR METALWORKING FLUID SOLUTIONS FOR SOLUTIONS

## OAKFLO<sup>®</sup> DSS 700

SEMISYNTHETIC, METALWORKING FLUID CONCENTRATE

<p><b>APPLICATIONS</b></p>	<p><b>OAKFLO<sup>®</sup> DSS 700</b> is recommended for general-purpose machining and grinding of ferrous and non-ferrous metals.</p> <p><b>Metals:</b> Carbon/Cast Steel, Cast/Nodular/Malleable/Gray Iron, Aluminum, High Speed Steel, High Alloy Steels, Stainless Steels</p> <p><b>Duty Range:</b> For light to moderate-duty operations</p>
<p><b>FEATURES &amp; BENEFITS</b></p>	<p><b>OAKFLO<sup>®</sup> DSS 700</b> metalworking fluid blends the advantages of synthetics with the performance of soluble oils.</p> <p><b>EXCELLENT BIOLOGICAL CONTROL</b> – Effective protection against bacteria and mold – No “Monday Morning” odors – Ensures long fluid life, minimizes use of additives, and increases operator satisfaction.</p> <p><b>OPERATOR and MACHINE FRIENDLY</b> – No Smoke – No slippery film on parts, machines or floors – Mild to skin when used as recommended – Liquid residue keeps machine tool components free-moving regardless of equipment age.</p> <p><b>CORROSION CONTROL</b> – Contains non-ferrous corrosion inhibitors.</p> <p><b>VERSATILE</b> – Its broad concentration range and performance capabilities allow excellent performance in both individual machine sumps and central system applications.</p> <p><b>ENVIRONMENTALLY-FRIENDLY</b> – Easy to maintain and can be recycled for extended tool life.</p> <p><b>Note:</b> OAKFLO<sup>®</sup> DSS 700B has the same performance characteristics as OAKFLO<sup>®</sup> DSS 700 but in addition, is designed to be low foaming in soft water (50 ppm total hardness)</p>

<p><b>RECOMMENDED STARTING DILUTIONS</b></p>	<p><b>FOR INDUSTRIAL USE ONLY</b>  <b>Recommended Starting Dilution: 5% (1:20)</b>  <b>Typical Operating Range: 5%- 10% (1:20 to 1:10)</b></p> <p><b>OAKFLO® DSS 700</b> 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 Oak Signature Technical Services. Not recommended for use with magnesium or alloyed magnesium.</p> <p><b>For concentration analysis, use the Total Alkalinity Titration Procedure, Non-Solvent Titration Procedure, or Refractometer.</b></p>
<p><b>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</b></p>	<p><b>Physical state:</b> Liquid  <b>Appearance and odor:</b> Clear / Chemical  <b>Colors available:</b> Undyed, Blue  <b>Solubility in water:</b> 100% Miscible  <b>Weight, lb/gal, 60°F (15.6°C):</b> 8.5  <b>Specific gravity, (H<sub>2</sub>O = 1):</b> 1.02  <b>Boiling point, °F (°C):</b> 212 (100.0)  <b>Flash point, COC, °F (°C):</b> None, Self extinguishing  <b>Fire point, COC, °F (°C):</b> None, Self extinguishing  <b>Freezing point (or pour point), °F, (°C):</b> 30 (-1)          If frozen, thaw completely at room temperature.  <b>pH, concentrate:</b> 9.5  <b>pH, 5.0% mix, typical operating conditions:</b> 8.8  <b>Silicone:</b> No for OAKFLO® DSS 700 / Yes for OAKFLO® DSS 700B</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: 2.2</b>          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>This product is to be used within 6 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><i>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.</i></b></p> <p style="text-align: center;">Cincinnati, Ohio 45209          1-513-458-8199 Fax: 1-513-458-817</p> <p style="text-align: right;"><b>PC B20123 11/15/2015</b></p>	

