



# YOUR METALWORKING FLUID SOLUTIONS FOR SOLUTIONS

## OAKFLO<sup>®</sup> DSS 760B

SEMISYNTHETIC, METALWORKING FLUID CONCENTRATE

<p><b>APPLICATIONS</b></p>	<p><b>OAKFLO<sup>®</sup> DSS 760B</b> is recommended for general-purpose machining and grinding of ferrous and non-ferrous metals. It is recommended for turning, reaming, drilling, tapping, milling, as well as internal grinding, centerless and center-type grinding, etc.</p> <p><b>Metals:</b> Cast Iron, Nodular Iron, Malleable Iron, Gray Iron, Carbon Steels, Cast Steel, High Speed Steel, High Alloy Steels, Stainless Steels and most Aluminum alloys.</p> <p><b>Duty Range:</b> For moderate to heavy-duty operations</p>
<p><b>FEATURES &amp; BENEFITS</b></p>	<p><b>OAKFLO<sup>®</sup> DSS 760B</b> contains a chlorinated EP lubricant for heavy-duty operations providing the performance capabilities of soluble oils.</p> <p><b>FOAM CONTROL</b> – Designed to be low foaming in soft water (less than 125ppm total hardness)</p> <p><b>LUBRICITY</b> – Physical and chemical lubricants provide good machining and grinding properties – Keeps parts and tools cool.</p> <p><b>EXCELLENT RANCIDITY CONTROL</b> – Contains a patented biostable microbial control package – Effective protection against bacteria and mold – Provides long life and minimizes the use of additives.</p> <p><b>EXCELLENT FERROUS CORROSION CONTROL</b> – Rust inhibitor package is extremely effective in preventing in-process rust on machine and parts – Also very effective of cast/malleable/gray and nodular iron.</p> <p><b>NON-FERROUS CORROSION CONTROL</b> – Contains non-ferrous corrosion inhibitors.</p> <p><b>GENERAL-PURPOSE PRODUCT</b> – Can be used economically throughout the shop on moderate to heavy-duty operations.</p> <p><b>OPERATOR FRIENDLY</b> – Easy to maintain and control – Waste treatable using standard fluid treatment procedures and systems – Can be recycled for reuse</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® DSY 35 BVX</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</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> Hazy / Chemical  <b>Colors available:</b> Undyed  <b>Solubility in water:</b> 100% Miscible  <b>Weight, lb/gal, 60°F (15.6°C):</b> 8.7  <b>Specific gravity, (H<sub>2</sub>O = 1):</b> 1.04  <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> 28 (-2)          If frozen, thaw completely at room temperature.  <b>pH, concentrate:</b> 9.7  <b>pH, 5.0% mix, typical operating conditions:</b> 8.5  <b>Total chlorine/chloride, wt%, calculated:</b> 3.22/&lt;50 ppm  <b>Total sulfur, wt%, calculated:</b> 0.35  <b>Silicone:</b> Yes</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: 1.5</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.          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;">3000 Disney Street          Cincinnati, Ohio 45209          1-513-458-8199 Fax: 1-513-458-817</p> <p style="text-align: right;"><b>PC B20140 12/162013</b></p>	

