



YOUR METALWORKING FLUID SOLUTIONS FOR SOLUTIONS

OAKFLO[®] DSS 790

SEMISYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>OAKFLO[®] DSS 790 is a semisynthetic metalworking fluid recommended for moderate to heavy-duty operations.</p> <p>Metals: Cast iron, Nodular Iron, Carbon Steels, Stainless Steels, Most Copper and Aluminum Alloys.</p> <p>Duty Range: For moderate to heavy-duty operations</p>
FEATURES & BENEFITS	<p>LUBRICITY – Extreme pressure lubricants and renewable additives allow for the performance capabilities of soluble oils – Excellent machining and grinding properties which extends tool life and keeps tools and parts cool.</p> <p>FOAM CONTROL – Can be used in a wide range of water qualities – Good foam control even in soft water (less than 125ppm total hardness)</p> <p>RANCIDITY CONTROL – Excellent protection against bacteria and mold which promotes long sump life and minimizes the use of additives.</p> <p>OUTSTANDING CORROSION CONTROL – Rust inhibitor package prevents in-process rust on machines and parts for both ferrous and non-ferrous applications</p> <p>VERSATILE – Multi-purpose product that is ideally suited when one metalworking fluid is required throughout the shop.</p>

<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)</p> <p>OAKFLO® DSS 790 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>For concentration analysis, use the 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: Clear / Chemical Colors available: Undyed Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 8.7 Specific gravity, (H₂O = 1): 1.04 Boiling point, °F (°C): 212 (100.0) Flash point, COC, °F (°C): NA Fire point, COC, °F (°C): NA Freezing point (or pour point), °F, (°C): Not Available If frozen, thaw completely at room temperature. pH, concentrate: 9.5 pH, 5.0% mix, typical operating conditions: 8.6 Total chlorine/chloride, wt%, calculated: 5.4/<50 ppm Total sulfur, wt%, calculated: 0.12 Silicone: Yes</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR: 1.5 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 as indicated by the lot number on the product label.</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 OAK SIGNATURE® 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 B20166 12/16/2013</p>	

