



YOUR METALWORKING FLUID SOLUTIONS FOR SOLUTIONS

OAKFLO[®] DSS VL65B

SEMISYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>OAKFLO[®] DSS VL65B is a VALUE LINE semisynthetic metalworking fluid.</p> <p>The VALUE LINE of products offers cost effective alternatives while maintaining good overall performance characteristics.</p> <p>Metals: Cast Iron, Nodular Iron, Carbon Steels, High Speed Steel, High Alloy Steels, Stainless Steels, Exotics and most Aluminum alloys.</p> <p>Duty Range: For moderate-duty machining and grinding applications such as milling, drilling, cut tapping, and surface grinding.</p>
FEATURES & BENEFITS	<p>OAKFLO[®] DSS VL65B metalworking fluid is a clean, completely water soluble, phenol-free, silicone-free, semisynthetic product.</p> <p>GENERAL PURPOSE PRODUCT – Can be used economically throughout the shop on moderate to heavy-duty operations.</p> <p>EXCELLENT CLEANLINESS – Has a very stable emulsion which makes it very clean, especially when compared to soluble oils.</p> <p>VERSATILE – Because of unique formulation, product can be used on tough applications like sawing but also versatile enough for surface grinding, milling or turning.</p> <p>“VALUE LINE” – Cost effective with OAK INTERNATIONAL performance.</p>

**RECOMMENDED
STARTING
DILUTIONS**

FOR INDUSTRIAL USE ONLY

Recommended Starting Dilution: 5% (1:20)
Typical Operating Range: 5%- 10% (1:20 to 1:10)

OAKFLO® DSS VL65B is to be mixed with water for use (add concentrate to water).

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.

For concentration analysis, use the Total Alkalinity Titration Procedure, Non-Solvent Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.

**TYPICAL
PHYSICAL AND
CHEMICAL
PROPERTIES**

Physical state: Liquid
Appearance and odor: Clear / Chemical
Colors available: Undyed
Solubility in water: 100% Miscible
Weight, lb/gal, 60°F (15.6°C): 8.67
Specific gravity, (H₂O = 1): 1.04
Boiling point, °F (°C): 212 (100.0)
Flash point, COC, °F (°C): None, Self extinguishing
Fire point, COC, °F (°C): NA
Freezing point (or pour point), °F, (°C): 28 (-2)
If frozen, thaw completely at room temperature.
pH, concentrate: 10.0
pH, 5.0% mix, typical operating conditions: 8.9
Total chlorine/chloride, wt%, calculated: 5.2/<50 ppm
Total sulfur, wt%, calculated: 0.2
Silicone: Yes

PACKAGING

Available in 5-gallon pails, 55-gallon drums, and bulk containers.

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.

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

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.

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