



YOUR METALWORKING FLUID SOLUTIONS FOR SOLUTIONS

OAKFLO[®] DST 6100 ML METALWORKING OIL

APPLICATIONS	<p>OAKFLO[®] DST 6100 ML is designed for use in misting applications or Minimal Quantity Lubrication (MQL) applications. It is designed for all ferrous metals and some aluminum.</p> <p>Metals: Cast Iron, Carbon Steels, High Speed Steel, High Alloy Steels, Stainless Steels, and some Aluminum alloys.</p> <p>Duty Range: For moderate to heavy-duty operations such as drilling, tapping, reaming and sawing.</p>
FEATURES & BENEFITS	<p>EXCELLENT LUBRICITY – Low cutting force. Contains a non-chlorinated, non-sulfur, synthetic lubricant.</p> <p>EXCELLENT TOOL LIFE AND SURFACE FINISH – Performs extremely well in milling tests conducted on steel parts. Used neat, no need to dilute with water or other materials.</p> <p>EXCELLENT CLEANLINESS – Finished parts and chips are almost dry. Very low mist, odors, and residue. Pares can be easily cleaned with and alkaline cleaner.</p> <p>LOW VISCOSITY FLUID – For easy application and excellent cleanliness.</p> <p>ENVIRONMENTALLY FRIENDLY – Product formula is derived from natural, renewable resources. Does not contain mineral oil.</p> <p>CORROSION CONTROL – Non-staining on ferrous metals and some non-ferrous metals, including aluminum alloys such as 2024 and 7075.</p> <p>ECONOMICAL – Minimal Quantity Lubricators applying fluid directly to parts minimize quantities of fluid used. Eliminates recharge and disposal costs associated with recirculating fluid systems.</p>

<p>RECOMMENDED STARTING DILUTIONS</p>	<p>FOR INDUSTRIAL USE ONLY</p> <p>Use neat (as is) for moderate to heavy-duty machining of ferrous and non-ferrous metals.</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>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</p>	<p>Physical state: Liquid Appearance and odor: Clear / Chemical Colors available: Undyed Solubility in water: Insoluble Weight, lb/gal, 60°F (15.6°C): 7.5 Specific gravity, (H₂O = 1): 0.90 Boiling point, °F (°C): 500 (260) Flash point, COC, °F (°C): 365 (185) Fire point, COC, °F (°C): 380 (190) Freezing point (or pour point), °F, (°C): 20 (-7) If frozen, thaw completely at room temperature. pH, concentrate: NA Total chlorine/chloride, wt%, calculated: 0.00/<50 ppm Total sulfur, wt%, calculated: 0.00 Silicone: None</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</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><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></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 B20073 8/132012</p>	

