



YOUR METALWORKING FLUID SOLUTIONS FOR SOLUTIONS

OAKFLO[®] DSY 4600

SYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>OAKFLO[®] DSY 4600 synthetic metalworking fluid is recommended for machining and grinding of ferrous metals.</p> <p>Metals: Cast Iron, Nodular Iron, Carbon Steels, Ferrous Metals</p> <p>Duty Range: For light to moderate-duty operations</p>
FEATURES & BENEFITS	<p>OAKFLO[®] DSY 4600 can be used in central systems as well as individual machines on ferrous applications. It is stable in both hard and soft water.</p> <p>RANCIDITY CONTROL – Exceptionally good bacteria and mold control.</p> <p>CLEANLINESS – Excellent clarity and cleanliness – Emulsifies very little tramp oil – Tramp oil floats on top of the mix and can be removed easily by an oil skimmer.</p> <p>EXCELLENT FOAM CONTROL – Even in operations with high agitation.</p> <p>EXCELLENT SETTLING PROPETIES – Cast iron and graphite fines settle readily – Mix stays clean – Finish-marring chips and grit do no recirculate throughout the system.</p> <p>DEPLETION RESISTANT – Lean make-up keeps the concentration at the recommended dilution since it is not easily degraded by bacteria, or depleted by high chip loads – Reduces costs by reducing the amount of concentrate required for make-up.</p> <p>CORROSION CONTROL – Excellent rust control on cast iron and steel due to its unique proprietary combination of rust inhibitors.</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® DSY 4600 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, BCG 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): 8.6

Flash point, COC, °F (°C): NA

Fire point, COC, °F (°C): NA

If frozen, thaw completely at room temperature. Inside storage is recommended

pH, concentrate: 9.9

pH, 5.0% mix, typical operating conditions: 9.1

Total chlorine/chloride, wt%, calculated: 0.00/0.1

Total sulfur, wt%, calculated: 0.00

Silicone: None

PACKAGING

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

REFRACTOMETER FACTOR: 3.9

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.

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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