



YOUR METALWORKING FLUID SOLUTIONS FOR SOLUTIONS

OAKFLO[®] DSO 5400X SOLUBLE OIL, MULTI-PURPOSE LUBRICANT

APPLICATIONS	<p>OAKFLO[®] DSO 5400X metalworking fluid is a premium soluble oil designed for moderate to heavy-duty machining and grinding of ferrous and non-ferrous materials.</p> <p>Metals: Carbon Steels, High Speed Steel, Cast Steels, Alloy Steels, Tool Steel, Stainless Steel, Cast Iron, Aluminum</p> <p>Duty Range: For moderate to heavy-duty operations</p>
FEATURES & BENEFITS	<p>EXCELLENT LUBRICITY – Contains a chlorinated extreme pressure lubrication package to perform on a variety of machining and grinding applications.</p> <p>VERY GOOD RANCIDITY CONTROL – Contains a microbial package which extends fluid life for long lasting, trouble-free performance.</p> <p>LOW FOAMING – Can be used in high turnover, high-pressure applications where foam control is required.</p> <p>WIDE APPLICATION RANGE – Can be used on a wide variety of metals and operations.</p> <p>OPERATOR FRIENDLY – Mild to skin – Easy to mix.</p>

<p>RECOMMENDED STARTING DILUTIONS</p>	<p>FOR INDUSTRIAL USE ONLY Use between 4.0% (1:20) and 6.7% (1:15) for moderate to heavy-duty machining and grinding ferrous and non-ferrous metals and neat (100%) as a gear box lubricant.</p> <p>OAKFLO® DSO 5400X is to be mixed with water for use. Add concentrate to water and stir or circulate to insure thorough mixing.</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): 8.4 Specific gravity, (H₂O = 1): 1.01 Boiling point, °F (°C): NA Flash point, COC, °F (°C): 360 (182) Fire point, COC, °F (°C): 380 (193) Freezing point (or pour point), °F, (°C): 28 (-2) If frozen, thaw completely at room temperature. pH, concentrate: NA pH, 5.0% mix, typical operating conditions: 8.6 Total chlorine/chloride, wt%, calculated: 7.53/<50 ppm Total sulfur, wt%, calculated: 0.10 Silicone: Yes</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR: 0.9 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 six months of its manufacture date indicated by the lot number on the container 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><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 B20097 2/15/2012</p>	

