



YOUR METALWORKING FLUID SOLUTIONS FOR SOLUTIONS

OAKFLO[®] DSS 791CU

SEMISYNTHETIC, METALWORKING FLUID CONCENTRATE

<p>APPLICATIONS</p>	<p>OAKFLO[®] DSS 791CU is designed for machining and grinding copper and brass. May also be used on some applications with other metals.</p> <p>Metals: Copper, Brass, Bronze, Cast Iron, Nodular Iron, Carbon Steels, High Speed Steel, High Alloy Steels, Stainless Steels, Aluminum.</p> <p>Duty Range: For moderate to heavy-duty operations</p>
<p>FEATURES & BENEFITS</p>	<p>OAKFLO[®] DSS 791CU is a new-generation semisynthetic metalworking fluid that blends the technological advantages of synthetic fluids with the performance capabilities of soluble oils.</p> <p>LUBRICITY – Physical and chemical lubricants provide good machining and grinding properties- Keeps parts and tools cool.</p> <p>NON-FERROUS CORROSION CONTROL – Excellent non-ferrous corrosion inhibitors which prevent stain on copper, brass, bronze and aluminum alloys.</p> <p>FERROUS CORROSION CONTROL – Corrosion inhibitor package is also effective in preventing in-process corrosion on machines and parts.</p> <p>SUPERIOR RANCIDITY CONTROL – Effective protection against bacteria and mold.</p> <p>GENERAL PURPOSE PRODUCT – Can be used economically throughout the shop on light, moderate and some heavy-duty operations; just vary the dilution to suit the job requirements.</p> <p>MACHINE FRIENDLY – Light residue keeps machine tool components free moving.</p> <p>ENVIRONMENTALLY FRIENDLY – Easy to maintain and control – It is waste treatable – It may also be recycled for reuse.</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 791CU 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): 8.4

Specific gravity, (H₂O = 1): 1.01

Boiling point, °F (°C): 212 (100.0)

Flash point, COC, °F (°C): None, Self extinguishing

Fire point, COC, °F (°C): None, Self extinguishing

Freezing point (or pour point), °F, (°C): 30 (-1)

If frozen, thaw completely at room temperature.

pH, concentrate: 9.0

pH, 5.0% mix, typical operating conditions: 8.6

Total chlorine/chloride, wt%, calculated: 0.00/<50 ppm

Total sulfur, wt%, calculated: 0.20

Silicone: None

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.

3000 Disney Street
Cincinnati, Ohio 45209
1-513-458-8199 Fax: 1-513-458-817

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