



# YOUR METALWORKING FLUID SOLUTIONS FOR SOLUTIONS

## OAKFLO<sup>®</sup> DSY 31 BVX SYNTHETIC, METALWORKING FLUID CONCENTRATE

<b>APPLICATIONS</b>	<p><b>OAKFLO<sup>®</sup> DSY 31 BVX</b> metalworking fluid is recommended for machining and grinding operations on non-ferrous and ferrous metals.</p> <p><b>Metals:</b> Wrought Aluminum Alloys (2024, 6061, 7050, 7075), Cast Aluminum Alloys (380, 390), Cast Iron, Nodular Iron, Carbon Steels, Stainless Steels, Titanium, Other Exotic Alloys</p> <p><b>Duty Range:</b> For moderate to heavy-duty operations</p>
<b>FEATURES &amp; BENEFITS</b>	<p><b>OAKFLO<sup>®</sup> DSY 31 BVX</b> is a unique, low pH synthetic metalworking fluid. This versatile product can be used as a creep feed grinding fluid for exotic metals and also form tap most aluminum alloys.</p> <p><b>EXCELLENT LUBRICITY</b> - Provides excellent tool life and surface finish.</p> <p><b>EXCELLENT CLEANLINESS</b> - Rejects tramp oil to keep product clean, which extends sump life.</p> <p><b>OPERATOR - FRIENDLY</b> - Provides excellent part visibility - A fresh mix is transparent - No Smoke - Low misting – The product runs at a low operating pH range, making it mild to the skin.</p> <p><b>EXCELLENT MACHINE COMPATIBILITY</b> - Very low foaming even when used with deionized water</p> <p><b>EXCELLENT RANCIDITY CONTROL</b> - Excellent fluid life - Minimizes the need for additives</p> <p><b>ENVIRONMENTALLY FRIENDLY</b> - Easily recycled</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 31 BVX** 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):** 8.8

**Specific gravity, (H<sub>2</sub>O = 1):** 1.05

**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):** 24 (-4)

If frozen, thaw completely at room temperature.

**pH, concentrate:** 7.7

**pH, 5.0% mix, typical operating conditions:** 7.5

**Total chlorine/chloride, wt%, calculated:** 0.00/0.09

**Total sulfur, wt%, calculated:** 0.00

**Silicone:** None

**PACKAGING**

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

**REFRACTOMETER FACTOR: 2.6**

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](http://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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