



# YOUR METALWORKING FLUID SOLUTIONS FOR SOLUTIONS

## OAKFLO<sup>®</sup> DSY 33 BVX SYNTHETIC, METALWORKING FLUID CONCENTRATE

<b>APPLICATIONS</b>	<p>OAKFLO<sup>®</sup> DSY 33 BVX metalworking fluid is recommended for heavy-duty machining and grinding operations on non-ferrous or ferrous metals.</p> <p><b>Metals:</b> Aluminum Alloys (2024, 6061, 7050, 7075, 380, 390), Cast Iron, Nodular Iron, Carbon Steels, Stainless Steels, Titanium, Other Exotic Alloys, Copper Alloys, Brass Alloys and Bronze Alloys</p> <p><b>Duty Range:</b> For moderate to heavy -duty operations</p>
<b>FEATURES &amp; BENEFITS</b>	<p>OAKFLO<sup>®</sup> DSY 33 BVX is a unique, low pH synthetic fluid designed for use as an aluminum machining fluid, including form tapping of most aluminum alloys. It also offers very good ability on ferrous metals, such as creep feed grinding of exotic materials.</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 - Mild to the skin. The OAKFLO<sup>®</sup> DSY 33 BVX operates at a very low pH range.</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>

<p><b>RECOMMENDED STARTING DILUTIONS</b></p>	<p><b>FOR INDUSTRIAL USE ONLY</b>  <b>Use between 5.0% (1:20) and 10.0% (1:10) for machining and grinding ferrous and nonferrous metals.</b></p> <p><b>OAKFLO® DSY 33 BVX</b> is to be mixed with water for use (add concentrate to water).</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><b>For concentration analysis, use</b> the Total Alkalinity Titration Procedure, BCG Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.</p>
<p><b>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</b></p>	<p><b>Physical state:</b> Liquid  <b>Appearance and odor:</b> Clear, chemical  <b>Colors available:</b> Undyed  <b>Solubility in water:</b> 100% Miscible  <b>Weight, lb./gal., 60°F (15.6°C):</b> 8.8  <b>Specific gravity, (H<sub>2</sub>O = 1):</b> 1.06  <b>Boiling Point, °F (°C):</b> 212 (100)  <b>Flash Point, COC, °F (°C):</b> None, self extinguishing  <b>Fire Point, COC, °F (°C):</b> NA  <b>Extinguishing media:</b> NA  <b>Unusual fire &amp; explosion hazards:</b> None  <b>Freezing point (or pour point), °F, (°C):</b> 24 (-4)          If frozen, product separates. Thaw completely at room temperature and stir thoroughly.  <b>pH, concentrate:</b> 7.9  <b>pH, 5.0% mix, typical operating conditions:</b> 7.5  <b>Total chlorine/chloride, wt%, calculated:</b> 0.00/&lt;0.1  <b>Total sulfur, wt%, calculated:</b> 0.00  <b>Silicone:</b> None  <b>Triazine:</b> None</p>
<p><b>PACKAGING</b></p>	<p><b>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</b></p>
<p><b>REFRACTOMETER FACTOR = 2.5</b> Multiply the scale reading obtained on your refractometer by the <b>Refractometer Factor</b> to obtain the mix concentration in percent.</p> <p><b>NOTE: Calibrate the refractometer so that it reads 0.0 with water, before testing the sample mix. Remove gross contaminants from the sample mix before testing.</b></p>	
<p>For additional information concerning OAKFLO® DSY 33 BVX, refer to its OSHA MSDS or contact Technical Services at 1-513-458-8199. Reprints/Updates of this Product Information Flyer (PIF) can be found on our web site, <a href="http://WWW.OAKINTERNATIONAL.COM">WWW.OAKINTERNATIONAL.COM</a> or from your OAK® INTERNATIONAL representative.</p> <p>Minor formulation changes or normal variations in the manufacture of this product may cause slight variances in the data presented on this sheet.</p> <p>Milacron Marketing Company          Cincinnati, Ohio 45209</p> <p>PC-10042 <span style="float: right;">04/03/2009</span></p>	

