



YOUR METALWORKING FLUID SOLUTIONS FOR SOLUTIONS

OAKFLO[®] DSY 35 BVX SYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>OAKFLO[®] DSY 35 BVX metalworking fluid is recommended for heavy-duty machining and grinding operations on non-ferrous or ferrous metals.</p> <p>Metals: Aluminum Alloys (2024, 6061, 7050, 7075, 380, 390), Cast Iron, Nodular Iron, Carbon Steels, Stainless Steels, Titanium, Other Exotic Alloys</p> <p>Duty Range: For moderate to heavy-duty operations</p>
FEATURES & BENEFITS	<p>OAKFLO[®] DSY 35 BVX is a unique, low pH synthetic fluid designed for heavy-duty aluminum machining, including form tapping, also exhibits excellent ferrous machining characteristics as well</p> <p>EXCELLENT LUBRICITY - Provides excellent tool life and surface finish – Excellent lubricity for machining non-ferrous metals.</p> <p>EXCELLENT CLEANLINESS - Rejects tramp oil and settles ferrous chips quickly to keep product clean, which extends sump life.</p> <p>OPERATOR - FRIENDLY - 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>EXCELLENT MACHINE COMPATIBILITY - Very low foaming even when used with deionized water</p> <p>EXCELLENT RANCIDITY CONTROL - Excellent fluid life - Minimizes the need for additives</p> <p>ENVIRONMENTALLY FRIENDLY - 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 35 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): 8.9
Specific gravity, (H₂O = 1): 1.07
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): 14 (-10)
If frozen, thaw completely at room temperature.
pH, concentrate: 7.9
pH, 5.0% mix, typical operating conditions: 7.5
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: 2.0

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.

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