



YOUR METALWORKING FLUID SOLUTIONS FOR SOLUTIONS

OAKFLO[®] DSY 4304

SYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>OAKFLO[®] DSY 4304 metalworking fluid is recommended 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-duty operations</p>
FEATURES & BENEFITS	<p>OAKFLO[®] DSY 4304 is a unique, low pH synthetic fluid designed for the aerospace industry</p> <p>CORROSION CONTROL – Provides excellent bimetallic corrosion control especially on 7475 and 6061 aluminum and steel.</p> <p>EXCELLENT CLEANLINESS - Rejects tramp oil 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 – Mild to the skin.</p> <p>EXCELLENT RANCIDITY CONTROL – Excellent fluid life – Minimizes the need for additives.</p> <p>EXCELLENT MACHINE COMPATIBILITY – Very low foaming even when used with deionized water.</p> <p>ENVIRONMENTALLY FRIENDLY - Easily recycled</p>

<p>RECOMMENDED STARTING DILUTIONS</p>	<p>FOR INDUSTRIAL USE ONLY Recommended Starting Dilution: 5% (1:20) Typical Operating Range: 5%- 10% (1:20 to 1:10)</p> <p>OAKFLO® DSY 4304 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>For concentration analysis, use the Total Alkalinity Titration Procedure, BCG 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): 8.9 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): 16 (-9) If frozen, thaw completely at room temperature. pH, concentrate: 8.2 pH, 5.0% mix, typical operating conditions: 8.0 Total chlorine/chloride, wt%, calculated: 0.00/0.09 Total sulfur, wt%, calculated: 0.00 Silicone: None</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>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. This product is to be used within 6 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>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.</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 B20153 2/16/2012</p>	

