



# CUSTOMER-FOCUSED METALWORKING FLUID SOLUTIONS

## OAKFLO® DSS-CV3

SEMISYNTHETIC, METALWORKING FLUID CONCENTRATE

<b>APPLICATIONS</b>	<p><b>OAKFLO DSS-CV3</b> is an economical, water soluble, semisynthetic metalworking fluid.</p> <p><b>Metals:</b> Cast Iron, Nodular Iron, Carbon Steels, Alloy Steels, Aluminum, Copper, Brass, Bronze</p> <p><b>Duty Range:</b> For light to moderate-duty operations</p>
<b>FEATURES &amp; BENEFITS</b>	<p><b>OAKFLO DSS-CV3</b> is a low-cost, general-purpose machining and grinding fluid, which can be used on a variety of materials and operations.</p> <p><b>EXCEPTIONALLY MILD</b> - A good choice for individual machine applications where mixes tend to become more concentrated than recommended.</p> <p><b>EXCELLENT CLEANLINESS</b> - Provides clean parts and keeps machines clean - Good residue characteristics - residue is easily removed with an alkaline cleaner or just warm water</p> <p><b>LOW OIL EMULSIFICATION</b> - Low Oil Emulsification - Extraneous oil can be skimmed from the mix, thus preserving performance characteristics and prolonging fluid life</p> <p><b>EXCELLENT FOAM CONTROL</b> - low foaming, even in soft water (less than 125 ppm total hardness)</p> <p><b>GOOD RANCIDITY CONTROL</b> - Inhibits the growth of bacteria and mold; helps to eliminate "Monday morning odor"</p> <p><b>ENVIRONMENTALLY-FRIENDLY</b> - Good sump life and operator acceptance - Is easy to maintain and control - It is waste treatable using standard fluid treatment procedures and systems - Can also be recycled for reuse using appropriate metalworking fluid recycling equipment</p>

<p><b>RECOMMENDED STARTING DILUTIONS</b></p>	<p><b>FOR INDUSTRIAL USE ONLY</b>  <b>Recommended Starting Dilution: 10% (1:10)</b>  <b>Typical Operating Range: 8% (1:13) to 12% (1:8)</b>  <b>For concentrations outside this range contact Technical Service at 513-458-8199.</b></p> <p><b>OAKFLO DSS-CV3</b> is to be mixed with water for use (add concentrate to water). Add no other substances to the concentrate or mix unless approved by Technical Services.</p> <p>Not recommended for use with magnesium or alloyed magnesium.</p> <p><b>For concentration analysis, use</b> the MI Titration Procedure, Non-Solvent Titration Procedure, Total Alkalinity 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> 8.4  <b>Specific gravity, (H<sub>2</sub>O = 1):</b> 1.00  <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> None, Self Extinguishing  <b>Freezing point, °F, (°C):</b> 30 (-3)          If frozen, product separates. Thaw completely at room temperature and stir thoroughly.  <b>pH, concentrate:</b> 9.9  <b>pH, 10.0% mix, typical operating conditions:</b> 9.6  <b>Total chlorine/chloride, wt%, calculated:</b> 0.00  <b>Total sulfur, wt%, calculated:</b> 0.140  <b>Silicones:</b> None</p>
<p><b>PACKAGING</b></p>	<p><b>Available in 19 Liter pails, 200 Liter drums and bulk containers.</b></p>
<p><b>REFRACTOMETER FACTOR = 3.7</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>This product to be used within six months of its manufacture date indicated by the lot number on the container label.</p>	
<p>For additional information concerning OAKFLO DSS-CV3, refer to its WHMIS MSDS, website or contact OAK SIGNATURE® Technical Services at 1-513-458-8199 in Ohio or 1-888-254-1919 in Canada. Reprints/Updates of this Product Information Flyer (PIF) can be found on our web site, <a href="http://WWW.OAKINTERNATIONAL.CA">WWW.OAKINTERNATIONAL.CA</a> or from your OAK SIGNATURE® 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>3/2/11 <span style="float: right;">Cincinnati, Ohio 45209</span></p>	

