



CUSTOMER – FOCUSED METALWORKING FLUID SOLUTIONS

OAKFLO[®] DSS 700

SEMISYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS

OAKFLO DSS 700 is recommended for general-purpose machining and grinding of ferrous and nonferrous metals.

Metals: Carbon/Cast Steel, Cast/Nodular/Malleable/Gray Iron, Aluminum, High Speed Steel, High Alloy Steels, Stainless Steels

Duty Range: For light to moderate-duty operations.

FEATURES & BENEFITS

OAKFLO DSS 700 metalworking fluid blends the advantages of synthetics with the performance of soluble oils.

EXCELLENT BIOLOGICAL CONTROL - Effective protection against bacteria and mold. No "Monday Morning" odors - This ensures long fluid life, minimizes the use of additives, and increases operator satisfaction

OPERATOR AND MACHINE-FRIENDLY - No smoke - No slippery film on parts, machines or floors - Mild to skin when used as recommended - Liquid residue keeps machine tool components free-moving regardless of equipment age.

CORROSION CONTROL – Contains nonferrous corrosion inhibitors.

VERSATILE - Its broad concentration range 1:20 (5%) to 1:10 (10%) and performance capabilities allow OAKFLO DSS 700 to perform well in both individual machine sump and central system applications.

ENVIRONMENTALLY-FRIENDLY - Easy to maintain and can be recycled for extended life.

**RECOMMENDED
STARTING
DILUTIONS**

FOR INDUSTRIAL USE ONLY

**Recommended Starting Dilution: 5% (1:20)
Typical Operating Range: 5% (1:20) to 10% (1:10)
For concentrations outside this range contact Technical
Service at 513-458-8199.**

OAKFLO® DSS 700 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. Not recommended for use with magnesium or alloyed magnesium.

For concentration analysis use a refractometer or the Non-Solvent Titration Procedure.Solvent Titration Procedure.

**TYPICAL
PHYSICAL AND
CHEMICAL
PROPERTIES**

Physical state:Liquid
Appearance and odor: Clear / Chemical
Colors available:..... Undyed, Blue
Solubility in water:..... 100% Miscible
Weight, lb/gal, 60°F (15.6°C):..... 8.5
Specific gravity, (H₂O = 1):..... 1.02
Boiling point, °F (°C):212 (100)
Flash point, COC, °F (°C): None, Self extinguishing
Fire point, COC, °F (°C): None, Self extinguishing
Freezing point (or pour point), °F, (°C):.....30 (-1)

If frozen, thaw completely at room temperature.

pH, concentrate: 9.6
pH, 5.0% mix, typical operating conditions: 9.0
Total chlorine/chloride, wt%, calculated: 0.000 / < 50 ppm
Total sulfur, wt%, calculated: 0.155
Silicones:.....None

PACKAGING

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

REFRACTOMETER FACTOR = 2.2 Multiply the scale reading obtained on most refractometers by the **Refractometer Factor** to obtain the mix concentration in percent.

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.

For additional information concerning **OAKFLO® DSS 700**, 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, WWW.OAKINTERNATIONAL.COM or from your OAK INTERNATIONAL representative.

Minor formulation changes or normal variations in the manufacture of this product may cause slight variances in the data presented on this sheet.
Consumable Products Division/ Milacron Marketing Company
Cincinnati, Ohio 45209

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ISO CERTIFIED

