



# CUSTOMER – FOCUSED METALWORKING FLUID SOLUTIONS

## OAKFLO<sup>®</sup> DSS T-TECH SEMISYNTHETIC, METALWORKING FLUID CONCENTRATE

### APPLICATIONS

**OAKFLO DSS T-TECH** is a general-purpose fluid recommended for machining and grinding aluminum, iron and steel. It has the performance capabilities of soluble oils. It is also recommended for tapping, reaming, turning, drilling, internal grinding, and centerless grinding.

**Metals:** Cast Iron, Nodular Iron, Carbon Steels, High Speed Steel, High Alloy Steels, Stainless Steels, Aluminum

**Duty Range:** For moderate to heavy-duty operations.

### FEATURES & BENEFITS

**OAKFLO DSS T-TECH** metalworking fluid is a clean, completely water soluble, phenol-free, silicone-free, semi synthetic product that contains an extreme pressure (EP) lubricant for superior machining and grinding capability. It is designed to be low foaming in soft water (less than 125 ppm total hardness).

**Advantages:** Economical, Excellent lubricity, Excellent rancidity and mold control, Outstanding cleanliness, Leaves a soft residue.

**Biostable:** Exceptionally good bacteria and mold control - Resists attack by mold and bacteria.

Is easily waste treatable using standard fluid treatment procedures and systems. It can also be recycled for reuse using appropriate metalworking fluid recycling equipment.

Very Cost effective.

**Versatile:** Specially designed for excellent machining and grinding of aluminum, iron and steel.

Parts and machines stay very clean.

Excellent corrosion control on both ferrous and nonferrous metals

**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 T-TECH** 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.

**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):**..... 8.7  
**Specific gravity, (H<sub>2</sub>O = 1):**..... 1.04  
**Boiling point, °F (°C):** .....212 (100)  
**Flash point, COC, °F (°C):** ..... None, Self extinguishing  
**Fire point, COC, °F (°C):** ..... NA  
**Extinguishing media:** ..... NA  
**Unusual fire & explosion hazards:** .....None  
**Freezing point (or pour point), °F, (°C):**.....24 (-4)  
If frozen, product separates. Thaw completely at room temperature and stir thoroughly.  
**pH, concentrate:** ..... 9.2  
**pH, 5.0% mix, typical operating conditions:** ..... 8.9  
**Total chlorine/chloride, wt%, calculated:**..... 3.50/< 50 ppm  
**Total sulfur, wt%, calculated:** ..... 0.20  
**Silicones:**.....None

**PACKAGING**

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

**REFRACTOMETER FACTOR = 1.7** 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 T-TECH**, 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](http://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  
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ISO CERTIFIED

