



OAK INTERNATIONAL
Global Metalforming Fluids

OAK DRAW[®] 704

STAMPING AND DRAWING FLUID CONCENTRATE

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| APPLICATIONS | <p>OAK DRAW 704 is a heavy-duty drawing and stamping fluid for ferrous and non-ferrous metals. OAK DRAW 704 combines the ultimate in extreme pressure lubrication and film strength with state-of-the-art synthetic lubricant technology. Because of its exceptional lubricity and anti-wear properties, OAK DRAW 704 will outperform many conventional oil-based lubricants on the market.</p> <p>Operations: OAK DRAW 704 performs well in deep drawing, stamping/blanking, bending/forming, punching/piercing and trimming operations.</p> <p>Duty Range: For heavy-duty operations.</p> |
| COMPETITIVE ADVANTAGES | <p>SUPERIOR DIE AND TOOL LIFE</p> <p>EXCELLENT CORROSION INHIBITION ON FERROUS METALS</p> <p>CLEANER PRESSES, DIES AND TOOLING</p> <p>VERSATILE PRODUCT – performs on presses with single, compound, progressive and transfer dies</p> <p>ENVIRONMENTALLY SOUND – eliminates oil mist and reduces disposal treatment procedures</p> <p>NO SOLVENTS OR FIRE HAZARDS</p> <p>SAFE ON NON-FERROUS AND EXOTIC ALLOYS</p> <p>NO GUMMING OR DEPOSITS WHEN APPLIED (AND MAINTAINED) AT PROPER CONCENTRATION</p> |

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| <p>GETTING STARTED</p> | <p>FOR INDUSTRIAL USE ONLY The proper concentration of OAK DRAW 704 for a particular metalforming process will vary dependent upon the type of metal, gauge of metal, process involved and method of lubricant application. We recommend the use of a refractometer to control concentration for economy and performance purposes. Add no other substances to the concentrate or mix unless approved by your OAK Representative. Not recommended for use with magnesium or alloyed magnesium.</p> |
| <p>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</p> | <p>Physical state: Liquid Appearance and odor: Clear, chemical Color available: Dark amber Solubility in water: 100% miscible Weight, lb/gal, 60°F (15.6°C): 9.0 Specific gravity, (H₂O = 1): 1.08 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): Not determined If frozen, thaw completely and stir thoroughly prior to using. pH, concentrate: 8.8 pH, 10.0% mix, typical operating conditions: 8.5 Total chlorine, wt%, calculated: 2 Total sulfur, wt%, calculated: Negligible Silicones: None</p> |
| <p>PACKAGING</p> | <p>Available in 5-gallon pails, 55-gallon drums and bulk containers.</p> |
| <p>REFRACTOMETER FACTOR = 1.25 Multiply the scale reading obtained on most refractometers by the Refractometer Factor to obtain the mix concentration in percent.</p> | |
| <p>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.</p> | |
| <p>For additional information concerning OAK DRAW 704, refer to its OSHA MSDS or contact OAK INTERNATIONAL at 1-269-651-9790.</p> | |
| <p>WARRANTY: Oak International, Inc. will grant credit on any product which proves defective in material or workmanship as determined by us subject to the following conditions: all material is subject to our inspection prior to issuing credit; any refund will be adjusted based on the volume of product used; no credit will be granted for used or unused product(s) over one year old as determined by the batch number. The terms in this warranty do not in any way extend to any product thereof covered by this agreement, which has a life, under normal usage, inherently shorter than the one year period indicated above. Except as set forth expressly in writing herein, there are no other warranties express or implied in respect of any product. No warranty of merchantability or fitness for purpose shall apply.</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.</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. 11/12/07 REV</p> | |