



OAK INTERNATIONAL
Global Metalforming Fluids

OAK DRAW[®] 730-HW-1

SYNTHETIC, METALFORMING FLUID CONCENTRATE

APPLICATIONS	<p>OAK DRAW 730-HW-1 is a medium-duty drawing and stamping fluid for ferrous and non-ferrous metals. When added to water, OAK DRAW 730-HW-1 forms a transparent solution with exceptional film strength and friction reducing properties. It works exceptionally well in hard water.</p> <p>Operations: OAK DRAW 730-HW-1 is used to draw, stamp, rollform, bend and knurl non-ferrous and ferrous metals.</p> <p>Duty Range: For medium-duty operations.</p>
COMPETITIVE ADVANTAGES	<p>STABLE IN HARD AND SOFT WATERS</p> <p>SUPERIOR DIE AND TOOL LIFE</p> <p>HIGH DETERGENCY KEEPS PRESS AND TOOLING CLEAN</p> <p>OIL-FREE PRODUCT</p> <p>NON-FOAMING FOR RECIRCULATING SYSTEMS</p> <p>EXCELLENT CORROSION PROTECTION ON FERROUS METALS</p> <p>EXCELLENT FILM STRENGTH TO MAXIMIZE PART COVERAGE AND FORMABILITY</p> <p>OUTSTANDING TRAMP OIL REJECTION PROPERTIES TO PREVENT SOLUTION RANCIDITY AND EXTEND SUMP LIFE</p> <p>DEPOSITED FILM IS DRY TO TOUCH, DEPENDENT ON CONCENTRATION</p>

<p>GETTING STARTED</p>	<p>FOR INDUSTRIAL USE ONLY The proper concentration of OAK DRAW 730-HW-1 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.</p> <p>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, Faint Color available: Yellow 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): NA Extinguishing media: NA Unusual fire & explosion hazards: None Freezing point (or pour point), °F, (°C): 32 (0) If frozen, thoroughly thaw and mix prior to using. pH, concentrate: 8.6 pH, 10% mix: 8.3 Total chlorine, wt%, calculated: 0.00 Total sulfur, wt%, calculated: Negligible Mercurials, phenols, PCB's, PTBBA, nitrate, diethanolnitrosamine, chlorinated paraffins, chlorinated solvents, mineral oil: None Silicones: Yes</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 1.7 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>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. 10/31/07 REV</p>	