



OAK INTERNATIONAL
Global Metalforming Fluids

OAK DRAW[®] 785

SYNTHETIC, METALFORMING FLUID CONCENTRATE

APPLICATIONS	<p>Oak Draw 785 is a heavy-duty, synthetic drawing and stamping lubricant for ferrous and non-ferrous metals.</p> <p>Oak Draw 785, when added to water, forms a transparent solution with exceptional film strength and friction-reducing properties.</p> <p>Oak Draw 785 is used to draw, stamp, roll form, bend and knurl steel, stainless steel, aluminum and copper.</p>
COMPETITIVE ADVANTAGES	<ul style="list-style-type: none">• Stable in hard or soft water.• Superior die and tool life.• High detergency keeps press and tooling clean.• Chlorine-free, sulfur-free, oil-free.• Non-foaming for recirculating systems.• Excellent corrosion control.• Excellent film strength to maximize part coverage and formability.• Outstanding tramp oil rejection properties to prevent solution rancidity and to extend sump life.• Dependent on concentration, deposited film is dry to touch.

<p>GETTING STARTED</p>	<p>FOR INDUSTRIAL USE ONLY</p> <p>Recommended starting dilution is 30% (add concentrate to water). The proper concentration of Oak Draw 785 for a particular metalforming process will vary dependent upon the type of metal, gauge of metal, process involved and method of lubricant application.</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 chemical Color available: Undyed (Yellow) Solubility in water: Complete at all dilutions Weight, lb/gal, 60°F (15.6°C): 8.6 Specific gravity, (H₂O = 1): 1.03 Boiling point, °F (°C): 212 (100) Flash point, Seta CC, °F (°C): None, self extinguishing Extinguishing media: N/A Unusual fire & explosion hazards: None Freezing point (or pour point), °F (°C): 27 (-3) If frozen, thaw completely at room temperature prior to use. pH, concentrate: 8.3 pH, 30.0% mix, typical operating conditions: 8.2 Total chlorine, wt%, calculated: 0.0 Total sulfur, wt%, calculated: 0.0 Silicones: Yes</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 2.4 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 785, 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. 6/20/07 REV</p>	