



OAK DRAW[®] 951

STAMPING AND DRAWING OIL

APPLICATIONS	<p>Oak Draw 951 Lubricant is specifically developed for a vacuum or thermal de-oiling process. This lubricant is designed to extend tool life, maximize forming operations and vaporize with heat from the formed product. This characteristic eliminates a post-cleaning operation.</p> <p>Oak Draw 951 can be removed in a vacuum furnace, CAB (Controlled Atmosphere Brazing) furnace, or a thermal de-oiling furnace.</p> <p>Oak Draw 951 Lubricant may be used on aluminum and aluminum alloys for fin production or stamping processes.</p>
COMPETITIVE ADVANTAGES	<ul style="list-style-type: none">▪ Good die and tool life.▪ Pre-tested on aluminum fin mills.▪ High lubricity and wet-ability for drawing aluminum sheetstock.▪ Safe on all aluminum and aluminum alloys.▪ Compatible with a CAB or vacuum brazing process.▪ Eliminates post cleaning by aqueous or vapor methods.▪ Vaporizes 100% at a relatively low furnace temperature.

<p>GETTING STARTED</p>	<p>FOR INDUSTRIAL USE ONLY</p> <p>Oak Draw 951 Lubricant is used as received and can be applied by immersion or spray methods.</p> <p>Add no other substances to the concentrate or mix unless approved by your OAK Representative.</p>
<p>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</p>	<p>Physical state: Liquid Appearance and odor: Clear, slightly petroleum Color available: Clear to pale yellow Solubility in water: Insoluble Weight, lb/gal, 60°F (15.6°C): 6.84 Specific gravity, (H₂O = 1): 0.82 Viscosity, SUS, 100°F: 38 Boiling point, °F (°C): > 350 (> 176.7) Flash point, COC, °F (°C): 255 (123.9) Extinguishing media: CO₂, foam, dry chemical Unusual fire & explosion hazards: None pH, concentrate: Not Applicable Total chlorine, wt%, calculated: 0.0 Total sulfur, wt%, calculated: 0.0 Silicones: None</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums and bulk containers.</p>
<p>For additional information concerning OAK DRAW 951, 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. 6/21/07 REV</p>	

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