



OAK KOOL 625A-E

PRODUCT DESCRIPTION:

An integral part of Oak's Coolant Management Program, Oak Kool 625A-E is a heavy-duty soluble oil cutting fluid. It is designed for severe operations on tough alloys where extreme pressure is required. When added to water, Oak Kool 625A-E forms a stable, long-lasting emulsion.

PRODUCT APPLICATIONS:

OAK KOOL 625A-E is recommended for severe machining operations including broaching, screw machining, gear cutting, tapping and reaming, as well as turning, milling and drilling.

FEATURES & BENEFITS:

- *Better finish and longer tool life through excellent lubricity in severe operations.*
- *Ideally suited for NC and CNC machines.*
- *Good corrosion protection on ferrous metals.*
- *Does not stain non-ferrous metals*
- *Long sump life because of good biological resistance.*
- *Good hard water stability to 500 ppm (29 grains).*
- *No costly sump side additives needed because Oak Kool 625A-E is low-foaming.*
- *Non-irritating to skin.*

DIRECTIONS FOR USE:

Clean system thoroughly, rinse with water and disinfect with Oak's Sump Cleaner. Oak Kool 625A-E can be metered through automatic dispensing system available as part of Oak's Coolant Management Program. Contact your Oak International Sales Representative regarding cleaning procedure and dispenser.

RECOMMENDED STARTING DILUTIONS:

OPERATIONS	CARBON & CAST STEELS	HIGH ALLOY STEELS, STAINLESS STEEL	TOOL STEELS	ALUMINUM
GRINDING	(4-5%) 1:25-1:20	(4-5%) 1:25-1:20	(5-6%) 1:20-1:17	(5-6%) 1:20-1:17
MILLING, DRILLING, CUT OFF, SAWING, TURNING & SCREW MACHINING	(5-7%) 1:20-1:14	(5-7%) 1:20-1:14	(6-8%) 1:17-1:12	(5-7%) 1:20-1:14
TAPPING, REAMING, BROACHING, AND FORM MILLING	(8-10%) 1:12-1:10	(8-10%) 1:12-1:10	(8-10%) 1:12-1:10	(8-10%) 1:12-1:10

PHYSICAL DATA:

APPEARANCE

Concentrate.....Clear Dark Brown Liquid

Dilution.....White emulsion

ODOR.....Bland

SPECIFIC GRAVITY.....0.96 @ 20°C (68°F)

SOLUBILITY IN WATER.....Emulsifies

pH (5% dilution).....8.7 typical

REFRACTIVE INDEX FACTOR.....1.0

Refractometer reading X 1.0 = % Oak Kool 625A-E.

SAFETY AND HANDLING:

Consult Material Safety Data Sheet for detailed information.

FIRST AID:

Consult Material Safety Data Sheet.

STORAGE:

Store indoors. Keep from Freezing. Do not exceed temperatures above 120°F or below 32°F.

DISPOSAL:

Dispose in compliance with federal, state and local regulations.

PACKAGING:

AVAILABILITY: 5 Gallon Pails, 55 Gallon Drums, Liquibins, Tank Trucks.

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.

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.

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