



# CUSTOMER-FOCUSED METALWORKING FLUID SOLUTIONS

## OAKFLO<sup>®</sup> DSO 5307 SOLUBLE OIL, MULTI-PURPOSE LUBRICANT

<b>APPLICATIONS</b>	<p><b>OAKFLO<sup>®</sup> DSO 5307</b> metalworking fluid is a premium soluble oil designed for moderate to heavy-duty machining and grinding of ferrous and non-ferrous materials. It is a multi-purpose lubricant. The concentrate can be used neat ("As is") for use as a "Way" or "Gearbox" lubricant. In addition, it can be mixed with water for use as a machining or grinding fluid.</p> <p><b>Note:</b> Review "Gearbox" and "Slide-Way" lubricant compatibility issues prior to conversion from straight oils (See the OAK<sup>®</sup> INTERNATIONAL Product Focus Technical Bulletin titled "<u><a href="#">Metalworking Fluids Used As Gearbox &amp; Way Lubes</a></u>").</p> <p><b>Metals:</b> Carbon Steels, High Speed Steel, Cast Steels, Alloy Steels, Tool Steel, Stainless Steel, Titanium, Cast Iron, Aluminum, Bronze, Brass, Copper</p> <p><b>Duty Range:</b> For moderate to heavy-duty operations</p>
<b>FEATURES &amp; BENEFITS</b>	<p><b>EXCELLENT LUBRICITY</b> - OAKFLO<sup>®</sup> DSO 5307 provides moderate to heavy-duty lubricity to perform on a variety of machining and grinding applications.</p> <p><b>MACHINE FRIENDLY</b> - OAKFLO<sup>®</sup> DSO 5307 is compatible with machine tool components and provides good ferrous and non-ferrous corrosion protection - Good thermal stability as a gearbox lubricant (i.e. Passes Cincinnati Machine's "Thermal Stability Test, Procedure B").</p> <p><b>LONG SUMP LIFE</b> - Good biological control for extended sump life</p> <p><b>WIDE APPLICATION RANGE</b> - Can be used on a wide variety of metals and operations</p> <p><b>OPERATOR FRIENDLY</b> - Mild - Easy to mix – Pleasant to use</p>

<p><b>RECOMMENDED STARTING DILUTIONS</b></p>	<p><b>FOR INDUSTRIAL USE ONLY</b>  Use between 4.0% (1:25) and 6.7% (1:15) for moderate to heavy-duty machining and grinding ferrous and nonferrous metals and neat (100%) as a gear box lubricant. Add concentrate to water and stir or circulate to insure thorough mixing.</p> <p><b>OAKFLO® DSO 5307</b> is to be mixed with water for use (add concentrate to water).</p> <p>Add no other substances to the concentrate or mix unless approved by OAK® Technical Services. Not recommended for use with magnesium or alloyed magnesium.</p> <p><b>For concentration analysis, use</b> the MI Titration Procedure, Non-Solvent Titration Procedure, or Refractometer.</p>
<p><b>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</b></p>	<p><b>Physical state:</b> Liquid  <b>Appearance and odor:</b> Clear / Chemical  <b>Colors available:</b> Undyed  <b>Solubility in water:</b> 100% Miscible  <b>Weight, lb/gal, 60°F (15.6°C):</b> 7.9  <b>Specific gravity, (H<sub>2</sub>O = 1):</b> 0.95  <b>Boiling point, °F (°C):</b> NA  <b>Flash point, COC, °F (°C):</b> 380 (193)  <b>Fire point, COC, °F (°C):</b> 395 (202)  <b>Freezing point (or pour point), °F, (°C):</b> 28 (-2)  If frozen, thoroughly thaw prior to using.  <b>pH, concentrate:</b> NA  <b>pH, 5.0% mix, typical operating conditions:</b> 8.2  <b>Total chlorine/chloride, wt%, calculated:</b> 0.50/&lt; 50 ppm  <b>Total sulfur, wt%, calculated:</b> 0.54  <b>Silicones:</b> None  <b>Triazine:</b> None</p>
<p><b>PACKAGING</b></p>	<p><b>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</b></p>
<p><b>REFRACTOMETER FACTOR = 0.9</b> Multiply the scale reading obtained on your refractometer by the <b>Refractometer Factor</b> to obtain the mix concentration in percent.</p>	
<p><b>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.</b></p>	
<p>This product to be used within six months of its manufacture date indicated by the lot number on the container label.</p>	
<p>For additional information concerning OAKFLO® DSO 5307, refer to its OSHA MSDS or contact Technical Services at 1-513-458-8199. Reprints/Updates of this Product Information Flyer (PIF) can be found on our web site, <b>WWW.OAKINTERNATIONAL.COM</b> or from your OAK® INTERNATIONAL representative.</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.  Consumable Products Division/ Milacron Marketing Company  Cincinnati, Ohio 45209</p>	
<p>9/19/06</p>	<p>ISO CERTIFIED</p>

