



CUSTOMER-FOCUSED METALWORKING FLUID SOLUTIONS

OAKFLO[®] DSO 5400X SOLUBLE OIL, MULTI-PURPOSE LUBRICANT

APPLICATIONS	<p>OAKFLO[®] DSO 5400X metalworking fluid is a premium soluble oil designed for moderate to heavy-duty machining and grinding of ferrous and non-ferrous materials.</p> <p>Metals: Carbon Steels, High Speed Steel, Cast Steels, Alloy Steels, Tool Steel, Stainless Steel, Cast Iron, Aluminum</p> <p>Duty Range: For moderate to heavy-duty operations</p>
FEATURES & BENEFITS	<p>EXCELLENT LUBRICITY - OAKFLO[®] DSO 5400X contains a chlorinated extreme pressure lubrication package to perform on a variety of machining and grinding applications.</p> <p>VERY GOOD RANCIDITY CONTROL - Contains a microbial control package which extends fluid life for long lasting, trouble-free performance</p> <p>LOW FOAMING - Can be used in high turnover, high-pressure applications where foam control is required</p> <p>WIDE APPLICATION RANGE - Can be used on a wide variety of metals and operations</p> <p>OPERATOR FRIENDLY - Mild to skin - Easy to mix</p>

<p>RECOMMENDED STARTING DILUTIONS</p>	<p>FOR INDUSTRIAL USE ONLY 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>OAKFLO® DSO 5400X is to be mixed with water for use (add concentrate to water). Add no other substances to the concentrate or mix unless approved by CIMCOOL® Technical Services.</p> <p>Not recommended for use with magnesium or alloyed magnesium.</p> <p>For concentration analysis, use the MI Titration Procedure, Non-Solvent Titration Procedure, Total Alkalinity Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.</p>
<p>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</p>	<p>Physical state: Liquid Appearance and odor: Clear / Chemical Colors available: Undyed Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 8.4 Specific gravity, (H₂O = 1): 1.01 Boiling point, °F (°C): NA Flash point, COC, °F (°C): 360 (182) Fire point, COC, °F (°C): 380 (193) Freezing point (or pour point), °F, (°C): 28 (-2) If frozen, thaw completely at room temperature. pH, concentrate: NA pH, 5.0% mix, typical operating conditions: 8.6 Total chlorine/chloride, wt%, calculated: 7.53/< 50 ppm Total sulfur, wt%, calculated: 0.10 Silicones: Yes</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 0.9 Multiply the scale reading obtained on your refractometer 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>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 5400X, 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, WWW.OAKINTERNATIONAL.COM or from your OAK® INTERNATIONAL representative.</p>	
<p><small>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</small></p>	
<p>9/19/06</p>	<p>ISO CERTIFIED</p>

