



CUSTOMER-FOCUSED METALWORKING FLUID SOLUTIONS

OAKFLO[®] DS0 5400

PREMIUM SOLUBLE OIL, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>OAKFLO DS0 5400 metalworking fluid is a premium soluble oil designed for moderate to heavy-duty machining and grinding of ferrous and nonferrous materials.</p> <p>OAKFLO DS0 5400 can be used in individual machines or central Systems.</p> <p>Metals: Carbon Steels, High Speed Steel, Cast Steels, Alloy Steels, Tool Steel, Stainless Steel, Titanium, Cast Iron, Aluminum, Bronze, Copper.</p> <p>Duty Range: For moderate to heavy-duty operations</p>
FEATURES & BENEFITS	<p>EXCELLENT LUBRICITY - contains a chlorinated extreme pressure lubrication package to perform on a variety of machining and grinding applications.</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>WASTE TREATABLE - Compatible with most conventional waste treatment methods.</p> <p>OPERATOR FRIENDLY - Mild to skin - Easy to mix - Pleasant to use.</p>

<p>RECOMMENDED STARTING DILUTIONS</p>	<p>FOR INDUSTRIAL USE ONLY Recommended Starting Dilution: 5% (1:20) Typical Operating Range: 5% (1:20) to 10% (1:10) For concentrations outside this range contact Technical Service at 513-458-8199.</p> <p>OAKFLO® DSO 5400 is to be mixed with water for use (add concentrate to water). Add no other substances to the concentrate or mix unless approved by Technical Services.</p> <p>Not recommended for use with magnesium or alloyed magnesium.</p> <p>For concentration analysis use a refractometer or the Non-Solvent Titration Procedure.</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): 8.53 Specific gravity, (H₂O = 1): 1.02 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): 26 (-3) If frozen, product separates. Thaw completely at room temperature and stir thoroughly. pH, concentrate: NA pH, 5.0% mix, typical operating conditions: 8.6 Total chlorine/chloride, wt%, calculated: 9.00/< 50 ppm Total sulfur, wt%, calculated: 0.13 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 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 OAKFLO DSO 5400, 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>03/02/06 ISO CERTIFIED</p>	

