



YOUR METALWORKING FLUID SOLUTIONS FOR SOLUTIONS

OAKFLO[®] DSO 650CF-AFC

PREMIUM SOLUBLE OIL, METALWORKING FLUID CONCENTRATE

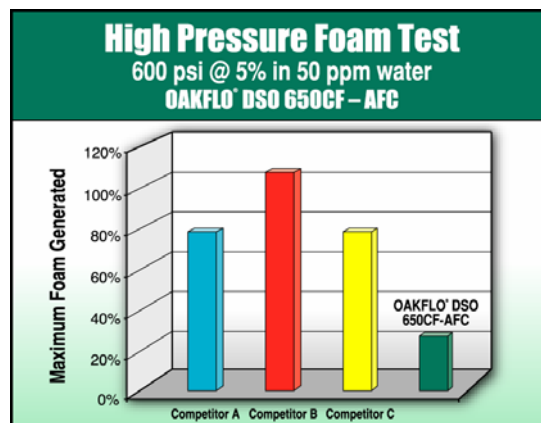
APPLICATIONS OAKFLO[®] DSO 650CF-AFC is a chlorine-free premium soluble oil, recommended for high fluid pressure and high volume flow applications where minimization of foam is critical for part quality and machine operations. It can be used for machining operations of ferrous and non-ferrous materials, where a heavy-duty fluid is desired. It can be used for machining operations including turning, drilling, tapping, reaming, gear cutting and broaching.

Metals: Carbon Steels, High Speed Steels, Cast Steels, Alloy Steels, Tool Steels, Stainless Steels, Cast Iron, Aluminum, Bronze, Brass, Copper

Duty Range: For heavy-duty operations

FEATURES & BENEFITS

OAK SIGNATURE[®] AFC Fluids provide "Advanced Foam Control" through the combination of product design, raw material selection and innovative antifoam technology. These fluids are the result of years of experience that have identified creative methods to prevent, control and reduce foam, even when fluids are used in high pressure delivery systems including through the tool systems. This expertise is only available in **OAK SIGNATURE[®] - AFC Fluids**.



EXCELLENT LUBRICITY – Contains mineral oil for physical lubricity – Also contains various lubricants for heavy-duty operations – Provides excellent tool life and surface finishes

EXCELLENT BIOLOGICAL CONTROL – Maintains control of bacteria and mold, resulting in extended fluid life

EXCELLENT CORROSION CONTROL – Controls ferrous and non-ferrous corrosion on parts and machine components

OPERATOR FRIENDLY – Mild to skin – Easy to mix – Pleasant odor

MACHINE FRIENDLY – Cleaner machines and work areas create a more pleasant work environment – Residue can be removed with water or alkaline cleaners – No solvent degreasers required as with straight oils

ECONOMICAL – Wide application on metals and operations – OAKFLO[®] DSO 650CF-AFC minimizes requirements for storage, mixing, charging, makeup and maintenance

RECOMMENDED STARTING DILUTIONS **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 OAK® Technical Service at 513-458-8199.

OAKFLO® DSO 650CF-AFC is to be mixed with water for use (add concentrate to water).

Add no other substances to the concentrate mix unless approved by OAK® Technical Services. Not recommended for use with magnesium or alloyed magnesium.

For concentration analysis, use the MI Titration Procedure, Non-Solvent Titration Procedure, Total Alkalinity Titration Procedure, OAKCHEK™ Test Strip, or Refractometer.

TYPICAL PHYSICAL AND CHEMICAL PROPERTIES

Physical state: Liquid
Appearance and odor: Hazy/Chemical
Colors available: Undyed
Solubility in water: 100% Miscible
Weight, lb/gal, 60° F (15.6° C): 7.8
Specific gravity, H₂O = 1): 0.94
Boiling point, °F (°C): 212 (100)
Flash point, COC, °F (°C): 345 (174)
Fire point COC, °F (°C): 355 (179)
Freezing point, °F (°C): <0 (<-18)
If frozen product separates, thaw completely at room temperature and stir prior to use.
pH, concentrate: NA
pH, 5.0% mix, typical operating conditions: 8.9
Total chlorine/chloride, wt%, calculated: 0.00/<50 ppm
Total sulfur, wt%, calculated: 0.24
Dicyclohexylamine: None

PACKAGING Available in 5-gallon pails, 55-gallon drums, and bulk containers.

REFRACTOMETER FACTOR = 1.0 Multiply the scale reading obtained on your OAK® Metalworking Fluid or other acceptable refractometer by the **Refractometer Factor** to obtain the mix concentration in percent.

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.

For additional information concerning OAKFLO® DSO 650CF-AFC, refer to its OSHA MSDS or contact OAK® 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® representative.

Minor formulation changes or normal variations in the manufacture of this product may cause slight variations in the data presented on this sheet.
Consumable Products Division/Milacron Marketing Company
Cincinnati, Ohio 45209

ISO Certified Company
9001/14001

OAK-AFC-01 11/07

