



CUSTOMER-FOCUSED METALWORKING FLUID SOLUTIONS

OAKFLO[®] DSS 5100 XP

SEMISYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>OAKFLO[®] DSS 5100 XP is designed for general machining and grinding of automotive aluminum parts. It is also recommended for general-purpose aluminum wheel machining on cast and wrought aluminum alloys</p> <p>Metals: Aluminum, Cast Iron, Carbon Steels</p> <p>Duty Range: For light to moderate duty operations</p>
FEATURES & BENEFITS	<p>EXCELLENT LUBRICITY - Provides excellent tool life and surface finish</p> <p>EXCELLENT MICROBIAL CONTROL - Excellent biostability - Provides long sump life</p> <p>EXCELLENT FOAM CONTROL - Very low foaming, without the use of silicone antifoam</p> <p>EXCELLENT CLEANLINESS - Rejects tramp oil, provides clean parts and keeps machines clean</p> <p>FORGIVING RESIDUE - The product is easily rinsed off parts for post-machining operations</p> <p>EXCELLENT CORROSION CONTROL - Specialized non-ferrous corrosion inhibitors eliminate part staining and prevent bi-metallic corrosion</p> <p>SUPERIOR MATERIAL AND APPLICATION COMPATIBILITY - Designed to meet requirements for aluminum wheel machining - Can be used on ferrous and non-ferrous metals where one product is needed for a variety of jobs</p> <p>OPERATOR-FRIENDLY - No smoke - No slippery film on parts, machinery or floor - Low misting - Mild to the skin</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® DSS 5100 XP 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</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): 8.8 Specific gravity, (H₂O = 1): 1.06 Boiling point, °F (°C): 212 (100) Flash point, COC, °F (°C): None, Self Extinguishing Fire point, COC, °F (°C): None, Self Extinguishing Freezing point (or pour point), °F, (°C): 16 (-9) If frozen, product separates. Thaw completely at room temperature and stir thoroughly. pH, concentrate: 9.6 pH, 5.0% mix, typical operating conditions: 8.7 Total chlorine/chloride, wt%, calculated: 0.00/< 50 ppm Total sulfur, wt%, calculated: 0.19 Silicones: No</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 1.6 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 DSS 5100 XP, 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 style="text-align: center;"><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>6/5/07</p>	

