



CUSTOMER-FOCUSED METALWORKING FLUID SOLUTIONS

OAKFLO[®] DSS 800CF

SEMISYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>OAKFLO DSS 800 CF is chlorine free and is recommended for general-purpose machining and grinding of ferrous metals. It can also be used on some moderate to heavy-duty applications on non-ferrous metals.</p> <p>Metals: Cast Iron, Nodular Iron, Malleable Iron, Gray Iron, Carbon Steels, Cast Steel, High Speed Steel, High Alloy Steels, Stainless Steels, Aluminum</p> <p>Duty Range: For moderate to heavy-duty operations</p>
FEATURES & BENEFITS	<p>OAKFLO DSS 800CF is a new-generation biostable semi-synthetic that blends the technological advantages of modern day synthetic fluids with the performance capabilities of soluble oils.</p> <p>LUBRICITY - Physical and chemical lubricants provide good machining and grinding properties - Keeps parts and tools cool.</p> <p>EXCELLENT RANCIDITY CONTROL - Contains a patented microbial control package - Effective protection against bacteria and mold - Provides long life and minimizes the use of additives.</p> <p>EXCELLENT FERROUS CORROSION CONTROL – The rust inhibitor package is extremely effective in preventing in-process rust on machines and parts - also very effective on cast/malleable/gray/ and nodular iron.</p> <p>NON-FERROUS CORROSION CONTROL – Contains non-ferrous corrosion inhibitors which prevent stain on aluminum alloys, brass, copper and bronze.</p> <p>GENERAL-PURPOSE PRODUCT - Can be used economically throughout the shop on light to moderate-duty operations; just vary the dilution to suit the job requirements.</p> <p>OPERATOR FRIENDLY - Easy to maintain and control - Waste treatable using standard fluid treatment procedures and systems - Can be recycled for reuse.</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 800 CF 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, Blue Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 8.5 Specific gravity, (H₂O = 1): 1.02 Boiling point, °F (°C): 211 (99) Flash point, COC, °F (°C): None, Self extinguishing Fire point, COC, °F (°C): None, Self extinguishing Freezing point (or pour point), °F, (°C): 28 (-2) If frozen, thaw completely at room temperature. pH, concentrate: 9.9 pH, 5.0% mix, typical operating conditions: 8.8 Total chlorine/chloride, wt%, calculated: 0.00/< 50 ppm Total sulfur, wt%, calculated: 0.242 Silicones: None Triazine: None</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 1.5 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>For additional information concerning OAKFLO DSS 800CF, 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>	

