



YOUR METALWORKING FLUID SOLUTIONS FOR SOLUTIONS

OAKFLO[®] DSS 807-AFC

SEMI-SYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS

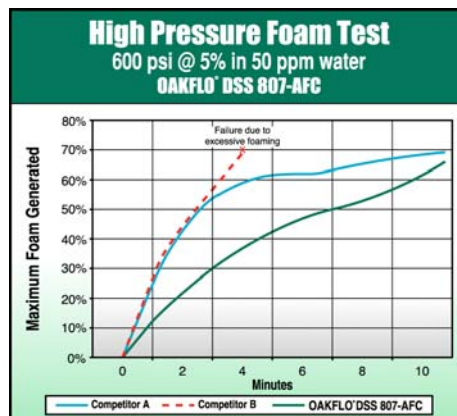
OAKFLO[®] DSS 807-AFC is a semi-synthetic recommended for high fluid pressure and high volume flow applications where minimization of foam is critical for part quality and machine operations. It can be used for machining operations of ferrous and some non-ferrous materials, where a moderate to heavy-duty fluid is desired. The product is chlorine free.

Metals: Most Aluminum Alloys, Cast Iron, Nodular Iron, Carbon Steels, High Speed Steels, High Alloy Steels, Stainless Steels, Most Non-Ferrous Alloys

Duty Range: For moderate to 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**.



LUBRICITY – A combination of lubricants provides good machining properties-Keeps parts and tools cool

EXCELLENT FERROUS CORROSION CONTROL – 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

SUPERIOR RANCIDITY CONTROL – Effective protection against bacteria and mold gives long fluid life

OPERATOR FRIENDLY – Mild to skin – Easy to mix – Pleasant odor – Keeps machines clean

VERSATILE – Suitable for a wide range of materials and operations – Can be used on aluminum alloys

ENVIRONMENTALLY FRIENDLY – is easy to maintain and control – Compatible with most conventional waste treatment methods

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® DSS 807-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: Clear to slight haze/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): 212 (100)
Flash point, COC, °F (°C): None, Self Extinguishing
Fire point COC, °F (°C): None, Self Extinguishing
Freezing point, °F (°C): 23 (-5)
If frozen, thaw completely at room temperature.
pH, concentrate: 9.4
pH, 5.0% mix, typical operating conditions: 9.0
Total chlorine/chloride, wt%, calculated: 0.00/<50 ppm
Total sulfur, wt%, calculated: 0.16
Dicyclohexylamine: None

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

REFRACTOMETER FACTOR = 1.4 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® DSS 807-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-04 11/07

