



CUSTOMER-FOCUSED METALWORKING FLUID SOLUTIONS

OAKFLO[®] DSS A-TECH SEMISYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>OAKFLO DSS A-TECH is recommended for general-purpose machining and grinding of non-ferrous metals where chlorinated EP additives are not permitted. It is well suited for one-product applications, where multiple metal types, including ferrous metals, are worked on various machining operations.</p> <p>Metals: Aluminum, Titanium, Copper, Bronze, and other exotic alloys, as well as ferrous metals (Cast Iron, Carbon Steels, Stainless Steels, etc.).</p> <p>Duty Range: For moderate-duty operations</p>
FEATURES & BENEFITS	<p>OAKFLO DSS A-TECH uniquely blends the newest technological advances of modern semisynthetic fluids to deliver superior performance in general operations on non-ferrous metals.</p> <p>EXCELLENT NON-FERROUS CORROSION CONTROL - Compatible with titanium and other exotic alloy metals - Non-staining on copper, and bronze alloys - Is an ideal product for use with aluminum - Specialized non-ferrous corrosion inhibitors are extremely effective in eliminating part-staining problems and preventing corrosion of machined parts - Designed to eliminate bi-metallic corrosion that can lead to part rejections.</p> <p>EXCELLENT BACTERIA AND MOLD CONTROL - Ensures long fluid life, minimizes the use of additives in central systems.</p> <p>ENVIRONMENTALLY-FRIENDLY - Is easy to maintain and control. It is waste treatable using standard fluid treatment procedures and systems. It can also be recycled for reuse using appropriate metalworking fluid recycling equipment.</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 A-TECH 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: Hazy / Chemical Colors available: Undyed Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 8.7 Specific gravity, (H₂O = 1): 1.04 Boiling point, °F (°C): 212 (100) Flash point, COC, °F (°C): None, self extinguishing Fire point, COC, °F (°C): NA Freezing point (or pour point), °F, (°C): 26 (-3) If frozen, product separates. Thaw completely at room temperature and stir thoroughly. pH, concentrate: 9.0 pH, 5.0% mix, typical operating conditions: 8.8 Total chlorine/chloride, wt%, calculated: 0.00/< 50 ppm Total sulfur, wt%, calculated: 0.0 Silicones: Yes</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 2.2 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 A-TECH, 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>	

