



# CUSTOMER-FOCUSED METALWORKING FLUID SOLUTIONS

## OAKFLO<sup>®</sup> DSS-CV7

SEMI-SYNTHETIC, METALWORKING FLUID CONCENTRATE

<b>APPLICATIONS</b>	<p><b>Oakflo<sup>®</sup> DSS-CV7</b> is a general-purpose fluid for machining and grinding iron, steel and some aluminum.</p> <p>It is also recommended for tapping, reaming, turning, drilling, internal grinding, and centerless grinding.</p> <p><b>Metals:</b> Cast Iron, Nodular Iron, Carbon Steels, High Speed Steel, High Alloy Steels, Stainless Steels and some Aluminums</p> <p><b>Duty Range:</b> For moderate to heavy-duty operations</p>
<b>FEATURES &amp; BENEFITS</b>	<p><b>Oakflo<sup>®</sup> DSS-CV7</b> metalworking fluid is a clean, completely water soluble, phenol-free, semi synthetic product that contains an extreme pressure (EP) lubricant for superior machining and grinding capability.</p> <p><b>ADVANTAGES</b> - Economical, Good lubricity, Good rancidity and mold control, Good cleanliness, Leaves a soft residue</p> <p><b>ENVIRONMENTALLY FRIENDLY</b> - 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><b>ECONOMICAL</b> - Cost effective</p> <p><b>VERSATILE</b> - Specially designed for machining and grinding of iron, steel and some aluminums</p> <p><b>CORROSION CONTROL</b> - Good corrosion control on both ferrous and most non-ferrous metals</p>

<p><b>RECOMMENDED STARTING DILUTIONS</b></p>	<p><b>FOR INDUSTRIAL USE ONLY</b>  <b>Recommended Starting Dilution: 10% (1:10)</b>  <b>Typical Operating Range: 8% (1:12) to 12% (1:8)</b>  <b>For concentrations outside this range contact Technical Service at 513-458-8199.</b></p> <p><b>Oakflo® DSS-CV7</b> 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><b>For concentration analysis, use</b> the MI Titration Procedure, Non-Solvent Titration Procedure, Total Alkalinity Titration Procedure, or Refractometer.</p>
<p><b>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</b></p>	<p><b>Physical state:</b> Liquid  <b>Appearance and odor:</b> Clear / Chemical  <b>Colors available:</b> Undyed  <b>Solubility in water:</b> 100% Miscible  <b>Mix appearance:</b> Hazy  <b>Weight, lb/gal, 60°F (15.6°C):</b> 8.5  <b>Specific gravity, (H<sub>2</sub>O = 1):</b> 1.01  <b>Boiling point, °F (°C):</b> 212 (100)  <b>Flash point, COC, °F (°C):</b> None, Self Extinguishing  <b>Fire point, COC, °F (°C):</b> None, Self Extinguishing  <b>Freezing point, °F, (°C):</b> 30 (-1)  Protect from Freezing.  <b>pH, concentrate:</b> 10.2  <b>pH, 10.0% mix, typical operating conditions:</b> 9.0  <b>Total chlorine/chloride, wt%, calculated:</b> 2.9/&lt;50ppm  <b>Total sulfur, wt%, calculated:</b> 0.3  <b>Silicones:</b> None</p>
<p><b>PACKAGING</b></p>	<p><b>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</b></p>
<p><b>REFRACTOMETER FACTOR = 2.7</b> Multiply the scale reading obtained on your refractometer by the <b>Refractometer Factor</b> to obtain the mix concentration in percent.</p> <p><b>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.</b></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-CV7, 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, <a href="http://WWW.OAKINTERNATIONAL.COM">WWW.OAKINTERNATIONAL.COM</a> or from your OAK® INTERNATIONAL representative.</p> <p>Minor formulation changes or normal variations in the manufacture of this product may cause slight variances in the data presented on this sheet</p> <p>Cincinnati, Ohio 45209      6/10/2011</p>	

