



# CUSTOMER-FOCUSED METALWORKING FLUID SOLUTIONS

## OAKFLO<sup>®</sup> DST 6100 ML METALWORKING OIL

<b>APPLICATIONS</b>	<p><b>OAKFLO DST 6100 ML</b> is designed for use in misting applications or Minimal Quantity Lubrication (MQL) applications. It is designed for all ferrous metals and some aluminum.</p> <p><b>Metals:</b> Cast Iron, Carbon Steels, High Speed Steel, High Alloy Steels, Stainless Steels, and some Aluminum alloys.</p> <p><b>Duty Range:</b> For moderate to heavy-duty operations such as drilling, tapping, reaming and sawing.</p>
<b>FEATURES &amp; BENEFITS</b>	<p><b>EXCELLENT LUBRICITY</b> - Low cutting force - Contains a non-chlorinated, non-sulfur, synthetic lubricant.</p> <p><b>EXCELLENT TOOL LIFE AND GOOD SURFACE FINISH</b> - Performs extremely well in milling tests conducted on steel parts - Used neat, no need to dilute with water or other materials.</p> <p><b>EXCELLENT CLEANLINESS</b> - Finished parts and chips are almost dry. Very low mist, odors, and residue. Parts can be easily cleaned with an alkaline cleaner, such as OAKWASH<sup>®</sup> DSC 2010 at 2%.</p> <p><b>LOW VISCOSITY FLUID</b> - for easy application and excellent cleanliness - Parts can be easily cleaned with an alkaline cleaner, such as CIMCLEAN<sup>®</sup> 30 at 2%.</p> <p><b>ENVIRONMENTALLY FRIENDLY</b> - Product formula is derived from natural, renewable resources. Does not contain mineral oil.</p> <p><b>CORROSION CONTROL</b> - Non-staining on ferrous metals and some non-ferrous metals, including aluminum alloys such as 2024 and 7075.</p> <p><b>ECONOMICAL</b> - Minimal Quantity Lubricators applying fluid directly to parts minimize quantities of fluid used - Eliminates recharge and disposal costs associated with recirculating fluid systems.</p>

<p><b>RECOMMENDED STARTING DILUTIONS</b></p>	<p><b>FOR INDUSTRIAL USE ONLY</b>  <b>Use neat (as is) for moderate to heavy-duty machining of ferrous and non-ferrous metals.</b></p> <p>Add no other substances to the concentrate or mix unless approved by Technical Services.</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> Insoluble  <b>Weight, lb/gal, 60°F (15.6°C):</b> 7.5  <b>Specific gravity, (H<sub>2</sub>O = 1):</b> 0.90  <b>Boiling point, °F (°C):</b> 500 (260)  <b>Flash point, COC, °F (°C):</b> 365 (185)  <b>Fire point, COC, °F (°C):</b> 380 (190)  <b>Freezing point (or pour point), °F, (°C):</b> 20 (-7)          If frozen, thaw completely at room temperature.  <b>pH, concentrate:</b> NA  <b>pH, 5.0% mix, typical operating conditions:</b> NA  <b>Total chlorine/chloride, wt%, calculated:</b> 0.0/ 0 ppm  <b>Total sulfur, wt%, calculated:</b> 0.0  <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>For additional information concerning OAKFLO DST 6100 ML, 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><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><b>03/02/06</b> <span style="float: right;"><b>ISO CERTIFIED</b></span></p>	

