YOUR METALWORKING FLUID SOLUTIONS FOR SOLUTIONS

OAKFLO® DSY 31 BVX

SYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS		**OAKFLO® DSY 31 BVX** metalworking fluid is recommended for machining and grinding operations, including creep feed grinding, on non-ferrous or ferrous metals. **Metals:** Wrought aluminum alloys (2024, 6061, 7050, 7075), Cast aluminum alloys (380, 390), Cast Iron, Nodular Iron, Carbon Steels, Stainless Steels, Titanium, Other Exotic Alloys **Duty Range:** For moderate to heavy -duty operations
FEATURES & BENEFITS		**OAKFLO® DSY 31 BVX** metalworking fluid is a unique, low pH synthetic fluid. This versatile product can be used as a creep feed grinding fluid for exotic metals and also form tap most aluminum alloys. **EXCELLENT LUBRICITY** - Provides excellent tool life and surface finish **EXCELLENT CLEANLINESS** - Rejects tramp oil to keep product clean, which extends sump life **OPERATOR - FRIENDLY** - Provides excellent part visibility - A fresh mix is transparent - No Smoke - Low misting – The product runs at a low pH operating range, making it mild to the skin. **EXCELLENT MACHINE COMPATIBILITY** - Very low foaming product, even when used with deionized water **EXCELLENT RANCIDITY CONTROL** - Excellent fluid life - Minimizes the need for additives **ENVIRONMENTALLY FRIENDLY** - Easily recycled

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 Signature Technical Service at 513-458-8199.** **OAKFLO® DSY 31 BVX** is to be mixed with water for use (add concentrate to water). Add no other substances to the concentrate or mix unless approved by Oak Signature Technical Services. Not recommended for use with magnesium or alloyed magnesium. **For concentration analysis, use** the Total Alkalinity Titration Procedure, BCG Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.
TYPICAL PHYSICAL AND CHEMICAL PROPERTIES		**Physical state:** Liquid **Appearance and odor:** Clear / Chemical **Colors available:** Undyed **Solubility in water:** 100% Miscible **Weight, lb/gal, 60°F (15.6°C):** 8.8 **Specific gravity, (H_2O = 1):** 1.05 **Boiling point, °F (°C):** 212 (100) **Flash point,COC, °F (°C):** None, Self Extinguishing **Fire point,COC, °F (°C):** NA **Freezing point, °F, (°C):** 24 (-4) If frozen, product separates. Thaw completely at room temperature and stir thoroughly. **pH, concentrate:** 7.7 **pH, *5.0%* mix, typical operating conditions:** 7.5 **Total chlorine/chloride, wt%, calculated:** 0.00/0.09 **Total sulfur, wt%, calculated:** 0.00 **Silicones:** None
PACKAGING		**Available in 5-gallon pails, 55-gallon drums, and bulk containers.**

REFRACTOMETER FACTOR = 2.6 Multiply the scale reading obtained on your 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® DSY 31 BVX, 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.

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