



YOUR METALWORKING FLUID SOLUTIONS FOR SOLUTIONS

OAKFLO[®] DSY 35 BVX

SYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>OAKFLO[®] DSY 35 BVX metalworking fluid is recommended for heavy-duty machining and grinding operations on non-ferrous or ferrous metals.</p> <p>Metals: Aluminum Alloys (2024, 6061, 7050, 7075, 380, 390), Cast Iron, Nodular Iron, Carbon Steels, Stainless Steels, Titanium, Other Exotic Alloys</p> <p>Duty Range: For moderate to heavy-duty operations</p>
FEATURES & BENEFITS	<p>OAKFLO[®] DSY 35 BVX is a unique, low pH synthetic fluid designed for heavy duty aluminum machining, including form tapping, but also exhibits excellent ferrous machining characteristics as well.</p> <p>EXCELLENT LUBRICITY - Provides excellent tool life and surface finish - Excellent lubricity for machining non-ferrous metals</p> <p>EXCELLENT CLEANLINESS - Rejects tramp oil and settles ferrous chips quickly to keep product clean, which extends sump life.</p> <p>OPERATOR - FRIENDLY - Provides excellent part visibility - A fresh mix is transparent - No Smoke - Low misting – The product runs at a low operating pH range, making it mild to the skin.</p> <p>EXCELLENT MACHINE COMPATIBILITY - Very low foaming even when used with deionized water</p> <p>EXCELLENT RANCIDITY CONTROL - Excellent fluid life - Minimizes the need for additives</p> <p>ENVIRONMENTALLY FRIENDLY - Easily recycled</p>

<p>RECOMMENDED STARTING DILUTIONS</p>	<p>FOR INDUSTRIAL USE ONLY Use between 5.0% (1:20) and 10.0% (1:10) for machining and grinding ferrous and nonferrous metals.</p> <p>OAKFLO® DSY 35 BVX is to be mixed with water for use (add concentrate to water).</p> <p>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.</p> <p>For concentration analysis, use the Total Alkalinity Titration Procedure, BCG Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.</p>
<p>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</p>	<p>Physical state: Liquid Appearance and odor: Clear / Chemical Colors available: Undyed Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 8.9 Specific gravity, (H₂O = 1): 1.07 Boiling point, °F (°C): 212 (100.0) Flash point, COC, °F (°C): None, Self extinguishing Fire point, COC, °F (°C): None, Self extinguishing Freezing point (or pour point), °F, (°C): 14 (-10) If frozen, thaw completely at room temperature. pH, concentrate: 7.9 pH, 5.0% mix, typical operating conditions: 7.5 Total chlorine/chloride, wt%, calculated: 0.00/<0.1 Total sulfur, wt%, calculated: 0.00 Silicone: None</p>
<p>PACKAGING</p>	<p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p>
<p>REFRACTOMETER FACTOR = 2.0 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® DSY 35 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.</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. Milacron Marketing Company Cincinnati, Ohio 45209</p> <p>PC-10043 04/03/2009</p>	

