



CUSTOMER-FOCUSED METALWORKING FLUID SOLUTIONS

OAKFLO[®] DSY 4620C

LOW-FOAMING, SYNTHETIC, CARBIDE GRINDING FLUID CONCENTRATE

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| APPLICATIONS | <p>OAKFLO DSY 4620C is designed specifically for carbide grinding applications and will maintain very low dissolved cobalt levels if maintained properly.</p> <p>Metals: Carbide.</p> <p>Duty Range: For moderate-duty operations.</p> |
| FEATURES & BENEFITS | <ul style="list-style-type: none">• Superior Cobalt Corrosion Inhibition – Maintains low levels of dissolved cobalt in the mix.• Excellent clarity, cleanliness and Foam Control.• Exceptionally Good Bacteria and Mold Control – No offensive odors caused by excessive bacteria.• Depletion Resistant – Lean make-up keeps the concentration at the recommended dilution, since bacteria do not easily degrade, OAKFLO DSY 4620C reduces costs by minimizing the amount of concentrate required for makeup.• Excellent Rust Control – A unique proprietary combination of corrosion inhibitors prevents corrosion of cast iron and steel machine tool components.• Emulsifies Very Little Tramp Oil – Tramp oil floats on top of the mix and can be removed easily by an oil-skimming device.• Pleasant to Use – Does not smoke or leave a slippery, oily film on parts, machines or surrounding areas – Low misting. |

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| <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 DSY 4620C is to be mixed with water for use (add concentrate to water). Add no other substances to the concentrate or mix unless approved by your Oak Signature representative.</p> <p>Not recommended for use with magnesium or alloyed magnesium.</p> <p>For concentration analysis use a refractometer, Alkalinity Titration, or BCG Titration Procedure.</p> |
| <p>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</p> | <p>Physical state: Liquid Appearance and odor: Clear, slight chemical Colors available: Undyed Solubility in water: 100% Miscible Weight, lb/gal, 60°F (15.6°C): 9.0 Specific gravity, (H₂O = 1): 1.08 Boiling point, °F (°C): 212 (100) Flash point, COC, °F (°C): None, self extinguishing Fire point, COC, °F (°C): NA Extinguishing media: NA Unusual fire & explosion hazards: None Freezing point (or pour point), °F, (°C): 22 (-6) If frozen, product separates. Thaw completely at room temperature and stir thoroughly. pH, concentrate: 10.3 pH, 5.0% mix, typical operating conditions: 9.1 Total chlorine/chloride, wt%, calculated: 0.00/0.10 Total sulfur, wt%, calculated: 0.00 Silicones: None</p> |
| <p>PACKAGING</p> | <p>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</p> |
| <p>REFRACTOMETER FACTOR = 1.9 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 4620C, 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> | |

