



YOUR METALWORKING FLUID SOLUTIONS FOR SOLUTIONS

OAKFLO[®] DSY 935

SYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS	<p>OAKFLO[®] DSY 935 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 935 is a unique, low pH synthetic fluid designed for the aerospace industry.</p> <p>EXCELLENT LUBRICITY - Provides excellent tool life and surface finish</p> <p>EXCELLENT CLEANLINESS - Rejects tramp oil 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 - 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 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 935 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. Not recommended for use with magnesium or alloyed magnesium.</p> <p>For concentration analysis, use the Total Alkalinity Titration Procedure, BCG Titration Procedure 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): 9.1 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): 13 (-11) If frozen, product separates. Thaw completely at room temperature and stir thoroughly. pH, concentrate: 8.3 pH, 5.0% mix, typical operating conditions: 7.9 Total chlorine/chloride, wt%, calculated: 0.00/0.12 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 = 2.3 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 935, 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-10046 4/30/2009</p>	

