



YOUR METALWORKING FLUID SOLUTIONS FOR SOLUTIONS

OAKFLO[®] DSY 950-AFC

SYNTHETIC, METALWORKING FLUID CONCENTRATE

APPLICATIONS

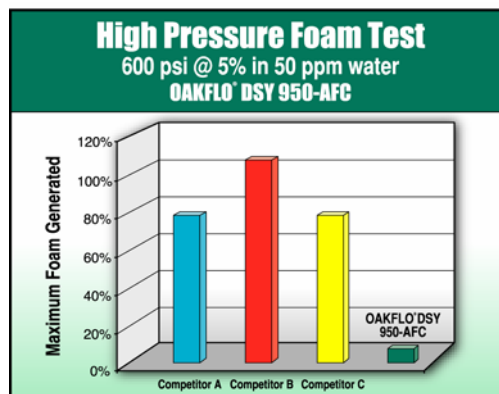
OAKFLO[®] DSY 950-AFC is a unique, low pH synthetic fluid designed for the aerospace industry. It is recommended for high fluid pressure and high volume flow applications where minimization of foam is critical for part quality and machine operations. It can be used for machining operations of ferrous and non-ferrous materials, where a heavy-duty synthetic fluid is desired. It is an excellent choice for central system applications.

Metals: Aluminum Alloys (2024, 6061, 7050, 7075, 380, 390), Cast Iron, Nodular Iron, Carbon Steels, Stainless Steels, Titanium, Other Exotic Alloys.

Duty Range: For moderate to heavy-duty operations

FEATURES & BENEFITS

OAK SIGNATURE[®] AFC Fluids provide "Advanced Foam Control" through the combination of product design, raw material selection and innovative antifoam technology. These fluids are the result of years of experience that have identified creative methods to prevent, control and reduce foam, even when fluids are used in high pressure delivery systems including through the tool systems. This expertise is only available in **OAK SIGNATURE[®] - AFC Fluids**.



EXCELLENT LUBRICITY – Provides excellent tool life and surface finish – Excellent lubricity for machining

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 – Mild to the skin

EXCELLENT MACHINE COMPATIBILITY – Very low foaming even when used with deionized water provides a very clean operating environment

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® Technical Service at 513-458-8199.

OAKFLO® DSY 950-AFC is to be mixed with water for use (add concentrate to water).

Add no other substances to the concentrate mix unless approved by OAK® Technical Services. Not recommended for use with magnesium or alloyed magnesium.

For concentration analysis, use the MI Titration Procedure, Non-Solvent Titration Procedure, Total Alkalinity Titration Procedure, OAKCHEK™ 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): 9.00
Specific gravity, H2O = 1): 1.06
Boiling point, °F (°C): 212 (100)
Flash point, COC, °F (°C): None, Self Extinguishing
Fire point COC, °F (°C): None, Self Extinguishing
Freezing point, °F (°C): -45 (-42.8)
If frozen product separates, thaw completely at room temperature and stir.
pH, concentrate: 8.2
pH, 5.0% mix, typical operating conditions: 7.9
Total chlorine/chloride, wt%, calculated: 0.00/0.09
Total sulfur, wt%, calculated: 0.00
Triazine: None
Dicyclohexylamine: None

PACKAGING Available in 5-gallon pails, 55-gallon drums, and bulk containers.

REFRACTOMETER FACTOR = 1.5 Multiply the scale reading obtained on your OAK® Metalworking Fluid or other acceptable 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 950-AFC, refer to its OSHA MSDS or contact OAK® 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® representative.

Minor formulation changes or normal variations in the manufacture of this product may cause slight variations in the data presented on this sheet.
Consumable Products Division/Milacron Marketing Company
Cincinnati, Ohio 45209

ISO Certified Company
9001/14001

OAK-AFC-06 11/07

