



# CUSTOMER-FOCUSED METALWORKING FLUID SOLUTIONS

## OAKFORM<sup>®</sup> DSO 6950 SST

PREMIUM SOLUBLE OIL, METALFORMING FLUID CONCENTRATE

<b>APPLICATIONS</b>	<p><b>OAKFORM<sup>®</sup> DSO 6950 SST</b> is a metal forming fluid designed for stainless steel operations. It can also be used on a variety of ferrous and non-ferrous metals.</p> <p><b>Metals:</b> Stainless Steels, Cold Rolled Steels, Most Galvanized Steels, and some non-ferrous metals</p> <p><b>Duty Range:</b> For Heavy-duty operations</p>
<b>FEATURES &amp; BENEFITS</b>	<ul style="list-style-type: none"><li>• Contains NON-SARA REPORTABLE CHLORINE</li><li>• Replaces straight oils in many applications</li><li>• Versatile – stable over a wide range of mix dilutions</li><li>• Clean – leaves a soft oily residue that washes off easily in alkaline or vapor degreasing systems</li><li>• Good corrosion control on parts and metal forming presses</li><li>• Silicone free</li></ul>

<p><b>RECOMMENDED STARTING DILUTIONS</b></p>	<p><b>FOR INDUSTRIAL USE ONLY</b>  <b>Recommended Starting Dilution: 10% (1:10)</b>  <b>Typical Operating Range: 10% (1:10) to 40% (1:2.5)</b>  <b>For concentrations outside this range contact Technical Service at 513-458-8199.</b></p> <p><b>OAKFORM® DSO 6950 SST</b> 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.</p> <p>Not recommended for use with magnesium or alloyed magnesium.</p> <p><b>For concentration analysis</b> use a refractometer or the Non-Solvent Titration Procedure.</p>
<p><b>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</b></p>	<p><b>Physical state:</b> Liquid  <b>Appearance and odor:</b> Clear / Chemical  <b>Colors available:</b> Undyed  <b>Solubility in water:</b> 100% Miscible  <b>Weight, lb/gal, 60°F (15.6°C):</b> 8.9  <b>Specific gravity, (H<sub>2</sub>O = 1):</b> 1.06  <b>Boiling point, °F (°C):</b> Not Applicable  <b>Flash point, COC, °F (°C):</b> 385 (196)  <b>Fire point, COC, °F (°C):</b> 400 (204)  <b>Freezing point (or pour point), °F, (°C):</b> -8 (-22)          If frozen, product separates. Thaw completely at room temperature and stir thoroughly.  <b>pH, concentrate:</b> Not Applicable  <b>pH, 20.0% mix, typical operating conditions:</b> 8.5  <b>Total chlorine/chloride, wt%, calculated:</b> 20.00/&lt; 50 ppm  <b>Total sulfur, wt%, calculated:</b> &lt; 1.0  <b>Silicones:</b> None</p>
<p><b>PACKAGING</b></p>	<p><b>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</b></p>
<p><b>REFRACTOMETER FACTOR = 1.0</b> Multiply the scale reading obtained on your refractometer by the <b>Refractometer Factor</b> to obtain the mix concentration in percent.</p> <p><b>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.</b></p> <p>This product to be used within six months of its manufacture date indicated by the lot number on the container label.</p>	
<p>For additional information concerning OAKFORM® DSO 6950 SST, 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, <a href="http://WWW.OAKINTERNATIONAL.COM">WWW.OAKINTERNATIONAL.COM</a> or from your OAK® INTERNATIONAL representative.</p> <p style="text-align: center;"><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>6/4/07</p>	

