



CUSTOMER-FOCUSED METALWORKING FLUID SOLUTIONS

OAKFORM[®] DSY 6400 SYNTHETIC, METALFORMING FLUID CONCENTRATE

APPLICATIONS	OAKFORM DSY 6400 is a synthetic fluid for moderate-duty metalforming of ferrous and most nonferrous metals.
FEATURES & BENEFITS	<ul style="list-style-type: none">• Excellent Lubricity - contains patented synthetic lubricants and an extreme pressure lubricant. Provides the lubricity needed to prevent galling, tearing, and scoring.• Corrosion control - for ferrous and some nonferrous metals. Passes 30 days in Blue M humidity cabinet with 95° Relative Humidity at 105° F.• Good cleanliness - Parts can be easily cleaned by alkaline wash.• Excellent residue characteristics - residue stays oily, does not cause gummy, sticky deposits on parts, tooling, or presses.• Versatile - can be used over a wide range of dilutions.• Good microbial control - works well in recirculating/recycling systems.

**RECOMMENDED
STARTING
DILUTIONS**

FOR INDUSTRIAL USE ONLY.

Use between 10% (1:10) and 50% (1:2) for light to moderate-duty metalforming of steels and some nonferrous metals.

OAKFORM DSY 6400 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.

Not recommended for use with magnesium or alloyed magnesium.

**TYPICAL
PHYSICAL AND
CHEMICAL
PROPERTIES**

Physical state: Liquid
Appearance and odor: Slightly hazy, chemical
Colors available: undyed
Solubility in water: 100% Miscible
Weight, lb/gal, 60°F (15.6°C): 8.73
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): -6 (-21) If frozen, thoroughly thaw prior to using.
pH, concentrate: 8.4
pH, 10.0% mix, typical operating conditions: 8.0
Total chlorine/chloride, wt%, calculated: 0.00/< 50 ppm
Total sulfur, wt%, calculated: 0.00
Silicones, mineral oil: none

PACKAGING

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

REFRACTOMETER FACTOR = 1.7 Multiply the scale reading obtained on most refractometers 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 OAKFORM DSY 6400, 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.

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

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ISO CERTIFIED

