



CUSTOMER-FOCUSED METALWORKING FLUID SOLUTIONS

OAKSPEC[®] DPH BUFFER METALWORKING FLUID ADDITIVE

APPLICATIONS	OAKSPEC DPH BUFFER is a metalworking fluid additive used to raise and/or buffer the mix pH in central system reservoirs. OAKSPEC DPH BUFFER typically raises the pH of a used metalworking fluid mix by 0.2 to 0.3 units. A secondary effect is improved ferrous corrosion control.
WHEN TO USE	Add to Oak Signature metalworking fluid mixes as directed by Technical Services. Use when the pH is below recommended operating specification, as determined by laboratory testing. If the pH must be raised more than 0.3 units, contact Technical Services at 1(513) 458-8199.
HOW TO USE	Raise the pH on a test sample of the metalworking fluid mixes in the lab first to see how much OAKSPEC DPH BUFFER is required. Then scale up.

**RECOMMENDED
STARTING
DILUTIONS**

FOR INDUSTRIAL USE ONLY

Use between 1:2,000 (0.05%) and 1:1,000 (0.1%) as an additive.

**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): 7.86
Specific gravity, (H₂O = 1): 0.94
Boiling point, °F (°C): 329 (165)
Flash point, COC, °F (°C): 188 (87)
Fire point, COC, °F (°C): NA
Freezing point (or pour point), °F, (°C): 30 (-1)
If frozen, thaw completely at room temperature.
pH, concentrate: 13.0
pH, 0.1% mix, typical operating conditions: 11.3
Total chlorine/chloride, wt%, calculated: 0.00/< 50 ppm
Total sulfur, wt%, calculated: 0.00
Silicones: None

PACKAGING

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

For additional information concerning OAKSPEC DPH BUFFER, 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 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

