



# CUSTOMER-FOCUSED METALWORKING FLUID SOLUTIONS

## **OAKTEC<sup>®</sup> D 1400 EDM** **ELECTRICAL DISCHARGE MACHINING FLUID**

<b>APPLICATIONS</b>	<p><b>OAKTEC D 1400 EDM</b> is a premium dielectric fluid developed to suspend particulate matter for filter removal, thus improving fluid cleanliness, bath life, and part surface finish quality.</p> <p><b>OAKTEC D 1400 EDM</b> requires minimal maintenance and is capable of handling all types of electrical discharge machining operations providing an increase in productivity and machine output.</p>
<b>FEATURES &amp; BENEFITS</b>	<p><b>LONG FLUID LIFE (WITH PROPER FILTRATION)</b></p> <p><b>LOW TO NO ODOR</b></p> <p><b>CLEAN OPERATING, WITH OUTSTANDING WORKER ACCEPTANCE</b></p> <p><b>SUPERIOR OXIDATION STABILITY</b></p> <p><b>LOW MAINTENANCE COSTS</b></p>

<b>RECOMMENDED STARTING DILUTIONS</b>	<p><b>FOR INDUSTRIAL USE ONLY</b>  <b>OAKTEC D 1400 EDM</b> is designed to be used undiluted / neat.  An effective filtration system is necessary to extend fluid life and machine performance.</p> <p>Add no other substances to the concentrate or mix unless approved by your OAK SIGNATURE Representative.</p>
<b>TYPICAL PHYSICAL AND CHEMICAL PROPERTIES</b>	<p><b>Physical state:</b> Liquid  <b>Appearance and odor:</b> Clear to straw yellow / Mild hydrocarbon odor  <b>Colors available:</b> Undyed  <b>Solubility in water:</b> Insoluble  <b>Weight, lb/gal, 60°F (15.6°C):</b> 6.7  <b>Specific gravity, (H<sub>2</sub>O = 1):</b> 0.8  <b>Viscosity, SUS at 100 F:</b> 39  <b>Flash point, PMCC, °F (°C):</b> 260 F (126)  <b>Auto Ignition °F (°C):</b> 428 F (220 C)  <b>Freezing point (or pour point), °F, (°C):</b> 20 F (-7)  If frozen thaw completely at room temperature.  <b>pH, concentrate:</b> NA  <b>pH, 5.0% mix, typical operating conditions:</b> NA  <b>Total chlorine, wt%, calculated:</b> None  <b>Total sulfur, wt%, calculated:</b> None  <b>Silicones:</b> None  <b>Dielectric strength, kV:</b> 54</p>
<b>PACKAGING</b>	<b>Available in 5-gallon pails, 55-gallon drums, and bulk containers.</b>
<p>For additional information concerning OAKFLO DSS 5150, 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<sup>®</sup> 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.  Consumable Products Division/ Milacron Marketing Company  Cincinnati, Ohio 45209</p> <p>5/13/08 <span style="float: right;">ISO CERTIFIED COMPANY</span></p>	

