

OAK® SIGNATURE METALWORKING FLUID SUGGESTED METERING TIP CHART*
MIX MASTER II, AUTOMATIC MIX MASTER AND MIX STATION. ALWAYS TEST MIX CONCENTRATION WITH REFRACTOMETER OR TITRATION.

Product	no tip	Concentration Mix Ratio (%)**													SUS-100F	DATE
		1:10 (10%)	1:15 (6.6%)	1:20 (5.0%)	1:25 (4.0%)	1:30 (3.3%)	1:35 (2.8%)	1:40 (2.5%)	1:45 (2.2%)	1:50 (2.0%)	1:60 (1.7%)	1:65 (1.5%)	1:70 (1.4%)	1:100 (1.0%)		
OAKFLO DSO 5700		NONE	NONE		GRAY	LT. BROWN		RED	WHITE	BLUE			MD. BROWN	ORANGE	1010	Mar-06
OAKFLO DSO 600				GRAY		BLACK		LT. BROWN				RED		BLUE	430	Feb-97
OAKFLO DSO 650		NONE	NONE		GRAY	LT. BROWN		RED	WHITE	BLUE			MD. BROWN	ORANGE	990	Feb-97
OAKFLO DSO 650 CF	12%	BLACK		RED		MD. BROWN									456	Sep-04
OAKFLO DSO 680B					GRAY	BLACK				LT. BROWN				RED	975	Feb-97
OAKFLO DSS 5050		LT. BROWN	RED	WHITE	MD. BROWN			GREEN		ORANGE			DK. BROWN	YELLOW	50	Jan-98
OAKFLO DSS 5100		LT. BROWN	RED	WHITE	BLUE	TAN		GREEN							161	Feb-00
OAKFLO DSS 5150		LT. BROWN	RED	WHITE	BLUE	TAN		GREEN							122	Sep-00
OAKFLO DSS 700		RED	WHITE	BLUE	MD. BROWN		GREEN	DK. BROWN			YELLOW		PURPLE	PINK	420	Jan-98
OAKFLO DSS 755		LT. BROWN	RED	WHITE	BLUE	MD. BROWN			GREEN		ORANGE	DK. BROWN		YELLOW	500	May-02
OAKFLO DSS 785			LT. BROWN	RED	WHITE	BLUE	TAN		GREEN						283	1-Jan
OAKFLO DSS 800		BLACK		RED	WHITE	BLUE	MD. BROWN				ORANGE		DK. BROWN	YELLOW	450	Jan-99
OAKFLO DSS T-TECH		LT. BROWN	RED	WHITE	BLUE	MD. BROWN			GREEN		ORANGE	DK. BROWN		YELLOW	520	Mar-00
OAKFLO DSY 4100			RED	WHITE	BLUE				MD. BROWN	GREEN	DK. BROWN			YELLOW	35	Feb-97
OAKFLO DSY 4200		BLACK	LT. BROWN	RED		WHITE	BLUE			MD. BROWN		GREEN		ORANGE	32	Feb-97
OAKFLO DSY 4300			WHITE	BLUE	MD. BROWN			GREEN		ORANGE	DK. BROWN			YELLOW	112	Jan-98
OAKFLO DSY 4305		BLACK	LT. BROWN	RED		WHITE	BLUE			MD. BROWN		GREEN		ORANGE	43	Apr-98
OAKFLO DSY 4620C		LT. BROWN	RED	WHITE	BLUE	MD. BROWN		GREEN		ORANGE	DK. BROWN		YELLOW	PURPLE	35	Feb-97
OAKFLO DSY 4700		LT. BROWN	WHITE	BLUE	MD. BROWN		GREEN	DK. BROWN			YELLOW	PURPLE	PINK		61	Feb-00
OAKFLO DSY 4800		BLACK	LT. BROWN	RED		WHITE	BLUE			MD. BROWN		GREEN		ORANGE	49	Feb-97
OAKFLO DSY 900		LT. BROWN	RED	WHITE	BLUE	MD. BROWN				GREEN		ORANGE	DK. BROWN	YELLOW	100	Feb-97
OAKFLO DSY 910		LT. BROWN	WHITE	BLUE	MD. BROWN		GREEN	DK. BROWN			YELLOW	PURPLE	PINK		59	Feb-97
OAKFLO DSY 935			WHITE	BLUE	MD. BROWN			GREEN		ORANGE	DK. BROWN			YELLOW	130	Oct-99
OAKFLO DSY 950			WHITE	BLUE	MD. BROWN			GREEN		ORANGE	DK. BROWN			YELLOW	158	Jun-04
OAKFLO DSY4600		LT. BROWN	RED	WHITE	BLUE	MD. BROWN				GREEN	ORANGE		DK. BROWN	YELLOW	35	Dec-05
OAKWASH DSC 2010						GREEN				ORANGE		YELLOW		PURPLE	40	NA
OAKWASH DSC 2050		LT. BROWN	RED		BLUE	MD. BROWN			ORANGE				YELLOW	PINK	40	Jun-00
OAKWASH DSC AL		LT. BROWN	RED		BLUE	MD. BROWN			ORANGE				YELLOW	PINK	40	Feb-98

* NOTE: Chart is a guide. Actual concentrations may vary. **Checking the actual mix ratio or concentration obtained at startup with a titration kit is recommended. Use OAK® Signature metalworking fluid concentrate at room temperature (~80 °F).**

** Mix ratios obtained at a flow pressure of 40 psig (275 KPa)

*** If the OAK Signature product you are using is not listed on this chart, please contact Technical Services (1-513-458-8199).

RED items are best estimates based on viscosity

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