



Product Information Flyer

DESCRIPTION

OAK DRAW 785 is a heavy-duty, synthetic drawing and stamping lubricant.

APPLICATION

OAK DRAW 785 is used to draw, stamp, roll form, bend and knurl ferrous and non-ferrous metals such as stainless steel, aluminum and copper.

OAK DRAW 785 forms a transparent solution with exceptional film strength and friction-reducing properties when added to water.

FEATURES & BENEFITS

LUBRICITY:

Contains a lubricity package that offers superior tool and die life.

CLEANLINESS:

Contains detergents, which keeps the press, and tooling clean. Product is chlorine, sulfur and oil free.

EASY TO APPLY:

Easily mixed and can be applied by spray, flood, or drip. The film strength of the product allows for total part coverage providing enhanced formability. Deposited film is dry to touch depending on concentration.

CORROSION CONTROL:

Offers good corrosion control for in process protection for the tooling, machine tool and part on ferrous and non-ferrous metals.

STABILITY:

Stable in hard and soft water. Non-foaming for re-circulating systems. Outstanding tramp oil rejection properties to prevent solution rancidity and extend sump life.

RECOMMENDED STARTING DILUTIONS

OAK DRAW 785 is to be mixed with water. Typically dilutions are from 10 to 30% and are dependent upon the type of metal, gauge of metal, process involved and method of lubricant application. Add no other materials to the concentrate or mix unless approved by your CIMCOOL® Territory Manager. Always add concentrate to water. Fluid may be more difficult to mix when water temperature is below 55 F (13 C).

Dilution Range 10% - 30% (1:10 to 1:3.3)

CONCENTRATION

BCG Titration, Total Alkalinity or Refractometer can be used.

The Refractometer Factor is 2.4.

Multiply the scale reading obtained on your CIMCOOL® Refractometer by this factor to obtain the mix concentration in percent. Calibrate the refractometer so that it reads 0.0 with water before testing the sample mix. Remove gross contaminants from the sample mixes before testing. A refractometer is only recommended for use in checking the concentration on a fresh charge.

TYPICAL PHYSICAL AND CHEMICAL PROPERTIES

Physical State: Liquid

Solubility in Water: 100% miscible

Flash Point/Sp. Gr./Boiling Point: See MSDS

pH, 30% mix, typical operating conditions: 8.2

Total Sulfur, wt%: 0

Appearance and Odor: Clear/Chemical

Weight, lb/gal, 60°F (15.6°C): 8.6

pH Concentrate: 8.3

Total Chlorine/Chlorides, wt%: 0/0

Silicone: Yes

HANDLING AND STORAGE

If frozen, product separates. Thaw completely at room temperature and stir prior to use. Inside storage is recommended.

SAFETY DATA SHEET

Available at www.cimcool.ca

For additional information refer to its SDS, website or contact CIMCOOL® Technical Services at 1-513-458-8199 in Ohio or 1-888-254-1919 in Canada.

Limitation of Liability: Under no circumstances, shall we or any affiliate of ours have any liability whatsoever for loss of use, or for any indirect or consequential damages. Minor formulation changes or normal variations in the manufacture of this product may cause slight variances in the data presented on this sheet.

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