



Product Information Flyer

DESCRIPTION

OAK DRAW 829-A is a heavy duty soluble oil metalforming fluid recommended for use on ferrous and most non-ferrous alloys including aluminum, copper and stainless steel.

APPLICATION

OAK DRAW 829-A is designed for operations such as stamping, drawing, blanking, bending, forming, punching, piercing and end-forming.

FEATURES & BENEFITS

LUBRICITY:

Exceptional lubricity package provide superior tool and die life.

CLEANLINESS:

Washes off parts easily with aqueous cleaners and most solvent (concentrate) systems.

CORROSION CONTROL:

Non-staining on ferrous and most non-ferrous alloys.

RECOMMENDED STARTING DILUTIONS

OAK DRAW 829-A is to be mixed with water but may be used undiluted for very heavy-duty operations. Dilutions are dependent upon the type of metal, gauge of metal, process involved and method of lubricant application. Always add concentrate to water. Fluid may be more difficult to mix when water temperature is below 55°F (12.7°C). Add no other materials to the concentrate or mix unless approved by your CIMCOOL® Territory Manager.

Dilution Range 5% to 50% (1:20 to 1:1)

CONCENTRATION

Non-solvent Titration, Total Alkalinity, CIMCHEK™ Test Strip or Refractometer can be used.

The Refractometer Factor is 1.0

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 afresh charge.

TYPICAL PHYSICAL AND CHEMICAL PROPERTIES

Physical State: Liquid

Solubility in Water: 100% miscible

Viscosity SUS @ 100°F (37.7°C): 820

pH Concentrate: NA

Total Chlorine wt%: 25

Silicone: Yes

Appearance and Odor: Clear/Bland

Weight, lb/gal, 60°F (15.6°C): 9.2

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

pH, Typical Operating at 5%: 9.4

Total Sulfur, wt%: Negligible

HANDLING AND STORAGE

If frozen, thaw completely at room temperature prior to use. Inside storage is recommended.

SAFETY DATA SHEET

Available at www.cimcool.ca

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

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