



EDM FLUID

(For Electrical Discharge Machining)

EDM Fluid is a low viscosity fluid with good stability and low color that is designed for use in electrical discharge machining. Electrical discharge machining is a metal removal process by a series of controlled electric discharges or sparks. The fluid insulates both the tool and the work piece. The fluid has a high flash point for safety along with good dielectric properties for proper insulation and controlled dielectric discharge during machining operations.

Its low viscosity provides good circulation through the spark gap and excellent filterability.

This fluid should be maintained by filtration, vacuum dehydration, etc as a dry, clean liquid for optimum performance.

NOTE that the spark discharge area between the work piece and tool must be completely immersed in oil to reduce the danger of explosion and fire.

TYPICAL CHARACTERISTICS

Grade	Medium
Product Code	16813
API Gravity (D 4052)	38.5
Specific Gravity @ 60 F	0.832
Pounds/gallon	6.94
Appearance	colorless, mild odor liquid
Color, Saybolt (D 156)	+27
Aniline point, F (D611)	187
Viscosity (ASTM D-445) cSt @ 40°C	4.2
Flash Point, PMCC, °F	250

The above data is subject to usual manufacturing variation. For more information and availability, call 1-800-442-LUBE.
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