

FORCE EDM OIL

DESCRIPTION

FORCE EDM OIL is a premium quality transparent Electrical-Discharge-Machine fluid. It offers excellent resistance to oxidation under the typical conditions of constant air exposure and high temperatures encountered during FORCE EDM OIL work, thereby reducing sludge formation and increasing oil life. The viscosity of FORCE EDM OIL allows for ready circulation of the fluid, even through narrow spark gaps, resulting in rapid dissipation of heat. FORCE EDM OIL is also specially formulated to allow rapid setting of metal fragments before recirculation to prevent distortion of spark values and improve finish quality. This fluid is readily filterable and is non-corrosive. FORCE EDM OIL is virtually colourless and has minimal odour. FORCE EDM OIL has a high flash point that minimizes the possibility of fire during use, provided that normal safety measures are followed. It offers superior electrical discharge, uniform insulation and rapid deionisation of the fluid after eroding spark discharges.

BENEFITS

- Superior dielectric properties.
- Excellent oxidation resistance.
- Colourless.
- Minimal odour.

TYPICAL RESULT

Characteristics	Test Method	FORCE EDM OIL
Viscosity Kinematic, at 40°C, cSt	ASTM D - 445	2.65
KB Value	ASTM D - 1133	25
Specific Gravity, 15°C	ASTM D - 4052	0.789
Color	ASTM D - 1500	+ 30
Flash Point, °C	ASTM D - 93	91
Pour Point, °C	ASTM D - 97	-50
Aromatic Content, wt%	UV	< 0.05
Copper Stripe	ASTM D - 130	1A
Initial Boiling Point, °C	ASTM - 86	223
Aniline Point, °C	ASTM - 611	89