



LUBRITA EDM OIL 02

SPARK EROSION OIL

LUBRITA EDM OIL is one of the most modern methods used for manufacture of complex recessed parts viz, molds or dies. Controlled removal of metal is achieved by generating sparks between an electrode and the job and which is submerged in an insulating medium. The correct insulating medium has to ensure that the eroded material is completely removed from the job as well as control the rate of cooling of the electrode. It should have proper di-electric value so as to permit controlled electrical discharge at the break-down voltage. It should also not create a fire hazard. Kerosene which is sometimes used as the insulating medium may not meet di-electric strength requirements since it is not specifically manufactured to meet these and its use should therefore be avoided.

LUBRITA EDM OIL is highly refined mineral oils of narrow boiling range manufactured to meet the di-electric strength requirements of end use.

BENEFITS:-

1. Have good di-electric strength.
2. Are non-corrosive and prolong the life of the electrode.
3. Have low surface tension and density allowing the eroded metal particles to be easily flushed out.
4. Are safer to use as these have high flash points.
5. Low odour and toxicity
6. Excellent filterability

TYPICAL REPORT:-

S:No	Test	Test Methods	Unit	Specification		Batch Test Report
				Min	Max	
1	Appearance	Visual	-	Min	Max	Clear & Bright
2	Crackle Test	Visual	-		Nil	Nil
3	Density @ 29.5 °C	ASTM D 1298	Kg/m ³	Report	-	0.7855
4	Colour	ASTM D 1500	-	-	Clear	Clear
5	Specific Gravity @ 29.5 °C					0.78
6	Kinematic Viscosity @ 40°C	ASTM D 445	mm ² /s	1.80	3.50	2.28
7	Flash Point COC	ASTM D 92	deg.C	80	110	102

HANDLING, HEALTH AND SAFETY

Lubricant consisting of highly refined mineral oils with specific additives. In normal conditions of use this lubricant presents no particular toxic hazard. All lubricants, of any kind should be handled with great care, particularly avoiding any contact with the skin.

Prevent any splashing and keep away from combustible materials. Store under cover and away from any risk of pollution. Disposes off the used oil correctly, don't pour down drains, into watercourses or the soil.