

MAK EDM OIL

Description

MAK EDM oil is a highly refined, narrow cut paraffinic base stock with low viscosity, specially developed for use as a premium dielectric fluid in electric discharge /spark erosion machining operations. The main functions of this product are to act as an insulator between tool and workpiece, spark conductor, coolant, flushing and settling of metal fines, along with low electrode wear, good surface finish and fine tolerances. MAK EDM oil has excellent oxidation stability which reduces the formation of oxidation byproducts that will alter the dielectric strength of the fluid.

Application

MAK EDM oil is recommended for use in Electrical Discharge Machines utilized to produce very fine and intricate cuts and profiles. It can be used on all ferrous and non-ferrous metals.

Benefits

- Mild odor and light colour result in greater operator acceptability
- Reduced chances of fire due to high flash point
- Outstanding oxidation stability ensures long service life
- Low viscosity of oil provides excellent flushing at the point of cut and filterability
- Negligible aromatics and sulphur content in the product makes safe and pleasant work environment
- High dielectric strength provides insulation of the tool & workpiece and helps control electric discharge during the machining operation

Performance Level

- Proprietary grade

Technical Specifications

Characteristics	Test method	MAK EDM OIL
Appearance	Visual	Clear & Bright
Colour	ASTM D 1500	L0.5
Density @15°C, Kg/m ³	ASTM D1298	0.8327
Kinematic Viscosity @ 40°C, cSt	ASTM D 445	3.75
Flash point, °C	ASTM D 92	120
Pour point, °C	ASTM D 97	-21
Copper corrosion test, 3hrs, 100°C	ASTM D 130	1a

All the mentioned values are typical which may vary from batch to batch.

Storage and Handling

- Indoor Storage is always preferable
- Barrels should be kept horizontally with bunk position at 3 O'clock 9 O'clock position
- Barrels should be kept away from dusty or heated areas.
- During handling any contact with dust must be avoided.

Health and Safety

These oils are not hazardous under normal conditions of use. For further guidance appropriate Material Safety Data Sheet (MSDS) may be referred.

Advice

- For any further advice on applications or otherwise please contact the nearest Bharat Petroleum Territory Office or Technical Services Department at the address given below.

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