

EDM OIL (SPARK EROSION OIL)

Hydrocut – ED- 1530

PRODUCT DESCRIPTION

Spark erosion is one of the modern cutting metal process. It is called as EDM wire cutting operation. . It is mainly used in prescribed operation like die and mild preparation .it can operate on any metals who conducts electric charges. Dielectric fluid is used during operation to work as an insulator they are three types aqua synthetic and emulsion type semisynthetic oil base and neat type direct oil base.

Hydrocut ed 1530 This oil used to prepare for specially for

Spark erosion cutting by brass wire electrode. It is semisynthetic formulation used in 10-20 percent with water. Which increases electrical conductivity and better metal removal rate.

Product quality

Hydrocut edm is semisynthetic low oil formula based fortified with anticorrosion additives ,water softeners, metal cleaning agents, preservator, lubricating polymers.

Its main features are

- 1- Easily soluble Maintains permanent emulsion
- 2- Clear non foaming fluid helps work piece visible
- 3- Gives proper viscosity and lubricity to dielectric fluid (water)
- 4- Used at 5-10 %
- 5- High cut ratio
- 6- Excellent cooling to electrode
- 7- Extends life of molybdenum wire.
- 8- Grate finishing cuts.

Test report

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| 1. Appearance | clear amber |
| 2. Density | 0.88 |
| 3. Viscosity | 24 cst @ 40 c |
| 4. Copper corrosion | 1b |
| 5. Emulsion stability | passed up to 400 ppm |
| 6. Cast iron corrosion test | passed |

Packing :- 50 / 200 kg