



EDM OIL 120

United EDM Oil 120 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 EDM work, thereby reducing sludge formation and increasing oil life. The viscosity of United EDM Oil 120 allows for ready circulation of the fluid, even through narrow spark gaps, resulting in rapid dissipation of heat. United EDM Oil 120 is also specially formulated to allow rapid settling of metal fragments before recirculation to prevent distortion of spark values and improve finish quality. This fluid is readily filterable and is non-corrosive. United EDM Oil 120 is virtually colorless and odorless.

United EDM Oil 120 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.

APPLICATIONS / BENEFITS

- Superior dielectric properties.
- Excellent oxidation resistance.
- Colourless.
- Odourless.

TYPICAL CHARACTERISTICS

TEST DESCRIPTION	METHOD	TYPICAL RESULTS
Specific Gravity @ 15 °C	ASTM D 4052	0.81
Flash Point, °C	ASTM D 92	133
IBP, oC	ASTM D 86	240
Kinematic Viscosity @40°C (cSt)	ASTM D 445	3
Aromatic Content wt%	UV	<0.03
Color	Saybolt	+30
Vapor Pressure		<0.001hPa at 20oC
Aniline Point, oC	ASTM D611	93.0