



# TECHNICAL DATA SHEET

## GRODAL EDM OIL

### ELECTRICAL DISCHARGE MACHINING OIL

#### DESCRIPTION

Grodal EDM oil is a mixture of highly refined hydrocarbon distillate. The product is colourless and virtually odourless. It exhibits a relatively high flash point that helps reducing the possibility of fire. The low viscosity of this fluid provides good circulation through the spark gap and more rapid removal of metal fines.

#### APPLICATION

Grodal EDM oil exhibits high dielectric strength which provides insulation of the tool and work piece which helps controlling electric discharge during the machining operation. It is used in Plunge or rams electrical discharge machining.

#### BENEFITS

- Mild odor.
- Relatively high flash and low viscosity.
- Excellent oxidation resistance.
- High dielectric strength.
- Good filterability.

#### TECHNICAL DATA

Colour & Appearance	:	Colourless liquid
Sp.Gravity @ 30°C	:	0.74- 0.77
Flash Point	:	Above 100 deg C
Kin Viscosity @ 40°C	:	2 to 3 cSt.

#### RECOMMENDATIONS

Grodal EDM oil is also effective as a glass grinding fluid.

#### SAFETY

This oil is unlikely to present any significant health or safety hazard when properly used in the recommended application as well as good standards of industrial and personal hygiene is maintained.

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