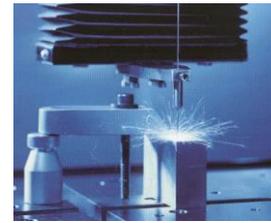
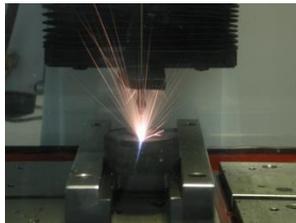


PRODUCT DATA SHEET

PRODUCT: EASTTO EDM FLUIDS

DESCRIPTION: Electric discharge machining is a metal removal process involving the removal of material from the work piece by a series of controlled electric discharges or sparks. The tool and the work piece are insulated by a special dielectric fluid. These fluids are formulated with a highly refined, narrow cut paraffinic base stock with excellent oxidation stability which helps reduce the formation of oxidation products that will alter the dielectric strength of the fluid. The product is colourless and virtually odourless. The product exhibits a relatively high flash point that helps to reduce the possibility of fire. The low viscosity of the fluid provides good circulation through the spark gap and more rapid removal and settling of metal fines.

APPLICATION: Recommended for use in: Dielectric fluid in finish-cut electrical discharge (spark erosion) machining operations. Electrical discharge machining in tool and die shops, and in manufacture of electronics, extrusions, air-craft components, hardware, tools, fasteners, silver-ware, cutlery, jewellery, appliances, valves and regulators. Grinding fluid in glass grinding operations.



Dielectric fluid in finish-cut electrical discharge (spark erosion) machining operations.

TYPICAL PROPERTIES

CHARACTERISTICS	EASTTO EDM FLUIDS		
	2	3	4
Grades	2	3	4
Colour	Colourless	Colourless	Colourless
Kinematic Viscosity at 40°C, cSt	2.0 – 3.0	3.0 – 4.0	4.0 – 5.0
Flash Point, PMCC, °C, Min.	107	108	130
DI-electric Strength, KVA	45	45	45

PACKING: 210 Litres M.S. Barrels, 50 Litres, 20 Litres

Date of Issue: 20.10.2014,

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These are typical figures and do not constitute a specification. In pursuit of continuous improvement, these figures may be changed without notice at the sole discretion of EASTERN PETROLEUM PVT. LTD.

