



TECHNICAL DATA SHEET

SUPERIOR Electrical Discharge Machining FLUID

Product Description:

OBLube Superior EDM fluid is a premium quality product which is formulated from high quality naphthenic light oil and a special non-metallic additive package. The high quality naphthenic light oil is severely refined to provide naturally high oxidation stability and excellent di-electric properties required of Electrical Discharge Machining (EDM) Fluids.

Benefits:

OBLube Superior EDM Fluid provides:

- Excellent Cooling Properties
- Excellent Di-Electric / Insulating Properties
- Excellent Filterability – easily separates from fine metal particles removed in ED machining.
- Excellent Penetrating Properties
- Minimal Gassing to Prevent Fumes
- Flushing Action to Remove Metal Particles from EDM machining.
- Excellent Oxidation Stability- provides long service life even at high temperatures.

Applications:

OBLube Superior EDM Fluid can be used in :

- Electrical Discharge Machining Equipment used in tool, die, and metal working industries.
- Accurate ED machining of all types of ferrous metals, aluminum, copper, brass, and bronze.
- Cooling and insulation of oil-filled power and distribution transformers.
- Cooling of oil-immersed sealed integrated pump/motor assemblies.

Typical Physical Characteristics:

OBLUBE SUPERIOR EDM FLUID			
Properties	Unit	Test Method	
Appearance		Visual	Clear & Bright Liquid
Color		ASTM D 1500	Max. 0.5
Specific Gravity @ 15°C		ASTM D 1298	0.872
Viscosity @ 40°C	cSt	ASTM D 445	8.6
Viscosity @ -30°C	cSt	ASTM D 341	700
Flash Point	°C	ASTM D 93	Min. 135
Pour Point	°C	ASTM D 97	Max. -30
Neutralization Value	mg KOH/g	ASTM D 974	Max. 0.03
Moisture Content	ppm	ASTM D 1533	Max. 30
Corrosive Sulfur		ASTM D 1275	Non-Corrosive
Gassing Tendency	µL/min.	ASTM D 2300B	Max. 30
Breakdown Voltage (electrode gap 2.5mm)			
As Delivered	kV	IEC 60156	Min. 30
After Treatment	kV		Min. 70

Health and Safety:

OBLUBE Lubricants are unlikely to present any significant health or safety hazard when properly used in the recommended application and good standards of personal hygiene are maintained. Use gloves which are impervious to oil and chemicals when handling used oils. Avoid skin contact. If lubricants come in contact with skin, wash immediately with soap and water.

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