

Product Data Sheet

Vacmul EDM 2 High Performance Electrical Discharge Machining Oil

Product Description

Vacmul EDM 2 is a high performance electrical discharge machining oil prepared from a special aromatic free base fluid plus additive to prolong service life.

Benefits

Vacmul EDM 2 offers the following benefits:

- Low viscosity and wetting ability ensure effective flushing of spark gap
- Long service life due to narrow boiling range and high breakdown voltage
- Resistance to oxidation and carbon formation reduces incidence of continuous arcing and the formation of resistive bridges
- Low aromaticity high flash point and low evaporation rate make the product safe for use in the machine shop
- No adverse effect on the electrode, the work, or machined parts of pumping system

Application

Vacmul EDM 2 is particularly recommended in EDM applications, where excellent surface finish is required. It is also recommended for roughing and complex profiling.

Vacmul EDM 2 can also be used for rolling aluminium and light duty machining of cast iron and those operations where swarf flushing is a principal requirement.

Health and Safety

Based on available toxicological information, it has been determined that this product poses no significant health risk when used and handled properly.

Details on handling, as well as health and safety information, can be found in the Material Safety Data Bulletin which can be obtained through Mobil Oil Company Ltd., by telephoning 01372 22 2000.

Typical physical characteristics are given in the table. These are intended as a guide to industry and are not necessarily manufacturing or marketing specifications.

Typical Characteristics

	Test Method	Vacmul EDM 2
Relative Density, 15/4°C		0.762
Viscosity, cSt at 20°C		2.6
Viscosity, cSt at 40°C		1.8
Flash Point, (PMCC) °C		98
Pour Point, °C		-6
Sulphur, (ppm)		<1
Aromatics, % IR Brandes		<1
Boiling Range, °C IBP		225
Boiling Range, °C FBP		250

Due to continual product research and development, the information contained herein is subject to change without notice.

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