

# MACRON EDM 110

## Neat EDM Oil for Spark Erosion

### DESCRIPTION

Macron EDM 110 is based on paraffinic hydrocarbons. Its very low aromatic content improves working conditions.

The product is colorless and has a very low odor.

The high dielectric strength and good flushing properties contribute to a high stock removal capacity.

Macron EDM 110 shows excellent chemical compatibility and a good filtration performance with usual filter media.

Macron EDM 110 can be used with graphite and copper electrodes.

### APPLICATION

Macron EDM 110 is a universal spark erosion oil which shows very good results with both rough and fine machining.

Even in very small erosion slots, the product shows a good flushing performance.

It also performs well in EDT machines for roller texturizing.

In addition, Macron EDM 110 can be used for grinding carbide cutting tools, as belt grinding oil for aluminum, or as magnaflux oil.

### RECOMMENDATIONS FOR USE

Macron EDM 110 is used neat as supplied.

### TYPICAL PHYSICAL PROPERTIES

| TEST                                  | TYPICAL VALUE    | TEST METHOD |
|---------------------------------------|------------------|-------------|
| Appearance                            | Colourless fluid |             |
| Specific gravity @ 20 °C              | 0.800            | ASTM D 4052 |
| Viscosity @ 40 °C, mm <sup>2</sup> /s | 2,3              | ASTM D 445  |
| Viscosity @ 20 °C, mm <sup>2</sup> /s | 3,4              | ASTM D 445  |
| Flash Point PMCC °C                   | 105              | ASTM D 93   |
| Copper corrosion                      | 1a               | ASTM D 130  |

### ADVANTAGES

- Chlorine free
- Very low aromatic components
- Free of heavy metals
- High dielectric strength
- Low volatility
- Very mild odor

### STORAGE

Product should be stored under cover in clean, dry conditions and protected from frost. Recommended storage temperature is between 5°C and 35°C. Use stock in delivery rotation. A shelf life of twenty four months can be anticipated.

### HEALTH AND SAFETY

Health and Safety Data Sheets are supplied to customers to comply with Section 6 of the Health and Safety at Work Act 1974, and should be closely studied prior to handling or use of the product. Copies are available from your Technical Health and Safety Officer. Various other advisory publications are available from the Health and Safety Executive and Her Majesty's Stationery Office.

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All data given in this Product Data Sheet are typical of this material. It does not however constitute a specification. We reserve the right to modify products without prior notice. All products, services and information supplied are provided upon the terms of our standard Conditions of Sale from time to time in force.

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