



SHELL MACRON[®] EDM 135 OIL

High quality electrical discharge machining oil

Product Description

Electric discharge machining is a metal removal process involving the removal of material from the workpiece by a series of controlled electric discharges or sparks. The tool and the workpiece are insulated by a special dielectric fluid. **Shell Macron[®] EDM 135** is a premium dielectric fluid meeting the requirements for insulation and controlled dielectric discharge during electric discharge machining operations. **Shell Macron[®] EDM 135** is formulated with a highly refined, narrow cut paraffinic base stock. The product is colorless and virtually odorless. The product exhibits a relatively high flash point that helps 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. **Shell Macron[®] EDM 135** has excellent oxidation stability which helps reduce the formation of oxidation products that will alter the dielectric strength of the fluid. **Shell Macron[®] EDM 135** exhibits a high dielectric strength which provides insulation of the tool and workpiece and helps control electric discharge during the machining operation. **Shell Macron[®] EDM 135** is also extremely effective as a glass grinding fluid.

Applications

- Plunge or ram electrical discharge machining
- Glass grinding

Features/Benefits

- mild odor
- relatively high flash and low viscosity
- outstanding oxidation resistance
- high dielectric strength
- excellent filterability

Typical Properties Macron[®] EDM 135 Oil

	Test Method	MACRON EDM 135 Oil
Product Code (drums)		6104600055
Appearance		Water White
Odor		Mild
Viscosity, cSt @ 40°C	D 445	3.45
Gravity, °API @ 60°F	D 1298	44.1
Pour Point, °F	D 97	5
Flash Point, COC, °F	D 92	275

Handling & Safety Information

For information on the safe handling and use of this product, refer to its Material Safety Data Sheet at <http://www.shell-lubricants.com/msds/>. If you are a Shell Distributor, please call **1+800-468-6457** for all of your service needs. All other customers, please call **1+800-840-5737** for all of your service needs. Information is also available on the World Wide Web: <http://www.shell-lubricants.com/>.