

SPARK EROSION OILS

Description:

Spark Erosion is one of the most modern methods used for manufacture of complex recessed parts viz, molds or dies. Sparks are generated between an electrode and the job, which is submerged in an insulating medium spark erosion oil. Spark erosion oil should have proper di-electric value, and also not create a fire hazard.

Salient Features:

IPOL SPARK EROSION Oils are highly refined mineral oils of narrow boiling range manufactured to meet the di-electric strength requirements of the end use.

Application:

It is used as an insulating medium to ensure the eroded material is completely removed from the job, by controlling the rate of cooling correctly.

Benefits:

1. Have good di-electric strength.
2. Non-corrosive and prolong the life of the electrode.
3. Have low surface tension and density.
4. Are safer to use as these have high flash points.
5. Require least make up, during use.

Product Data

Typical Results: IPOL Spark Erosion Oils

Characteristics	Test Methods IS 1448	Results			
		SEO 203	SEO 270	SEO 350	SEO 450
Appearance	Visual	Bright & Clear			
Specific Gravity @30°C	IS 1442: P 32	0.757	0.757	0.757	0.757
Flash Point (COC)°C Min.	P:69	108	108	108	108
Pour Point °C, max.	P:10	0	0	0	0
Viscosity cSt @40°C	P:25	2.6	3.1	3.05	2.3 *
Copper Corrosion	P:15	1A	1A	1A	1A
Di-electric Strength	IS-6792	40	40	40	40

(* 3.22 cSt @ 20°C)

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