Mobil

Vacmul EDM 3

Mobil Industrial , Singapore

Multipurpose Electro Discharge Machining Fluids

Product Description

Vacmul EDM 3 fluid is multipurpose dielectric fluid for use in all discharge machines working by penetration especially for roughing, finishing and superfinishing work. Vacmul EDM is very pure fluid designed for maximum machine productivity and operator comfort when used in electrical-discharge machining, also called spark-erosion machining. In this metalworking process metal is removed from a workpiece by applying a potential difference between the workpiece and a shaped electrode. Vacmul EDM has the ability to provide uniform insulation and then to permit controlled electrical discharge at the breakdown voltage.

Vacmul EDM 3 has the correct balance of viscosity, volatility, oxidation stability, heat transfer characteristics, low odour and low toxicity. Vacmul EDM 3 is a highly refined, narrow-cut, low viscosity fluid specially suited to finishing operations where a high quality finish is required. It functions as an insulator between tool and workpiece, spark conductor, coolant and as a flushing oil for chip removal. Vacmul EDM is recommended for roughing operations where a high metal removal rate is required and for finishing and superfinishing work.

Features and Benefits

Features	Advantages and Potential Benefits
Highflash point	Limits fire risk
Excellent filterability through cartridge and earth	Increased production
High wetability	Ensures liquid / metal contact and fewer rejects
Bright, clean and odourless.	Easy viewing of work piece and fixtures
Low skin sensitivity in normal use	Easy handling and improved workshop environment
Non fatty compared to more viscous fluids.	Higher metal removal rate and stable electrical discharge
Good detergency with respect to small particles.	Provides uniform insulation, higher precision and surface finish

Applications

- Excellent for all electro discharge machines that work by penetration.
- Especially suitable for roughing, finishing and superfinishing work.

Typical Properties

Vacmul EDM	3
Density @ 15°C, kg/l ASTM D1298	0.799
Colour, Saybolt	+30
Viscosity cSt at 40°C mm2/s ASTM D445	2.37
Flash Point, (P.M.) °C	108
IBP °C	243
FBP °C	272
Appearance	Clear and Bright

Health and Safety

Based on available information, this product is not expected to produce adverse effects on health when used for the intended application and the recommendations provided in the Material Safety Data Sheet (MSDS) are followed. MSDS's are available upon request through your sales contract office, or via the Internet. This product should not be used for purposes other than its intended use. If disposing of used product, take care to protect the environment.

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Typical Properties are typical of those obtained with normal production tolerance and do not constitute a specification. Variations that do not affect product performance are to be expected during normal manufacture and at different blending locations. The information contained herein is subject to change without notice. All products may not be available locally. For more information, contact your local ExxonMobil contact or visit www.exxonmobil.com
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