



# TECHNICAL DATA

## GB EDM FLUID

### APPLICATIONS

GB EDM FLUID is a transparent, very low odour, low viscosity dielectric fluid for EDM machining, and is especially suitable for superfine finishing operations. Its main applications include machining moulds for die-casting or plastic injection machines, and its use in aerospace turbine blade production. It is also used for fine boring of aerofoil honeycombs in nickle alloys, eg Inconel 718, and may be used either on individual machines or in centralised systems.

### PERFORMANCE FEATURES

GB EDM FLUID offers the following features:

- Very low odour
- Very low aromatic content
- Smoke-free operation
- High flash point
- Efficient flushing of spark debris
- Minimal micro-soldering between component, swarf and electrode
- Low viscosity for fine surface finish
- Suitability for all types of filtration including diatomeous earth
- High oxidation resistance
- Excellent thermal stability
- Long service life

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## **GB LUBRICANTS**

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# GB LUBRICANTS

**CHARACTERISTICS**

TEST	UNIT	METHOD	TYPICAL PHYSICAL CHARACTERISTICS
Appearance	-	-	Colourless liquid
Density @ 15°C	kg/m <sup>3</sup>	ASTM D 4052	813
Kinematic Viscosity @ 20°C	cSt	ASTM D 445	3.5
Kinematic Viscosity @ 40°C	cSt	ASTM D 445	2.4
Flash Point (PMCC)	°C	ASTM D 93	103
Copper Corrosion	-	ASTM D 130	1a
Pour Point	°C	ASTM D97	-50

**STORAGE AND HANDLING**

GB EDM FLUID should be stored under cover and protected from extreme temperatures (below 5°C and above 35°C). Avoid water collecting in the rim of upturned barrels. GB EDM FLUID has a shelf-life of 12 months from the date of supply.

Further information on GB EDM FLUID can be obtained by referring to the corresponding Safety Data Sheet.

***The Company policy is to ensure that a range of products is supplied which complies with the latest specifications and codes within the relevant industry. As part of this development process, we therefore reserve the right to amend formulations without prior notice.***