

## DIVYOL SPARK EROSION OIL 25

### Applications:

Divyol Spark Erosion Oil 25 is a highly refined mineral oil of narrow boiling range specially formulated to meet the dielectric strength requirements of their use in various applications. This fluid is low viscosity spark erosion oil specially formulated for use on all ferrous and non-ferrous metals and all EDM machines carrying out roughing as well as fine finishing. It is designed for spark erosion machines of all sizes, and specially recommended for very fine spark erosion machining operations, particularly in small EDM machines. Spark Erosion is a widely used modern method of manufacturing dies. With proper dielectric value it enables controlled electrical discharge at the break-down voltage. It should also not create a fire hazard. Kerosene which is sometimes used as the insulating medium may not meet the dielectric strength requirements since it is not specifically manufactured to meet these; hence it is advisable to avoid kerosene.

### Advantages:

Divyol Spark Erosion Oil 25 enables good separation of fine swarf. It has long fluid life, anti-foaming properties and excellent oxidation stability which protects against corrosion. It is also non-staining, low-fuming and least odorous.

### Typical properties:

Sr. No.	Characteristics	Test Method	Divyol Spark Erosion Oil 25
1	Appearance	Visual	Bright and clear
2	Kinematic viscosity at 40 °C, min.	ASTM D 445	2.3
3	Flash point, COC, °C, min.	ASTM D 92	106
4	Pour point, °C, max.	ASTM D 97	-9
5	Copper corrosion at 100 °C, 3 hrs	ASTM D 130	1a
6	Dielectric strength	IS:6792	40

The above properties are typical values and do not constitute specification of the product.

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