



An ISO 9001:2015 Certified Co.

Product Data Sheet

DC Electro Discharge Machining (EDM) Oil or Spark Erosion Oil

- ISO Designation: ISO-L-MHA
- ISO Viscosity Grades: 2,3,5
- Performance Standards: ISO 6743-7:1986
- Usage Guidelines: Specifically formulated as a low-fuming, non-staining EDM oil
- Composition: Base Oil Group II, Additives: None

Physico-Chemical Properties: DC Electro Discharge Machining (EDM) Oil or Spark Erosion Oil

S.No.	Characteristics	Test Method	2	3	5
1	Kinematic Viscosity @40°C, cSt, range	IS 1448 P:25	1.8 to 2.2	2.7 to 3.3	4.5 to 5.5
2	Pour Point, °C, max	IS 1448 P:10	-15	-12	-12
3	ASTM Colour, max	IS 1448 P:12	0.5	0.5	0.5
4	Flash Point (COC), °C, min	IS 1448 P:69	140	150	150
5	Copper Corrosion, 100°C, 3 hrs	IS 1448 P:15	1a	1a	1a
6	Dielectric Strength	IS 6792	40	40	40

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