



INDUSTRIAL  
LUBRICANTS &  
SERVICES LIMITED

## Technical Data sheet

# ILS SPARK EROSION FLUID

A High Performance Electric Discharge Machining Fluid

### Description

**ILS Spark Erosion Fluid** is a high quality, HSE friendly machining fluid based on a low viscosity highly refined mineral oil designed for use in all electric discharge machining applications. Providing effective cooling of the electrode and workpiece while providing the necessary insulating characteristics, ILS Spark Erosion Fluid enables optimum metal removal and excellent surface finish.

### Typical Applications

**ILS Spark Erosion Fluid** is suitable for use on all ferrous and non-ferrous metals and all EDM machines carrying out roughing as well as fine finishing.

### Benefits

- Provides good cooling due to low viscosity of the product
- Good performance in narrow gap operations
- Very low Aromatic content ensures operator friendly product
- Long Fluid Life
- No foaming
- Good separation of fines

### Typical Characteristics

Concentrate	Test Method	Typical Properties
Appearance	Visual	Clear Water White Liquid
Density @ 15 °C (Kg/M <sup>3</sup> )	ASTM D1298	0.81 - 0.85
Flash Point (PMCC) °C	ASTM D 93	>100°C
Kinematic Viscosity @ 40°C(cSt)	ASTM D 445	2-3 cSt

**Note : Data is typical and does not constitute a specification**