



**Product Data**

## **Ilocut EDM 401**

High performance Electric Discharge Machining Fluid

### **Description**

Castrol Ilocut™ EDM 401 is a medium viscosity mineral oil based high performance electric discharge machining (EDM) fluid, designed to enable optimum rates of metal removal, together with low electrode wear, good surface finish and fine tolerances.

It is especially formulated to provide exceptional performance in all spark-erosion applications.

### **Application**

Ilocut EDM 401 is recommended for use on all ferrous and non ferrous metals. It is designed for large electric discharge machines and is particularly suited for roughing operations where high rate of metal removal is required.

### **Advantages**

- Optimum viscosity ensures good cooling and flushing action in narrow spark gaps
- Low odour and light colour result in greater operator acceptability
- Lower aromatics result in a safe and pleasant work environment
- Excellent filterability and high oxidation stability ensures long service life

## Typical Characteristics

Name	Method	Units	
Appearance	Visual		Clear, transparent
Viscosity at 40°C	DIN 51562	mm <sup>2</sup> /s	3.2 - 4.6
Viscosity at 100°F	ASTM D 446	SUS	36.5 – 41.2
Density at 15°C	DIN 51757 ASTM D 1298		807 min
	calculated	lbs/gal	6.72 min
Flashpoint PMCC	ISO 2719	°C	115 min
	ASTM D 93	°F	240 min
Copper corrosion	ISO 2160 ASTM D 130		1b

## Storage

To avoid product deterioration always keep the container/drum tightly sealed. Store the product in a cool, dry place away from direct sunlight. Prevent exposure to frost and avoid water ingress. For optimum product stability, it is preferable to store the product indoors between 5°C and 45 °C / 41°F and 113°F.

For more details, please refer the product safety data sheet.

Ilocut EDM 401

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Castrol (UK) Limited, PO BOX 352, Chertsey Road, Sunbury On Thames, Middlesex, TW16 9AW  
Orders/Enquiries: 0345 9645111 Technical Enquiries: 0345 082 1719  
[www.castrol.com/industrial](http://www.castrol.com/industrial)