



# EDOf fluid 30S, 60S, 70S

Special fluids for highspeed steel form grinding, *chlorine free*

## Description

The **EDOf fluid 30S, 60S** end **70S** are a special formula oils devised for the most demanding highspeed steel form grinding.

The fluids contain highly refined hydrocarbons, water-treated and with additives to sensibly reduce friction occurrences between the grinding wheel and the metal.

The **EDOf fluid 30S, 60S** e **70S** have been designed for the demanding tasks of utensil manufacturing and gear form grinding. These fluids combine both a reduction of the coefficient of friction between the grinding wheel and the metal, and proper refrigeration and cleansing of the contact area, with good filtration qualities.

Aside from satisfying machine operation requirements, as this range of products made from highly refined and purified raw materials they provide further safety guarantees for employees and their working environment.

## Properties and advantages

The **EDOf fluid 30S, 60S** end **70S** ensure the advantages set out below, thanks to the water treated hydrocarbons resulting in almost colourless (**30S**) or of a light straw colour (**60S** and **70S**) and odourless, having been chosen for the unique formulation including a short distillation range and low IPA levels.

- The colour is light and transparent, thus allowing perfect visibility of the contact area.
- It is possible, depending on the contact area between grinding wheel and metal, to choose the fluid with the most appropriate viscosity value.
- Optimum cooling properties.
- Optimum cleansing properties.
- Good and fast settling of metal swarf.
- Low fume and odour emission.
- Fast aeration and absence of persisting foam.
- Reduced fluid consumption during mechanical working of the items.
- Stable viscosity even after long periods of use.
- Reduced coefficient of friction even when complex shapes are required.
- Reduced grinding wheels optimisation, conducive to higher production levels.
- Optimum precision end profiling.
- Thermal-stress resistance due to long-lasting chemical and physical stability.
- Low fume emission and evaporation loss.
- Free from chlorine and its derivatives.
- Highly filterable through the filtering systems.
- Maximum hygiene and environmental safety levels.



# EDOf fluid 30S, 60S, 70S

Special fluids for highspeed steel form grinding, *chlorine free*

## Use

The **EDOf fluid 30S, 60S** end **70S** are used for all the highspeed steel form grinding operations in utensil manufacturing (including solids manufacturing) and for gear form grinding. They are particularly used in cubic boron nitride grinding wheels.

It is advisable to maintain the operating temperature below 25°C when using low viscosity fluids, and, in any case, never above 35°C, with range excursions within 5°C between minimum and maximum temperature.

The properties of the fluids are in accordance with the requirements of the main world form-grinding manufacturers.

## Storage, health and safety

Keep stock *indoors*; should this not be possible, keep drums horizontal to prevent water trickling in and deterioration of the written information. Do not stock at temperatures above 60°C, or expose to sun heat or freezing temperatures.

Further health and hygiene information is available on request.

## Main characteristics

EDOf fluid			30S	60S	70S
Characteristics	Test Method	Measure	Values		
Colour	ASTM D 1500		< 0,5	< 0,5	< 0,5
Density at 15°C	ASTM D 4052	kg/Lt	0,836	0,889	0,893
Kinematic viscosity at: 20°C 40°C	ASTM D 445	cSt cSt	14,8 7,4	35,2 14,0	56,1 20,0
Flash point (PM)	ASTM D 93	°C	> 120	> 140	> 140
Initial boiling point	DIN 51751	°C	> 260	> 270	> 270
Wear	Reichert (15N)	mm <sup>2</sup>	20	22	24

The above are production data and are not intended as specification values