



Product Data

Ilocut EDM 401

High performance Electric Discharge Machining Fluid and hydrocarbon solvent Cleaner

Description

Castrol IlocutTM EDM 401 is a low odour, high flash point de-aromatised hydrocarbon solvent suitable for high performance electric discharge machining and different cleaning operations. It has excellent solvency power and is compatible with all metal substrates and most non-metal substrates.

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.

It is also recommended for following cleaning operation:

Spray / Flood wash

Spray for flood wash applicaiton should be carried out in suitable low pressure cleaning equipment.

Soak Tank

Components should be fully immersed in neat product. Contact time depends on soil severity.

Ultrasonic Tank

Components should be fully immersed in neat product.

Wipe Method

Product should be applied neat via hand held spray or brush and the surface is then wiped to clean finish.

Advantages

- EC Solvent Directive (1999/13/EC): Solvent is not classified as a volatile organic compound (VOC) at 20°C (68°F)
- Optimum viscosity ensures good cooling and flushing action in narrow spark gaps
- Low odour and light colour result in greater operator acceptability
- High flash point, low aromatic content result in a safe and pleasant work environment
- Excellent filterability and high oxidation stability ensures long service life
- Excellent solvency power against animal, vegetable and mineral fats and oils and very low surface tension, allowing the fluid to penetrate into difficult to reach areas – improves parts cleanliness and reduces re-work
- No waste water is produced and solvent can be recycled by distillation – highly effective and yet economical

Typical Characteristics

Name	Method	Units	
Appearance			Clear, transparent
Viscosity at 40°C		mm ² /s	3.2 - 4.6
Viscosity at 100°F		SUS	36.5 – 41.2
Density at 15°C			807 min
		lbs/gal	6.72 min
Flashpoint PMCC		°C	120 min
		°F	248 min
Copper corrosion			1b

Subject to usual manufacturing tolerances.

User Advice

- May swell some rubber and plastics during long-term contact.
- The high flash point solvent supports compliance with the EC Solvent Directive (1999/13/EC). Please note, that its low volatility extends the drying time compared to conventional non-VOC compliant products.
- Should not be used for cleaning live electrical equipment.

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.

Illocut EDM 401
12 Dec 2024

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