



LUBRICANTS



Product Data Sheet

Gulf EDM 24

Mineral Oil Base, Low Viscosity Electrical Discharge Machining Fluid

Premium quality, low viscosity dielectric oil for **electric discharge machining (EDM)**. It is readily filterable, non-corrosive and dissipates heat rapidly. It is especially formulated to provide exceptional performance in all spark-erosion applications. The low viscosity supports rapid flushing and allows particulates to fall from gap quickly to improve surface finish. Can be used in electric discharge machines of all sizes and is equally suitable for roughing operations where a high metal removal rate is required, as well as finishing and super-finishing operations.

Features and Benefits

- High flash point, Non-staining
- Low mild odor
- Easy removal and cleaning
- Low viscosity, Produces low smoke
- Rapidly dissipates heat
- Finishes require little buffing

Applications

- Discharge machines of all sizes
- Suitable for roughing operations

Typical Properties

Property	Test Method	Result
Product Code		335458
Kinematic Viscosity, cSt @ 40°C	ASTM D445	2.4
Viscosity, SUS @ 100°F	ASTM D2161	34
Acid Number, mg KOH/g	ASTM D974	0.02
Color, Saybolt	ASTM D156	30+
Flash Point	ASTM D92	235°F
Specific Gravity	ASTM D4052	0.758
Density, lbs/gal	ASTM D4052	6.31
Appearance		Clean and Bright

**Note: Values shown are typical and do not constitute a specification. Minor variations in product are to be expected in normal manufacturing. Always confirm with the original manufacturer's recommendation for proper equipment operating requirements.*

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