



**TWIN SPECIALTIES CORP.**

15 East Ridge Pike  
CONSHOHOCKEN, PA 19428  
(610) 834-7900 FAX (610) 834-7903

**TWIN-KUT EDM OIL 51**  
**Electrical Discharge Machining Oil**

TWIN-KUT EDM OIL is a general purpose dielectric oil featuring a high flash point and a low level of volatility for maximum safety and minimum loss of fluid due to evaporation during use. This oil exhibits good oxidation stability even under the conditions of elevated temperatures at the spark gap and exposure to air found in the EDM process. This is a long-lasting oil that typically resists sludge formation for an extended time under normal use conditions. Excellent heat transfer properties provide adequate quenching of metal surfaces after each spark and cool the workpiece and tool preventing dimensional variations in the workpiece caused by thermal expansion.

TYPICAL CHARACTERISTICS

Specific gravity, 60/60°F	0.85 (7.05 lb/gal)
Vis, SUS @ 100°F	40.3
Pour, °F	10
Color, ASTM	L 0.5
Flash, Pensky Martens	260
Dielectric strength, KV (ASTM-D-877)	46

STORAGE AND HANDLING

Store in a closed container in a dry area. Protect from moisture. Introduction of even trace quantities of moisture damages the dielectric properties of EDM oils, significantly reducing their efficiency.