



Electro-Discharge Machining Fluid.

APPLICATIONS

- **DIEL 300 S** is a light viscosity, light colored, odorless fluid designed for Electro Discharge machining operations.
- **DIEL 300 S** is recommended for all EDM applications including rough machining and finishing. It is used for complex profiles with particularly tight tolerances. This product is an excellent coolant for quenching melted and vaporized metal removed from the workpiece, and it is a good flushing medium to disperse these small metal particles. It is important to continuously filter the EDM fluid to remove both foreign particles and the solids metal by-products of the machining process.
- **DIEL 300 S** is a very fluid petroleum product with a very narrow distillation range making it particularly suitable for spark erosion work.

ADVANTAGES

- Very low volatility.
- High flash point.
- Excellent resistance to oxidation.
- Free of any toxic element.

TYPICAL CHARACTERISTICS	METHODS	DIEL 300 S
Appearance	Visual	Light Colored Liquid
Viscosity at 40°C, cSt	ASTM D 445	4.5 - 5.5
Density @ 60 °F, lbs./gal.	ASTM D 1298	7.26
Specific Gravity @ 60/60 °F	ASTM D 1298	0.871
Flash Point, COC, °F	ASTM D 92	285
Sulfur Content, ppm	ASTM D 4927	10
Pour Point, °F	ASTM D 97	-20
Dielectric Strength, KV		46.0
Conradson Carbon, %wt.	ASTM D 189	Nil
Ash, %wt.	ASTM D 482	Nil
Copper Corrosion, 3h @ 100°C	ASTM D 130	1A - 1B

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