

METAL WORK EDF-K2

Electric Discharge Machining Oil Recommended for Machines of Mitsubishi Electric Corp.

METAL WORK EDF-K2 is a high-speed synthetic oil for electric discharge machining that improves upon the evaporation loss and color stability of its predecessor, METAL WORK EDF-K, without compromising its superior machining performance. In addition to the oxidation and thermal stability required for electric discharge machining oil, **METAL WORK EDF-K2** has been developed to achieve high-accuracy and high-efficiency machining while considering the working environment with features such as low odor and low skin irritation.

● SPECIAL FEATURES

1. Excellent Machining Performance

METAL WORK EDF-K2 is blended with additives to improve workability, enhancing processing speed and stabilizing machining characteristics across a wide range of operations, from roughing to finishing. Therefore, it can increase productivity and machining accuracy compared to commercially available additive-free machining oils.

2. Improvement of the Work Environment

METAL WORK EDF-K2 is formulated with a synthetic hydrocarbon base oil that has low odor and causes less skin irritation, along with antioxidants to improve oxidation and thermal stability. This formulation reduces the stickiness and discoloration problems often found in high-speed machining oils, thereby improving the work environment.

3. Applicable to a Wide Range of Machining

METAL WORK EDF-K2 is designed with the proper viscosity for electric discharge machining oil, making it suitable for a wide range of machining such as precision microfabrication, deep machining, high-speed

roughing, through-hole machining, and bottom shape machining.

● CONTAINERS

200-liter drum and 20-liter pail can

● TYPICAL PROPERTIES OF METAL WORK EDF-K2


Appearance		Transparent liquid
Color (ASTM)		L0.5
Density (15°C)	g/cm ³	0.776
Kinematic viscosity (40°C)	mm ² /s	2.29
Flash point (PM)	°C	85
Pour point	°C	-12.5

Note: The typical properties are subjected to change without notice.
(May 2024)



Handling Precautions

▼ Follow these precautions when handling this product.

Composition :	Base Oil(s), Additives
Hazard pictograms:	
Signal word:	Danger
Hazard Statement:	Combustible liquid May be fatal if swallowed and enters airways
Precautionary Statements: Prevention	<ul style="list-style-type: none">• Do not handle until all safety precautions have been read and understood.• Wear protective gloves/protective clothing/eye protection/face protection.• Do not allow the eyes to become exposed to the product. Do not swallow the product.• Keep away from heat, hot surfaces, sparks, open flames and other ignition sources. No smoking.• Wash hands thoroughly after handling.• Do not eat, drink or smoke when using this product.
Response	<ul style="list-style-type: none">• IF SWALLOWED: Immediately call a POISON CENTER/doctor.• IF SWALLOWED: Rinse mouth. Do NOT induce vomiting.• If the eyes are exposed to the product: Rinse the eyes with plenty of running water and immediately contact a physician.• IF ON SKIN: Wash with plenty of soap and water.• Do NOT induce vomiting.
Storage	<ul style="list-style-type: none">• The product must be stored in a cool, well-ventilated location where it will not be exposed to direct sunlight.• Containers that have been opened must be tightly sealed.• Store in a well ventilated place.• Store locked up.
Disposal	<ul style="list-style-type: none">• Dispose of contents/container in accordance with local/regional/national/international regulations.• If there are any doubts about proper methods of handling the product, contact the point of purchase before proceeding with usage.