

Dielectrics

IME-Series



Human Technology
for man, environment
and machines

HUTECH

The right mediums for spark erosion

oelheld dielectrics IME have been tested in extensive experiments, have proven themselves in practice for decades and are recommended by leading manufacturers of spark erosion plants.

oelheld dielectrics IME possess greatest disruptive strength, they are clear fluids and are almost odourless. During erosive process they do not change their colour. They have the same purity as pharmaceutical white oil and are free of aromatic compounds.

Whether in rough cut operations or in fine work – the dielectric must meet the specific requirements of each particular case of application.

The high-performance dielectrics for use in electrical discharge machining are produced on a synthetic base and have additives with aging inhibitors.



Advantages:

- high dielectric strength
- high degree of metal removal
- excellent resistance of electrode wear
- good aging stability
- effective cooling
- good filterability
- high operational safety
- physiologically tested
- long operating time

Dielectric IME 63

Dielectric IME 63 is extremely thin-bodied and has a particularly low surface tension. It is especially suitable for very fine finishing where the least possible spark gap is required (e.g. micro drilling of spinnerets and the manufacturing of microelectronic parts).

Dielectric IME 82

Dielectric IME 63 is extremely thin-bodied and has a particularly low surface tension. It is especially suitable for very fine finishing where the least possible spark gap is required (e.g. micro drilling of spinnerets and the manufacturing of microelectronic parts).

Dielectric IME 110

Dielectric IME 110 is mostly used if a flashpoint of 100 °C is required for safety reasons, while simultaneously much finishing still has to be done. It is universal usable from fine finishing till roughing works. Best results will be reached by using graphite electrodes.

Dielectric IME 126

Dielectric IME 126 is characterised by very high metal removal and is particularly suited for roughing operations, such as the manufacturing of forging dies. It can only be used for finishing, if the best possible flushing conditions are ensured.

dielectrics	Density at 15°C g/cm ³	Viscosity at 20°C mm ² /s	Flash-point °C	Dielectric-strength (KV)
IME 63	0,77	1,2	6,3	58
IME 82	0,79	2,0	82	59
IME 110	0,78	2,4	106	57
IME 126	0,82	3,8	114	52