oelheld®
innovative fluid technology

IonoPlus®
Dielectric

A tough nut for copycats...!

HUTEC

Powerful advantages for spark erosion:

Fully synthetic universal-high-performance dielectric with satellite electrodes

After long years of research oelheld introduces an entirely new, powerful concept into dielectrics: **IonoPlus®**. Unlike conventional mineral oil products, this combination of high performance synthetic products is enriched with satellite electrodes in a special blending process. Besides having the best possible effectiveness in flushing and the greatest possible disruptive strength, **IonoPlus®** offers a whole series of unique advantages.

IonoPlus® dielectric has been thoroughly tested in respect to operational safety and industrial hygiene.

Toxic or allergic symptoms cannot occur during use. A tolerance limit in the air surrounding the place of work (TLV value) is not reached.

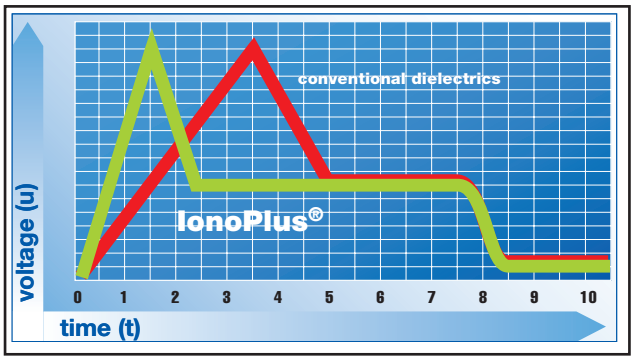
IonoPlus® dielectric can be used in all conventional filtration systems. The regulations for flammable liquids (VbF) do not apply to **IonoPlus®**.

IonoPlus®3000 is a truly universal dielectric and is suited for all operations from the finishing process to the most effective rough cut.

Technical Data IonoPlus®3000:		
Colour	fluorescent green	
Specific gravity at 60° F (g/cm³)	0,79	ASTMD 4052
Density (lbs/gal)	6,58	
Viscosity at		
+68° F (cSt)	3,80	ASTMD 445
+104° F (cSt)	2,50	ASTMD 445
Pourpoint ° F	-5	ASTMD 97
Flashpoint ° F	224,6	ASTMD 93
Aromatic content (weight %)	<0,01	AM-S 140.31

IonoPlus®3000 ET is a special low viscous dielectric especially for all kind of fine operations with small spark gaps.

Technical Data IonoPlus®3000 ET:		
Colour	fluorescent green	
Specific gravity at 60° F (g/cm³)	0,77	ASTMD 4052
Density (lbs/gal)	6,41	
Viscosity at		
+68° F (cSt)	1,90	ASTMD 445
+104° F (cSt)	1,40	ASTMD 445
Pourpoint ° F	< -40	ASTMD 97
Flashpoint ° F	145	ASTMD 93
Aromatic content (weight %)	<0,002	AM-S 140.31



- **Greater resistance to electrode wear**

  Macromolecules surround the electrode like a protective grid.

- **Improved surface quality**

  Satellite electrodes bring about an optimal distribution of discharges.

- **Shining results in the polishing process**

  Within a minimum amount of time a surface roughness of less than 0.1µ can be achieved.

- **Best possible dispersing capacity**

  Swift dispersal of waste particles helps actively to prevent burn spots from forming.

- **Improvemment of the wear performance**

  Shortens the time needed to build up the ionization bridge.

HUTEC

Human Technology
for man, environment
and machines

HIRSCHMANN

Hirschmann Engineering USA, Inc.