

Electrical Discharge Machining Filter Media

Delivering a consistent high purity dielectric fluid.

The filtration of the dielectric fluid in Electrical Discharge Machining (EDM) processes is essential for the quality of the finish and the dimensional accuracy of the workpieces to be produced.

Ahlstrom-Munksjö offers a complete range of filter media for dye-sink and wire-cut EDM applications. Our expertise in designing and producing high performance liquid filtration media ensures excellent media stability during total filter lifetime. Delivering optimal particulate removal and extended dust holding capacity, providing process reliability and reduced running costs.

Ahlstrom-Munksjö EDM portfolio includes **CellTech EDM** media which cover most of the filtration needs of electro-erosion processes. It also includes **Synthetic EDM** premium offering which is recommended for most demanding applications.

Benefits

- ✔ Complete range of particulate removal efficiency covering EDM needs.
- ✔ High wet mechanical resistance and excellent durability in dielectric fluids.
- ✔ High corrugation, easy processing, and best pleat stability for optimal filter design.
- ✔ 100% synthetic offering for ultrafine particulate removal and lowest ions release levels.

Ahlstrom-Munksjö CellTech EDM

First class corrugated cellulose media reinforced with a highly resistant phenolic resin covering all filtration fineness from standard dye-sinking needs to more and more demanding wire-cut EDM processes. Provides reliability and longer service life to the filter elements; guarantees clean dielectric fluid and optimal running of EDM machines. The table below represents only a selection of the grades which can be used in EDM applications.

	Basis Weight	Efficiency*	Thickness	Corrugation Depth	Air Permeability	Burst Strength	MD Stiffness
GRADES	g/m ²	µm @ 90%	µm	µm	L/m ² /s @200 Pa	kPa	g
BF 60/66 AD PLUS-G	155	15	400	300	190	380	6.2
BF 90/40 AD PLUS-G	130	12	335	240	110	400	4.5
BF 120/33 S AD PLUS-G	150	10	400	250	80	450	6.5
BF 300/40 LE H AD PLUS-G	165	6	450	300	48	500	8.0

*Multi-pass test results according to ISO19438.

Ahlstrom-Munksjö Synthetic EDM

Premium full synthetic filter media recommended when best workpiece accuracy and surface finish is needed. Ahlstrom-Munksjö Synthetic EDM delivers the highest removal efficiency of ultrafine particles as well as excellent flow properties keeping a very high level of mechanical strength. In addition, the binder-free structure enables a minimal introduction of ions in the dielectric fluid so increases the lifetime of the ion-exchange resins and, combined with high filtration efficiency, reduces the downtime when a filter is replaced.

	Basis Weight	Efficiency*	Thickness	Corrugation Depth	Air Permeability	Burst Strength	MD Stiffness
GRADES	g/m ²	µm @ 90%	µm	µm	L/m ² /s @200 Pa	kPa	g
AK10525FS HE CA	70	4	280	-	115	490	0.5

*Multi-pass test results according to ISO19438.

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