Eni Aquamet 85

APPLICATIONS

Eni Aquamet 85 is a semi-synthetic water miscible cutting fluid with very high technological characteristics, excellent grinding performance and in heavy-duty machining operations such as: turning, milling, boring and drilling on all ferrous materials, both on single and central plants.

It's usage can be extended to aluminum and its alloys, after a staining test.

Suitable for pipe shaping.

CUSTOMER ADVANTAGES

- High stability and duration of the emulsion in use
- Excellent machining performance on steels and in particular on cast iron.
- Low foam formation in a wide range of water hardness (optimal range: 15-40°F)

SPECIFICATIONS & APPROVALS

- ISO 6743/7 MAE

Eni Aquamet 85

CHARACTERISTICS

Properties	Method	Unit of Measure	Typical
Characteristics of the concentrate			
Appearance	-	-	clear
Density at 20°C	ASTM D 1298	kg/m³	1000
Characteristics of the emulsion			
Aspect of emulsion (3%, water 20 °F)	-	-	traslucent
pH emuls. 3%	ASTM D 1287	-	9.4
Corrosion on paper	DIN 51360	-	pass at 4%
Corrosion test	IP 125	-	pass at 2%
Refractometric factor	-	-	1.9

WARNINGS

- Before start the emulsification operation, it is necessary to carry out adequate cleaning of the tanks and cooling circuits with suitable products.
- Prepare the mixture using an emulsifier, if possible.
- In case of manual mixing, it is recommended to add the product in the water slowly and shaking the mixture. Never vice versa, to avoid problems of emulsion instability.
- To prevent the product deterioration, due to the heat changes for the exposure of the outdoor containers, storage in closed environments at temperatures between +5 and +30° C, is recommended.
- Periodical monitor of the lubricant cooler status is recommended. This is in order to ensure the steady state of the operating parameters and the useful life of the emulsion over time.
- In order to obtain the best results, it is recommended to always follow the above indicated instruction.
- More detailed information will be provided by the Eni Technical Assistance Service.

HANDLING INFORMATIONS

- Here below are reported the recommended concentrations; However, adjustment of effective concentration is necessary according to the specific operational conditions. Given the complex nature of aluminum alloys, it's suggested to check always the stain test before any processing.

Processing	Cast Iron	Steel, Steel Inox	Aluminum and Alloys
Grinding	3%	4%	
Turning, Milling	4%	6%	6%
Boring, Drilling	6%	8%	8%