



APPLICATIONS

Eni Aquamet 260 EP is a semisynthetic EP cutting fluid suitable for heavy duty metal cutting operations such as: tapping, boring, deep drilling and rough grinding operations on all ferrous materials.

The product guarantees excellent performance in single and centralized plants.

Eni Aquamet 260 EP can be used for stamping, deep drawing and blanking of medium gravity; for these operations, the percentage of use can fluctuate between 10 and 20%.

CUSTOMER ADVANTAGES

- Excellent cutting, cooling and lubricating capacity
- Excellent stability and duration of the emulsion in use
- Free from bactericidal formaldehyde donor
- Suitable for cutting operations with a wide range of water hardness (optimal range: 15-40°F)
- Low foam formation, even under high pressure delivery

SPECIFICATIONS & APPROVALS

- ISO 6743/7 MAF





CHARACTERISTICS

Properties	Method	Unit of Measure	Typical
Characteristics of the concentrate			
Visual aspect	-	-	clear
Density at 20°C	ASTM D 4052	kg/m ³	1020
Characteristics of the emulsion			
Aspect of emulsion (3%, water 20 °F)	-	-	traslucent
pH emuls. 5%	ASTM D 1287	-	9.1
Corrosion test	IP 125	-	pass at 2%
Refractometric factor	-	-	1.4

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 INFORMATION

Processing	Cast Iron	Steel, Steel Inox
Grinding	3%	3%
Boring, Drilling	5%	5%
Deep Drilling, Tapping, Threading	6%	7%



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