



APPLICATIONS

Eni Aquamet 86 is a water miscible cutting oil free of chlorine and secondary amines.

Specific for grinding, turning and milling operations on medium alloyed steel and cast iron, for single and centralized plants.

Eni Aquamet 86 can be used for forming and profiling of steel and stainless steel tubes at 6-8%.

CUSTOMER ADVANTAGES

- Free from chlorine and secondary amines
- Excellent emulsion stability and consequent reduction of the maintenance operations
- Excellent anti-rust performance in machining of steels and in particular on cast iron
- Low tendency to foam in a wide range of water hardness (optimal range: 15-40° F)
- Good lubricating power with consequent reduction of tool wear

SPECIFICATIONS - APPROVALS

- ISO 6743/7 MAE





CHARACTERISTICS

Properties	Method	Unit	Typical
Characteristics of the concentrate			
Appearance	-	-	clear liquid
Density at 15°C	ASTM D 1298	kg/m ³	1035
Characteristics of the emulsion			
Emulsion appearance (3%, water 20°F)	-	-	translucent
pH emuls. 5%	ASTM D 1287	-	9.25
Corrosion on paper	DIN 51360	-	pass 5%
Refractometric factor	-	-	2.5

WARNINGS

- Before preparing the emulsion, it is necessary to carry out adequate cleaning of the tank and the circuits of the machine tool with suitable products
- Prepare the emulsion using preferably an emulsifier
- In case of manual mixing, it is recommended to add the product in the water slowly and shaking the mixture, never vice versa in order to avoid problems of emulsion instability
- Store the product in closed warehouses at temperature between +5 and +30°C in order to prevent product deterioration due to thermal shocks
- Monitoring of the working emulsion is recommended in order to ensure emulsion performance in time and prolong its useful life
- More detailed information will be provided by the Eni Technical Assistance Service

HANDLING INFORMATION

- Here below are reported the recommended concentrations, however the effective





concentration will be defined according to the specific operative conditions

Processing	Cast Iron	Steel, Steel Inox
Grinding	5%	5%
Turning, Milling	6%	7%

