# Eni Aquamet 260 EP

## APPLICATIONS

**Eni Aquamet 260 EP** is a semisynthetic EP cutting fluid free of formaldehyde donor bactericide.

Suitable for severe cutting operations such as: tapping, boring, deep drilling and rough grinding operations on all ferrous materials.

**Eni Aquamet 260 EP** can be used for stamping, deep drawing and blanking machinings of medium severity at a percentage between 10 and 20%.

The product guarantees excellent performance in single and centralized plants.

## CUSTOMER ADVANTAGES

- Excellent cooling and lubricant properties for a lower tool wear and a better workpieces finishing
- Excellent emulsion stability, reduction of the maintenance operations
- Free from formaldehyde donor bactericide
- Suitable in a wide range of water hardness (optimal range: 15-40°F)
- Low foam formation, even with high pressure delivery

## SPECIFICATIONS - APPROVALS

- ISO 6743/7 MAF

# Eni Aquamet 260 EP

## CHARACTERISTICS

| Properties | Method | Unit | Typical |
|---|---|---|---|
| **Characteristics of the concentrate** | | | |
| Visual appearance | - | - | clear |
| Density at 20°C | ASTM D 4052 | kg/m³ | 1020 |
| **Characteristics of the emulsion** | | | |
| Emulsion appearance (3%, water 20°F) | | - | traslucent |
| pH emuls. 5% | ASTM D 1287 | - | 9.1 |
| Corrosion | IP 125 | - | pass at 2% |
| Refractometric factor | - | - | 1.4 |

## 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 warehouse 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 the emulsion performance in the time and to 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 actual

concentration should be determined in accordance with the specific operating conditions.

| Processing | Cast Iron | Steel, Steel Inox |
|---|---|---|
| Grinding | 3% | 3% |
| Turning, Milling | 4-5% | 4-5% |
| Boring, Drilling | 5% | 5% |
| Deep Drilling, Tapping, Threading | 6% | 7% |