



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





CHARACTERISTICS

Properties	Method	Unit	Typical
<![CDATA[Characteristics of the concentrate]]>			
Visual appearance	-	-	clear
Density at 20°C	ASTM D 4052	kg/m ³	1020
<![CDATA[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%

