



# eni Aquamet 104

**eni AQUAMET 104** is a multipurpose emulsifiable product, with excellent technological characteristics. It contains highly refined mineral oil, EP(chlorine) and lubricant additives.

## CHARACTERISTICS (TYPICAL VALUES)

### AQUAMET 104

| PRODUCT  |                        | EMULSION                        |       |
|--|------------------------|---------------------------------|-------|
| Appearance   | Liquid                 | Appearance                      | Milky |
| Colour   | Light brown            | pH at 3% in demineralised water | 9.4   |
| Density at 20°C  | 0,97 g/cm <sup>3</sup> | Corrosion test at 2% IP 125     | Pass  |
| Nitrites, Phosphorus, Phenols, Secondary and aromatic amines | Not present            | Refractometer factor            | 1.2   |

## PROPERTIES AND PERFORMANCES

- Milky emulsion.
- Low formation of foam with wide range of water hardness (optimal range from 15° to 40° F)
- Suitable for high-pressure applications.
- Highly resistant to microbial pollution.
- Free of triazinic biocides, aromatic and secondary amines.

## APPLICATIONS

**eni AQUAMET 104** is recommended for cutting operations of medium and high severity such as tapping, threading, drilling and sawing on all ferrous materials, plus aluminium and its alloys, as well as yellow alloys.

*Here below are reported the suggested concentrations; adjustment can be necessary on the base of the working conditions..*

*In the case of aluminium, copper and their alloys, always perform the stain test before processing.*

# eni Aquamet 104



|   | MATERIAL PROCESSED |                 |                      |                   |
|---|--------------------|-----------------|----------------------|-------------------|
|   | Cast Iron – Steel  | Stainless Steel | Aluminium and alloys | Copper and alloys |
| <b>Machining</b>  |                    |                 |                      |                   |
| Turning, milling  | 4 %                | 5 %             | 5 %                  | 5 %               |
| Medium-severe operations:<br>boring, drilling                 | 5 %                | 6 %             | 6 %                  | 6 %               |
| Severe operations:<br>tapping, threading and<br>deep drilling | 6 %                | 8 %             | 8 %                  | 6 %               |

## NOTE

To obtain the best possible results, follow the procedures indicated below:

- before preparing the emulsion, clean and sterilise the tank and the circuits with suitable detergents and bactericides;
- prepare the emulsion using a blender, if possible;
- in the case of manual mixing, it is always best to add the concentrate to water, in order to avoid problems of emulsion instability;
- to prevent deterioration of the product due to sudden changes in temperature or as a result of outdoor display of the containers, it is best to store the product in closed settings, at temperatures between +5° and +30°C.

Detailed information shall be supplied by the Technical Assistance Service.