



APPLICATIONS

Eni Aquamet 85 Plus is a new technology cutting fluid, free of formaldehyde donor bactericide, chlorine and secondary amines; formulated with detergents, anticorrosive and antirust agents.

It is suitable for grinding and for cutting operations of medium severity such as: turning, milling, drilling, on steel and cast iron in single and centralized plants.

Eni Aquamet 85 Plus can be used for tube forming at 6-8%.

CUSTOMER ADVANTAGES

- Free from bactericide and secondary amines for a lower ecotoxicological impact and better conditions of the working environment
- High emulsion stability with consequent reduction of the maintenance operations
- Good cooling and lubricating properties for a longer tool life
- Excellent antirust properties
- Chlorine free, lower disposal costs
- Low tendency to foam in a wide range of water hardness (optimal range 15-40°F) and at high delivery pressure

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	1020
Characteristics of the emulsion		-	
Emulsion appearance	-	-	translucent
PH (5% Emulsione)	ASTM D 1287	-	9.25
Corrosion on paper	DIN 51360	-	pass at 5%
Refractometric factor	-	-	1.7

WARNINGS

- Before preparing the emulsion, it is necessary to carry out an adequate cleaning of the tanks and the circuits of the machine tools with suitable products
- Prepare the emulsion using possibly 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, 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 performances 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	5%	5%
Turning, Milling	6%	7%
Boring, Drilling	7-10%	7-10%



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