



eni aquamet 104 Plus

eni aquamet 104 Plus is an emulsifiable cooling lubricant, multifunctional applicable, with excellent technical properties. Mineral oil containing, heavy metal free cooling lubricant with EP additives and synthetic lubricant additives.

Characteristics (typical figures):

| Product | | Emulsion | |
|---|------------------------|-----------------------------|-------|
| Appearance | Liquid | Appearance | Milky |
| Colour | Light brown | pH at 3% desalted water | 9,4 |
| Density at 20°C | 1,01 g/cm ³ | Corrosion test at 2% IP 125 | Pass |
| Viscosity at 40°C | 28 cSt | Refractometer factor | 1,2 |
| Nitrites, PTBB, Phosphor, Phenols, secondary amines | Not contained | | |

Properties and Performance:

- milky emulsion
- low foam formation
- suitable for the application in water with a large range of hardness (optimum range from 15° to 40°F)
- suitable for high-pressure applications
- biostatic additives
- very resistant against bacterial degradation
- free from secondary amines
- free of formaldehyde releasing agents

Applications:

eni aquamet 104 Plus is a universal cooling lubricant for all moderately and heavy machining processes of aluminium, steel and cast iron.

The recommended application concentrations are listed as follows:

At the application of aluminium, copper and their alloys a test should always be accomplished first.

| Machining | Material | | | |
|----------------------------------|------------------|-----------------|----------------------|-------------------|
| | Cast iron, steel | Stainless steel | Aluminium and alloys | Copper and alloys |
| Turning | 4% | 5% | 4% | 4% |
| Working station | 4% | 5% | 6% | 5% |
| Difficult application conditions | 6% | 8% | 8% | 6% |

eni aquamet 104 Plus



Indications:

The product meets the requirements of the TRGS 611 Section 4.

Please observe the valid VDI Guidelines 3035 and 3397 (1-3) as well as the Regulations of the TRGS 611 Section 5 for the application. When mixing always give the concentrate into the water, a more homogeneous emulsion is achievable by using an automatic mixing unit. A frost-free storage is necessary to maintain the functionality of the cooling lubricant concentrate.

The product is a water hazardous liquid.

The occupational medical precautions have to be observed according to GefStoffV (Ordinance on Hazardous Substances) §15, §16 and annex V.

The BG (professional society) regulation 143 - operations with cooling lubricants - has to be observed for a safety operation.

For specific technical questions please contact our technical department. Get information in reference to our training seminar about the subject cooling lubricants.