

Eni aquamet LMK – STO Plus

Eni aquamet LMK-STO Plus is a water-emulsifiable metalworking fluid concentrate, specially developed for general machining of cast iron as well as alloyed and unalloyed steels. Thanks to the incorporated inhibitors, Eni aquamet LMK-STO Plus can also be used for light machining of aluminum.

Physical properties (typical values):

Eni aquamet LMK- STO Plus	Value	Unit	Test procedure
Total oil content	ca. 20	%	
Viscosity (20°C)	ca.170	mm ² /s	DIN 51 562
Density (15°C)	991	kg/m ³	Din 51 757
pH-value (5%)	10,5		DIN 51369
	(Decrease with use)		
Corrosion test (4%)	0-0	Korr.- Grad	DIN 51360 T.2

Quality features:

- Free from boric acid and formaldehyde-releasing substances
- Low-foaming metalworking fluid emulsion with selected EP additives
- Very good wetting and flushing properties, highly effective corrosion protection
- Complies with TRGS 611
- Long service life due to permanent buffering, outstanding pH stability
- In accordance with the latest occupational medical findings

Possible uses:

Eni aquamet LMK-STO Plus is a universal metalworking fluid for all medium-duty and heavy-duty machining operations of cast iron, alloyed and unalloyed steels, as well as for light machining of aluminium. This latest-generation product meets all requirements for a high-performance, stable metalworking fluid.

Recommended use concentrations depending on application and materials:

• General machining operations:	8.0% \pm 1%
• Difficult machining operations, depending on requirements:	8.0% – 10.0%
• Grinding from:	5%
• Refractometer factor:	1.3

Notice:

The product complies with the requirements of TRGS 611, Section 4. For application, please observe the applicable VDI guidelines 3035 and 3397 (1-3) as well as the specifications of TRGS 611, Section 5. When preparing the emulsion, always add the concentrate to the pre-filled mixing water; a more homogeneous emulsion can be achieved by using mixing devices. To maintain the functionality of the metalworking fluid concentrate, frost-free storage is required.

The product is a liquid hazardous to water.

Occupational medical preventive measures must be taken in accordance with the German Hazardous Substances Ordinance (GefStoffV), Sections 15 and 16 and Annex V. DGUV Regulation 109-003 – Activities involving metalworking fluids (formerly BGR/GUV-R 143) – must be applied to ensure safe handling.

Further information is available from our application engineering department.