

AGIP AQUAMET 104



AGIP AQUAMET 104 is a multipurpose emulsifiable product, with excellent technological characteristics. It contains highly refined mineral oil, EP and synthetic lubricant additives.

CHARACTERISTICS (TYPICAL FIGURES)

AGIP AQUAMET 104

PRODUCT		EMULSION	
Appearance	Liquid	Appearance	Milky
Colour	Light brown	pH at 3% in demineralised water	9,4
Density at 20° C	1,01 g/cm ³	Corrosion test at 2% IP 125	Passed
Viscosity at 40° C	28 cSt	Refractometer factor	1,2
Nitrites, PTBB, Phosphorus, Phenols, Secondary and aromatic amines	Not present		

PROPERTIES AND PERFORMANCES

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

APPLICATIONS

AGIP AQUAMET 104 is recommended for cutting operations of medium and high severity such as tapping, threading and drilling 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.

MACHINING	MATERIAL PROCESSED			
	Cast Iron - Steel	Stainless Steel	Aluminium and alloys	Copper and alloys
Turning	4 %	5 %	4 %	4 %
Working Stations	4 %	5 %	6 %	5 %
Severe operations	6 %	8 %	8 %	6 %

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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.