



# Eni aquamet LMK CLE

**Eni aquamet LMK CLE** is a water emulsifiable cooling lubricant for general machining of cast iron and steel as well as for grinding.

## Characteristics (typical Values):

Eni aquamet LMK CLE		Unit	Test method
Mineral oil content	Ca. 10	%	
Density (15 °C)	1,07	g/cm <sup>3</sup>	DIN EN ISO 12185
Viscosity (20°C)	60	mm <sup>2</sup> /s	DIN EN ISO 3104
pH value (5%)	9,8		DIN 51369
Corrosion test (5%)	0-0	Corr.-grade	DIN 51360 T.2

## Properties and Performance:

- boric acid free, amine containing cooling lubricant
- great technically stable emulsion which results in long downtimes
- very low foaming cooling lubricant emulsion
- forms stable emulsions with water from 10°dh to 30°dh
- finely dispersed emulsions ensure great cooling and rinsing power
- Good corrosion protection
- Universally applicable in machines as well as central systems
- formaldehyde separator free

## Applications:

**Eni aquamet LMK CLE** is an universally applicable cooling lubricant for all light and medium severe and severe machining operations of steel and cast iron. This product fulfills the requirement for a high performance, very stable cooling lubricant.

The recommended application concentration depends on the application as well as on the working materials

- Grinding: Starting with 5,0%
- Machining of cast iron and steel: Starting with 8%

The concentration of the emulsion in use can be checked by a Refractometer. Therefore you need to multiply the read off value with the Refractometer factor.

Factor: Refractometer - 1,9

## 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.



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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. 128/5000

The DGUV regulation 109-003 - Activities with cooling lubricants (previously: BGR / GUV-R 143) - must be used for safe handling. For specific technical questions please contact our technical department. Get information in reference to our training seminar about the subject cooling lubricants.