



ENI UNIMET SR

ENI UNIMET SR is a cutting fluid soluble in water, totally synthetic, free of mineral oil, chlorine, and bactericide recommended for grinding and light cutting operations on ferrous metals, aluminium, copper and their alloys.

CHARACTERISTICS (TYPICAL VALUES)

ENI UNIMET SR

PRODUCT		EMULSION	
Appearance	Light amber	Appearance	Transparent
Density at 20°C kg/l	1,112	pH at 5% in demineralised water	9.3
Refractometer factor	1.9	Corrosion test at 2% IP 125	Pass

PROPERTIES AND PERFORMANCES

- excellent anti-rust power;
- long lasting applications, thanks to excellent resistance to bacterial breakdown;
- Low formation of foam with wide range of water hardness (optimal range from 15° to 40° F)
- low tendency to foam even under high pressure delivery.
- absence of sticky residues on machinery.

APPLICATIONS

ENI UNIMET SR is mainly recommended for grinding operations on ferrous metals.

It can also be used in light cutting operations like turning and milling on ferrous metals, on aluminium, copper and their alloys.

The percentages of use can vary from 4 to 8%, depending on the severity of the operation.

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
Grinding	4%	5%		
Turning, milling	6 %	7 %	7 %	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.