

Q8 Baroni XEPL

High performance semi-synthetic soluble cutting fluid for ferrous and aluminium

Q8 BARONI is a range of high performance soluble metalworking grades which are developed to be free from added chlorinated paraffin. The range which is tolerant in both hard and soft water is suitable for a wide variety of applications and materials, please refer to each product data sheet.

Description

Q8 Baroni XEPL is a medium mineral oil content fluid which will form a high quality stable milky micro emulsion when mixed with water. Q8 Baroni XEPL is free from added chlorine and secondary amines and compliant with the TRGS 611 specification. Q8 Baroni XEPL contains excellent lubricity additives which have a high detergency, providing a high quality surface finish to the machined pieces. Q8 Baroni XEPL is suitable for use in soft and hard water areas resulting in fluid stability and long sump life.

Application

- Q8 Baroni XEPL is designed for the heavy duty machining applications on ferrous and non-ferrous metals, it being a multi material application product. Q8 Baroni XEPL is especially suited for high pressure feed and speed machining on modern CNC machinery due to its low foaming capability. It is also suited for aluminum machining including tapping applications.
- Reference should be made to the relevant Q8 Material Safety Data Sheet before use.

Features and Benefits

- Q8 Baroni XEPL is a multipurpose high performance product, suitable for both ferrous and non-ferrous metals.
- Q8 Baroni XEPL is TRGS 611 compliant.
- Q8 Baroni XEPL incorporates a highly effective anti-corrosion package ensuring protection to machine tools and components.
- Q8 Baroni XEPL forms a highly stable micro-emulsion resulting in extended fluid life. This reduces the requirement for fluid change-over resulting in overall reduced fluid costs.
- High detergency results in excellent tramp oil rejection, high cleanliness and operator visibility.
- Excellent wetting and detergency characteristics ensure that Q8 Baroni XEPL is suitable for use in soft and hard water areas resulting in minimal residue build up.
- Extreme low foaming in all water conditions minimises spillages and waste, improves machine efficiency and reduces "trip out" in automatic systems
- Free from added chlorine and secondary amine ensures environmental compliance, user friendly to the operator.

User Instructions

- Recommended concentrations are listed below, in certain applications it may be beneficial to run at higher concentrations than those stated below. Further advice is available from your Q8Oils representative or from metal@Q8Oils.com

Usage, Care and Maintenance

- The correct mixing procedure is to add Q8 Baroni XEPL to water and stir. Positive displacement (Dosatron type) mixing units are recommended for this operation and are available on request.
- Recommended concentrations are listed below, in certain applications it may be beneficial to run at higher concentrations than those stated below.

Type	Copper Alloys
General machining	5%
Medium/Heavy machining	8%

Type	Steel
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General machining 5%
Medium/Heavy machining 10%

Type Cast Iron
General machining 5%
Medium/Heavy machining 5%

Type Aluminum
General machining 5%
Medium/Heavy machining 9%
Tapping 10%

- Further advice is available from your Q8Oils representative or from metal@Q8Oils.com.
- In order to preserve the integrity of this product, drums should be stored inside a building protected from frost and direct sunlight.

Properties	Method	Unit	Typical
Appearance (Neat)		-	Clear dark fluid
Appearance (Emulsion)		-	Milky Emulsion
Density		g/ml	0.960
pH Value, 3% emulsion		Unit	9.1
Corrosion Test	IP 287	-	4.0 % breakpoint
Refractometer factor		-	1.2 (reading x factor = true concentration)

The figures above are not a specification. They are typical figures obtained within production tolerances.

