PRODUCT DATA SHEET

Q8 Brunel XF 277

Excellent performance boron and amine free water soluble cutting fluid for yellow metals

Description

Q8 Brunel XF 277 is a water soluble cutting fluid for machining operations of yellow metals and zinc, like tapping points and connectors. The amine-free fluid forms a tight milky emulsion when mixed with water and has an outstanding filterability. The advanced formulation provides an excellent chemical- and biological stability. Due to its very low foaming properties (even in relative soft water), Q8 Brunel XF 277 is also suitable for high pressure- and high speed applications.

Applications

Q8 Brunel XF 277 is a high performance soluble metal working fluid specifically designed for machining operations of yellow metals and zinc, like tapping points and connectors.

User instructions

1. *The correct mixing procedure is to add Q8 Brunel XF 277 to water and stir. For this operation we recommend positive displacement (Dosatron type) mixing units.*
2. *In order to preserve the integrity of this product drums should be stored inside a building protected from frost and direct sunlight.*
3. *Recommended concentrations are listed below.*

General machining	*3 – 10%*

Note: In some circumstances and applications, it is beneficial to exceed the recommendations shown above.

Environment, Health and Safety

Q8 Brunel XF 277 is free of added formaldehyde, chlorine, boron, boric acid and secondary amines. It is compliant with the TRGS 611 specification. This ensures environmental safety & operator health. Please consult the Material Safety Data Sheet for instructions regarding safe handling and environmental issues.

Properties

	Method	Unit	Typical
Appearance (Emulsion)	*Visual*	*-*	*Milky*
Density, 20 °C	*D 4052*	*kg/l*	*0.94*
Kinematic Viscosity, 40 °C	*D 445*	*mm²/s*	*39*
pH@3% in 400 ppm CaCO3 water	*D 1287*	*pH*	*9*
Refractometer Factor	*-*	*-*	*0.9*
Mineral oil content	*-*	*%*	*54*
Corrosion characteristics of water-mix metalworking fluids	*IP 125*	*%*	*4%*

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

Remarks

Please contact your Q8Oils representative for further advice and support on your specific application and equipment.