PRODUCT DATA SHEET

Q8 Brunel XF 732

Exceptional performing extremely biostable water-soluble cutting fluid

Description

Q8 Brunel XF 732 is an advanced biostable soluble metalworking fluid incorporating the latest technology of high purity synthetic base fluids obtained chemically from natural gas in an unique combination with lubricity additives and selected key components to provide outstanding performance. Q8 Brunel XF 732 offers superior wetting and detergency characteristics, reducing fluid drag out and ensuring excellent machine cleanliness. Fluid consistency remains stable in either soft or hard make-up water.

Applications

Q8 Brunel XF 732 is designed to excel on a wide range of high speed machining applications processing ferrous materials. The versatile formulation is highly resistant to bacterial infection and significantly exceeds conventional fluid duration periods, providing noticeable cost and waste reductions. With limited maintenance required, Q8 Brunel XF 732 is ideally suited for centralised systems and single sump machines. It is recommended for medium to heavy machining on ferrous materials, including high alloy steel and cast iron. The use can be extended to some copper alloys and low to medium duty application on some aluminium alloys.

User instructions

1. The correct mixing procedure is to add Q8 Brunel XF 732 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 (5-40 ˚C) protected from frost and direct sunlight.
3. Recommended concentrations are listed below.

General machining	4 – 6 %
Severe operations	8 – 12 %

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

Environment, Health and Safety

Q8 Brunel XF 732 has an advanced safety profile. It does not contain biocides and it is free of chlorine, cresols, nitrites, boron, boric acid, DCHA and secondary amines. It is compliant with the TRGS 611 specification. This ensures environmental safety & operator health. Also the reduced smell in the application improves operator environment. Please consult the Material Safety Data Sheet for instructions regarding safe handling and environmental issues.

Properties

	Method	Unit	Typical
Base fluid content	-	%	20
Density, 20 ˚C	D 4052	g/ml	0.966
Kinematic Viscosity, 40 ˚C	D 445	mm²/s	37
Appearance (Emulsion)	Visual	-	Semi-translucent
pH@3% in 400 ppm CaCO3 water	D 1287	pH	9.5
Determination of rust prevention characteristics of water-mix metalworking fluids	IP 287	%	3
Corrosion characteristics of water-mix metalworking fluids	IP 125	%	2
Refractometer Factor	-	-	1.7

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.