PRODUCT DATA SHEET

Q8 Brunel XF 470

Exteme performance ester based water soluble cutting fluid for heavy duty aluminium and aluminium-alloys machining

Description

Q8 Brunel XF 470 is an advanced ester based water soluble cutting fluid for heavy duty aluminium and aluminium-alloys machining. It forms a semi-translucent emulsion when mixed with water and it is very low foaming and tramp oil rejecting. Q8 Brunel XF 470 has an excellent chemical- and biological stability and offers a high detergency and advanced cleanliness. Its high ester content makes the fluid highly polar to surfaces, providing a very high lubricity that substantially increases tool life and surface finish. Q8 Brunel XF 470 is free from boron, boric acid, formaldehyde, chlorine, secondary amine and is TRGS 611 compliant. It has an advanced safety profile and extreme low foam characteristics.

Applications

Q8 Brunel XF 470 is recommended for all heavy duty machining applications on aluminium and aluminium alloys. The product can easily cut and grind machine steel, stainless steel, titanium, Inconel and high silicon steel alloys. It is a multi application product for various materials and suitable for use in soft and hard waters.

User instructions

1. The correct mixing procedure is to add Q8 Brunel XF 470 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.

High performance machining and tapping	6 – 8%
Severe machining	8 – 12%

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

Environment, Health and Safety

Q8 Brunel XF 470 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	-	Semi-translucent
Density, 20 °C	D 4052	kg/l	0.99
pH@5 % in 400 ppm CaCO3 in water	E 70	-	9.1
Refractometer Factor	-	-	1.5
Corrosion characteristics of water-mix metalworking fluids	IP 125	%	3 %
Determination of rust prevention characteristics of water-mix metalworking fluids	IP 287	%	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.