PRODUCT DATA SHEET

Q8 Brunel XF 322

Low foaming, biostable, high performance, semi synthetic soluble cutting fluid

Description

Q8 Brunel XF 322 is a multipurpose low foam water soluble cutting fluid. It provides an excellent chemical- and biological stability and a good detergency, offering advanced cleanliness.

Applications

This product is recommended for CNC machines, Machining Centres, Flexible Manufacturing Systems and all centralised systems. This product is especially developed for the machining of casted aluminium alloys and in particular alloy wheels. This product is also suitable for machining steel alloys and stainless steel.

User instructions

1. *The correct mixing procedure is to add Q8 Brunel XF 322 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	*4 - 6 %*
Heavy duty machining	*7 – 12 %*

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

Environment, Health and Safety

Q8 Brunel XF 322 is free of added formaldehyde, chlorine, boron, boric acid, secondary amines, phenol derivatives and sulfonates. The biocide technology used is non skin sensitizing. 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*	*-*	*Tight milky*
Density, 20 °C	*D 4052*	*g/ml*	*0.981*
pH@3% in 400 ppm CaCO3 water	*D 1287*	*pH*	*9.4*
Kinematic Viscosity, 40 °C	*D 445*	*mm²/s*	*83.5*
Refractometer Factor	*-*	*-*	*1.5*
Determination of rust prevention characteristics of water-mix metalworking fluids	*IP 287*	*%*	*4*
Corrosion characteristics of water-mix metalworking fluids	*IP 125*	*%*	*2*
Mineral oil content	*-*	*%*	*26*

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.

Sustainability

The product Carbon Footprint (PCF), cradle-to-gate (Q8Oils state of the art facility in Belgium), of Q8 Brunel XF 322 is ***1.06*** *kg* CO_2*eq / kg.*
Please contact Q8Oils to learn more about the positive environmental impact, the handprint, of this product.
For more info check here

we take care