

Q8 Brunel XF 527

High performance full synthetic non-cobalt leaching grinding fluid

Description

Q8 Brunel XF 527 is an advanced non-cobalt leaching synthetic grinding fluid for all hard metals grinding operations, including all surface grinding, cylindrical grinding, as well as tool and cutter grinding. It is developed to give the highest quality finish in all operations. When diluted with water it forms a true solution rather than an emulsion, which gives excellent wheel and workpiece visibility. Q8 Brunel XF 527 uses the latest full synthetic anti-corrosion additive technologies. It provides outstanding corrosion protection, suitable for stain-free machining of ferrous metals.

Applications

Q8 Brunel XF 527 is recommended for all hard metals (e.g. tungsten carbide) grinding operations including all surface grinding, cylindrical (internal and external) grinding, as well as tool and cutter grinding. It is particularly recommended for creep feed and centreless operations. It is not however, suitable for grinding alloys containing zinc or magnesium.

User instructions

1. The correct mixing procedure is to add Q8 Brunel XF 527 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 grinding	3.5-5.0%
Steels and hard carbide materials grinding	5 – 6%

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

Environment, Health and Safety

Q8 Brunel XF 527 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	-	Transparent
Density, 20 °C	D 4052	g/ml	1.111
pH@3% in 400 ppm CaCO3 water	D 1287	pH	9.0
Refractometer Factor	-	-	1.4
Mineral oil content	-	%	0
Corrosion characteristics of water-mix metalworking fluids	IP 125	%	2
Determination of rust prevention characteristics of water-mix metalworking fluids	IP 287	%	3

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.