

Q8 Bach XAS 6

Extreme performance, neat cutting oils.

Q8 Bach XAS is just one of the many product ranges within the Q8 Bach metalworking series, which cover active and non-active products at optimum, high and extreme levels of performance.

Description

Q8 Bach XAS is a range of chlorine free, active, neat cutting oils for machining of cast iron, carbon steel and high alloy steels, like stainless steel and heat resistant steel alloys.

Application

- Typical applications (guide only):

Grinding, drilling and turning:

Q8 Bach XAS 6

General machining, broaching and gear shaping:

Q8 Bach XAS 16 & 24

Broaching and very severe operations:

Q8 Bach XAS 42

- Medium viscosity, active type chlorine free cutting oil for turning, drilling and threading of high alloyed steels such as stainless, chrome-nickel and heat resistant steels.

Benefits

- Light coloured
- Oxidation stable
- Minimum mist formation
- High cutting power
- Long tool life even with high speed operations
- Long service life of the oil

Features and Benefits

Features

- Extreme removal performance
- Extreme oxidation stability
- Low air release
- Low foam
- Extreme performance additives
- Free of chlorine and heavy metals
- Extends tool life
- Excellent surface finish of work pieces

Benefits

- For very severe operations
- Long oil life
- No cavitation
- Lower tool wear
- High load properties to protect tool
- Human exposure acceptable products
- Reduces costs
- No re-works

- The formulation is based on very high quality base fluids (Group III).

Usage, Care and Maintenance

- There is a risk of staining of copper and copper-alloys.
- In some applications, it can be used for machining aluminium and magnesium.
- In order to preserve the integrity of these products, they should be stored and protected from water-entry and frost.
- Reference should be made to the relevant Q8 Material Safety Data Sheet before use.



Properties	Method	Unit	Typical
Absolute Density, 15 °C	D 4052	g/ml	0.845
Kinematic Viscosity, 40 °C	D 445	mm ² /s	5.9
Colour	D 1500	-	L2.0
Pour Point	D 97	°C	-27
Flash Point, COC	D 92	°C	130
Copper Strip, 3 h, 100 °C	D 130	-	4
Sulphur	XRF	% mass	1.9
Chlorine	XRF	% mass	nil
Four Ball Test, Weld Load	IP 239	kg	>770
Four Ball Wear Test, 1800 rpm, 54.4°C, 60 kg, Wear Scar	D 4172	mm	0.79

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

Extreme Performance						
High Performance	Cast Iron	Carbon Steel	Alloyed Steel	Stainless Steel/ Nickel Alloys	Aluminium	Copper/ Copper Alloys
Optimum Performance						
General Machining	Q8 Bach XAS 24	Q8 Bach XAS 24	Q8 Bach XAS 24	Q8 Bach XAS 24	Q8 Bach XNF 15	Q8 Bach XNF 15
	Q8 Bach XAF 22				Q8 Bach XND 22	Q8 Bach XND 22
	Q8 Bach XNRG 25					
Deep Hole Drilling	Q8 Bach XAH 10	Q8 Bach XAH 10	Q8 Bach XAH 10	Q8 Bach XAH 10	Q8 Bach XND 12	Q8 Bach XND 12
	Q8 Bach XNRG 12					
Broaching	Q8 Bach XAS 42	Q8 Bach XAS 42	Q8 Bach XAS 42	Q8 Bach XAS 42	Q8 Bach XNF 36	Q8 Bach XNF 36
	Q8 Bach XAF 22	Q8 Bach XAS 24	Q8 Bach XAS 24	Q8 Bach XAS 24		
	Q8 Bach XNI 15	Q8 Bach XAR 20	Q8 Bach XAR 20	Q8 Bach XAR 20	Q8 Bach XND 31	Q8 Bach XND 31
Gear Shaping	Q8 Bach XAS 24	Q8 Bach XAS 24	Q8 Bach XAS 24	Q8 Bach XAS 24		
Honing	Q8 Bach XNK					
Gear Hobbing	Q8 Bach XNF 36					
	Q8 Bach XNRG 44					

The Q8Oils range of neat cutting fluids is developed for use with a broad selection of machining applications and materials. These products should support you in production, optimized work piece surface finish and maximum tool life. All the products are free from chlorinated hydrocarbons.



