

Q8 Baroni XCIH

Low foaming, Hard water stable, metalworking fluid for Ferrous Machining

Q8 BARONI Range

Q8 BARONI is a range of high performance soluble metalworking grades which are developed to be free from added chlorinated paraffin. The range which is tolerant in both hard and soft water is suitable for a wide variety of applications and materials, please refer to each product data sheet.

Applications

Q8 Baroni XCIH is recommended for CNC machines, Machining Centres, Flexible Manufacturing Systems and all centralised systems. It is designed for the majority of ferrous materials, especially cast iron and high tensile steels, and is also suitable for most copper based alloys.

Q8 Baroni XCIH is also recommended for grinding applications where a mineral oil based fluid is preferred. Advanced technology ensures that it will outperform traditional fully synthetic grinding fluids, whilst ensuring machine protection and high standards of surface finish.

Product Description

Q8 Baroni XCIH is a semi synthetic, water mix fluid for the general machining of ferrous and non-ferrous materials. It is designed for use in modern high flow machining centres specifically for hard water areas.

This product has been developed to keep machines extremely clean throughout the coolant life. The lubrication characteristics at the tool tip chip interface, helps prevent built up edge. When mixed with water it forms a semi translucent to white opaque emulsion that is completely stable and long lasting. The bio-stable properties mean that the emulsion does not degrade or produce bad odours, and the emulsion needs little or no maintenance. The formulation does not contain added chlorine, sulphur, cresols, phenols or nitrites.

Summary of Main Features and Benefits

- Formulated to give optimum performance in areas where water hardness levels are greater than 200ppm
- Outstanding cleanliness & corrosion protection when machining cast iron
- Biostable emulsion for long sump life with no bad odours
- Easily maintained, has excellent filterability and is especially suitable for centralised systems
- Developed for use in new high pressure systems

Typical Inspection Data

Appearance (Neat)	Straw – Amber Fluid
Appearance (Emulsion)	Semi Translucent - White Opaque
pH @ 5%	9.6
Density @ 20C	0.993
Corrosion Test IP 287	2.5% breakpoint
Refractometer factor	1.1 (reading x factor = true concentration)

User Instructions

Q8 Baroni XCIH is easily mixed. The correct mixing procedure is to add Q8 Baroni XCIH to water and stir. Positive displacement (Dosatron type) mixing units are recommended for this operation and are available on request. (Never add water to Q8 Baroni XCIH as this can cause invert type emulsions). Recommended emulsion strengths are listed below, for optimum biostability use at concentrations of 3% or above.

Further advice is available from youQ8Oils representative or from metal@Q8Oils.com

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|-------------------------|-------------|
| • Grinding applications | 3.0 – 5.0% |
| • Non-ferrous machining | 3.0 – 5.0% |
| • General machining | 5.0 – 6.0% |
| • High tensile steels | 5.0 – 10.0% |

In order to preserve the integrity of this product drums should be stored inside a building protected from frost and direct sunlight.

Health and Safety

Reference should be made to the relevant Q8 Material Safety Data Sheet before use.
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