

Q8 Baroni XCIS

Low foaming, 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 XCIS 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 XCIS 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 XCIS 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, where high foaming may be a problem, particularly in soft 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 white opaque emulsion that is completely stable and long lasting. The biostable 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 less than 200ppm
- Outstanding cleanliness 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 Fluid
Appearance (Emulsion)	White Opaque
pH @ 5%	9.6
Density @ 20C	0.995
Corrosion Test IP 287	2.5% breakpoint
Refractometer factor	1.1 (reading x factor = true concentration)

User Instructions

Q8 Baroni XCIS is easily mixed. The correct mixing procedure is to add Q8 Baroni XCIS 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 XCIS as this can cause invert type emulsions).

Recommended emulsion strengths are listed below, in certain applications it may be beneficial to run at higher concentrations than below. For optimum biostability use at concentrations of 3% or above. Further advice is available from your Q8Oils representative or from metal@Q8Oils.com

- | | |
|-------------------------|-------------|
| • 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.
Feb14,v4

