

# Q8 Baroni XGPH

**Low foaming, hard water stable, bio-stable, high quality soluble cutting fluid**

## 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 PDS.

## Application

This product is recommended for CNC machines, Machining Centres, Flexible Manufacturing Systems and all centralised systems. The product is suitable for a wide range of materials including cast iron, stainless steel, high tensile steel, yellow metals, aluminium alloys, and titanium.

It has been formulated to give optimum performance in hard water. In soft water <250 ppm we would recommend using Q8 Baroni XGPS.

## Product Description

Q8 Baroni XGPH is a multipurpose, semi-synthetic, water mix cutting fluid with synthetic lubricity enhancers designed for medium to difficult duty machining. The lubrication characteristics at the tool tip chip interface, helps prevent built up edge.

The product is designed to keep machines extremely clean throughout the coolant life. When mixed with water it forms a semi translucent to 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.

Q8 Baroni XGPH is specifically designed for use in modern high flow machining centres, where high foaming may be a problem, especially in hard water areas.

The formulation does not contain added chlorine, sulphur, cresols, phenols or nitrites. Rust and corrosion protection are outstanding, and no sticky residues or sludges are deposited on machine parts.

## Summary of Main Features and Benefits

- Excellent multifunctional cutting fluid
- Suitable for difficult to machine metals
- Developed for hard water areas
- 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

## Typical Inspection Data

Appearance (Neat)	Straw Fluid
Appearance (Emulsion)	Semi Translucent - White Opaque
pH @ 5%	9.0 – 9.5
Density @ 20C	0.984
Corrosion Test IP 287	2.5% breakpoint
Refractometer factor	1.11 (reading x factor = true concentration)

## User Instructions

Q8 Baroni XGPH is easily mixed. The correct mixing procedure is to add Q8 Baroni XGPH 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 XGPH 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 those stated. Optimum biostability is obtained at concentrations of 3% or above.

Further advice is available from your Q8 representative or from metal@Q8Oils.com

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|-------------------------|-------------|
| • Non ferrous machining | 4.0 – 6.0%  |
| • General machining     | 5.0 – 7.0%  |
| • 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.

Jan14, v3

