Q8 Baroni XMG

Soluble metalworking fluid for magnesium and aluminium alloys

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

Application
Q8 Baroni XMG is a water soluble cutting and grinding fluid that has been developed to give superb machining performance on magnesium and aluminium alloys. The applications include turning, drilling, milling, thread cutting, forming, boring, deep hole drilling, reaming and grinding applications.
Q8 Baroni XMG is also suitable for use with ferrous alloys, Inconel and other high spec alloys and oil resistant plastics and other non-ferrous materials.

Product Description
Q8 Baroni XMG is a water soluble cutting and grinding fluid for machining magnesium and aluminium alloys. It has excellent low foaming characteristics making it suitable for high and low pressure CNC systems and has been developed to give exceptional emulsion stability in hard water applications.

Summary of Main Features and Benefits
- Recommended for machining of magnesium and aluminium alloys
- Increased tool life
- Good hard water stability – typically 50 - 400ppm
- Long sump life
- Low foam characteristics
- TRGS 611 compliant
- Free from sulphur & chlorine Extreme Pressure (EP) additives
- Free from secondary amines, triazine biocides, sodium nitrite & silicon defoamers

Typical Inspection Data

Appearance (Neat)	Amber liquid
Appearance (Emulsion)	Milky
Density@ 20C	0.960
pH @ 5%	9.0
Corrosion Test IP287	5.0% breakpoint
Refractometer Factor	1.0 (reading x factor = true concentration)

User Instructions
Q8 Baroni XMG is easily mixed. The correct mixing procedure is to add Q8 Baroni XMG 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 XMG 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

- General machining 5.0 – 6.0%
- Thread cutting & forming 6.0 – 8.0%
- Deep hole drilling & boring 6.0 – 8.0%
- Reaming 8.0 – 10.0%
- Grinding 5.0%

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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