

Q8 Baroni XSP

Biostable, semi synthetic, soluble cutting fluid for aerospace 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 XSP is developed for difficult to machine aerospace alloys including aluminium, stainless steels, titanium, inconel, nimonics, copper containing alloys & aerospace alloys including 7000 series. It is also suitable on ferrous alloys and a wide range of plastics and composites including carbon fibre. Q8 Baroni XSP is designed for turning, drilling, milling threading, boring, deep hole drilling, reaming and Mapal reaming applications. It can also perform in creep feed grinding applications

Product Description

Q8 Baroni XSP is a multipurpose, semi-synthetic, water soluble cutting and grinding fluid. It is a long life fluid formulated to give high performance on difficult to machine alloys and has been formulated to give ultra-low foam characteristics in applications where the emulsion is delivered at high pressures.

Summary of Main Features and Benefits

- Increased tool life
- Excellent corrosion protection
- Suitable for difficult to machine metals
- Long sump life
- Ultra low foam characteristics
- Free from Sulphur, Chlorine and Phosphorus Extreme Pressure (EP) additives
- Q8 Baroni XSP contains more than 50% mineral oil as recommended for Mapal reaming

Typical Inspection Data

Appearance (Neat)	Amber liquid
Appearance (Emulsion)	Semi-translucent
Odour	Bland
Density @ 20C	0.970
pH @ 5%	9.1
Corrosion Test IP287	2.0% breakpoint
Refractometer Factor	1.1 (reading x factor = true concentration)

User Instructions

Q8 Baroni XSP is easily mixed. The correct mixing procedure is to add Q8 Baroni XSP 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 XSP 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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|--------------------------------|-------------|
| • General machining | 5.0 – 7.0% |
| • Deep hole drilling & tapping | 6.0 – 8.0% |
| • Mapal reaming | 9.0 – 11.0% |
| • Creep feed grinding | 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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