

## Q8 Baroni XEPL

Formaldehyde free, high performance multi-purpose semi synthetic cutting fluid

### Description

Q8 Baroni XEPL is a multipurpose water mix cutting fluid, formulated with a medium high oil content and synthetic lubricity additives designed to excel on a wide range of materials and applications. When mixed with water it forms a highly stable micro emulsion in both hard and soft water. Q8 Baroni XEPL is free from added chlorine and secondary amines and compliant with the TRGS 611 specification. In addition, it is also free from formaldehyde and skin sensitizers. Q8 Baroni XEPL contains excellent lubricity additives which have a high detergency, providing a high quality surface finish to the machined pieces. Q8 Baroni XEPL is suitable for use in soft and hard water areas resulting in fluid stability and long sump life.

### Applications

Q8 Baroni XEPL is designed for the heavy duty machining applications on ferrous and non-ferrous metals, it being a multi material application product. Q8 Baroni XEPL is especially suited for high pressure feed and speed machining on modern CNC machinery due to its low foaming capability. It is also suited for aluminum machining including tapping applications.

### User instructions

1. The correct mixing procedure is to add Q8 Baroni XEPL to water and stir. For this operation we recommend positive displacement (Dosatron type) mixing units.
2. In order to preserve the integrity of this product, drums should be stored inside a building protected from frost and direct sunlight.
3. Recommended concentrations are listed below.

General machining	5%
Medium/Heavy machining on cast iron	5%
Medium/Heavy machining on copper	8%
Medium/Heavy machining on aluminium	9%
Tapping in aluminium	10%
Medium/Heavy machining on steel	10%

Note: In some circumstances and applications, it is beneficial to deviate from the recommendations shown above.

### Environment, Health and Safety

Please consult the Material Safety Data Sheet for instructions regarding safe handling and environmental issues.

### Properties

	Method	Unit	Typical
Appearance (Neat)	Visual	-	clear and dark fluid
Appearance (Emulsion)	Visual	-	milky emulsion
Density, 20 °C	D 4052	g/ml	0.96
pH@5% in 400 ppm CaCO3 water	E 70	-	9.3
Refractometer Factor	-	-	1.2

The figures above are not a specification. They are typical figures obtained within production tolerances.

### Remarks

Please contact your Q8Oils representative for further advice and support on your specific application and equipment.