

## Q8 Brunel XF 355

High performance semi-synthetic water soluble cutting fluid for ferrous- and aluminium alloys

### Description

Q8 Brunel XF 355 is a high mineral oil content semi-synthetic fluid for heavy duty machining applications on ferrous and non-ferrous metals. It forms a high quality stable tight milky emulsion when mixed with water, resulting in extended fluid life and reduced fluid costs. The excellent lubricity additives provide a high quality surface finish to the machined pieces. Q8 Brunel XF 355 incorporates a highly effective anti-corrosion package, ensuring protection to machine tools and components. It is suitable for use in soft and hard water areas.

### Applications

Q8 Brunel XF 355 is designed for heavy duty machining applications on ferrous and non-ferrous metals, it being a multi-material application product. It is especially developed for high pressure feed and speed machining on modern CNC machinery due to its low foaming capability. It is also suitable for aluminium machining including tapping application.

### User instructions

1. The correct mixing procedure is to add Q8 Brunel XF 355 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.

	Copper	Steel	Cast iron	Aluminium
General machining	5 %	5 %	5 %	5 %
Medium/Heavy machining	8 %	10 %	5 %	9 %
Tapping				10 %

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

### Environment, Health and Safety

Q8 Brunel XF 355 is free of added formaldehyde, chlorine, boron, boric acid and secondary amines. It is compliant with the TRGS 611 specification. This ensures environmental safety & operator health. Please consult the Material Safety Data Sheet for instructions regarding safe handling and environmental issues.

### Properties

	Method	Unit	Typical
Appearance (Emulsion)	Visual	-	Semi-translucent
Density, 20 °C	D 4052	g/ml	0.971
Kinematic Viscosity, 40 °C	D 445	mm <sup>2</sup> /s	86
pH@3% in 400 ppm CaCO <sub>3</sub> water	D 1287	pH	9.4
Refractometer Factor	-	-	1.1
Mineral oil content	-	%	40
Corrosion characteristics of water-mix metalworking fluids	IP 125	%	2
Determination of rust prevention characteristics of water-mix metalworking fluids	IP 287	%	3

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.