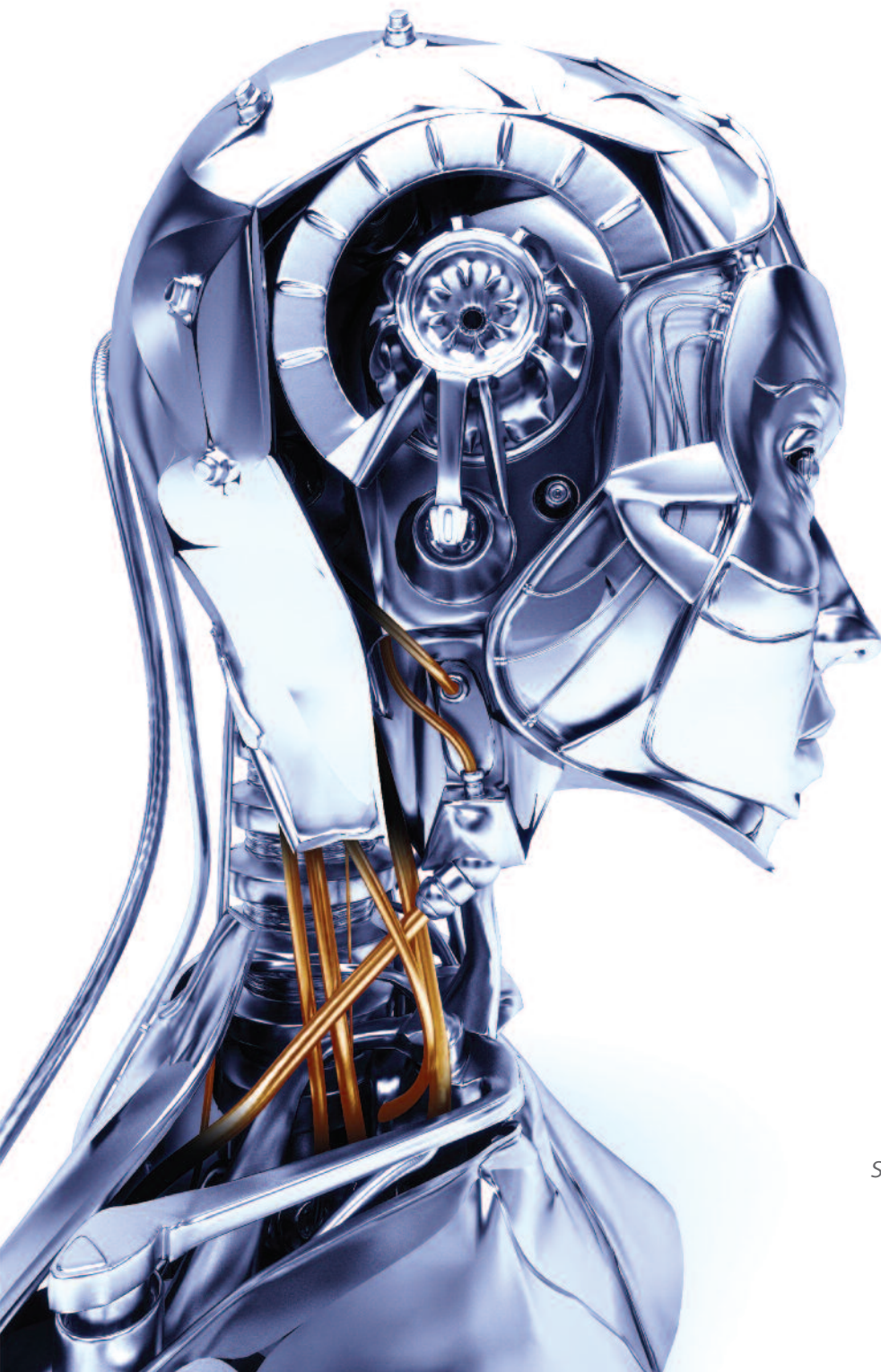


# Q8 Oils

a revolution in metalworking fluids

**tech**   
*boosting performance*



*soluble & neat metalworking fluids*

# smart engineering solutions

*Metalworking fluids are one of the most complex liquids owing to their chemistry and the environment in which they have to perform. The wide range of materials and applications means that it is not possible to develop one formulation that fits all requirements. It is therefore essential to offer a wide product range so that customers can confidently choose the metalworking fluid best suited to their process and application.*



*Complex chemistry, new materials and difficult applications require smart engineering solutions.*

As well as performance requirements, we recognise our customers' commercial needs. By offering a range of high performance products we can help the customer balance criteria such as surface finish, the severity of the working environment and productivity, against cost. High performance chemistry comes at a higher price; for example, the machining of aerospace titanium compared to steel, requires smart and different engineering solutions.



*Innovation in materials and engineering techniques must be matched by innovation in metalworking fluids.*

On the following pages, the table and graphs will help you identify candidate products in the Q8Oils range. You can verify then your choice by referring to our data sheets which give a detailed profile of each product. Alternatively, you may request a visit from a Q8Oils product specialist to discuss your requirements in more detail (see back page).

Please visit [www.Q8Oils.com](http://www.Q8Oils.com) for more information on Metalworking Fluids ranges.

# Q8 Brunel

is a superior range of high performance soluble metalworking grades which are developed to challenge the demands and meet the needs of advanced engineering applications. The range which has an advanced safety profile is fully compliant with environmental and chemical legislation, free from Boron, Boric Acid, Formaldehyde, Chlorine and Secondary Amines, the range is also suitable for use in both hard and soft water.



Q8Oils Field Service Technicians are specialists in finding solutions, or improving existing performance.

Q8 Brunel Product Type	Application			Materials										Emulsion appearance	Density (20°)	pH @5% in 400 ppm	Refractometer Factor	Corrosion IP 125	Corrosion IP 287			
	Machining	Grinding	Tube	Copper Alloys	Cast Iron	Steel	Stainless Steel	Aluminium	AA 6000	AA 7000	Titanium	Inconel	Carbide									
<b>Semi-synthetic</b>																						
Q8 Brunel XF 111	✓	✓															Translucent	1.018	9.1	2.10	2.5%	4.0%
Q8 Brunel XF 132	✓	✓															Translucent	1.044	9.4	1.50	2.0%	4.0%
Q8 Brunel XF 263	✓	✓															Semi-translucent	0.991	9.0	1.20	2.0%	4.0%
Q8 Brunel XF 343	✓																Semi-translucent	0.992	9.2	1.30	3.0%	5.0%
<b>Ester-based</b>																						
Q8 Brunel XF 280	✓																Tight milky	0.954	9.6*	0.90	3.0%	6.0%
Q8 Brunel XF 450	✓																Semi-translucent	1.000	9.2	1.60	2.0%	4.0%
<b>Synthetic</b>																						
Q8 Brunel XF 527			✓														Transparent	1.100	9.6*	1.50	2.0%	3.0%
Q8 Brunel XF 442	✓	✓															Yellow straw fluid	1.045	9.2	2.40	3.0%	5.0%
Q8 Brunel XF 530	✓	✓															Transparent	1.079	9.4	1.50	2.0%	2.0%
Q8 Brunel XF 575			✓														Transparent	1.065	9.3	2.00	2.0%	2.0%

Recommended Consult Q8Oils

\*D.I water

# Q8 Berlioz

is a range of soluble metalworking grades which are developed to be Formaldehyde Free, TRGS 611 compliant, Chlorine free and Secondary Amine free, tolerant to both Hard and Soft water.



Regardless of the material, machining environment or application, we have a product for the task.

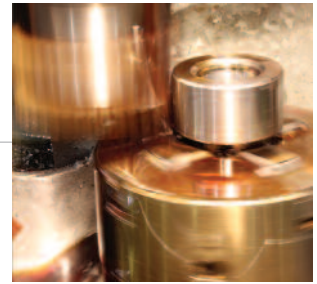
Q8 Berlioz Product Type	Application			Materials										Emulsion appearance	Density (20°)	pH @5% in 400 ppm	Refractometer Factor	Corrosion IP 125	Corrosion IP 287			
	Machining	Grinding	Tube	Copper Alloys	Cast Iron	Steel	Stainless Steel	Aluminium	AA 6000	AA 7000	Titanium	Inconel										
<b>Mineral Based</b>																						
Q8 Berlioz XMR	✓																Milky	0.893	9.8*	0.90	2.0%	4.0%
<b>Semi-synthetic</b>																						
Q8 Berlioz XAD	✓	✓	✓														Semi-translucent	1.007	9.4	1.50	2.0%	3.0%
Q8 Berlioz XVP	✓	✓															Transluc. Emulsion	1.017	9.3	1.60	2.0%	4.0%
Q8 Berlioz XVH	✓	✓															Tight milky	0.968	9.1	1.00	3.0%	4.0%
Q8 Berlioz XMA	✓	✓															Semi-translucent	1.000	9.3	1.30	2.5%	4.0%
Q8 Berlioz XRC	✓	✓															Translucent	1.037	9.5	2.30	2.0%	3.0%
<b>Synthetic</b>																						
Q8 Berlioz XRS			✓														Transparent	1.082	9.6	2.30	2.0%	3.0%

Recommended Consult Q8Oils

\*D.I water

## Q8 Bach

is a range of neat cutting fluid, developed for use with a broad selection of machining applications and materials. Q8 Bach range should support you in production, optimise work piece surface finish, and maximise tool life. All products in Q8 Bach range are free from chlorinated hydrocarbons.



Q8 Bach uses base oils which makes them very oxidation stable, so maintaining viscosity and product integrity, leading to longer service life.

Q8 Bach Product Type	Description	Operation	Cutting Performance	Sulphur	Viscosity 40°C (mm <sup>2</sup> /s)	Flash point COC (°C)	Copper Strip (3h)
Q8 Bach XNRG 44	Extreme performance non-active, mineral oil and chlorine free, cutting fluids for machining of cast iron, carbon steel and high alloy steels, like stainless steel and heat resistant type of steels, aluminium, copper and copper-alloys.	Gear hobbing, broaching and very severe operations		Inactive	44	304	1b
Q8 Bach XNRG 25		General machining, gear hobbing, broaching and very severe operations		Inactive	25	253	1b
Q8 Bach XNRG 15		Drilling & deep hole drilling		Inactive	12	200	1b
Q8 Bach XAH 10	Extreme performance active cutting oil for deep hole drilling	Deep hole drilling		Active	11.2	165	4a
Q8 Bach XAS 42	Extreme performance active cutting oil for machining of cast iron, carbon steel, high alloyed steels, stainless steel and heat resistant steel alloys	Extreme severe operations		Active	41	210	4a
Q8 Bach XAS 24		General machining, broaching and gear shaping		Active	24.2	204	4a
Q8 Bach XAS 16		General machining, broaching and gear shaping		Active	16	144	4a
Q8 Bach XAR 20	High performance active neat cutting oil for severe and critical cutting operations of high alloy steels, like stainless steel and high nickel steel	Severe operations like broaching, hobbing and shaping		Active	19	180	4a
Q8 Bach XNF 36	High performance non-active cutting oil for machining of light and medium alloyed steels and non-ferrous metals	Broaching & gear hobbing		Inactive	36.2	202	1b
Q8 Bach XNF 28		General machining for more severe operations		Inactive	27.6	196	1b
Q8 Bach XNF 15		General machining		Inactive	15	186	1b
Q8 Bach XNF 10		Deep hole drilling		Inactive	9.5	130	1b
Q8 Bach XNF 6		Grinding & drilling		Inactive	5.5	126	1b
Q8 Bach XND 31	Optimum performance non-active cutting oil for machining of non-ferrous metals	Severe operations		Inactive	30.3	198	1b
Q8 Bach XND 22		General machining		Inactive	22	180	1b
Q8 Bach XND 12		Drilling & deep hole drilling		Inactive	12	166	1b
Q8 Bach XNK	High performance low viscosity cutting fluid	Honing and Superfinishing	Inactive	4.7	132	1b	
Q8 Bach MQL 20	High performance Minimum Quantity Lubrication fluid	Sawing, cutting and forming of aluminium and steels by micro-spraying or drip-lubrication	Inactive	18.5	190	1b	

Machining Operation	Operation Severity	Cutting Speed	Cutting Fluid Activity
Broaching, internal			
Pipe threading			
Tapping			
Broaching, surface			
Forming & thread grinding			
Threading, general			
Gear shaping, rotary			
Thread rolling, rotary			
Gear shaping			
Reaming			
Deep drilling			
Drilling, boring			
Thread rolling, rack			
Hobbing, gear spline			
Milling			
Turning			
Band and hand sawing	Low	High	Low

The table left identifies the performance level required from the metalworking fluid in relation to the severity of the operation.

As the severity of the machining operation increases, the speed of operation decreases and the need for antiwear and EP protection increases.



# Q8Oils product range

*Our metalworking fluids are the result of more than 100 years of product development and application experience. Our chemists and product engineers take a unique, innovative and progressive approach to developing different grades for different applications. We develop smart products that extend tool life and significantly reduce operating costs, while staying a step ahead of the new demands arising from higher fluid pressures, faster cutting speeds, new materials and tool technologies.*



*Ensuring a healthy environment for the machine operator is a key consideration in our product and service philosophy.*

To achieve this we constantly seek new components to improve chemical and biological stability, including biodegradable and synthetic esters. Combined with the latest active and non-active chemistry our products have excellent wetting, anti-wear and EP properties. They maximise cooling, resist foaming, improve tool life and eliminate corrosion and staining to ensure excellent component surface quality. Our products are formulated to resist attacks from micro-organisms such as bacteria and fungi. They perform equally well in hard or soft water, maintain machine cleanliness and ensure operator safety. With low misting, low evaporation and low odour, Q8Oils products also improve the workshop environment.



*Confidence in our products, services and people, has been a key factor in establishing Q8Oils reputation as a trusted partner.*

There are four product families in the Q8Oils portfolio. Selection depends on the type of chemistry required:

- **Q8 Berlioz:**  
*soluble fluids that are free of Formaldehyde, Chlorine and Secondary Amine.*
- **Q8 Bach:**  
*neat metalworking oils.*
- **Q8 Brahms:**  
*neat forming oils.*
- **Q8 Brunel:**  
*Soluble fluids that are free from Boron, Boric Acid, Formaldehyde, Chlorine and Secondary Amines.*

*Product research & development is the foundation of superior performance and customer productivity.*



*Q8Oils extensive research & development facilities carry out a full range of testing in order to develop superior products, including: torque tapping test TTT microtap, Cameron plint, four ball weld, Reichert, corrosion, Falex EP, material compatibility, oxidation, emulsion, quenching and many more.*

# about Q8Oils

*Q8Oils is part of the Kuwait Petroleum Corporation (KPC), one of the world's largest oil companies. With 120 years of known reserves and crude oil production levels of 2.9 million barrels per day, it is ranked the seventh largest oil producer in the world. KPC's business spans every segment of the hydrocarbon industry: on and offshore exploration, production, refining, marketing, retailing, petrochemicals and marine transportation.*

Backed by the significant corporate resources of our parent company, Q8Oils is a fully integrated lubricants organisation. Using high quality base oils we manufacture an extensive range of oils in our own blending plants and have established state of the art European laboratories for development and technical support work. Today, Q8Oils metalworking fluids are used by customers in more than 80 countries around the world.



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