

# Q8 Bach XNF 15

High performance, neat cutting oils.

Q8 Bach XNF is just one of the many product ranges within the Q8 Bach metalworking series, which cover active and non-active products at optimum, high and extreme levels of performance.

### Description

Q8 Bach XNF products are chlorine free, non-active neat cutting oil for machining of light and medium alloyed steels and non-ferrous metals, like copper and aluminium.

### Application

- The additives incorporated in this grade make it an ideal recommendation for the machine-shop where one oil is used for the maximum number of operations on different metals.

- Typical applications (guide only):

|                                 |                     |
|---------------------------------|---------------------|
| Grinding, drilling and turning: | Q8 Bach XNF 6       |
| Deep hole drilling:             | Q8 Bach XNF 10      |
| General machining:              | Q8 Bach XNF 15 & 28 |
| Broaching and gear hobbing:     | Q8 Bach XNF 36      |

- A non-active type general purpose cutting oil, chlorine-free, light in colour, low in odour and well suited for the general machining of stainless steels and recommended for severe machining operations involving non-ferrous metals and high tensile steels

### Benefits

- Very light colour
- Q8 Bach XNF 36 is a dual purpose oil, i.e. also suitable as hydraulic oil
- Almost no odour
- Oxidation stable
- Minimum mist formation
- High cutting power
- Long tool and oil service life

### Features and Benefits

#### Features

- High removal performance
- High oxidation stability
- High performance additives
- Free of chlorine and heavy metals
- High tool life
- High surface finish of work pieces

#### Benefits

- For very severe operations
- Long oil life
- High load properties
- Human exposure acceptable products
- Reduces costs
- No re-works

- The formulation is based on high quality hydro-treated mineral oils.

### Usage, Care and Maintenance

- Suitable for copper and copper-alloys; no risk on staining.
- In order to preserve the integrity of these products, they should be stored and protected from water-entry and frost.
- Reference should be made to the relevant Q8 Material Safety Data Sheet before use



| Properties                  | Method | Unit               | Typical |
|-----------------------------|--------|--------------------|---------|
| Viscosity Grade             | -      | -                  | 15      |
| Absolute Density, 15 °C     | D 4052 | g/ml               | 0.8572  |
| Kinematic Viscosity, 40 °C  | D 445  | mm <sup>2</sup> /s | 14.6    |
| Kinematic Viscosity, 100 °C | D 445  | mm <sup>2</sup> /s |         |
| Viscosity Index             | D 2270 |                    |         |
| Colour                      | D 1500 |                    | L0.5    |
| Copper Strip, 3 h, 100 °C   | D 130  |                    | 1       |
| Flash Point, COC            | D 92   | °C                 | 186     |
| Pour Point                  | D 97   | °C                 | -12     |
| Sulphur                     | XRF    | % mass             | 0.95    |
| Chlorine                    | XRF    | % mass             | nil     |
| Four Ball Test, Weld Load   | IP 239 | kg                 | 520     |

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

| Extreme Performance |                 |                |                |                                   |                |                          |
|---------------------|-----------------|----------------|----------------|-----------------------------------|----------------|--------------------------|
| High Performance    | Cast Iron       | Carbon Steel   | Alloyed Steel  | Stainless Steel/<br>Nickel Alloys | Aluminium      | Copper/<br>Copper Alloys |
| Optimum Performance |                 |                |                |                                   |                |                          |
| General Machining   | Q8 Bach XAS 24  | Q8 Bach XAS 24 | Q8 Bach XAS 24 | Q8 Bach XAS 24                    | Q8 Bach XNF 15 | Q8 Bach XNF 15           |
|                     | Q8 Bach XAF 22  |                |                |                                   | Q8 Bach XND 22 | Q8 Bach XND 22           |
|                     | Q8 Bach XNRG 25 |                |                |                                   |                |                          |
| Deep Hole Drilling  | Q8 Bach XAH 10  | Q8 Bach XAH 10 | Q8 Bach XAH 10 | Q8 Bach XAH 10                    | Q8 Bach XND 12 | Q8 Bach XND 12           |
|                     | Q8 Bach XNRG 12 |                |                |                                   |                |                          |
| Broaching           | Q8 Bach XAS 42  | Q8 Bach XAS 42 | Q8 Bach XAS 42 | Q8 Bach XAS 42                    | Q8 Bach XNF 36 | Q8 Bach XNF 36           |
|                     | Q8 Bach XAF 22  | Q8 Bach XAS 24 | Q8 Bach XAS 24 | Q8 Bach XAS 24                    |                |                          |
|                     | Q8 Bach XNI 15  | Q8 Bach XAR 20 | Q8 Bach XAR 20 | Q8 Bach XAR 20                    | Q8 Bach XND 31 | Q8 Bach XND 31           |
| Gear Shaping        | Q8 Bach XAS 24  | Q8 Bach XAS 24 | Q8 Bach XAS 24 | Q8 Bach XAS 24                    |                |                          |
| Honing              | Q8 Bach XNK     |                |                |                                   |                |                          |
| Gear Hobbing        | Q8 Bach XNF 36  |                |                |                                   |                |                          |
|                     | Q8 Bach XNRG 44 |                |                |                                   |                |                          |

The Q8Oils range of neat cutting fluids is developed for use with a broad selection of machining applications and materials. These products should support you in production, optimized work piece surface finish and maximum tool life. All the products are free from chlorinated hydrocarbons.



