

## Q8 Bach AHL

Low viscosity heavy duty neat cutting fluid with active EP additive package (UK market only)

### Description

Q8 Bach AHL is low viscosity neat cutting oil with low odour characteristics. It is formulated with active extreme pressure additive package with long chain chlorinated paraffin and lubricity additives dramatically reducing tool wear and machine power consumption. The powerful EP additive is active at all temperatures and therefore excellent finishes can be achieved at various speeds and feeds from the heaviest removal of stock right down to finishing with light cuts. The lubricity agent allows maximum contact of the fluid with the work piece at all times eliminating judder and a poor finish. The Q8 mist-reducing additive package is also incorporated in the formulation reducing the generation of potentially unpleasant and harmful mists into the machine shop atmosphere.

### Applications

Q8 Bach AHL is recommended for deep hole and gun drilling and fine broaching operations on all hard to machine steel alloys. It is also recommended for honing operations using all grit sizes and types including those incorporating diamond materials. Traditional honing fluids are paraffin based and the cutting performance of this product is proven to be far superior. Q8 Bach AHL gives excellent performance on all steels including high tensile, high alloy steels, and stainless. It is not suitable for use with non-ferrous metals because of the active EP package.

### User instructions

In order to preserve the integrity of this product, drums should be stored inside a building protected from frost and direct sunlight.

### Environment, Health and Safety

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

### Properties

	Method	Unit	Typical
Appearance	Visual	-	Pale
Density, 15 °C	D 4052	g/ml	0.91
Kinematic Viscosity, 40 °C	D 445	mm <sup>2</sup> /s	10
Flash Point, COC	D 92	°C	140
Copper Strip, 3 h, 100 °C	D 130	-	4
Chlorine	ASTM D 6443	% mass	10

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.