

## Q8 Bach NKM

Heavy duty, non-active neat cutting fluid (UK market only)

### Description

Q8 Bach NKM is a pale coloured, heavy duty, low odour neat cutting oil whose performance is totally independent of sulphur additives. The product is formulated with synthetic lubricity additives and a non-sulphurised EP additive package with long chain chlorinated paraffin. The Q8 mist-reducing additive package is also incorporated in the formulation.

### Applications

This product is recommended for all heavy duty machining operations and where a non-sulphurised oil is necessary or preferred. Excellent performance in operations where an excellent surface finish is of prime importance. Operations include heavy duty turning, threading, and automatic work, milling, drilling, boring, reaming, shaping. Q8 Bach NKM gives excellent performance on all ferrous and non-ferrous materials, including aircraft alloys.

The EP additive package provides boundary lubrication at the tool tip chip interface. This level of lubrication helps prevent the build up of edge and chip welding. It also dramatically reduces tool wear and machine power consumption. The lubricity additive allows continuous spreading of the oil to the tool chip eliminating oil starvation, judder and a poor finish when using big cuts and high feed rates. Q8 BACH NKM is particularly recommended for use in machine shops where mist can be a problem. Uncontrolled machine shop mist can affect the health of machine operators. Mist also settles out on the surrounding environment creating an unhealthy working area.

### 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	0.89
Kinematic Viscosity, 40 °C	D 445	mm <sup>2</sup> /s	31
Flash Point, COC	D 92	°C	210
Copper Strip, 3 h, 100 °C	D 130	-	1
Chlorine	ASTM D 6443	% mass	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.