MAXIM™ METALWORKING DATAFILE

MAXUS Q-LS

MAXUS Q-LS is a water extendible, general purpose semi-synthetic cutting and grinding fluid formulated to perform exceptionally in a variety of machine operations.
MAXUS Q-LS, when mixed with water, forms a water-thin transparent micro-emulsion that exhibits excellent cooling properties for superior finishes and increased tool life. Q-LS is recommended for use when machining, sawing and grinding ferrous and non ferrous materials where machinability requirements range from mild to moderately severe. The substancial amount of EP additives and high mole weight polymerized esters yield a non-tacky, but significantly inhanced performance in boundry lubrication. For this reason, the Q-LS is also recommended for use in stamping, tube rolling, drawing and forming operations where the severity of the application is light to moderate. The opaque emulsion is non-foaming, silicon and chlorine free, and is easy to mix in both soft and hard water.

MAXUS Q-LS remains highly transparent to afford the machine operator full view of the work. The effective biostatic system formulated into the Q-LS yields a high resistance to microbial degradation and rancidity; this allows for longer coolant life in machine sumps and central coolant systems without special maintenance procedures. Unlike many solubles and synthetics, the Q-LS remains fluid in and on the surfaces of the machining center allowing slideways, chucks, and tooling to work freely without a hard-to-clean dry or sticky residue.
MAXUS Q-LS incorporates a three part DEA FREE rust inhibitor package that provides complete protection for machine tool surfaces and parts in process. MAXUS Q-LS also contains an inhibitor to prevent galvanic corrosion between stacked parts. This feature makes the Q-LS well suited for the machining of cast iron, copper and its alloys as well as a variety of machine operations on aluminum.

Recommended Starting Dilutions

Machining - drilling, turning, milling, tapping, boring, and reaming
1 : 20 (5%) to 1 :10 (10%)

Sawing / Grinding - centerless, surface, cylindrical, internal.
1 : 20 (5%) to 1 : 14 (7%)

Concentration Check

Concentration	1:33 (3%)	1:25 (4%)	1:20 (5%)	1:17 (6%)	1:14 (7%)	1:12 (8%)	1:11 (9%)	1:10 (10%)
Refractometer Reading (Brix Scale)	----	----	2.1	2.6	3.0	3.4	3.8	4.2

MAXUS Q-LS Continued

MAXUS Q-LS Performance Advantages

+ Unique Tool / Wheel Performance - Excellent cooling properties and extreme pressure lubricity combine to provide extended tool life.
+ Excellent Cleanliness - Remains semi-transparent ; good settling properties provide for ease of contaminant removal; low foaming; non-drying on machine surfaces.
+ Exceptional Corrosion Control - Prevents in-process corrosion of work pieces and machine tool parts.
+ Long Life - More tolerant of hard water and tramp oils and has a high resistance to rancidity for longer sump life.
+ High operator exceptance.

Typical Physical Characteristics

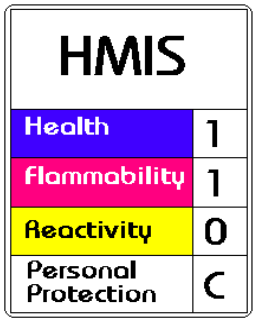
Specific Gravity, 60/60F	1.08
Flash Point, COC F	none
pH, fresh,1:20 (5%) dilution	9.7 -9.9
Color, dilution	opaque/undyed or blue-green
Color, concentrate	undyed or blue- Also available in Red upon request

Packaging

MAXUS Q-LS is available in 55 gallon steel drums, totes and bulk quantities.

Shipping Identification / Labeling:

PETROLEUM / CHEMICAL COMPOUNDS
CLASS 55 NFMC 48580 SUB.4
Label: Amine based compound - Possible eye irritant due to alkalinity in concentrate. Water-diluted material is not expected to be primary eye irritant when used as recommended. Read and understand Material Safety Data Sheet before handling or disposing of this product.



For additional information, product samples, etc., please contact;
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