



GULF METALWORKING FLUIDS

your local global brand

GULF CASCADE GP-AS / GP-ASD (blue)

High quality Heavy Duty water-mix metalworking fluid designed for multiple applications including yellow metals

Description

GULF CASCADE GP-AS / GP-ASD is a high performance, Chlorine free semi-synthetic soluble metalworking fluid that produces a highly stable micro emulsion. This product has been designed to provide excellent machining performance on a wide range of materials, including Stainless and high alloy Steels, low Carbon Steels, Brass and Aluminium.

Performance Benefits

- Chlorine Free
- Rejects Tramp Oil
- Excellent surface finish
- Enhanced Tool Life
- High Lubricity
- Improved Sump Life
- Low Foaming
- Suitable for Hard and Soft Water
- Excellent Anti-Corrosion properties
- Free from aggressive skin irritants

Recommended Applications and Dilutions

General machining 4% to 6%

Drilling 6% to 10%

Thread cutting 5% to 7%

Grinding, centreless, cylindrical, surface 3% to 5%

Milling 5% to 7%

Typical Properties

Appearance	GP-AS: Dark Amber GP-ASD: Blue Fluid
Emulsion Type	Semi Translucent Blue
Foaming Tendency	Low
Specific Gravity	0.95
Mineral oil content	50%
pH @ 5%	9.0
IP 287 Corrosion Test %	3.0
Defoam ml (3% in 50ppm water)	Nil @ 5 Seconds
Refractometer Factor	1.1

Kenson Lubricants Limited | Arvan House | Brookfield Drive | CANNOCK | Staffordshire WS11 0JN. Tel 01543 500640 Fax 01543 500641

E-Mail sales@kensonlubricants.com

technical@kensonlubricants.com

Website: www.kensonlubricants.com



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Storage:

- Store in a cool, well ventilated area
- Store inside, ideally between 10°C and 30°C
- Store away from direct heat and frost
- Shelf life 12 months from the date of manufacture
- Avoid water collecting on the barrel top

Product Mixing:

Gulf advise the use of automated mixing systems. If mixing manually, always add the concentrate to the water with maximum agitation, if water is added to the concentrate, the emulsions may prove unstable. Avoid mixing with very cold concentrate or water. Check emulsion strength using a calibrated refractometer. Details of where to purchase equipment and how to use it are available from the Gulf Technical Department.

Product Management:

The working concentration should be carefully controlled and monitored on a daily basis as higher and lower working concentrations have health and safety implications. Machines should be cleaned out regularly. Fluid and particulate contaminants should be kept to a minimum. This is important especially in terms of bacterial control and is in line with the latest advice from government and professional sources. Detailed reference sources are quoted in the MSDS.

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