



GULF METALWORKING FLUIDS

your local global brand

GULF CASCADE GP-CS

Ultra high quality chlorine free Extreme Pressure water-mix metalworking fluid designed for multiple applications, particularly in soft water areas

Description

Very high performance, ultra long-life watermix metalworking fluid. Chlorine-free, exceptional bio-stability, ultra stable micro-emulsion.

GULF CASCADE GP-CS is an ultra modern medium oil, ultra long-life, and semi-synthetic watermix cutting fluid specially designed for soft water areas.

- Excellent corrosion protection
- Excellent EP performance
- Ultra long sump life
- Chlorine, Secondary Amines & Sulphur free
- Operator friendly
- Excellent corrosion protection
- Excellent surface finish
- Enhanced tool-life
- Very Low foaming
- Multi-metal suitable, including yellow metals and cast iron
- Clear emulsion providing excellent machining visibility
- Free from sticky deposits on machine surfaces

Recommended Applications and Dilutions

- Grinding cylindrical 3-5%
- General machining 4-6%
- Sawing, drilling, turning 4-6%
- Milling and threading, Roll Forming 5-7%

Material Suitability

- Low to medium tensile steels.
- Cast Iron - exceptional
- Brass
- Titanium alloys
- Plastics

General Compatibility

- Waters from 30ppm to 300ppm (Calcium hardness)
- Low foaming tendency
- Suitable for high pressure applications
- Suitable for low pressure applications

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Typical Physical Properties

Appearance – Concentrate	Dark Amber fluid
Appearance - Emulsion	Translucent
IP 287 Corrosion Test %	2.0
Defoam ml (5% in 50ppm water)	Nil (30 seconds)
Specific Gravity - Concentrate	1.04
pH @ 5%	9.5
Refractometer Factor	1.3
Mineral Oil Content	22%

Storage:

- Store inside, ideally between 10°C and 30°C
- Store out of direct sunlight
- Shelf life of 6 months from the date of supply
- 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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