



GULF METALWORKING FLUIDS

your local global brand

GULF CASCADE EP-SAX

An ultimate water-mix metalworking fluid designed for multiple applications

Product Description:

GULF CASCADE EP-SAX has been formulated to cross all performance boundaries. The formulation is based on a unique additive combination working in perfectly balanced synergy to enable neat oil applications such as broaching and gear cutting to be considered for a switch to water soluble technology. This super high performance product is also inherently low foaming and is a perfect choice for use in hard water conditions. GULF CASCADE EP-SAX is without doubt a superb choice of fluid for every difficult application.

Applications and Suitability:

GULF CASCADE EP-SAX offers excellent cutting performance and can be used in all types of arduous manufacturing applications. The performance additives incorporated into the fluid provide outstanding surface finish on all types of aluminium and associated alloys as well as steels. The unique formulation prevents scum and soap formation associated with more reactive materials. GULF CASCADE EP-SAX has been proven to have outstanding tool life performance when used in the machining of titanium as well as demonstrating superb properties when used in the machining of high tensile steels.

Features & Benefits

- Excellent high sheer performance characteristics
- Loaded with EP performance
- NP Ethoxylates free
- Used in all difficult applications
- Low foaming tendency
- Multi-metal compatible
- Outstanding levels of boundary lubrication

Recommended Dilutions:

General Machining 5-6% Gear Cutting 6% Deep Hole Drilling 7% Broaching 9%

Typical Test Data

| | |
|----------------------------------|--|
| Appearance of Concentrate: | Amber liquid |
| Odour: | Sweet |
| Emulsion Appearance: | Milky white |
| Specific Gravity: | 1.022 |
| pH @ 5%: | 9.3 |
| IP287 Breakpoint, %: | 2.0 |
| De-foam in 50p.p.m. water: | Nil after 10 seconds |
| Reichert Performance @ 10%: | Noise Reduction 3.0m Load Capacity 3.64Kg/mm ² |
| Refractometer Correction Factor: | 1.1 |



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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.