



GULF METALWORKING FLUIDS

your local global brand

GULF CASCADE EP-XLL

An Ultra Long Life water-mix metalworking fluid designed for arduous conditions

Product Description:

Gulfcut GULF CASCADE EP-XLL is a low-oil, high performance semi-synthetic soluble metalworking fluid that produces an ultra stable micro emulsion. This product has been designed to provide the maximum possible sump life, even in highly arduous operating conditions. GULF CASCADE EP-XLL is particularly low foaming, even in soft water conditions, and also low scumming in hard water conditions.

Material Compatibility:

Gulfcut GULF CASCADE EP-XLL is suitable for machining a wide variety of materials including low to medium tensile steels, stainless steels, aluminium, high density plastics and other difficult to machine materials. The performance on Cast Iron is also excellent.

Gulfcut **GULF CASCADE EP-XLL is free from Triazine, Sodium Nitrite, and Phenols.**

Typical Physical Properties:

Appearance	Amber Fluid
Emulsion Type	Translucent
Foaming Tendency	Low
Specific Gravity	1.02
Mineral oil content	23%
pH @ 3%	9.6
IP 287 Corrosion Test %	3.0
Defoam ml (3% in 50ppm water)	Nil @ 30 Seconds
Refractometer Factor	1.5
Reichert Lubricity Characteristics (10% dilution). Noise Reduction:	11.0 metres
Load Bearing Capacity (5% dilution)	3.05

Recommended Dilutions:

General Machining: 5-6% Thread Cutting: 4-6% Milling: 4-6% Drilling: 6-10%

Grinding - centre-less, cylindrical, surface: 3% to 5%



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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.