



GULF METALWORKING FLUIDS

your local global brand

GULF CASCADE GP-CI

High Quality Cost Effective water-mix metalworking fluid for Cast Iron & Steel

Description:

GULF CASCADE GP-CI is a high quality, highly biostable, Chlorine free semi synthetic cutting fluid specifically formulated to incorporate the latest advances in additive technology.

This product has been developed to provide improved levels of boundary lubrication to give excellent machining performance without the use of chlorine EP additives. Special synthetic extreme pressure additives have been incorporated to maximise machining performance and enhance surface finish, which combine with a highly biostable micro-emulsion to provide extended sump life and improved tool life.

Gulf CascadeGP-CI has been specially developed to give cast iron engine block manufacturers greater machining flexibility and increased tool performance during difficult operations such as drilling and tapping where high levels of boundary lubrication is essential. The product provides the user with the very best in biostability and corrosion protection performance demanded for cast iron machining, whilst also having the inherent flexibility to machine other ferrous materials. Gulf Cascade GP-CI is therefore ideally suited to customers largely machining cast iron and steel.

Benefits

- High resistance to bacteria attack
- Low foam in soft water.
- High Lubricity
- Excellent wetting performance
- Long term emulsion stability
- Very long sump life
- Low hazard
- Very economical in-use
- Excellent resistance to tramp oil contamination
- Superb surface finish

Typical Applications

- General machining

Concentrations %

2 - 4

Material Compatibility

- Cast Iron
- Steel
- Oil resistant plastics, carbon fibre & non ferrous materials

Water Compatibility

- Typical 100 to 300 ppm (calcium carbonate)
- Designed for low foam
- Suitable for high and low pressure CNC systems

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Typical Physical Properties:

Appearance – Concentrate:	Amber fluid
Odour:	Bland
Specific Gravity – Concentrate:	1.00
Foaming Tendency (5% in 50 ppm water)	Low (Nil ml in 60 seconds)
Appearance - Emulsion	Clear Translucent
EP Performance	High
Reichert Lubricity Characteristics (10% dilution):	
Noise Reduction (Metres):	19.0
Load Bearing Capacity (Kg/mm2):	1.311
IP287 Corrosion Test	2.0%
Refractometer Factor	1.9
Ph @ 5% Emulsion	9.1

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.

