



GULF METALWORKING FLUIDS

your local global brand

GULF CASCADE GP

High Quality water-mix metalworking fluid designed for multiple applications

Description

A high quality, chlorine free, water-miscible soluble oil coolant designed to give outstanding performance when machining a wide variety of materials from aluminium alloys to steels.

Gulf Cascade GP derives its performance from a synergistic blend of high lubricity additives which help to provide the user with a coolant capable of meeting the most demanding requirements in terms of surface finish and tool life.

Gulf Cascade GP produces a highly stable milky emulsion which provides a very clean working environment and which also tolerates hard waters and is very low foaming in soft waters.

Gulf Cascade GP provides excellent corrosion protection and is non-staining to sensitive materials.

Benefits

- Excellent lubricity
- Pleasant to use
- Extended sump life
- Chlorine free formulation
- Excellent surface finish
- Enhanced tool-life
- Low foaming
- Suitable for sensitive alloys

Typical Physical Properties

Appearance	Brown liquid
Emulsion Type	Milky
Foaming Tendency	Low
Specific Gravity at 20°C	0.94
Lubricity	Very High
pH @ 5%	9.3



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Recommended Applications and Dilutions

General machining of free cutting metals: 5%

Difficult operations/materials: 8 – 10%

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.