



# GULF METALWORKING FLUIDS

your local global brand

## GULF CASCADE GR-SF

**High Performance chlorine & boron free synthetic water mix grinding fluid which leaves no sticky deposits around the grinding wheel**

### Description

High performance, long service life watermix synthetic grinding fluid. Chlorine-free, Boron-free and secondary amine. Absolutely no tacky residues. GULF CASCADE GR-SF is an ultra modern synthetic long-life watermix grinding fluid with excellent corrosion protection and cleanliness.

### Material Compatibility

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

### Water Compatibility

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

### Performance Benefits

- High resistance to bacteria attack
- Ultra Low foam
- Enhanced wheel life
- Excellent corrosion protection
- Long term emulsion stability
- No sticky deposits
- Low hazard – operator friendly
- Highly stable emulsion
- Transparent emulsion - Excellent visibility
- Superb surface finish

### Recommended Applications and Dilutions

- Grinding cylindrical 2 - 3%
- Surface 2 – 3%
- Centreless 3 – 5%
- Creep-feed 4 – 6%



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### Typical Physical Properties

Appearance - Concentrate	Yellow fluid
Specific Gravity - Concentrate	1.08
Foaming Tendency	Low
Appearance - Emulsion	Clear Yellow
IP287 Corrosion Test	2.0%
Refractometer factor	2.1
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.