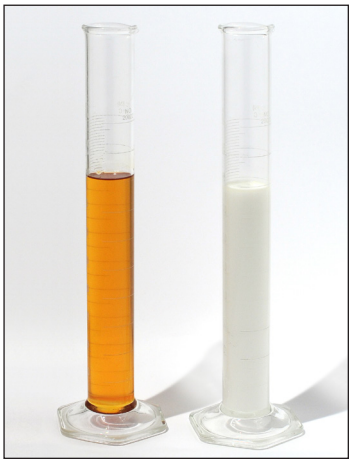
CITGO TRUKUT® GP 205

Date 04/18

DESCRIPTION: CITGO Trukut GP 205 is a conventional general purpose cutting fluid designed to be readily mixed with water to form a stable emulsion. Designed for a variety of machining operations, it is suitable for use on ferrous and non-ferrous metals.

FEATURES:

- Forms stable emulsions in various water qualities
- Multi-metal and general purpose applications
- Good residual corrosion properties
- Free from chlorinated paraffins
- Excellent corrosion prevention properties



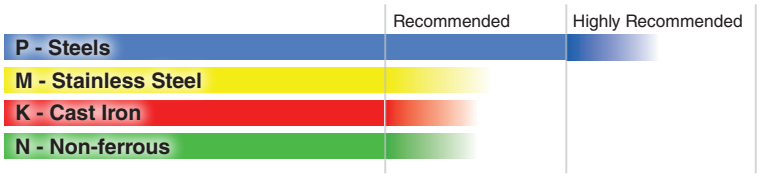
Concentrate | Diluted with Water

BENEFITS:

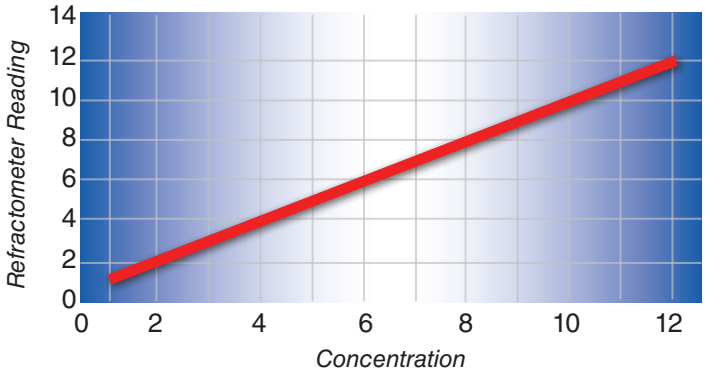
- Product performance is constant and machine remains clean
- Wide application range reduces the need for several products
- Increases the time between in process operations and protects the machine tool parts from rust
- Reduces disposal costs
- Reduces the need for in-process corrosion protection fluids

APPLICATIONS: CITGO Trukut GP 205 is recommended for milling, turning, drilling, grinding and other metalworking operations on ferrous and non-ferrous metals where efficiency of an emulsifiable oil is preferred. Trukut GP 205 has excellent cooling and rust prevention properties. It is also a preferred grinding fluid.

Material Compatibility



Refractometer Chart



Refractometer Reading at 10% = 10.0 °Brix
Refractometer Factor = 1.0

(Continued)

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Date 04/18 - (Continued)

TYPICAL PROPERTIES - CITGO TRUKUT® GP 205

Material Code	639468001
Gravity, Specific, ASTM D1298, 60/60°F	0.91
Density, lb/gal	7.59
Flash Point, COC, ASTM D92, °F (°C)	320 (160)
Viscosity, cSt at 40°C	35
Color, ASTM D1500	3.0
Pour Point, ASTM D97, °F (°C)	32 (0)
pH at 5% in Deionized	9.6
Corrosion (modified Iron Chip Rust test)	Pass
Copper Corrosion, ASTM D130, 3 hrs at 212°F	1B
Emulsion Stability, 24 hrs at 77°F	
Deionized Water	Pass
Hard Water	Pass
Solution Stability, 24 hrs at 30°F	Pass
Appearance	Yellow

METAL MACHINABILITY GROUPS

Machining Operation	**1** Non-Ferrous, Soft Metals	**2** Nickel Alloys, Nitralloy Steels, Cast Irons and Alloy Steels (up to 200 Brinell)	**3** Stainless Steels, "Monel" Metals, Cast Irons and Alloy Steels (200 to 300 Brinell)	**4** Titanium Alloys, High Tensile Nickel Alloys, Austentic Stainless Steels, Tool Steel and High Tensile Alloy Steels (300 to 400 Brinell)
Turning, Boring, Milling, Forming, Drilling, Sawing	**5-7%**	**5-7%**	**8-12%**	**8-12%**
Tapping, Thread Rolling, Reaming, Screw Cutting, Broaching	**5-7%**	**5-7%**	**8-12%**	**8-12%**
Gear Shaping, Form and Thread Milling, Shaving, Hobbing, and Trepanning	**5-7%**	**5-7%**	**8-12%**	**8-12%**
Internal and External Grinding, Form and Thread Grinding	**5-7%**	**5-7%**	**5-7%**	**5-7%**
Stamping	**5-10%**	**5-10%**	**5-10%**	**5-10%**

Note: Dilution ratios shown are approximate and may require higher or lower water concentrations depending on a number of factors including the type of metal cut, machine speed, the severity of the operation, metal hardness, etc.

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