



CITGO TRUKUT® OILS

Date 1/09

- DESCRIPTION:** CITGO Trukut Oils are versatile, soluble cutting fluids designed for a variety of machining operations. CITGO Trukut 205 is a conventional emulsifiable oil that will readily mix with water to produce a stable emulsion. CITGO Trukut 210 is designed to form stable emulsions without excessive foaming in hard or soft water. It is inhibited with biocide and fungicide to control rancidity and foul odor development. CITGO Trukut 220 is a medium duty general purpose soluble oil that possesses excellent lubricity and corrosion protection, carries mild EP properties, and contains biocide and fungicide. CITGO Trukut 230 is a heavy duty soluble oil that possesses all of the properties of Trukut 220 plus chlorine, giving it excellent EP characteristics.
- QUALITIES:** CITGO Trukut oils are formulated from high quality mineral oils. The emulsifiers are adjusted to the base oils used in order to provide stable emulsions regardless of the oil/water ratio used. These oils afford efficient cooling and lubrication. They provide excellent rust protection to both the cutting tool and the metal part being machined. Trukut 210, 220 and 230 contain an effective biocide and fungicide for protection against bacteria and fungus.
- APPLICATIONS:** CITGO Trukut 205 is recommended for milling, turning, drilling and other metalworking operations on ferrous and non-ferrous metals where emulsifiable oils are preferred. Due to excellent cooling properties, it is also a preferred grinding coolant. CITGO Trukut 210 is recommended for use as a coolant, lubricant and rust preventative in machining operations such as: Drilling, Threading, Shaping, Hobbing, Tapping, Turning, Sawing. CITGO Trukut 220 contains extreme pressure additives which permit its use in many machining operations where the lubrication requirements are too severe for regular soluble oils. It is well suited for automatic screw machines where a single cutting fluid may be required to function in a wide variety of operations involving both non-ferrous and ferrous metals. CITGO Trukut 230 is a versatile, heavy-duty soluble cutting fluid containing chlorine and is designed for use on non-ferrous metals and alloy steels where extreme pressure properties are needed. It performs well in a variety of cutting operations such as turning, boring, drilling, and thread chasing and grinding.

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TYPICAL PROPERTIES:

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	Trukut 205	Trukut 210	Trukut 220	Trukut 230
Material Code	639205001	639210001	639221001	639231001
Gravity, Specific, ASTM D1298, 60/60°F	0.9100	0.9110	0.9600	0.9700
Density, lb/gal	7.58	7.59	8.00	8.08
Flash Point, COC, ASTM D92, °F (°C)	388 (170)	311 (155)	311 (155)	311 (155)
Viscosity, cSt at 40°C	30	37.8	131	111
Color, ASTM D1500	3.0	L5.0	L5.0	Green
Pour Point, ASTM D97, °F (°C)	-44 (-42)	-44 (-42)	-44 (-42)	-44 (-42)
pH ¹	10.5	10.8	9.85	10.1
Corrosion (modified Iron Chip Rust test)	Pass	Pass	Pass	Pass
Copper Corrosion, ASTM D130, 3 hrs at 212 °F	1B	1B	1B	1B
Emulsion Stability, 24 hrs at 77°F				
Deionized Water	Pass	Pass	Pass	Pass
Hard Water	Pass	Pass	Pass	Pass
Solution Stability, 24 hrs at 30°F	Pass	Pass	Pass	Pass

¹NOTE: One part oil, three parts water.