



CITGO TRANSKUT® OIL

Date 1/09

**DESCRIPTION:** CITGO Transkut Oil is a general-purpose cutting oil containing sufficient sulfur additives and chlorinated compounds to retain transparency. It has been successfully used in moderate severity operations where visibility of the tool or work piece is desired.

- FEATURES:**
- Contain an effective mist suppressant
  - Promote longer tool life and high quality part surface finish
  - Provide better visibility of parts being machined
  - Apply to machining low to medium carbon steels as well as some stainless steels

**APPLICATIONS:** CITGO Transkut Oil is recommended for machining steel alloys having a machinability rating of 60% and above. It is being used in automatic screw machines and in similar equipment for:

Cut-off	Forming	Shaving
Drilling	Reaming	Chamfering
Threading	Hobbing	Broaching

**NOTE:** Since this fluid contains active sulfur, it should not be used with yellow metals (copper, brass, bronze, etc.).

**TYPICAL PROPERTIES:**

**CITGO TRANSKUT® OIL**

<b>ISO VIS Grade</b>	<b>HD 200</b>
Material Code	639562001
Gravity, ASTM D 4052, °API	19.8
Gravity, Specific, 60/60°F, ASTM D 1298	0.94
Density, lb/gal	7.8
Flash Point, ASTM D 92, °F (°C)	320 (160)
Viscosity, ASTM D 445, cSt at 40°F	39
cSt at 100°F	5.4
ASTM D 2161, SUS at 100°F	200
SUS at 210°F	45
Color, ASTM D 1500	2
Pour Point, ASTM D 97, °F (°C)	-20 (-29)
Sulfur, ASTM D 2622, w%	2.0
Active Sulfur, w%	1.9
Chlorine, w%	2.2
Lubricity Additive, %	3
Falex Load Wear Test, ASTM D 3233 Part B	4260
Four Ball EP, ASTM D 2783	
Weld Point, kgf	800+
Load Wear Index, kfg	100+
Copper Corrosion 3 hrs. at 212°F	4C