



CITGO AUTOKUT® OIL

Date 1/09

DESCRIPTION: CITGO Autokut Oil is a dark, heavy-duty cutting oil compounded with a highly sulfurized natural ester. Sulfur content enables heavy-duty cutting.

- FEATURES:**
- Contains an effective mist suppressant
 - Provides high quality finish of work pieces
 - Promotes higher production rate and longer tool life due to anti-weld and extreme pressure protection
 - Remains stable throughout long service life
 - Permits easy degreasing of work pieces by conventional methods
 - Promotes fast settling of chips
 - Will not harm machine tool parts
 - Resists harmful sludging

APPLICATIONS: CITGO Autokut Oil can be used for cutting operations on ferrous metals and alloys where machinability is approximately 50%. It can be used in all automatic screw machines and in similar equipment for broaching, milling, threading, gear cutting and tapping.

CITGO Autokut Oil can also be used for forming, cold heading, and stamping of low carbon steels. Since staining may be a problem, it is not recommended for machining non-ferrous metals.

NOTE: Since these fluids contain active sulfur, they should not be used with yellow metals (copper, brass, bronze, etc.).

TYPICAL PROPERTIES:**CITGO AUTOKUT® OIL**

Grade	250
Material Code	639566001
Gravity, ASTM D 4052, °API	21.3
Specific Gravity @ 60°F, ASTM D 1298	0.93
Density, lb/gal	7.7
Flash Point, ASTM D 92, °F (C°)	320 (160)
Viscosity, ASTM D 445, cSt at 40°C	50
cSt at 100°C	7.6
ASTM D 2161, SUS at 100°F	260
SUS at 210°F	51
Color, ASTM D 1500	Dark Brown
Pour Point, ASTM D 97, °F (°C)	5 (-15)
Total Sulfur, ASTM D 2622, w%	4.0
Active Sulfur, m%	0.7
Lubricity Additive, %	17
Falex Load Wear Test, ASTM D 3233, Part B	2050
Four Ball EP, ASTM D 2783	
Weld Point, KG	800+
Load Wear Index	100+
Copper Corrosion, ASTM D 130	
3 hrs. at 212°F	4C