



CITGO AUTOKUT® IS SERIES

Date 04/18

**DESCRIPTION:** CITGO Autokut IS Series are non-staining metal removal oils designed for machining non-ferrous metals and many ferrous metals. CITGO Autokut IS Series are available in two viscosity grades to meet the requirements of a modern engineering facility. The lower viscosity grade is used for higher speed lighter duty applications and the higher viscosity is used for slower speed heavier duty operations.

- FEATURES:**
- Excellent lubricity and mild EP
  - Compatible with all metals
  - Chlorine free
  - Light in color
  - Contain a stable oil mist suppressant



- BENEFITS:**
- Improved productivity and lower costs of operation
  - Non staining on ferrous and non-ferrous metals
  - Benefits environmental needs and reduces disposal costs
  - Light color aids visibility of operation
  - Improves working environment and worker safety by minimizing mist formation

**APPLICATIONS:** **CITGO Autokut IS 15** is a low viscosity oil, primarily recommended for all machining operations on aluminum and magnesium and their alloys. This light viscosity product has additional applications in deep drilling and the honing of steel, cast iron and alloyed copper.

**CITGO Autokut IS 46** is designed for more severe duty applications and contains a high level of non-staining extreme pressure agent to permit its use over a wide variety of materials, and over a wide range of cutting depths, feeds and speeds. It can also be used in turning, sawing, milling and drilling of non-ferrous metals as well as some plain carbon steels and free-machining steel alloys.



**Material Compatibility**

	Recommended	Highly Recommended
<b>P - Steels</b>	Highly Recommended	
<b>M - Stainless Steel</b>	Recommended	
<b>K - Cast Iron</b>	Not Recommended	
<b>N - Non-ferrous</b>	Highly Recommended	

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## TYPICAL PROPERTIES - CITGO AUTOKUT® IS SERIES

Grade	IS 15	IS 46
Material Code	639440001	639443001
Gravity, ASTM D4052, °API	31.9	31.1
Gravity, Specific, ASTM D1298, 60/60°F	0.866	0.870
Density, lb/gal	7.1	7.3
Flash Point, COC, ASTM D92, °F (°C)	361 (183)	428 (220)
Viscosity, cSt at 40°C	18	45
cSt at 100°C	3.9	6.9
SUS at 100°F	95	230
SUS at 210°F	39	49
Color, ASTM D1500	0.5	0.5
Pour Point, ASTM D97, °F (°C)	-44 (-42)	-6 (-21)
Copper Corrosion, ASTM D130, 3 hrs at 212°F	1 A/B	1 A/B
Active Sulfur	No	No
Phosphorus	No	No
Lubricity Additive	Yes	Yes

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