

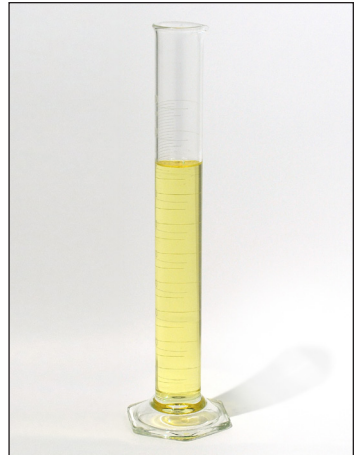


CITGO AUTOKUT® AS SERIES

Date 04/18

**DESCRIPTION:** CITGO Autokut AS Series are transparent, highly active metal removal fluids designed for severe machining operations. Citgo Autokut AS series is available in four different viscosity grades to meet the requirements of a modern engineering facility.

- FEATURES:**
- Contains active sulfur and other anti-weld components
  - High levels of lubricity
  - Low odor
  - Chlorinated paraffin free
  - Light in color
  - Contains a stable oil mist suppressant



- BENEFITS:**
- Improved productivity and lower costs of operation
  - Excellent surface finish at high feeds and speeds
  - Improved worker acceptability
  - Reduction in disposal costs and reduced risk of rust
  - Aids visibility of operation
  - Improves working environment and worker safety by minimizing mist formation

**NOTE:** Not recommended for yellow or non-ferrous metals

**APPLICATIONS:** CITGO Autokut AS Series are formulated for machining operations involving alloyed, stainless and chrome steels. These products are intended for severe machining operations such as broaching, tapping and cold-heading. Lower viscosity grades are used for higher speed lighter duty applications and higher viscosity is used for slower speed heavier duty operations.



**Material Compatibility**

	Recommended	Highly Recommended
P - Steels	Yes	Yes
M - Stainless Steel	Yes	Yes
K - Cast Iron	Yes	Yes

(Continued)



## CITGO AUTOKUT® AS SERIES

Date 04/18 - (Continued)

## TYPICAL PROPERTIES - CITGO AUTOKUT® AS SERIES

Grade	AS 15	AS 32	AS 46	AS 68
Material Code	639430001	639432001	639433001	639434001
Gravity, ASTM D4052, °API	33.6	31.1	29.7	28.2
Gravity, Specific, ASTM D1298, 60/60 °F	0.857	0.870	0.878	0.886
Density, lb/gal	7.2	7.3	7.3	7.4
Flash Point, COC, ASTM D92, °F (°C)	349 (176)	363 (184)	356 (180)	356 (180)
Viscosity, cSt at 40°C	16.6	30.7	45.5	65.4
cSt at 100°C	3.8	5.6	7.1	8.9
SUS at 100°F	89	158	245	338
SUS at 210°F	39	45	50	56
Color, ASTM D1500	1.0	1.5	1.5	1.5
Pour Point, ASTM D97, °F (°C)	-45.4 (-43)	-22 (-30)	-14.8 (-26)	-14.8 (-26)
Copper Corrosion, ASTM D130, 3 hrs at 212°F	4	4	4	4
Active Sulfur	Yes	Yes	Yes	Yes
Phosphorus	No	No	No	No
Lubricity Additive	Yes	Yes	Yes	Yes

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