



CITGO® Trukut® GP 205

OVERVIEW

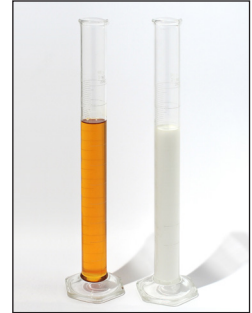


- A conventional, general purpose cutting fluid designed to be readily mixed with water to form a stable emulsion.
- Designed for a variety of machining operations and suitable for use on ferrous and non-ferrous metals.

FEATURES & BENEFITS

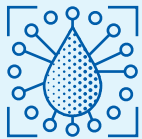


- Forms stable emulsions in various water qualities.
- Multi-metal and general purpose applications.
- Free of chlorinated paraffins.
- Excellent corrosion prevention and residual corrosion properties reduce the need for in-process corrosion protection fluids.
- Reliable product performance keeps machinery clean.
- Wide application range reduces the need for several products.
- Increases the time between in-process operations and protects the machine tool parts from rust.
- Reduces disposal costs.



Concentrate Diluted with Water

APPLICATIONS

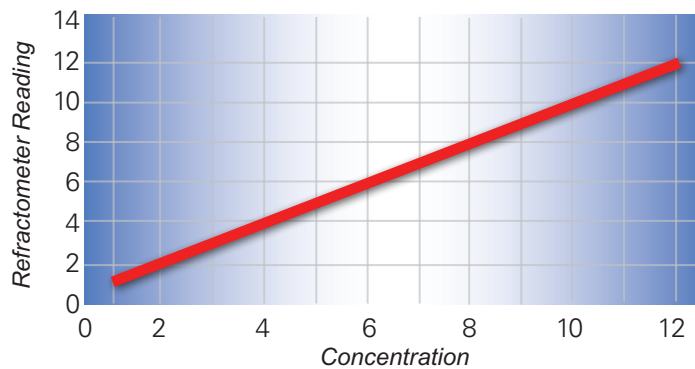


- Recommended for milling, turning, drilling, grinding, and other metalworking operations on ferrous and non-ferrous metals where efficiency of an emulsifiable oil is preferred.
- Preferred for grinding operations.

Material Compatibility

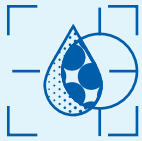
	Recommended	Highly Recommended
P - Steels	[Bar with gradient from blue to white]	
M - Stainless Steel	[Bar with gradient from yellow to white]	
K - Cast Iron	[Bar with gradient from red to white]	
N - Non-ferrous	[Bar with gradient from green to white]	

Refractometer Chart



Refractometer Reading at 10% = 10.0 °Brix
 Refractometer Factor = 1.0

PROPERTIES



Typical Properties for CITGO Trukut GP 205:

Material Code	639468001
Gravity, Specific, ASTM D1298, 60/60°F	0.94
Density, lb/gal	7.83
Flash Point, COC, ASTM D92, °F (°C)	311 (155)
Viscosity, cSt at 40°C	111
Color, ASTM D1500	L5.0
Pour Point, ASTM D97, °F (°C)	32 (0)
pH at 5% in Deionized	9.0
Corrosion (modified Iron Chip Rust test)	Pass
Copper Corrosion, ASTM D130, 3 hrs at 212°F	1B
Emulsion Stability, 24 hrs at 77°F	
Deionized Water	Pass
Hard Water	Pass
Solution Stability, 24 hrs at 30°F	Pass
Appearance	Amber

METAL MACHINABILITY GROUPS[™]

Machining Operation	1 Non-Ferrous, Soft Metals ⁽²⁾	2 Nickel Alloys, Nitalloy Steels, Cast Irons and Alloy Steels (up to 200 Brinell)	3 Stainless Steels, "Monel" Met- als, Cast Irons and Alloy Steels (200 to 300 Brinell)	4 Titanium Alloys, High Tensile Nickel Alloys, Austentic Stainless Steels, Tool Steel and High Tensile Alloy Steels (300 to 400 Brinell)
Turning, Boring, Milling, Forming, Drilling, Sawing	5-7%	5-7%	7-9%	7-9%
Tapping, Thread Rolling, Reaming, Screw Cutting, Broaching	5-7%	5-7%	8-10%	8-10%
Gear Shaping, Form and Thread Milling, Shaving, Hobbing, and Trepanning	5-7%	5-7%	8-10%	8-10%
Internal and External Grinding, Form and Thread Grinding	5-7%	5-7%	5-7%	5-7%
Stamping	10%	10%	20%	20%

Note: Dilution ratios shown are approximate and may require higher or lower water concentrations depending on a number of factors including the type of metal cut, machine speed, the severity of the operation, metal hardness, etc.

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