



CITGO TRUKUT® GP 205

Date 10/12

DESCRIPTION: CITGO Trukut GP 205 is 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, it is suitable for use on ferrous and non-ferrous metals.

- FEATURES:**
- Forms stable emulsions in various water qualities
 - Multi-metal and general purpose applications
 - Good residual corrosion properties
 - Free from chlorinated paraffins
 - Excellent corrosion prevention properties

- BENEFITS:**
- Product performance is constant and machine remains 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
 - Reduces the need for in-process corrosion protection fluids

APPLICATIONS: CITGO Trukut GP 205 is recommended for milling, turning, drilling, grinding and other metalworking operations on ferrous and non-ferrous metals where efficiency of an emulsifiable oil is preferred. Trukut GP 205 has excellent cooling and rust prevention properties. It is also a preferred grinding fluid.

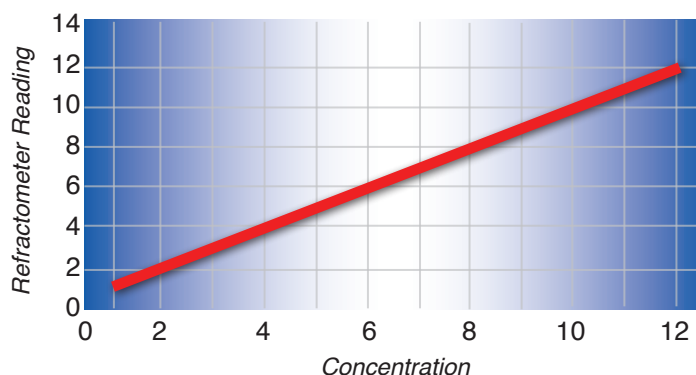


Concentrate Dilution

Material Compatibility

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

Refractometer Chart



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

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Date 10/12 - (Continued)

TYPICAL PROPERTIES - CITGO TRUKUT® GP 205

Material Code	639468001
Gravity, Specific, ASTM D 1298, 60/60°F	0.91
Density, lb/gal	7.59
Flash Point, COC, ASTM D 92, °F (°C)	320 (160)
Viscosity, cSt at 40°C	35
Color, ASTM D 1500	3.0
Pour Point, ASTM D 97, °F (°C)	32 (0)
pH at 5% in Deionized	9.6
Corrosion (modified Iron Chip Rust test)	Pass
Copper Corrosion, ASTM D 130, 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	Yellow

METAL MACHINABILITY GROUPS

	1 Non-Ferrous, Soft Metals	2 Nickel Alloys, Nitalloy Steels, Cast Irons and Alloy Steels (up to 200 Brinell)	3 Stainless Steels, "Monel" Metals, 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)
Machining Operation				
Turning, Boring, Milling, Forming, Drilling, Sawing	5-7%	5-7%	8-12%	8-12%
Tapping, Thread Rolling, Reaming, Screw Cutting, Broaching	5-7%	5-7%	8-12%	8-12%
Gear Shaping, Form and Thread Milling, Shaving, Hobbing, and Trepanning	5-7%	5-7%	8-12%	8-12%
Internal and External Grinding, Form and Thread Grinding	5-7%	5-7%	5-7%	5-7%
Stamping	5-10%	5-10%	5-10%	5-10%

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.