



CITGO ORDNANCE® OIL 912 Series

Date 10/06

DESCRIPTION: CITGO Ordnance Oil 912 are light bodied cutting fluids compounded with active sulfur additives and a special chlorinated compound. These oils are specifically for use on ferrous metals, including stainless steel, in all machining processes where heavily fortified, light-bodied cutting fluids are needed.

- FEATURES:**
- Formulated with effective mist suppressants to control stray mist.
 - Exhibit low viscosities allow for easy penetration of the fluid into the cut zone.
 - Fully compatible with carbide tools.
 - Provide rapid chip removal and effective cooling of the work piece.
 - Promote excellent work piece finish.
 - Extend tool life.

APPLICATIONS: CITGO Ordnance Oil 912 is an excellent cutting fluid for deep hole drilling in various ferrous metals. It is recommended for other types of machining processes where a heavily fortified, light-bodied cutting fluid is needed.

CITGO Ordnance HD Oil 912 is a higher viscosity version of CITGO Ordnance 912 designed for heavier machining operations. CITGO Ordnance HD 912 should be used when the limits of CITGO Ordnance 912 are exceeded due to its higher viscosity.

CAUTION: CITGO Ordnance 912 Oils contain active sulfur; they should not be used on yellow metals where staining is a concern.

TYPICAL PROPERTIES:

CITGO ORDNANCE OIL 912

	Ordnance 912	Ordnance HD 912
Material Code	639559001	639568001
Gravity, ASTM D 4052, °API,	22	21
Gravity, Specific, 60/60°F, ASTM D 1298	0.92	0.92
Density, lb/gal	7.7	7.7
Flash Point, ASTM D 92, °F (°C)	360 (182)	302 (150)
Viscosity, ASTM D 445, cSt at 40°C	17	29
ASTM D 2161, SUS at 100°F	93	149
Pour Point, ASTM D 97, °F (°C)	-10 (-23)	-17 (-27)
Sulfur, ASTM D 2622, w%	1.8	3.6
Active Sulfur, w%	0.7	1.13
Fatty Material, %	3.5	8.0
Chlorine, w%	2.3	2.6
Falex Load Wear Index, ASTM D 3233 Part B	2475	2400
Four Ball EP, ASTM D 2783		
Weld Point, kfg	400	620
Load Wear Index, kfg	57.58	81.63
Copper Corrosion, ASTM D 130	4C	4C