



CITGO TRANSKUT® OILS

Date 01/05

DESCRIPTION: Transkut® Oils are general-purpose cutting oils containing sufficient sulfur additives and chlorinated compounds to retain transparency. They have been successfully used in moderate severity operations where visibility of the tool or work piece is desired.

- FEATURES:**
- Contain an effective mist suppressant
 - Promote longer tool life and high quality part surface finish
 - Provide better visibility of parts being machined
 - Apply to machining low to medium carbon steels as well as some stainless steels

APPLICATIONS: Transkut® Oils are recommended for machining steel alloys having a machinability rating of 60% and above. They are being used in automatic screw machines and in similar equipment for:

Cut-off Drilling Threading	Forming Reaming Hobbing	Shaving Chamfering Broaching
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NOTE: Since these fluids contain active sulfur, they should not be used with yellow metals (copper, brass, bronze, etc.).

TYPICAL PROPERTIES:

CITGO TRANSKUT® OILS

ISO VIS Grade	200	HD 200
Material Code	639561001	639562001
Gravity, ASTM D 4052, °API	22.5	19.8
Gravity, Specific, 60/60°F, ASTM D 1298	0.92	0.94
Density, lb/gal	7.7	7.8
Flash Point, ASTM D 92, °F (°C)	360 (182)	320 (160)
Viscosity, ASTM D 445, cSt at 40°F	35	39
cSt at 100°F	5.1	5.4
ASTM D 2161, SUS at 100°F	200	200
SUS at 210°F	43	45
Color, ASTM D 1500	6	2
Pour Point, ASTM D 97, °F (°C)	-40 (-40)	-20 (-29)
Sulfur, ASTM D 2622, w%	0.9	2.0
Active Sulfur, w%	0.3	1.9
Chlorine, w%	1.1	2.2
Lubricity Additive, %	0	3
Falex Load Wear Test, ASTM D 3233 Part B	2200	4260
Four Ball EP, ASTM D 2783		
Weld Point, kgf	250	800+
Load Wear Index, kfg	42.56	100+
Copper Corrosion 3 hrs. at 212°F	4C	4C