C I T G O T R U K U T ® N C 2 0 0 S E R I E S

Date 01/05

DESCRIPTION: CITGO Trukut® NC 205 is a conventional emulsifiable oil that will readily mix with water to produce a stable emulsion. CITGO Trukut® NC 215 is a heavy-duty soluble oil which combines the superior cooling characteristics of a conventional emulsifiable oil with the extreme pressure properties of a mineral oil cutting lubricant. Neither product is formulated with chlorinated compounds.

QUALITIES: CITGO emulsifiable cutting fluids are formulated from high quality mineral oils. The emulsifiers are adjusted to the base oils used in order to provide stable emulsions regardless of the oil/water ratio used. These oils afford efficient and economical cooling and lubrication. They provide excellent rust protection to both the cutting tool and the metal part to be machined.

APPLICATIONS: CITGO Trukut® NC 205 is recommended for milling, turning, drilling and other metalworking operations on ferrous and non-ferrous metals where emulsifiable oils are preferred. Due to excellent cooling properties, it is also a preferred grinding coolant. CITGO Trukut® NC 215, in addition to forming very stable emulsions, contains extreme pressure additives which permit its use in many machining operations where the lubrication requirements are too severe for regular soluble oils. It is well suited for automatic screw machines where a single cutting fluid may be required to function in a wide variety of operations involving both non-ferrous and ferrous metals.

TYPICAL PROPERTIES:

CITGO TRUKUT® NC 200 SERIES

Grade	**NC 205**	**NC 215**
Material Code	639205001	639216001
Gravity, ASTM D 4052, °API	23.8	22.3
Gravity, Specific, ASTM D 1298, 60/60°F	0.91	0.92
Pounds Per Gallon	7.58	7.66
Flash Point, COC, ASTM D 92, °F (°C)	338 (170)	343 (173)
Viscosity, cSt at 40°C	30	36.9
cSt at 100°C	4.6	5.5
SUS at 100°F	155	169
SUS at 210°F	41	43
Color, ASTM D 1500	3.0	5.0
Pour Point, ASTM D 97,°F(°C)	-44 (-42)	-54 (-48)
Corrosion(1)	Pass	Pass
Copper Corrosion, ASTM D 130, 3 hrs at 212°	1B	1B
Falex Load, ASTM D 3233(2)	–	1,500
pH(3)	9.3	8.4
Emulsion Stability, 24 hrs at 77°F(4)		
Deionized Water	Pass	Pass
Hard Water	Pass	Pass
Solution Stability, 24 hrs at 30°F	Pass	Pass

Notes:

(1) Modified Iron Chip Rust Test.
(2) 10% solution in distilled water.
(3) One part oil, three parts water
(4) A. 80:20 distilled water - cream 7 ml., oil trace max.; typical is 0.0 cream, 0.0 oil.
B. 90:10 500 ppm hard water - cream 7 ml., oil trace max.; typical is 0.0 cream, 0.0 oil.