

## Castrol Variocut B 27

High performance neat cutting oil

### Description

Castrol Variocut™ B 27 is a chlorine and heavy-metal free neat cutting oil.

### Application

Variocut B 27 is designed for broaching and gear cutting of steel and cast iron. It is suitable for gear hobbing, gear shaping and grinding. Variocut B 27 contains active sulphur and is not compatible with yellow metals.

	Cast Iron	Low-medium alloyed steel	High alloyed steel /nickel-chromium alloys	Titanium alloys	Aluminium alloys	Yellow metals
Honing/Superfinishing	-	-	-	-	-	-
Grinding	-	✓	✓	--	-	-
Drilling	-	-	-	-	-	-
Broaching/Gear manufacturing	✓	✓	-	-	-	-
General machining	✓	✓	✓	-	-	-

### Advantages

- Advanced additive technology gives high extreme pressure (EP) lubricity properties and lowers production costs through extended tool life
- Improved surface finish and increased cutting speeds leads to improvement of process efficiency
- Our chlorine and heavy-metal free formulation improves the environmental profile and reduces disposal costs

## Typical Characteristics

Properties	Standard	Unit	Data
Appearance	Visual	Visual	Amber
Viscosity @ 40°C	DIN 51562	mm <sup>2</sup> /s	23
Viscosity@ 100°F	ASTM D 446	[SUS]	110
Density @ 15°C	DIN 51757 ASTM D 1298	kg/m <sup>3</sup>	873
	Calculated	lbs/gal	7.29
Flashpoint COC	ISO 2592	°C	>190
	ASTM D 92	°F	>370
Copper corrosion	ISO 2160 ASTM D 130	3 hr at 100°C	4c

	ester	active sulphur	inactive sulphur	phosphorous	calcium	chlorine	zinc
Additives	+	+	-	+	-	-	-

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