

Castrol Variocut B 46 TC

High performance neat cutting oil

Description

Castrol Variocut™ B 46 TC is a chlorine and heavy-metal free neat cutting oil.

Application

Variocut B 46 TC is designed for high performance broaching and gear cutting of ferrous metals. Suitable for gear hobbing, gear shaping and drilling. Variocut B 46 TC 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	Yellow
Viscosity @ 40°C	DIN 51562	mm ² /s	15
Viscosity@ 100°F	ASTM D 446	[SUS]	77
Density @ 15°C	DIN 51757 ASTM D 1298	kg/m ³	900
	Calculated	lbs/gal	7.51
Flashpoint COC	ISO 2592	°C	>140
	ASTM D 92	°F	>280
Copper corrosion	ISO 2160 ASTM D 130	3 hr at 100°C	2b

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

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 13 October 2008 Version 1