



Product Data

Variocut B 30

High performance neat cutting oil

Description

Castrol Variocut™ B 30 is a chlorine free neat cutting oil.

Application

Variocut B 30 is designed for arduous broaching of stainless steels and difficult to machine high tensile steel alloys. It is also suitable for gear hobbing, gear cutting and gear shaping.

Variocut B 30 contains active sulphur and is not compatible with yellow metals.

ü ü suggested core application ü possible application, please consult Castrol representative prior to use

	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	ü	ü ü	ü ü			
General Machining	ü	ü ü	ü ü			

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 free formulation improves the environmental profile and reduces disposal costs

Typical Characteristics

Name	Test Method	Unit	Variocut B 30
Appearance	Visual	-	Amber
Density @ 15°C / 59°F	ASTM D1298 / ISO 12185	kg/m ³ - lbs/gal	888 - 7.41
Kinematic Viscosity @ 40°C / 104°F	ASTM D446 / DIN 51562	mm ² /s	23
Flash Point - open cup method	ASTM D92 / ISO 2592	°C/°F	>160 / >320
Copper corrosion (3 hrs@100 °C/212°F)	ASTM D130 / ISO 2160	Rating	4c

Typical Physical Characteristics

	Ester	Active Sulphur	Inactive Sulphur	Phosphorous	Calcium	Chlorine	Zinc
Additives	ü	ü	ü	ü			ü

Storage

To avoid product deterioration always keep the container/drum tightly sealed. Store the product in a cool, dry place away from direct sunlight. Prevent exposure to frost and avoid water ingress. For optimum product stability, it is preferable to store the product indoors between 5°C and 45 °C / 41°F and 113°F.

For more details, please refer the product safety data sheet.

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