



Product Data

Variocut D 270

High performance neat cutting oil

Description

Castrol Variocut™ D 270 is a chlorine and heavy-metal free neat cutting oil.

Application

Variocut D 270 is designed for gun drilling, broaching and gear manufacturing of ferrous alloys.

This product 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		ü	ü			
Grinding						
Drilling		ü ü	ü ü			
Broaching/Gear manufacturing		ü ü	ü ü			
General machining						

ü ü ü core application ü ü recommended application ü suggested application, please consult Castrol representative

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		Yellow
Viscosity @ 40°C	DIN 51562	mm ² /s	19
Density @ 15°C	DIN 51757 ASTM D 1298	kg/m ³	895
Flashpoint COC	ISO 2592	°C	170
Copper corrosion	ISO 2160 ASTM D 130	3 hr at 100°C	4c

Additional Information

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

Storage

To avoid product deterioration, keep the container/drum tightly sealed always. Prevent any frost and water ingress. Store it in a cool and dry place away from direct sunlight. It is preferable to store the product indoors always. For more details, please refer the product safety data sheet.

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