



Variocut G 613 HC

High performance neat cutting oil

Description

Castrol Variocut™ G 613 HC is a neat cutting oil based on the latest generation of Extreme High Viscosity Index (EHVI) hydrocracked base oils formulated without chlorinated paraffines.

Application

Variocut G 613 HC is designed for grinding and general machining of ferrous and yellow metals with CBN and carborundum wheels.

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	Titanium alloys	Aluminium alloys	Yellow metals
Honing / Super finishing						
Grinding	ü ü	ü ü	ü		ü ü	ü
Drilling	ü	ü			ü ü	ü
Broaching						
Gear manufacturing	ü ü	ü ü			ü ü	ü
General machining	ü ü	ü	ü		ü ü	ü

Advantages

- Low oil mist and foam characteristics, even at high pressures and flow rates, can lead to a reduction in oil consumption and increased production rates
- Superior additive technology helps to lead to extremely high cutting and grinding efficiencies, increased tool life, improved surface finish and lower overall operating costs
- Excellent wetting characteristics can reduce drag out and result in lower product usage
- Good filtering characteristics and high oxidation stability can increase product lifetime
- Multi-metal machining using our superior additive technology provides opportunity for product consolidation
- Formulated without chlorinated paraffines helps to improve the environmental profile and reduces disposal costs where applicable
- Low odour, light colour and low mist qualities helps to improve operator acceptability

Typical Characteristics

Name	Test Method	Unit	Variocut G 613 HC
Appearance	Visual	-	Light Yellow
Specific Gravity @ 15°C	ASTM D1298 / ISO 3675	g/ml	0.83 - 0.85
Kinematic Viscosity @ 40°C	ASTM D445 / ISO 3104	mm ² /s	13
Flash Point - open cup method	ASTM D92 / ISO 2592	°C	192
Copper corrosion (3 hrs@100°C)	ASTM D130 / ISO 2592	Rating	1b

Subject to usual manufacturing tolerances.

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.

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

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