



Variocut G 615 HC

High performance neat cutting oil

Description

Castrol Variocut™ G 615 HC is a neat cutting oil based on the latest generation of Extreme High Viscosity Index (EHVI) hydrocracked base oils with high flash point without the use of chlorinated additives.

Application

Variocut G 615 HC is designed for high speed, creep feed grinding, especially gear grinding of ferrous and yellow metals with CBN and carborundum wheels.

√√ suggested core application √ 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						
General machining	√√	√√			√√	√√

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 leads to extremely high cutting and grinding efficiencies, increased tool life, improved surface finish and lower overall operating costs
- Low viscosity and excellent wetting characteristics helps to reduce drag out and result in lower product usage
- Good filtering characteristics and high oxidation stability increase product lifetime
- Multi-metal machining using our superior additive technology provides opportunity for product consolidation
- Low odour, light colour and low mist qualities result in high operator acceptability
- Formulated without chlorinated paraffines helps you to fulfil aspects of legislative requirements and waste treatment requirements that specify that this chemical is excluded

Typical Characteristics

Properties	Standard	Unit	Data
Appearance	Visual		Yellow
Viscosity @ 40°C	DIN 51562	mm ² /s	14
Density @ 15°C	DIN 51757 ASTM D 1298	kg/m ³	858
Flashpoint COC	ISO 2592	°C	208
Copper corrosion	ISO 2160 ASTM D 130	3 hr at 100 °C	1a

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 / 41°F and 113°F.

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

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