



Variocut™ B 30 SP

High performance neat cutting oil

Description

Castrol Variocut™ B 30 SP is a chlorine and heavy-metal free neat cutting oil.

Application

Variocut B 30 SP 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 SP 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 / nickelchromium alloys	Titanium alloys	Aluminium alloys	Yellow metals
Honing/Superfinishing						
Grinding						
Drilling						
Broaching		ü ü	ü ü			
Gear manufacturing		ü ü	ü ü			
General machining		ü ü	ü ü			

Advantages

- Advanced additive technology gives high extreme pressure (EP) lubricity properties and helps to lower production costs through extended tool life
- Improved surface finish and increased cutting speeds can lead to improvement of process efficiency
- Our chlorine and heavy metal free formulation improves the environmental profile and reduces disposal costs

Typical Characteristics

Name	Method	Units	Variocut B 30 SP
Appearance	Visual	-	Amber
Density @ 15°C / 59°F	ISO 12185 / ASTM D4052	kg/m ³	878
Kinematic Viscosity @ 40°C / 104°F	ISO 3104 / ASTM D 445	mm ² /s	23
Flash Point - open cup method	ISO 2592 / ASTM D92	°C/°F	150
Copper corrosion (3 hrs@100°C/212°F)	ISO 2160 / ASTM D130	Rating	4c

Subject to usual manufacturing tolerances.

Additional Information

	Ester	Active Sulphur	Total Sulfur	Phosphorous	Calcium	Chlorine	Zinc
Additives	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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