



Variocut D 824

High performance neat cutting oil

Description

Castrol Variocut™ D 824 is a chlorine and heavy metal free neat cutting oil.

Application

Variocut D 824 is designed for gun drilling, broaching and gear manufacturing of cast iron and medium alloyed steels.

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						
Grinding						
Drilling	•••	•••	•••			
Broaching/Gear manufacturing	••	••				
General machining	•	•	•			

••• core application •• recommended application • 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		Amber
Viscosity @ 40°C	DIN 51562	mm ² /s	12
Density @ 15°C	DIN 51757 ASTM D 1298	kg/m ³	905
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	o	o	o	o	o		

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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