

Variocut B 46 TC

High performance neat cutting oil

Description

Castrol Variocut™ B 46 TC is a neat cutting oil formulated without chlorinated paraffins and zinc additives.

Application

Variocut B 46 TC is designed for high performance broaching and gear cutting of ferrous metals. Suitable for gear hobbing, gear shaping and drilling.

Variocut B 46 TC 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 / nickel-chromium alloys	Titanium alloys	Aluminium alloys	Yellow metals
Honing/ Superfinishing						
Grinding						
Drilling	ü ü	ü ü	ü ü	ü		
Broaching/Gear manufactorin	ü ü	ü ü	ü ü	ü		
General machining	ü ü	ü ü	ü ü	ü		

Advantages

- Advanced additive technology gives high extreme pressure (EP) lubricity properties to help lowering production costs through extended tool life
- Improved surface finish and increased cutting speeds can lead to improvement of process efficiency
- Formulated without chlorinated paraffins which help you to fulfil aspects of legislative and waste treatment requirements that specify that these chemicals are excluded

Typical Characteristics

Properties	Standard	Unit	Data
Appearance	Visual		Yellow
Viscosity @ 40°C	DIN 51562 ASTM D 445	mm ² /s	16
Viscosity @ 100°F	ASTM D 445	SUS	77
Flashpoint COC	ISO 2592 ASTM D 92	°C/°F	>140/280
Copper corrosion	ISO 2160 ASTM D 130	3 hr at 100 °C	2b

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

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