

Variocut G 399

High performance neat cutting oil

Description

Castrol Variocut™ G 399 is a chlorine and heavy-metal free, low viscosity neat cutting oil.

Application

Variocut G 399 is designed for grinding, honing and superfinishing of ferrous materials. Product meets high finishing demands of bearings. 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
Honing/Superfinishing	✓	✓	✓	-	-	
Grinding	✓	✓	✓	-	-	
Drilling	-	-	-	-	-	
Broaching/Gear manufacturing	-	-	-	-	-	
General machining	-	-	-	-	-	

Advantages

- Excellent flushing and lubrication properties extend grinding wheels and honing stone life by enabling high surface finish and dimensional accuracy
- Low viscosity and excellent wetting characteristics reduce drag out and result in lower product usage
- Good filtering characteristics and high oxidation stability increases product lifetime
- Our chlorine and heavy-metal free formulation improves the environmental profile and reduces disposal costs

Characteristics

Properties	Standard	Unit	Data
Appearance	Visual	Visual	Yellow
Viscosity @ 40°C	DIN 51562	mm ² /s	5.5
Viscosity@ 100°F	ASTM D 446	[SUS]	45
Density @ 15°C	DIN 51757 ASTM D 1298	kg/m ³	835
	Calculated	lbs/gal	6.97
Flashpoint COC	ISO 2592	°C	> 130
	ASTM D 92	°F	> 265
Copper corrosion	ISO 2160 ASTM D 130	3 hr at 100°C	4c

	ester	active sulphur	inactive sulphur	phosphorous	calcium	chlorine	zinc
Additives	+	+	+	-	-	-	

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