

## Castrol 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	-	-	-	-	-	-

### 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	Visual	Amber
Viscosity @ 40°C	DIN 51562	mm <sup>2</sup> /s	12
Density @ 15°C	DIN 51757 ASTM D 1298	kg/m <sup>3</sup>	919
Flashpoint	ISO 2592	°C	170
Copper corrosion	ISO 2160 ASTM D 130	3 h at 100°C	4c

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

Castrol, Variocut, and the Castrol logo are trademarks of Castrol Limited, used under licence

This data sheet and the information it contains is believed to be accurate as of the date of printing. However, no warranty or representation, express or implied, is made as to its accuracy or completeness. Data provided is based on standard tests under laboratory conditions and is given as a guide only. Users are advised to ensure that they refer to the latest version of this data sheet.

It is the responsibility of the user to evaluate and use products safely, to assess suitability for the intended application and to comply with all applicable laws and regulations. Material Safety Data Sheets are available for all our products and should be consulted for appropriate information regarding storage, safe handling, and disposal of the product. No responsibility is taken by either BP plc or its subsidiaries for any damage or injury resulting from abnormal use of the material, from any failure to adhere to recommendations, or from hazards inherent in the nature of the material. All products, services and information supplied are provided under our standard conditions of sale. You should consult our local representative if you require any further information.

Castrol Limited, Pipers Way, Swindon, Wiltshire SN3 1RE, UK  
[www.castrol.com/industrial](http://www.castrol.com/industrial)