



Variocut B 27

High performance neat cutting oil

Description

Castrol Variocut™ B 27 is a chlorine and heavy-metal free neat cutting oil.

Application

Variocut B 27 is designed for broaching and gear cutting of steel and cast iron. It is suitable for gear hobbing, gear shaping and grinding. Variocut B 27 contains active sulphur and is not compatible with yellow metals.

	Cast Iron	Low-medium alloyed steel	High alloyed steel / nickel- chromium alloys	Titanium alloys	Aluminum alloys	Yellow metals
Honing/Superfinishing	-	-	-	-	-	-
Grinding	-	X	X	-	-	-
Drilling	-	-	X	-	-	-
Broaching/Gear manufacturing	X	X	-	-	-	-
General machining	X	X	X	-	-	-

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

Name	Method	Units	

Typical Physical Characteristics

Properties	Unit	Standard	Data
Appearance	Visual	Visual	Amber
Viscosity @ 40°C	mm ² /s	DIN 51562	23
Viscosity @ 100°F	[SUS]	ASTM D 446	110
Density @ 15°C	kg/m ³	DIN 51757	873
	lbs/gal	ASTM D 1298	
Flashpoint COC	°C	Calculated	>190
	°F	ISO 2592	
Copper corrosion	3 hr at 100°C	ASTM D 92	>370
		ISO 2160	
		ASTM D 130	4c

	Ester	Active sulphur	Inactive sulphur	Phosphorous	Calcium	Chlorine	Zinc
Additives	+	+	-	+	-	-	-

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BP Lubricants USA Inc., 1500 Valley Road, Wayne, NJ 07470
 Telephone: +1-888-CASTROL Product Information: +1-877-641-1600
www.castrol.com/en_us/b2b/home.html