



# Variocut™ G 600 HC

High performance neat cutting oil

## Description

Castrol Variocut™ G 600 HC (previously called Variocut™ G 600 HC NA) is a chlorine and heavy-metal free neat cutting oil based on the latest generation of Extreme High Viscosity Index (EHVI) hydrocracked base oils.

## Application

Variocut G 600 HC is designed for high speed, creep feed grinding, especially gear grinding of ferrous and yellow metals with CBN and carborundum wheels.

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

ü ü suggested core application    ü possible application, please consult Castrol representative prior to use

## Advantages

- Low oil mist and foam characteristics, even at high pressures and flow rates, can lead to a reduction in oil consumption and increased production rates.
- Superior additive technology helps to improve cutting and grinding efficiencies, increased tool life, surface finish and can lower overall operating costs.
- Low viscosity and excellent wetting characteristics can reduce drag out and helps to reduce product usage.
- Good filtering characteristics and high oxidation stability can increase product lifetime.
- Multi-metal machining using our superior additive technology may provides opportunity for product consolidation.
- Our chlorine and heavy-metal free formulation helps to improve the environmental profile and reduces disposal costs.
- Low odour, light colour and low mist qualities result in high operator acceptability.

## Typical Characteristics

Description	Method	Units	Variocut G 600 HC
Appearance	CN-TM-007	-	Pale Yellow
Viscosity @ 40°C	ASTM D 445	mm <sup>2</sup> /s	9.8 - 12.8
Density @ 15°C	CN-TM-084	lbs/gal	0.83 - 0.86
Flash Point PMCC	ASTM D 93	°C	160 - 170
Copper corrosion	ASTM D 130	3 hr @ 100 °C	1b

## Additional Information

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

## Storage

To avoid product deterioration always keep the container/drum tightly sealed. For optimum product stability, store between 5°C/41°F and 45°C/113°F in a cool, dry place away from direct sunlight. Prevent exposure to frost and avoid water ingress. It is preferable to store the product indoors.

For more details, please refer to the product safety data sheet.

**This product was previously called Variocut™ G 600 HC NA. The name was changed in 2015.**

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08 Dec 2015

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