



## Variocut G 408 HC

High performance neat cutting oil

### Description

Castrol Variocut™ G 408 HC is a neat cutting oil based on the latest generation of Extreme High Viscosity Index (EHVI) hydrocracked base oils, formulated without chlorinated paraffins.

Variocut G 408 HC can be used in both individual machines and centralised systems.

### Application

Variocut G 408 HC is especially designed for hard metal grinding and tungsten carbide grinding with diamond wheels. It can also be used for light duty grinding, drilling and general machining of aluminium and yellow metals and is suitable for spark erosion applications.

In order to maximise product performance, it is recommended that adequate filtration system is used.

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

### Advantages

- Low oil mist and foam characteristics, even at high pressures and flow rates, lead to a reduction in oil consumption and increased production rates
- Superior additive technology leads to very low cobalt leaching tendency, improved grinding performance and cleaner grinding wheels
- Low viscosity and excellent wetting characteristics reduce drag out and result in lower product usage
- Good filtering characteristics and high oxidation stability increase product lifetime
- Our chlorine and heavy-metal free formulation improves the environmental profile and reduces disposal costs
- Low odour, light colour and low mist qualities result in high operator acceptability

## Typical Characteristics

| Name               | Method                   | Units              |
|--------------------|--------------------------|--------------------|
| Appearance         | Visual                   |                    |
| Viscosity at 40°C  | DIN 51562                | mm <sup>2</sup> /s |
| Viscosity at 100°F | ASTM D 446               | SUS                |
| Density at 15°C    | DIN 51757<br>ASTM D 1298 |                    |
|                    | Calculated               | lbs/gal            |
| Flashpoint COC     | ISO 2592                 | °C                 |
|                    | ASTM D 92                | °F                 |
| Copper corrosion   | ISO 2592<br>ASTM D 130   |                    |

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°F.

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

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Castrol Industrial, Technology Centre , Whitchurch Hill , Pangbourne , Reading , RG8 7QR , United Kingdom

<http://msdspds.castrol.com>