



Variocut B 46 TC

High performance neat cutting oil

Description

Castrol Variocut™ B 46 TC is a chlorine and heavy-metal free neat cutting oil.

Application

Variocut B 46 TC is designed for high performance broaching and gear cutting of ferrous metals. Suitable for gear hobbing, gear shaping and drilling. Variocut B 46 TC contains active sulphur and is not compatible with yellow metals.

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

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

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		Yellow
Viscosity @ 40°C	DIN 51562 ASTM D 445	mm ² /s	16
Viscosity @ 100°F	ASTM D 445	SUS	77
Flashpoint COC	ISO 2592 ASTM D 92	°C/°F	>160/320
Copper corrosion	ISO 2160 ASTM D 130	3 hr at 100 °C	2b

Additional Information

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

Storage

To avoid product deterioration, keep the container/drum tightly sealed always. Prevent any frost and water ingress. Store it in a cool and dry place away from direct sunlight. It is preferable to store the product indoors always. For more details, please refer the product safety data sheet.

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