



Product Data

Variocut B 46 TC

High Performance Neat Cutting Oil

Description

Castrol VariocutTM B 46 TC is a chlorinated paraffin- and heavy metal free neat cutting oil.

Application

Variocut B 46 TC is primarily designed for high performance broaching and gear cutting of ferrous metals. It is suitable for gear hobbing, gear shaping, and drilling. This product can also be used in form grinding, creep feed grinding as well as cut and form tapping.

Variocut B 46 TC contains active sulfur 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	-	-	-	√	-	-
Drilling	√	√	√	√	-	-
Broaching/Gear manufacturing	√	√	√	√	-	-
General machining	√	√	√	√	-	-

Advantages

- Advanced additive technology provides high extreme pressure (EP) lubricity properties, and can aid in lowering production costs through extended tool life, improved surface finish and increased cutting speeds.
- Improved surface finish and increased cutting speeds help to improve process efficiency.
- Our chlorinated paraffin and heavy metal free formulation improves the environmental profile and can reduce disposal costs.

Typical Characteristics

Name	Method	Units	Value
Appearance	Visual	Visual	Yellow
Viscosity @ 100F	ASTM D 446	SUS	77
Viscosity, Kinematic 40C	ASTM D 445	cSt	15
Flash Point, COC	ASTM D 92	°F	280
Copper Corrosion, 3hrs @ 100C	CN-TM-020		2b
Density @ 15C	CN-TM-084	g/ml	0.88
	CN-TM-084	lb/gal	7.35

Additional Information

	Ester	Active Sulfur	Inactive Sulfur	Phosphorus	Calcium	Chlorinated Paraffin	Zinc
Additives	√	√	√	√	√	-	-

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12 Jan 2018

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