



Product Data Sheet

Variocut G 600 HC

High performance neat cutting oil

Description

Castrol Variocut™ G 600 HC 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.

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	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

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

Properties	Standard	Unit	Data
Appearance	Visual		Pale Yellow
Viscosity @ 40°C	DIN 51562 ASTM D 445	mm²/s	9.2
Flashpoint COC	ISO 2592 ASTM D 92	°C	>165
Copper corrosion	ISO 2160 ASTM D 130	3 hr at 100 °C	1b
RBOT	ASTM D 2272	min	185

Subject to usual manufacturing tolerances.

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. 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.

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

Variocut G 600 HC
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