



Product Data

Castrol Variocut G 399

High-performance neat cutting oil

Description

Castrol Variocut™ G 399 is a chlorine- and heavy metal-free, low viscosity neat cutting oil.

Application

Variocut G 399 is designed for grinding, honing and superfinishing of ferrous materials. Product meets high finishing demands of bearings. This product contains active sulphur 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

- Excellent flushing and lubrication properties help extend grinding wheels and honing stone life by enabling high surface finish and dimensional accuracy.
- Low viscosity and excellent wetting characteristics reduce drag out and can result in lower product usage.
- Good filtering characteristics and high oxidation stability help increase product lifetime.
- Our chlorine- and heavy metal-free formulation improves the environmental profile and reduces disposal costs.

Typical Characteristics

Properties	Unit	Standard	Data
Appearance	Visual	Visual	Yellow
Viscosity @ 40°C	mm ² /s	DIN 51562	5.5
Viscosity@ 100°F	[SUS]	ASTM D 446	45
Density @ 15°C	kg/m ³	DIN 51757 ASTM D 1298	835
	lbs/gal	Calculated	6.97
Flashpoint COC	°C	ISO 2592	> 130
	°F	ASTM D 92	> 265
Copper corrosion	3 hr at 100°C	ISO 2160 ASTM D 130	4c

	Ester	Active sulphur	Inactive sulphur	Phosphorous	Calcium	Chlorine	Zinc
Additives	+	+	+	-	-	-	-

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1812/2006, version 1.0

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