



Variocut C Moly Dee

High Performance Tapping Fluid

Description

Castrol Variocut™ C Moly Dee (previously named Moly Dee CF Tapping Fluid) is a high performance tapping fluid that improves threading accuracy, extends tool life, improves surface finishes and increases production. Variocut C Moly Dee is suggested for use on most metals, including aluminum, titanium and steel. It is especially effective on difficult-to-machine metals such as stainless steel and aerospace alloys.

Application

Used straight, Variocut C Moly Dee should be applied directly to the tool/workpiece interface from a spout-top can or other applicator. Used as an additive with straight cutting oils, it should be poured into a high agitation area in the machine sump. Add approximately one gallon of Variocut C Moly Dee to every ten gallons of conventional cutting oils. Variocut C Moly Dee is recommended for use on most metals including aluminum, titanium and steel. It can stain copper or copper alloys if not removed following use.

This product is not water soluble and should not be mixed with water soluble oils or synthetic coolants. Consult your Castrol Sales Engineer for questions regarding compatibility.

Advantages

- Outstanding thermal and chemical stability means improved threading performance. This resistance to breakdown allows adherence to closer tolerances and provides smoother, more accurate threads
- The molybdenum disulfide withstands pressures up to 400,000 psi, which is beyond the yield point of any known metal. This reduces metal-to-metal contact and results in longer tool life
- Contains selected extreme pressure additives, including sulfur and MoS₂ that promote optimum metal cutting performance and improved surface finishes.
- The synergistic combination of friction reducing lubricants and chemical activity permits faster speeds and increases production.

Typical Characteristics

Name	Method	Units	Variocut C Moly Dee
Appearance	Visual	-	Grey
Specific Gravity @ 15°C / 59°F	ASTM D4052 / ISO 12185	kg/m ³	0.948
Kinematic Viscosity @ 100°C / 212°F	ASTM D 445 / ISO 3104	mm ² /s	800
Flash Point, COC	CN-TM-039	°F	410
Bulk Density	-	lbs/gal	7.91
Copper Corrosion	ASTM 130 / ISO 2160	Rating	4c
Chlorine	CN-TM-012	-	No
Fat	MW-TM-321	-	Yes

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.

This product was previously named Moly Dee CF Tapping Fluid. The name changed in 2015

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