



# Variocut D 249

High performance neat cutting oil

## Description

Castrol Variocut D 249 is a heavy duty chlorine and heavy metal free neat cutting oil specially formulated with a unique combination of extreme pressure additives, lubricity additives and base oil to optimize machining performance, improve tool life and enhance surface finish in severe machining applications. It's high level of additization ensures a similar finish and tool life as that of a chlorinated product.

Variocut D 249 is suitable for use in central systems as well as individual machines.

## Application

Variocut D 249 is specially designed for deep-hole drilling (or gun drilling) applications on difficult-to-machine alloys, including high alloy steel and stainless steel. It is also suitable for high surface speed machining including form and crush grinding on alloy steel and stainless steel.

Variocut D 249 contains active sulfur and is not compatible with yellow metals.

	Cast Iron	Low-medium alloyed steel	High alloyed steel / stainless steel	Titanium alloys	Aluminum alloys	Yellow metals
Honing/ Super finishing						
Grinding	..	...	...			
Drilling	..	...	...	..		
Broaching/ Gear manufacturing	..	..	..	..		
General machining				..		

.. Indicates increasing suitability

## Advantages

- Advanced additive technology and EP additives give high lubricity properties and lower production costs through extended tool life
- Extremely high anti-weld properties prevent burnishing or tearing wall finish; frequently eliminates need for further finishing
- Low viscosity and excellent wetting characteristics reduce drag out and result in lower product usage
- Good filtering characteristics and high oxidation stability increase product lifetime
- Our chlorine and heavy metal free formulation improves the environmental profile and reduces disposal costs

## Typical Characteristics

Name	Method	Units	Value
Appearance	CN-TM-007	Visual	Yellow
Viscosity at 40°C	CN-TM-101	mm <sup>2</sup> /s	17
Viscosity at 100°F	CN-TM-101	SuS	85.77
Density at 15°C	Calculated	lbs/gal	7.24
Flashpoint COC	CN-TM-039	°C	170 (Typical)
	CN-TM-039	°F	340 (Typical)
Copper Corrosion	CN-TM-020	3 hr at 100°C	4c

## Additional Information

	Ester	Active Sulfur	Inactive Sulfur	Phosphorous	Calcium	Chlorine	Zinc
Additives							

## Storage

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

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