



# Variocut C 814 HC

High performance neat cutting oil

## Description

Castrol Variocut™ C 814 HC is a neat cutting oil based on the latest generation of Extreme High Viscosity Index (EHVI) hydrocracked base oils and advanced synthetic ester technology formulated without chlorinated paraffines. It is especially developed to optimise machining performance, enhance surface finish and help to lower the overall operating costs.

## Application

Varioicut C 814 HC is especially designed for gear production machining of ferrous alloys.

It contains active sulphur and is not compatible with yellow metals.

√√ suggested core application    √ 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						
Grinding	√√	√√	√		√	
Drilling	√	√	√		√	
Broaching/ Gear manufactorin	√√	√√	√		√	
General machining	√√	√√	√		√	

## Advantages

- Low oil mist and foam characteristics, even at high pressures and flow rates, lead to a reduction in oil consumption and increased production rates
- Superior additive technology leads to extremely high cutting and grinding efficiencies, help to increased tool life, improved surface finish and lower overall operating cost
- Good filtering characteristics and high oxidation stability can increase product lifetime
- Formulated without chlorinated paraffines helps you to fulfil aspects of legislative requirements and waste treatment requirements that specify that this chemical is excluded
- Low odor, light color and low mist qualities can lead to high operator acceptability

## Typical Characteristics

Properties	Standard	Unit	Data
Appearance	Visual		Amber/Yellow
Viscosity @ 40°C	DIN 51562 ASTM D 445	mm <sup>2</sup> /s	14
Density @ 15°C	DIN 51757 ASTM D 1298	kg/l	851
Flashpoint COC	DIN EN ISO 2592 ASTM D 92	°C	196°C
Copper corrosion 3 hr at 100 °C 3 hr at 50° C 3 hr at RT	DIN EN ISO 2160 ASTM D 130		4a 2c 1b

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.

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