



## Variocut B 9

High performance neat cutting oil

### Description

Castrol Variocut™ B 9 (earlier called as Ilobroach 9 CF) is a chlorine and heavy-metal free neat cutting oil, which is based on synthetic ester and mineral oil technology.

### Application

Variocut B 9 is designed for high performance broaching and gear cutting operations of ferrous metals in aerospace industry.

Variocut B 9 contains active sulphur and is not compatible with yellow metals.

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						
Grinding						
Drilling	ü	ü ü	ü ü	ü ü		
Broaching	ü	ü ü	ü ü	ü ü		
Gear manufacturing	ü	ü ü	ü ü	ü		
General machining	ü	ü ü	ü ü	ü		

### Advantages

- Advanced additive technology gives high extreme pressure (EP) lubricity properties and lowers production costs through extended tool life
- Improved surface finish and increased cutting speeds leads to improvement of process efficiency
- Our chlorine and heavy-metal free formulation improves the environmental profile and reduces disposal costs

## Typical Characteristics

Name	Method	Units	Variocut B 9
Appearance	Visual	-	Yellow
Kinematic Viscosity @ 40°C / 104°F	ASTM D445 / ISO 3104	mm <sup>2</sup> /s	11
Flash Point - open cup method	ASTM D92 / ISO 2592	°C/°F	160 / 320
Copper corrosion (3 hrs@100°C/212°F)	ASTM D130 / ISO 2160	Rating	4c
Density@15°C	NFT 60 172	g/ml	0.870

## 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.

The product was previously called Ilobroach 9 CF. The name has been changed in 2015.

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