



Mobilcut Series

Mobil Industrial , India

Aqueous Metal Working Fluid

Product Description

Mobilcut is the trademark for ExxonMobil's line of high performance water miscible metal removal fluids. Formulated with leading edge base oils, additives, and emulsifiers, the Mobilcut series products provides dependable performance in a wide array of metal removal processes. The products are designed to work in a variety of hard and soft water qualities and offer low foam potential and long-term corrosion protection for machine and components. Low maintenance and inherently stable, Mobilcut products are designed for the modern machine shop where long service life, excellent machining performance and health and environmental concerns are important factors for increased productivity. These products are supplied in concentrated form and require mixing with water at the point of use.

Mobilcut 100 is a water miscible cutting fluid with excellent solubility. Its highly stable and bio-resistant formulation developed for use as a general purpose, cost effective metal working fluid. It can be used on all types of work piece material for general cutting, milling, drilling, tapping, grinding and reaming applications with low to medium tensile steel, cast iron, aluminum and their alloys.

Mobilcut 140 is a high performance long life water soluble metalworking fluid. It produces a very stable emulsion when diluted with water. It provides excellent corrosion inhibition performance even in extreme hard water conditions. It is specially designed for machining and grinding operations on aluminum alloys. It is also suitable for all ferrous and non-ferrous alloys for moderate to heavy cutting, milling, drilling, tapping, grinding and reaming applications.

Mobilcut 220 is a long life semi-synthetic water soluble metalworking fluid, suitable for all moderate to heavy machining and grinding operations on all ferrous and its alloys. It forms a translucent micro-emulsion and has a unique formula with high performance extreme pressure additives, corrosion inhibitor packages and biocides which prevent bacterial & fungal attack and provides long life. It works very well in general machining and specially grinding of cast Iron, grey iron, steel and its alloys where conventional soluble oil may not deliver adequate performance.

Mobilcut 250 is a high performance versatile semi synthetic water soluble metalworking fluid. It is designed for a broad range of metals for use in cutting and grinding operations. It forms a fine milky emulsion. The unique additive package of this product makes it a first choice for precision machining and consistent high quality manufacturing. It can be used on aluminum alloys, Steel alloys and other metals for grinding, turning, drilling, milling, tapping and reaming operations.

Features and Benefits

The Mobilcut series of products are designed to help increase the productivity of modern machine shops by providing high performance features

Features	Advantages and Potential Benefits
Form stable emulsions and solutions Resistant to biological growth Low foaming potential High degree of corrosion protection Good separability from fines Wide Range of applicability Compatible with high performance Mobil Vactra Oil No slideway lubricants	Ease of use and maintenance Helps increase sump life and reduces unpleasant odor Helps improve performance even in high pressure systems Helps reduce machine maintenance and rework of materials Helps improve filterability and surface finish Potential to consolidate products and reduce inventories Easy separation and removal of tramp oil

Applications

Mobilcut 100: Milky soluble metalworking fluid suitable for general cutting, milling, drilling, tapping, sawing, grinding and reaming applications with light to moderate machining of mild steel, cast iron, aluminum and their alloys. Ideal for water hardness up to 600ppm.

Mobilcut 140: Long life milky soluble metalworking fluid, suitable for all moderate to heavy cutting, milling, drilling, tapping, sawing, grinding and reaming applications with medium to heavy machining of mild steel, cast iron, aluminum and their alloys. Ideal for water hardness up to 1000ppm.

Mobilcut 220: High performance translucent semi synthetic metalworking fluid, suitable for grinding and moderate to heavy cutting, milling, drilling, tapping, and reaming applications of cast Iron, steel and its alloys. Ideal for water hardness up to 700ppm.

Mobilcut 250: High performance milky semi synthetic metalworking fluid, suitable for moderate to heavy, cutting, milling, drilling, tapping, and reaming applications of aluminum and steel alloys. Ideal for water hardness up to 800ppm.

Properties and Specifications

Property	100	140	220	250
Appearance (concentrate), -, Visual	Clear Liquid Brown	Clear Liquid Brown	Clear pale yellow liquid	Clear pale yellow to Brown liquid
Corrosion Break Point, %, IP 287	6	5	3.0	3.5
Density @ 29.5 deg C, g/ml, ASTM D4052	0.927	0.910	0.997	1.000
Refractive Index factor @ 5% Emulsion in D.M. Water, Number, IHTP-001	0.96	0.92	1.5	1.2
Total Alkalinity, % Wt, KOH, IHTP-010	1.1	1.5	7.7	7.4
pH of 5% Emulsion in D.M Water, Number, IHTP-004	9.8	9.7	9.5	9.3

Health and Safety

Health and Safety recommendations for this product can be found on the Material Safety Data Sheet (MSDS) @ <http://www.msds.exxonmobil.com/psims/psims.aspx>

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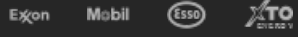
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Typical Properties are typical of those obtained with normal production tolerance and do not constitute a specification. Variations that do not affect product performance are to be expected during normal manufacture and at different blending locations. The information contained herein is subject to change without notice. All products may not be available locally. For more information, contact your local ExxonMobil contact or visit www.exxonmobil.com

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