# Mobilmet™ 760 Series

Mobil Industrial , Byelorussia

Oil Based Cutting Fluids

## Product Description

Mobilmet™ 760 Series are extra high performance neat cutting oils. They are chlorine-free and are intended for severe cutting operations especially on difficult to machine steels. Mobilmet 760 Series oils are not recommended for use with copper and it's alloys due to its aggressiveness towards these softer yellow metals. In comparison with other leading premium cutting oils, Mobilmet 760 Series oils have demonstrated superior surface finish, extended tool life and control of built-up edge. Their light colour enables the work area to be seen during machining operations. Closer tolerances are consistently achieved. The oils are formulated to prevent the formation of oil mist in the vicinity of the machine tool, thus contributing to a safer and more pleasant working environment.

With the benefit of comprehensive development testing using modern machining equipment, plus extensive customer evaluations, Mobilmet 760 Series products, have become the products of choice for many machine shops.

## Features and Benefits

The Mobilmet brand of cutting fluids has gained a well-deserved reputation for innovation and outstanding performance over the years. The Mobilmet 760 Series are an important member of this family with their chlorine-free and low-misting additive technology. This formulation approach yields superb performance in a wide range of applications, while providing the environmental and disposal benefit of being chlorine-free.

Additional features and potential benefits of Mobilmet 760 products include:

| Features | Advantages and Potential Benefits |
|---|---|
| Superb machining performance | Increased production resulting from longer tool life and reduced downtime for tool changes |
| | Improved surface finish, closer tolerances and reduced formation of built-up edge resulting in fewer rejects |
| Excellent lubricity | Cooler work pieces and increased feed rates possible for reduced operating costs |
| Broad multi-purpose capability | Suitability for a wide range of severe machining operations on difficult steels |
| Light transparent colour | Provides a clear view of the tool and work piece |
| Anti-mist formulation | Improved workplace safety |

## Applications

Mobilmet 760 Series are recommended for severe cutting operations on normal and difficult to machine steels. Specific applications, by grade, include:

- Mobilmet 762 is particularly suitable for drilling, deep hole drilling (less than 20 mm diameter), threading, tapping, parting-off and automatic lathe operations on small work pieces
- Mobilmet 763 is recommended for deep hole drilling (greater than 20 mm diameter), drilling, tapping, threading, milling, gear shaping, broaching, parting-off and automatic lathe operations
- Mobilmet 766 is used for tapping, threading, milling, gear shaving and shaping, broaching, planing, parting-off and automatic lathe operations

## Properties and Specifications

| Property | 762 | 763 | 766 |
|---|---|---|---|

| Property | 762 | 763 | 766 |
|---|---|---|---|
| Chlorine, ppm, ASTM D6443 | NIL | NIL | NIL |
| Density @ 15 C, g/cm3, ASTM D4052 | 0.87 | 0.87 | 0.88 |
| Flash Point, Cleveland Open Cup, °C, ASTM D92 | 160 | 180 | 205 |
| Kinematic Viscosity @ 100 C, mm2/s, ASTM D445 | 3.0 | 4.0 | 6.0 |
| Kinematic Viscosity @ 40 C, mm2/s, ASTM D445 | 10 | 18 | 36 |
| Sulfur, Active, wt%, ASTM D1662 | 1.6 | 1.6 | 1.6 |

### 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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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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