MOBILCUT ™250-NEW

Mobil Industrial , Finland

Aqueous Metal Working Fluid

Product Description

Mobilcut is the trademark for Mobil Industrial lubricants line of high performance water miscible metal removal fluids. Formulated with leading edge base oils, additives, and emulsifiers, the Mobilcut series of non-chlorinated 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, 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. All Mobilcut products are free of formaldehyde release agents (FAD).

Mobilcut 250-New is an amine and boron free high quality micro emulsion water miscible metalworking fluid designed to form a translucent emulsion which is suitable for hard and soft water in a range of 15 - 25°dH and stable in use up to 60°dH. Fluid is designed to minimize skin irritation and provide long operation life at the same time. Particularly suitable for aluminium machining.

Features and Benefits

The Mobilcut series 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	Ease of use and maintenance
Long term inherent stability	Increases batch life and reduces unpleasant odors
Low foaming potential	Improved performance even in high pressure systems
Resists formation of sticky residues	Improves machine cleanliness
High degree of corrosion protection	Reduces machine maintenance and rework of materials
Good separability from fines	Improves filterability and surface finish
Wide Range of applicability	Potential to consolidate products and reduce inventories
Compatible with high performance Mobil Vactra Oil No slideway lubricants	Easy separation and removal of tramp oil
Neutral Odor	Enhances the workplace environment

Applications

Mobilcut 250-New: micro emulsion cutting fluid is primarily intended for the machining of

aluminum and aluminum alloys. It may also be used on a wide variety of ferrous materials where a more versatile fluid is required.

Fluid type is micro emulsion. Typical mineral oil content is 45%. Optimal water hardness range is from 15 to 25 ° dH. Its refractometer factor is 1.0

Recommended concentrations for typical operations:

Low alloy steels - milling, turning: 7-10%

Carbon alloy steels, difficult machining: 7-12%

Aluminum, Aluminium machining: 7-12%

Specifications and Approvals

This product has the following approvals:
Safran Pr6300 for 15CDV6 alloy steel

Properties and Specifications

Property	
Appearance, AA.Lab.101	Brown homogeneous turbid liquid
Appearance, 4.0% in 20 deg dH Water, AA.Lab.101	fine disperse, no cream
Kinematic Viscosity @ 20 C, mm2/s, ASTM D7042	215
Density 15 C, kg/m3, DIN EN ISO12185	977
pH-Value 4.0% in 20 deg dH Water, DIN 51369	9.4

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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