



Mobilcut Series

Aqueous Metal Working Fluids

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 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 conventional milky soluble oil that readily mixes with different waters to form stable emulsions. Its versatile performance makes it suitable for a wide range of metal cutting and grinding operations for both ferrous and non ferrous materials where economical performance is the main consideration. It offers excellent emulsion stability and long-term corrosion protection for both components and machine tool.

Enhanced with lubricity agents, Mobilcut 140 is a long life water soluble fluid making it an ideal choice for moderate to heavy duty machining applications in the modern machine shop. It is formulated to provide long service life and good emulsion stability and durability while helping to increase tool life and surface finish, even in difficult machining operations. Mobilcut 140 is an ideal choice where excellent machining performance is required for a wide variety of materials and applications while being easy to monitor and maintain.

Mobilcut 230 is a high performance semi-synthetic fluid that readily emulsifies in water to form a stable micro-emulsion. The product is designed for a wide range of water qualities and is resistant to foaming, even in high pressure systems. Mobilcut 230 is suitable for a range of applications on both ferrous and non ferrous alloys making it an ideal choice when consolidating metal working fluids. The product offers extended coolant life relative to conventional soluble oils when properly maintained while maintaining a high degree of machining performance.

Mobilcut 250 is a high performance semi-synthetic fluid formulated to enhance performance when machining aluminum and aluminum alloys and where low staining potential is important on sensitive components. Containing high levels of lubricity agents, it provides high machining performance of carbon and alloy steels and yellow metals.

Mobilcut 320 is a bio stable mineral oil synthetic cutting fluid which provides excellent residual corrosion protection, non-sticky residues and excellent separability from Mobil Vactra Oil Numbered series. It is designed for general grinding operations where a high quality surface finish, outstanding cooling and low foaming potential are the primary requirements. It will help maintain free and open grinding wheels for maximum performance and shows a marked stability for long service life.

Mobilcut 350 is a high performance, bio stable, synthetic (mineral oil free) fluid with outstanding tramp oil rejection and low foam properties.

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	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

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 100: General machining of easy to machine steels and copper alloys in light to moderate duty machining operations such as milling, turning, sawing, boring, drilling and reaming.

Mobilcut 140: Machining of aluminum and high machinability steels in o moderate to heavy duty operations such as milling, turning, sawing, boring, drilling and reaming where the lubricity of a soluble oil is desired.

Mobilcut 230: High performance, semi synthetic cutting fluid, primarily recommended for machining steels, easier to machine stainless steels, and cast iron in milling, tuning, sawing, boring, drilling and reaming.

Mobilcut 250: Semi synthetic cutting fluid 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.

Mobilcut 320: Synthetic (mineral oil-free) fluid for grinding of steels and cast iron. Not suitable for Tungsten Carbide (Cobalt leaching).

Mobilcut 350: Synthetic (mineral oil-free) fluid for general cutting and grinding operations of ferrous materials from light to severe duty, designed for modern machining equipment and high surface finish.

Typical Properties

Mobilcut	100	140	230	250	320	350
Concentrate Appearance	Slight haze liquid	Amber liquid	Amber liquid	Dark amber liquid	Dark Green liquid	Clear amber liquid
Diluted Appearance	Milky	Milky	Translucent	Semi-translucent	Clear fluorescent green	Clear, transparent
Fluid Type	Soluble	Soluble	Semi-synthetic	Semi-synthetic	Synthetic	Synthetic
Mineral Oil Content (in concentrate)	85%	55%	50%	40%	0%	0%
Visc @ 40°C, cSt	32	59	54	70	5	17.5
pH	10 ⁽¹⁾	9 ⁽²⁾	9.3 ⁽³⁾	9.7 ⁽²⁾	9.4 ⁽³⁾	9.2 ⁽³⁾
Breakpoint, %v	2.7	3	3	3	2.5	3
Refractometer Correction Factor	1.0	1.485	1.474	1.483	1.414	1.9
Specific Gravity @ 20°C	0.881 ⁽⁴⁾	0.945	0.97	0.945	1.1	1.095
Pour Point, °C	-10	-42	-36	-45	-24	< 0

Notes:

⁽¹⁾ 10% in distilled water

⁽²⁾ 5% in distilled water

⁽³⁾ 3% in distilled water

⁽⁴⁾ 15.6°C

Health and Safety

Based on available information, this product is not expected to produce adverse effects on health when used for the intended application and the recommendations provided in the Material Safety Data Sheet (MSDS) are followed. MSDS's are available upon request through your sales contact office, or via the Internet. This product should not be used for purposes other than its intended use. If disposing of used product, take care to protect the environment.

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