

Product Data Sheet

Mobilcut 321 High Performance Synthetic Biostable Metalworking Fluid

Product Description

Mobilcut 321 is a fully biostable mineral oil free metalworking fluid specially formulated for high performance grinding and light duty machining.

Mobilcut 321 is a carefully balanced product designed to give excellent machining performance and long charge life.

Benefits

Mobilcut 321 offers the following benefits:

- Excellent performance in grinding operations
- Very low foam potential even when severely agitated in soft water
- Fully biostable for long charge life
- Leaves a soft highly mobile fluid residue on machine slides and fixtures
- Excellent separation from fines
- Outstanding resistance to corrosion even in high chloride water
- Free from nitrites, secondary amines and phenolic materials
- No adverse effect on machine tool paintwork

Applications

Mobilcut 321 is recommended for all grinding operations including form grinding.

It is also suitable for light duty machining of easy to machine ferrous materials and pressure testing of components.

Recommended Dilutions

Centreless Grinding	4 – 6%
Cylindrical & Surface Grinding	4 – 6%
Form Grinding	5 – 8%

Consult your local Mobil Area Sales Engineer for a precise concentration recommendation based on the application.

Storage

Mobilcut 321 concentrate must be stored in frost free conditions minimum temperature 5°C.

Health and Safety

Based on available toxicological information, it has been determined that this product poses no significant health risk when used and handled properly.

Details on handling, as well as health and safety information, can be found in the Material Safety Data Bulletin which can be obtained through Mobil Oil Company Ltd., by telephoning 01372 22 2000.

Typical physical characteristics are given in the table. These are intended as a guide to industry and are not necessarily manufacturing or marketing specifications.

Product Characteristics

Mobilcut 321

Appearance	Clear Green/Orange Fluid
Specific Gravity at 20°C	1.10
Solution Type	Green fluorescent solution
pH at 3% Emulsion	8.7 - 9.1
Corrosion Test (IP 287)	2% Break Point

Due to continual product research and development, the information contained herein is subject to change without notice

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