

## Product Description

The Mobilcut 200 Series are high performance, multi-purpose water soluble, semi-synthetic cutting fluids. They are formulated from high quality base oils, emulsifiers and additives to provide effective machining performance in a wide variety of operations. The higher oil content emulsion gives excellent cutting performance and outstanding machine tool lubrication and corrosion protection. They are designed for a range of light to moderate duty cutting operations (Mobilcut 222) to moderate to heavy duty machining (Mobilcut 232 and 242) on ferrous and non-ferrous metals.

The Mobilcut 200 Series are readily emulsifiable in water and form stable micro-emulsions. The products are engineered to be suitable for a wide range of water qualities and are resistant to foaming, even in high pressure systems. Mobilcut 200 Series emulsions can provide extended coolant life relative to conventional soluble oils, with proper cutting fluid maintenance.

The Mobilcut 200 Series are nitrite and chlorine free.

## Features and Benefits

The Mobilcut 200 Series of water soluble cutting fluids have gained a well-deserved reputation for outstanding performance over the years. They provide multi-functional machining and lubrication capabilities. Features and potential benefits of the Mobilcut 200 Series include:

Features	Advantages and Potential Benefits
Excellent machining capabilities	Increased production resulting from longer tool life and reduced downtime for tool changes and wheel dressing.
	Improved surface finish and dimensional accuracy resulting in fewer rejects and better quality finished parts.
	Increased productivity with potential increases in feed rates and machine speeds with no adverse effects on tool life or other factors.



Easy to monitor and maintain	Assures consistent and reliable performance
Wide application range	Product rationalization possibilities and potential for reduced inventory costs
Suitable for a wide range of water qualities	Multi-site, multi-seasonal application range
Excellent protection against rust and corrosion	Helps to prolong the life of machine tools and can provide short term protection for workpieces
Free of chlorine or nitrite	Reduces disposal costs and protects the environment
Low odor	Improved working conditions

## Applications

The Mobilcut 200 Series is recommended for a wide range of machining operations on metals of various hardnesses. They can be equally used on both ferrous and non-ferrous metals.

Mobilcut 222 is suitable for general purpose cutting and grinding. Mobilcut 232 is suitable for moderate to heavy duty machining. Mobilcut 242 is suitable for heavier duty operations and particularly for aluminium machining with low stain potential.

### Operations / Recommended Dilutions

	Mobilcut 222	Mobilcut 232	Mobilcut 242
Grinding (non-critical)	4-5%		
Turning, drilling, milling	4-8%	4-8%	
Heavy duty machining (ferrous)	6-8%	5-8%	4-7%
Tough aluminum machining		4-8%	5-8%

To obtain the best performance using Mobilcut 200 Series, it is recommended to clean and sterilise the machine by using Mobilcut ESC and then flush with diluted product.

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## Typical Properties

Grade	222	232	242
Concentrate			
Appearance	Amber Liquid	Amber Liquid	Green Liquid
Density @ 20C	0.99	0.967	0.973
Dilution			
Appearance @ 3%	Translucent	Semi - Translucent	Green Translucent
pH @ 3%	9.4 - 9.8	9.2 - 9.6	8.8 - 9.0
Cast Iron Corrosion, Breakpoint, %	2	2	2

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## 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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