



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 and corrosion performance and long service life.

Features and Benefits

Mobilcut 321 is an oil free product that helps to keep the grinding wheel free and open for maximum performance. Mobilcut 321 is designed for general grinding operations where high surface finish, cooling and low foam are primary requirements. Mobilcut 321 is formulated to provide long service life and on evaporation of water the residues are soft and mobile helping to keep the machine and sensitive instruments such as automatic micrometers clean and in good operating order.

Features	Advantages and Potential Benefits
Excellent performance in most grinding operations	Accurately produced components Reduced inventory of coolants
Very low foam potential even when severely agitated in soft water	Improved filtration of fines Improved visibility of workpiece Improved housekeeping
Fully biostable for long charge life.	Long service life Reduced bacterial activity Lower smell associated with bacteria
Leaves a soft highly mobile fluid residue on machine slides and fixtures.	Minimises sticky residues, which can cause sensitive measuring equipment to function incorrectly
Excellent separation from fines	Improved filterability Improved surface finish
Free from triazine biocides, nitrites, secondary amines and phenolic materials	Easier disposal Reduced health and safety risks Reduced rework of components
Outstanding resistance to corrosion	Minimises corrosion to components, machine and fixtures
Minimal effect on machine tool paint	Appearance of machine Reduced corrosion potential to machine

Applications

- Most grinding operations, light duty machining of easy to machine ferrous materials and pressure testing of components
- Recommended dilutions
- Centerless grinding 3 - 5%
- Cylindrical and surface grinding 2 - 4%
- Form grinding 5 -10%
- Consult your local ExxonMobil Area Engineer for a precise concentration recommendation based on the application

Typical Properties

Mobilcut 321

Appearance

Yellow

5/14/2015	Mobilcut 321
Appearance	Color
Break Point %	2.5
Solution Appearance	Clear colourless solution
pH	9.4
Specific Gravity @ 20 °C	1.10
Refractometer Factor	1.8

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 contract 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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ExxonMobil Lubricants Private Limited
4th Floor Building 10, Tower C, DLF Cyber City, Gurgaon, Haryana 122002 India

+91 124 6581 601
<http://www.exxonmobil.com>

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