

Chlorinated Paraffins Must Go

EPA plans to eliminate key ingredient in many honing oils and cutting fluids

Recently, the EPA announced plans to ban the production and sale of Chlorinated Paraffins effective May of 2016. Chlorinated Paraffins are the ZDDP of the metalworking fluid industry, and just like the reduction of ZDDP in motor oils caused many problems for engine builders and engine parts manufacturers alike, the complete elimination of Chlorinated Paraffins for honing oils and cutting fluids has the potential to cause many headaches.

Chlorinated Paraffins are very effective EP (extreme pressure) additives. The Chlorinated Paraffin reacts with the metal surface to prevent welding and scoring under extreme high pressures and loads. Thus, Chlorinated Paraffins are very effective in extending tool life and improving surface finishes in metal cutting and metal forming operations such as honing.

Popular honing oils like Sunnen MAN-845 contain Chlorinated Paraffins, so products like MAN-845 may not be available for sale this time next year unless the EPA grants a waiver or Sunnen reformulates the product.

Fortunately, many non-chlorinated products do exist. For example, Sunnen MB-30 is a non-chlorinated honing oil, so you do have options.

As you can see, this change imposed by the EPA will cause many shops and parts manufacturers to work through a “learning curve” while we all figure out how to get the surface finish and tool life we all expect without Chlorinated Paraffins.

To that end, now is the time to get started. Contact your honing and boring machine suppliers to see what combination of cutting tools and fluids they recommend in a non-chlorinated world. ■



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