



ATG Associated Tube Group

Designers and Manufacturers
of Specialty Engineered Products

A270 Sanitary Stainless Steel Tubing

For Dairy, Food, Beverage, and
Other Sanitary Applications.

Associated Tube's sanitary tube is ideal for the dairy, food and beverage industries where the highest degree of purity and cleanliness is essential. It is certified to the requirements of ASTM A270, 3A standards and most user specifications. Our tubing is manufactured from the finest quality raw materials made exclusively to Associated Tube melt parameters.

Our customers have come to rely on the quality of our sanitary tube products as well as our uncompromised commitment to total customer satisfaction.

We stock all sanitary tube sizes from 1/2" (12.7 mm) to 6" (150 mm) OD in 20 ft. standard lengths. Custom lengths and sizes are available upon request.

A DIVISION OF

 **SAMUEL MANU-TECH INC.**



A270 Sanitary Stainless Steel Tubing

Materials

T304L and T316L available from stock.
Other grades are available upon request.

Quality and Mechanical Tests

To assure the highest quality standards, our tubing is subjected to extensive testing and inspection programs that meet or exceed ASTM A270/A1016/A1016M test requirements. Testing includes reverse bend, reverse flattening, and flange tests. Eddy current testing is performed on 100% of the sanitary tube produced.

Annealing

Inline hydrogen bright annealing to 1900°F (1040° C) minimum followed with a rapid quench.

Surface Finishes

Surface finish is 20 μ-in Ra (0.5 μm) ID maximum, 30 μ-in Ra (0.8 μm) OD maximum surface roughness measured per ASME/ANSI B46.1 with the profilometer reading at 90 degrees to the lay. Other finishes available upon request.

Packaging

As a final step to ensure purity standards, each tube is packaged using 2 mil poly sleeving and both ends are sealed using air tight end caps. Tubes are packaged in protective tri-wall boxing. When specified, wood boxes and all export requirements can be provided.

Marking

Bright annealed tubing is line-stenciled with OD, wall, ASTM specifications, size, grade, heat number, production date and time. OD polished tube is marked on one end of each tube with a removable label stating ASTM specification, manufacturer, grade and heat number. Continuous line stencil available on request.

LaserTube® and LaserTube SST® are Registered Trademarks of Associated Tube USA Inc.



A Partner, Not Just a Supplier

Our goal is to build long-term relationships with our customers by working closely at every stage of the order – from the initial inquiry to on-time delivery of the exact product required.

Chemical Composition

Elements	304L (wt%)	316L (wt%)
(C) Carbon, max	0.035	0.035
(Mn) Manganese, max	2.00	2.00
(P) Phosphorus, max	0.040	0.040
(S) Sulfur, max	0.030	0.030
(Si) Silicon, max	0.75	0.75
(Ni) Nickel	8.0 – 13.0	10.0 – 15.0
(Cr) Chromium	18.0 – 20.0	16.0 – 18.0
(Mo) Molybdenum	N/A	2.0 – 3.0
(Fe) Iron	Balance	Balance

Dimensional Tolerance

OD Size	Nominal Wall	Outside Dia	Length	Wall
1/2" (12.7)	.065" (1.65)	+/- .005 (0.13)	+1/8" (3.18) -0	+/-10%
3/4" (19.1)	.065" (1.65)	+/- .005 (0.13)	+1/8" (3.18) -0	+/-10%
1" (25.4)	.065" (1.65) / .049 (1.25)	+/- .005 (0.13)	+1/8" (3.18) -0	+/-10%
1-1/2" (38.1)	.065" (1.65) / .049 (1.25)	+/- .008 (0.20)	+1/8" (3.18) -0	+/-10%
2" (63.5)	.065" (1.65) / .049 (1.25)	+/- .008 (0.20)	+1/8" (3.18) -0	+/-10%
2-1/2" (63.5)	.065" (1.65)	+/- .010 (0.25)	+1/8" (3.18) -0	+/-10%
3" (76.2)	.065" (1.65)	+/- .010 (0.25)	+1/8" (3.18) -0	+/-10%
4" (101.6)	.083" (2.11)	+/- .015 (0.38)	+1/8" (3.18) -0	+/-10%
6" (152.4)	.109" (2.77)	+/- .030 (0.76)	+3/16" (4.76) -0	+/-10%



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ISO 9001:2000 CERTIFIED

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