

**DMTV**  
STAINLESS

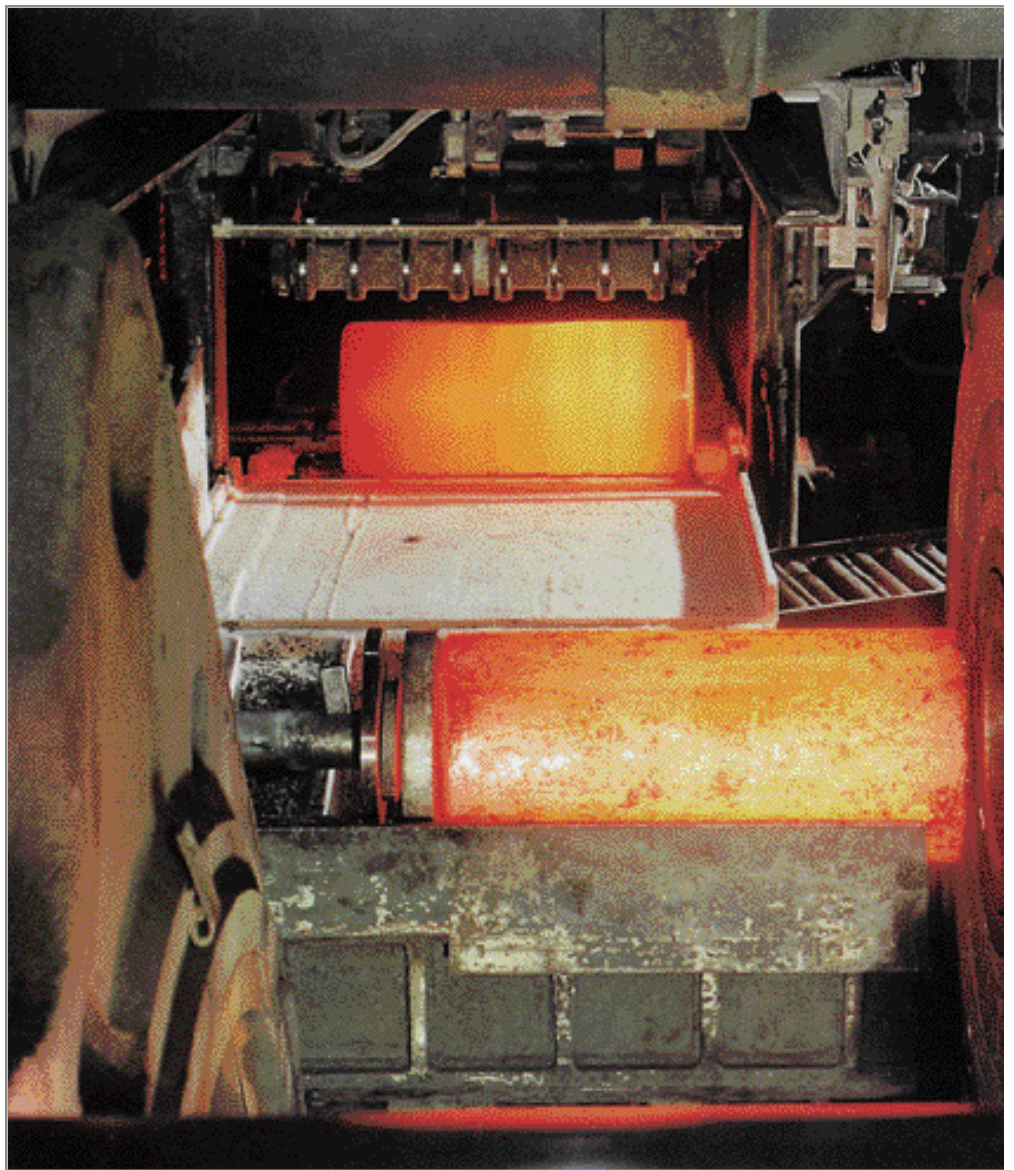


**Seamless Stainless  
Hollow Bar &  
Mechanical Tubing  
in Standard & VALIMA  
grades**





## Hollow Bar & Mechanical



# Tubing for the manufacturing industries

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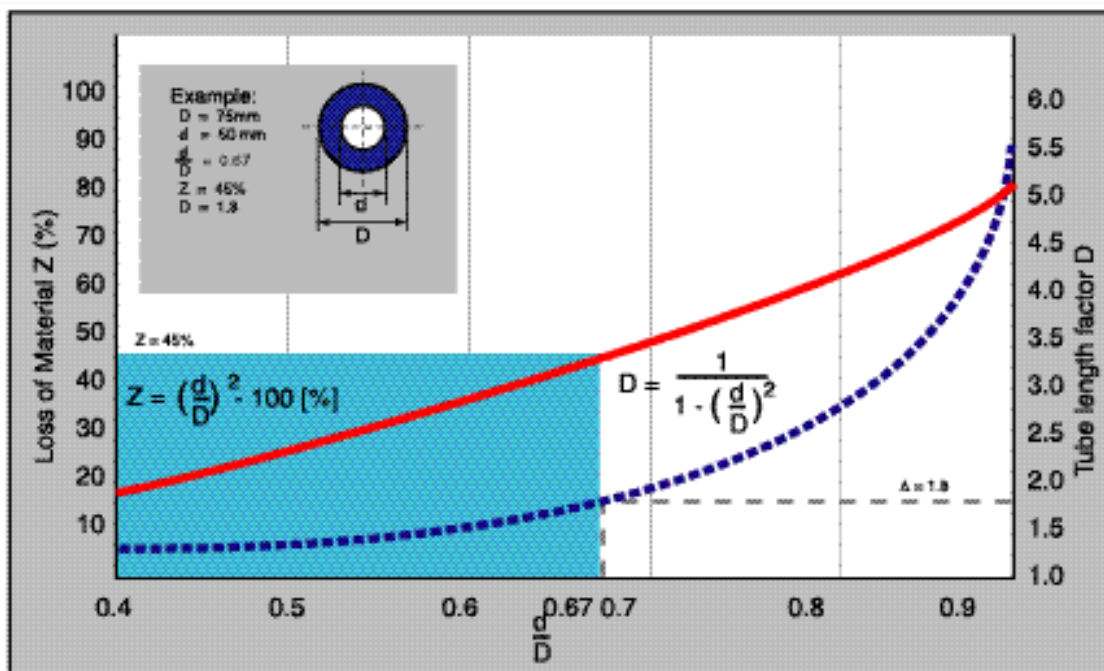
# Hollow Bar advantages for component manufacturing industries

Hollow Bar and Mechanical Tubing provide an economic and efficient means of supplying high quality raw material stock for the manufacture of radially machined components; the sensible alternative to the use of solid bar.

Hollow Bar minimizes material wastage and reduces the total machining requirements by avoiding the initial drilling operation.

Typical manufacturers that use stainless steel Hollow Bar to make components that are used in:-

- **general engineering**
- **chemical & petrochemical plants**
- **automotive production**
- **paper production plants**
- **textile production plants**
- **food production equipment**
- **anti-friction and slide bearing production**



## Typical material savings

The red line represents the loss of material 'Z' involved when turning a solid round into a Mechanical Tube. Here 45% of the solid round must be removed for this purpose. The dotted line illustrates the tube length factor 'D', which indicates the extra length available for the mechanical parts production as opposed to solid rounds of the same weight. The example shows a 1.8-fold tube length increase, which means that almost twice as many parts can be made from the tubular weight of material.

# Machining allowances & production tolerances

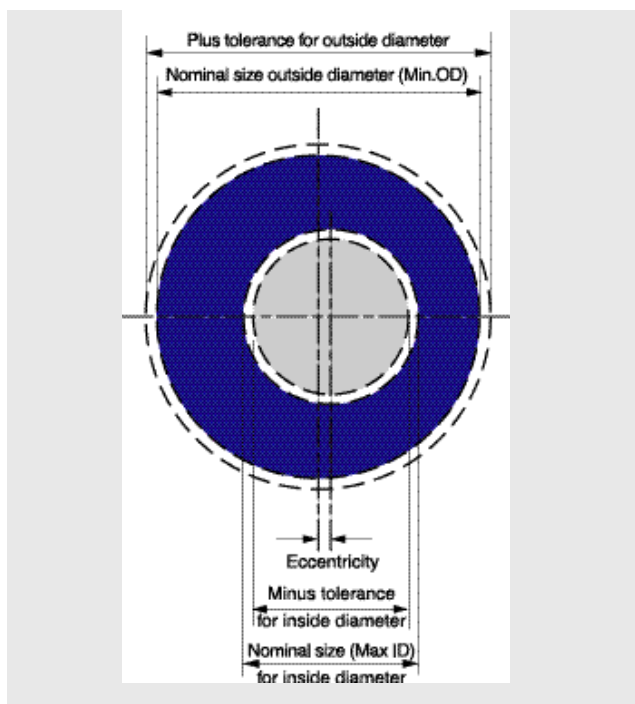
Hollow Bar is manufactured in the size ranges most frequently required by mechanical engineering manufacturing companies.

However, in the case of Hollow Bar, the tolerance range for the outside diameter lies in the plus range, and for the inside diameter in the minus range. The wall thickness tolerance is determined by the degree of centre offset; this is due to the effect of the tolerance for the outside and inside diameter, the wall thickness and the centre offset. (See diagram below.)

In the case of Mechanical Tubing to ASTM A 511, the outside diameter and the wall dimensions generally lie in the centre of the tolerance range. Thus, when ordering product for machining it is important to take into account the differences in the tolerances between the Hollow Bar and the ASTM A 511 Mechanical Tubing specifications.

In most cases the machining set up is based on centring the outside diameter.

## Standard Hollow Bar Tolerances



The diagram gives a general idea of the production related tolerances for Hollow Bar

Outside diameter range	Machining tolerances			
	For the outside diameter D	For the inside diameter d	For eccentricity (centre offset) E	For out-of-straightness h
32 D 250 mm	-0/+2% (min. 1mm)	+0/-2% (min. 1.5mm)	10%	1 mm/m

Outside diameter range	Machining allowances	
	For the outside diameter	For the inside diameter
32 D < 70 mm	1.0 mm	1.0 mm
70 D 132 mm	1.0 mm	1.0 mm
132 < D 200 mm	1.0 mm	2.0 mm
200 < D 250 mm	1.0 mm	2.0 mm

Note: The machining allowances are recommended minimum values and are related to short-length mechanical parts (L<2.5 x D, max. 250mm). Machining allowances for longer parts or special machining procedures can be customised. Machining allowances when ordering Mechanical Tubing to ASTM A 511 are different to those for Hollow Bar and are detailed on page 9.

# Hollow Bar – Standard sizes

Rough size and weight			Finish-turned sizes			
			Externally centred		Internally centred	
Nominal outside diameter mm	Nominal inside diameter mm	Theoretical weight kg/m	Max. outside diameter mm	Min. inside diameter mm	Max. outside diameter mm	Min. inside diameter mm
32	20	4.29	31.0	22.0	30.1	21.0
32	16	5.15	31.0	18.2	30.0	17.0
36	25	4.65	35.0	26.9	34.2	26.0
36	20	6.01	35.0	22.1	34.0	21.0
36	16	6.87	35.0	18.3	34.0	17.0
40	28	5.61	39.0	29.9	38.1	29.0
40	25	6.58	39.0	27.0	38.1	26.0
40	20	7.94	39.0	22.2	38.0	21.0
45	32	6.84	44.0	34.0	43.0	33.0
45	30	7.59	44.0	32.0	43.0	31.0
45	28	8.30	44.0	30.2	42.9	29.0
45	20	10.62	44.0	22.3	43.0	21.0
50	36	8.17	49.0	37.9	48.1	37.0
50	32	9.84	49.0	34.2	47.9	33.0
50	28	11.30	49.0	30.3	47.9	29.0
50	25	12.26	49.0	27.3	48.0	26.0
56	40	10.37	55.0	42.1	54.0	41.0
56	36	12.23	55.0	38.2	53.9	37.0
56	28	15.35	55.0	30.4	53.8	29.0
56	25	16.32	55.0	27.6	53.7	26.0
63	50	10.15	62.0	51.9	61.0	51.0
63	45	13.07	62.0	47.2	60.8	46.0
63	40	15.68	62.0	42.4	60.8	41.0
63	36	17.54	62.0	38.4	60.9	37.0
63	32	19.20	62.0	34.6	60.7	33.0
71	56	13.06	70.0	57.9	69.0	57.0
71	45	19.90	70.0	47.3	68.9	46.0
71	36	24.37	70.0	38.6	68.7	37.0
75	60	13.92	74.0	61.9	73.0	61.0
75	50	20.70	74.0	52.2	72.9	51.0
75	40	26.23	74.0	42.6	72.7	41.0
80	63	16.58	79.0	65.1	77.9	64.0
80	50	25.64	79.0	52.5	77.7	51.0
80	45	28.57	79.0	47.6	77.7	46.0
80	40	31.18	79.0	42.9	77.5	41.0
85	45	33.83	84.0	47.8	82.5	46.0
90	71	20.80	89.0	73.0	88.0	72.0
90	63	27.42	89.0	65.2	87.8	64.0
90	56	32.56	89.0	58.7	87.6	57.0
90	50	36.48	89.0	52.8	87.5	51.0

# Hollow Bar – Standard sizes

Rough size and weight			Finish-turned sizes			
			Externally centred		Internally centred	
Nominal outside diameter mm	Nominal inside diameter mm	Theoretical weight kg/m	Max. outside diameter mm	Min. inside diameter mm	Max. outside diameter mm	Min. inside diameter mm
95	75	23.08	94.0	77.0	92.9	76.0
95	67	30.11	94.0	69.3	92.8	68.0
95	50	42.38	94.0	53.1	92.4	51.0
100	80	24.55	99.0	82.0	97.9	81.0
100	71	32.91	99.0	73.3	97.8	72.0
100	63	39.54	99.0	65.6	97.6	64.0
100	56	44.68	99.0	59.0	97.4	57.0
106	90	22.02	105.0	91.9	103.9	91.0
106	80	32.43	105.0	82.1	103.9	81.0
106	71	40.79	105.0	73.5	103.7	72.0
106	63	47.42	105.0	65.9	103.4	64.0
106	56	52.56	105.0	59.3	103.2	57.0
112	90	30.36	111.0	92.1	109.8	91.0
112	80	40.77	111.0	82.5	109.6	81.0
112	71	49.13	111.0	73.8	109.5	72.0
112	63	55.76	111.0	66.2	109.2	64.0
118	90	39.16	117.0	92.2	115.8	91.0
118	80	49.57	117.0	82.6	115.6	81.0
118	71	57.93	117.0	74.1	115.3	72.0
118	63	64.56	117.0	66.5	115.0	64.0
125	100	38.36	124.0	102.0	122.9	101.0
125	90	50.00	124.0	92.4	122.7	91.0
125	80	60.42	124.0	82.9	122.3	81.0
125	71	68.78	124.0	74.4	122.0	72.0
132	106	42.26	131.0	108.0	129.8	107.0
132	90	61.47	131.0	92.7	129.4	91.0
132	80	71.88	131.0	83.3	129.1	81.0
132	71	80.24	131.0	74.8	128.8	72.0
140	112	48.12	139.0	114.1	137.8	113.0
140	100	63.71	139.0	102.6	137.5	101.0
140	90	75.34	139.0	93.2	137.1	91.0
140	80	85.76	139.0	83.7	136.8	81.0
150	125	47.74	149.0	126.9	147.9	126.0
150	112	66.61	149.0	114.5	147.6	113.0
150	106	74.62	149.0	108.8	147.3	107.0
150	95	88.17	149.0	98.4	147.0	96.0
150	80	104.25	149.0	84.2	146.4	81.0
160	132	56.48	159.0	134.0	157.7	133.0
160	122	72.04	159.0	124.4	157.5	123.0
160	112	86.38	159.0	115.0	157.2	113.0
160	90	113.60	159.0	94.2	156.4	91.0

# Hollow Bar – Standard sizes

Rough size and weight			Finish-turned sizes			
Nominal outside diameter mm	Nominal inside diameter mm	Theoretical weight kg/m	Externally centred		Internally centred	
			Max. outside diameter mm	Min. inside diameter mm	Max. outside diameter mm	Min. inside diameter mm
170	140	64.19	169.0	143.1	167.6	142.0
170	130	80.73	169.0	132.5	167.5	131.0
170	118	98.96	169.0	121.1	167.1	119.0
170	106	115.43	169.0	109.8	166.6	107.0
170	100	123.00	169.0	104.1	166.4	101.0
180	150	68.74	179.0	153.1	177.6	152.0
180	140	86.51	179.0	143.4	177.5	142.0
180	130	103.05	179.0	133.0	177.1	131.0
180	125	110.86	179.0	128.3	176.9	126.0
180	100	145.31	179.0	104.6	176.1	101.0
190	160	73.34	189.0	163.0	187.6	162.0
190	150	92.33	189.0	153.4	187.4	152.0
190	140	110.10	189.0	143.9	187.1	142.0
190	132	123.43	189.0	135.4	186.8	133.0
190	106	161.33	189.0	110.8	185.9	107.0
200	170	77.99	199.0	173.0	197.6	172.0
200	160	98.21	199.0	163.4	197.4	162.0
200	150	117.20	199.0	153.9	197.1	152.0
200	140	134.96	199.0	144.5	196.7	142.0
200	112	178.19	199.0	117.0	195.8	113.0
212	180	88.08	211.0	183.1	209.5	182.0
212	170	109.52	211.0	173.4	209.4	172.0
212	130	183.02	211.0	134.6	208.0	131.0
224	180	121.43	223.0	183.5	221.3	182.0
224	170	142.87	223.0	174.0	220.9	172.0
224	160	163.09	223.0	164.6	220.6	162.0
224	140	199.84	223.0	145.7	219.9	142.0
236	190	133.96	235.0	193.5	233.2	192.0
236	170	178.07	235.0	174.6	232.5	172.0
236	150	217.27	235.0	155.7	231.8	152.0
240	170	190.21	239.0	174.8	236.4	172.0
250	200	153.45	249.0	203.7	247.0	202.0

Standard sizes - Other dimensions can be supplied on agreement.

All the above dimensions, including the tables on pages 6 & 7, are for maximum length  $L < 2.5 \times D$ , max. 250mm.

# Mechanical Tubing to ASTM A 511

## Standard sizes

Outside diameter inches	Wall thickness inches	Outside diameter mm	Wall thickness mm	Outside diameter inches	Wall thickness inches	Outside diameter mm	Wall thickness mm
2.00	0.188 to 0.500	50.80	4.78 to 12.70	6.00	0.250 to 1.000	152.40	6.35 to 25.40
2.25	0.188 to 0.750	57.15	4.78 to 19.05	6.25	0.250 to 1.500	158.75	6.35 to 38.10
2.50	0.188 to 0.750	63.50	4.78 to 19.05	6.50	0.250 to 1.500	165.10	6.35 to 38.10
2.75	0.188 to 0.875	69.85	4.78 to 22.23	6.75	0.375 to 1.500	171.45	9.53 to 38.10
3.00	0.188 to 0.875	76.20	4.78 to 22.23	7.00	0.375 to 1.500	177.80	9.53 to 38.10
3.12	0.188 to 0.875	79.38	4.78 to 22.23	7.25	0.375 to 1.500	184.15	9.53 to 38.10
3.25	0.188 to 0.875	82.55	4.78 to 22.23	7.50	0.375 to 1.500	190.50	9.53 to 38.10
3.50	0.188 to 0.875	88.90	4.78 to 22.23	7.75	0.375 to 1.500	196.85	9.53 to 38.10
3.75	0.250 to 0.875	95.25	6.35 to 22.23	8.00	0.375 to 1.500	203.20	9.53 to 38.10
4.00	0.250 to 0.875	101.60	6.35 to 22.23	8.25	0.375 to 1.500	209.55	9.53 to 38.10
4.25	0.250 to 1.000	107.95	6.35 to 25.40	8.50	0.375 to 1.500	215.90	9.53 to 38.10
4.50	0.250 to 1.000	114.30	6.35 to 25.40	8.75	0.500 to 1.500	222.25	12.70 to 38.10
4.75	0.250 to 1.000	120.65	6.35 to 25.40	9.00	0.500 to 1.500	228.60	12.70 to 38.10
5.00	0.250 to 1.000	127.00	6.35 to 25.40	9.25	0.750 to 1.500	234.95	19.05 to 38.10
5.25	0.250 to 1.000	133.35	6.35 to 25.40	9.50	0.750 to 1.500	241.30	19.05 to 38.10
5.50	0.250 to 1.000	139.70	6.35 to 25.40	9.75	0.875 to 1.500	247.65	22.23 to 38.10
5.75	0.250 to 1.000	146.05	6.35 to 25.40				

## Production tolerances

Permissible manufacturing tolerances for outside diameter, wall thickness and cut lengths for hot finished round tubing per ASTM A 511

Outside diameter, in.	Ratio of wall thickness to outside diameter	Outside diameter tolerance, in.	Wall thickness tolerance, %				Cut length, in.*
			0.109" and under	0.109" to 0.172" incl.	Over 0.172" to 0.203" incl.	Over 0.203"	
Under 3	All wall thicknesses	+/- 0.023	+/- 16.5 %	+/- 15 %	+/- 14 %	+/- 12.5 %	3/16
3 to 5 1/2 excl.	All wall thicknesses	+/- 0.031	+/- 16.5 %	+/- 15 %	+/- 14 %	+/- 12.5 %	3/16
5 1/2 to 8 excl.	All wall thicknesses	+/- 0.047				+/- 12.5 %	3/16
8 to 9 3/4 incl.	5% and over	+/- 0.047 **				+/- 12.5 %	3/16

\* These tolerances apply to cut lengths up to and including 24ft (7.3m). For lengths over 24ft, and additional over tolerance of 1/8" (3.1mm) for each 10ft (3m) or fraction thereof shall be permissible, up to a max. tolerance of 1/2" (12.7mm).

\*\* DMV manufacturing tolerance for these dimensions is +/- 1%.

# Materials

## Standard grades

Hollow Bar and Mechanical Tubing are supplied in a range of specially selected stainless and acid-resistant standard grades chosen to cover the majority of the corrosion and processing problems that occur in day to day practice.



DMV Designation	USA			France		Germany			Others	
	UNS	Designation (grade)	Standard ASTM	Designation	Standard NF	Material No.	Designation DIN	Standard DIN	Standard (SS)	Standard (BS)
DMV 304	S 30400	MT304 (TP 304)	A 511 (A 312)	Z6CN18.09	A49-117	1.4301	X5CrNi18.10	17456 (17458)	2333	304 S 15
DMV 304 L	S 30403	MT304L (TP 304L)	A 511 (A 312)	Z2CN18.10	A49-317 (A49-117)	1.4306	X2CrNi19.11	17456 (17458)	2352	304 S 11
DMV 316	S 31600	MT316 (TP 316)	A 511 (A 312)	Z6CND17.11	(A49-117)	1.4401	X5CrNiMo17.12.2	17456 (17458)		316 S 31
DMV 316 L	S 31603	MT316L (TP 316L)	A 511 (A 312)	Z2CND17.12	A49-317 (A49-117)	1.4404	X2CrNiMo17.13.2	17456 (17458)		316 S 11
DMV 316 L Mos						1.4435	X2CrNiMo18.14.3	17456 (17458)	2353	316 S 13
DMV 321	S 32100	MT321 (TP 321)	A 511 (A 312)	Z6CNT18.10	(A49-117)	1.4541	X6CrNiTi18.10	17456 (17458)	2337	321 S 31
DMV 316 Ti		TP 316 Ti		Z6CNDT17.12	(A49-117)	1.4571	X6CrNiMoTi17.12.2	17456 (17458)	2350	
DMV 22.5	S 31803					1.4462	X2CrNiMoN22.5.3 (SEW400)			
DMV 26.4	(S 32900)	AISI 329	(A 790)			1.4460	X3CrNiMo25.7.2		2324	

(...) Grade designation and/or Standard not specific for Hollow Bars.

# VALIMA Grades

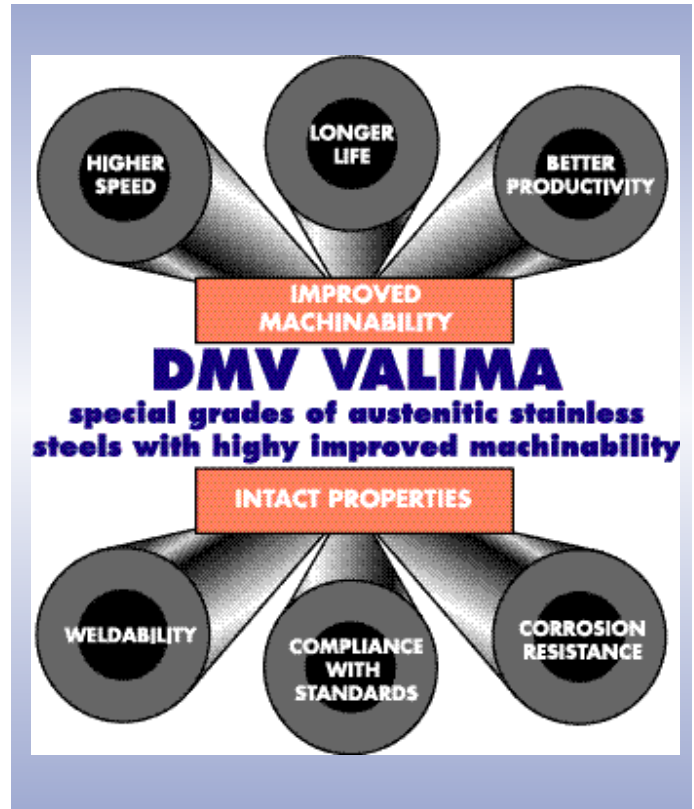
... special stainless grades that offer enhanced machining characteristics

In VALIMA materials you have a versatile product.

VALIMA grades offer better machining properties. This is the result of a combination of the melting-method and a specific extrusion process.

- The inclusion of low melting point malleable oxides play a significant role of self-lubricating the metal-tool interface.
- A narrow range of sulphur content.
- The elimination of hard and abrasive inclusions.

Machining VALIMA hollows at high speed with carbide tools offers a surprisingly good finishing performance because of the easy break-up of chips and cuttings which also results in the reduction of cutting edge tool-tip wear.

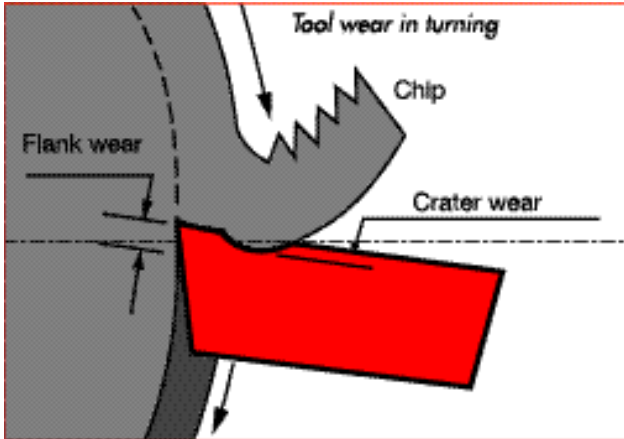


VALIMA Designation	DMV Designation	USA			France		Germany			Others	
		UNS	Designation (grade)	Standard ASTM	Designation	Standard NF	Material No.	Designation DIN	Standard DIN	Standard (SS)	Standard (BS)
VALIMA 304	DMV 304 MC	S 30400	MT 304 (TP 304)	A 511 (A 312)	Z6CN18.09	(A49-117)	1.4301	X5CrNi18.10	17456 (17458)	2333	304 S 15
VALIMA 304 L	DMV 304 LMC	S 30403	MT 304L (TP 304L)	A 511 (A 312)	Z2CN18.10	A49-317 (A49-117)	1.4306	X2CrNi19.11	17456 (17458)	2352	304 S 11
VALIMA 316	DMV 316 MC	S 31600	MT 316 (TP 316)	A 511 (A 312)	Z6CND17.11	(A49-117)	1.4401	X5CrNiMo17.12.2	17456 (17458)		316 S 31
VALIMA 316 L	DMV 316 LMC	S 31603	MT 316L (TP 316L)	A 511 (A 312)	Z2CND17.12	A49-317 (A49-117)	1.4404	X2CrNiMo17.13.2	17456 (17458)		316 S 11
VALIMA 4435	DMV 316 L Mos*MC						1.4435	X2CrNiMo18.14.3	17456 (17458)	2353	316 S 13
VALIMA 329	DMV 26.4 MC	(S32900)	(TP 329)	(A 790)			1.4460	X3CrNiMoN25.7.2		2324	

(...) Grade designation and /or Standard not specific for Hollow Bars.

\* DMV 316L with 2.5 - 3% Mo.

## VALIMA machining characteristics



### High speed machining

Higher cutting speeds lead to improved productivity. VALIMA Hollow Bars can be machined at speeds 50% higher than that for standard materials. Higher speeds also lead to easier chip break-up.

### Longer tool life

Often machining ordinary austenitic stainless steels, results in rapid tool wear and even cutting tool failure that leads to long uneconomic and unwanted downtimes. Machining of VALIMA products have shown that, with optimum tool setting, a 40-80 per cent increase in tool life can be expected.

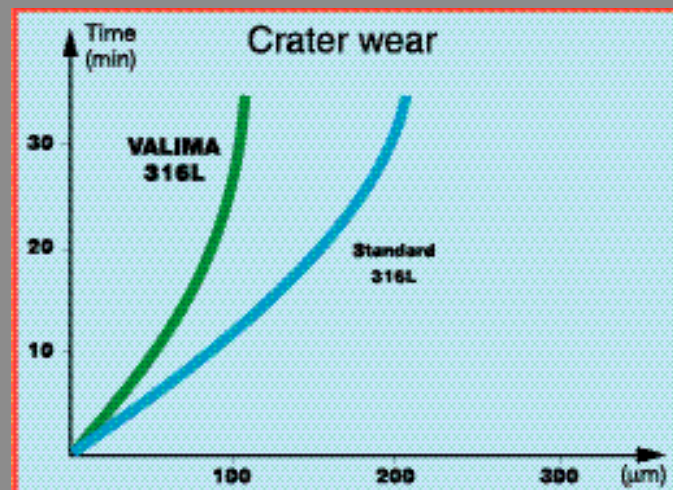
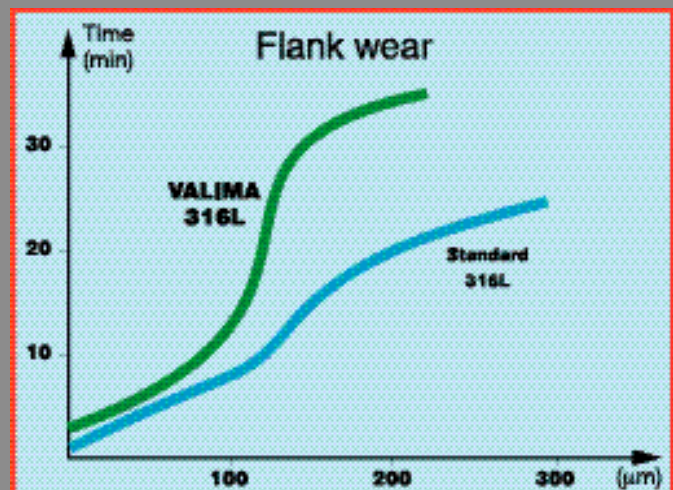
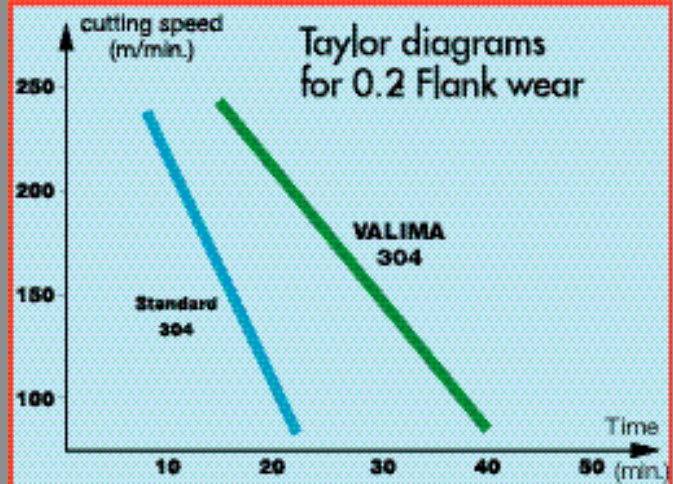
### Product consistency

The consistency of the VALIMA products, and their machining characteristics, enables cutting speed to be reliably increased while extending the tool life and reducing maintenance downtime, thus producing significant improvements in productivity.

Industrial experience has proven that in many cases modified tool setting has resulted in a 30 per cent gain in productivity.

### Problem solving

DMV has a policy of constantly seeking to improve its product lines. Should you encounter any particular problems in the use of VALIMA products, our technical specialists are always available to provide specific technical or metallurgical solutions.





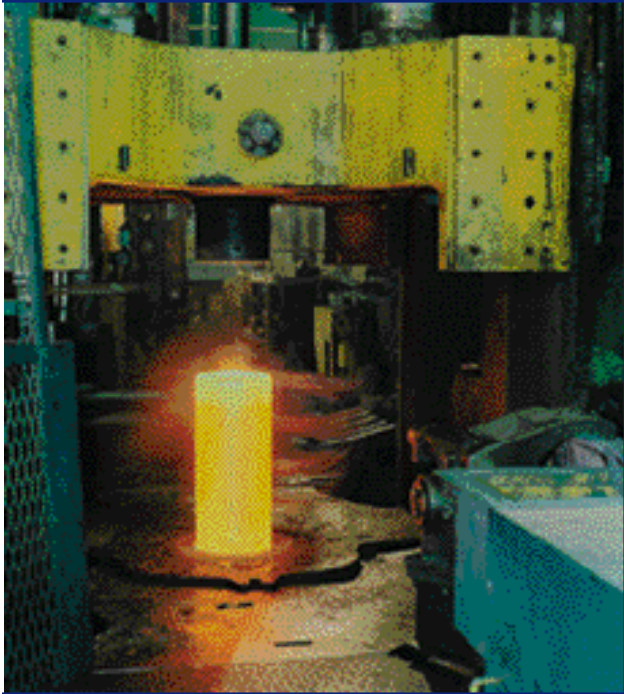
## VALIMA recommended cutting criteria

Based upon our laboratory and industrial experience of the Valima material grades, it is recommended that the following enhanced cutting criteria can be successfully employed when carrying out drilling, turning, threading or milling operations.

Automatic machining (single-point turning)	Cutting speed m/mm with:		Depth of cut mm	Feed mm/t	Carbide insert ISO
	Plain carbide	Coated carbide			
VALIMA 304L	120	170	2	0.1	M 10 - M 20
VALIMA 316L	95	140	2	0.1	M 10 - M 21
CNC Turning	Cutting speed m/mm with:		Depth of cut mm	Feed mm/t	Carbide insert ISO
	Plain carbide	Coated carbide			
VALIMA 304L	150	200	3	0.4	P10 - P20 - P25
VALIMA 316L	120	160	3	0.4	P10 - P20 - P25
Turning	Cutting speed m/mm with:		Depth of cut mm	Feed mm/t	Carbide insert ISO
	Plain carbide	Coated carbide			
TP 304L	115	150	3	0.4	
TP 316L	90	125	3	0.4	

*The above figures should be compared with those in the "Machining Data Handbook", 3rd edition. Cutting conditions for a tool life of 30 mn (plain carbide) or 15 mn (coated carbide).*

# DMV Quality management



## Quality assurance

All DMV Hollow Bar or Mechanical Tubes are produced in accordance with DMV's strict manufacturing procedures. DMV's facilities and manufacturing procedures have received ISO 9001/9002 certification.

## Material testing certificates

The type of test certificate required must be agreed upon when ordering.

Compliance of the chemical analysis with the delivery specification and, if required, the typical characteristics can be certified in a test report 2.2 according to EN 10204.

Results from tests carried out on the order lot are certified in an inspection certificate 3.1.B according to EN 10204.

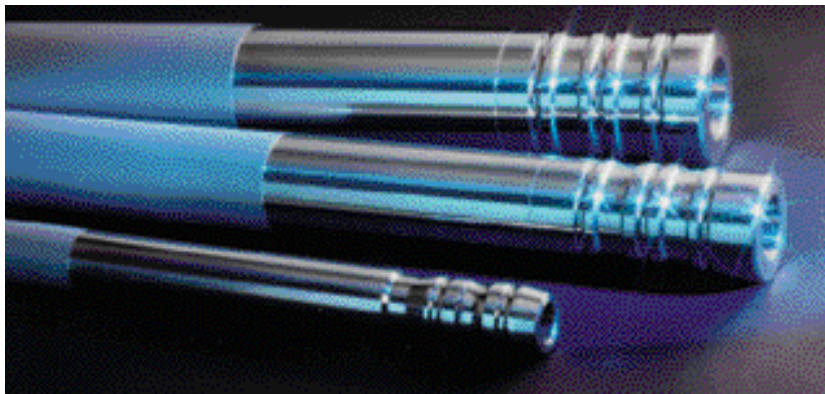
All test results other than tensile test results can also be documented in a specified test report 2.3 according to EN 10204.

## Marking

Unless otherwise agreed, tubes are externally marked with the manufacturer's name and the material designation.

Tubes subject to acceptance inspection are additionally marked with the inspector's stamp and, where applicable, with a stamp verifying that ultrasonic testing has been carried out.

Other or additional marking methods can be agreed with DMV, when placing your order.



## Materials testing certificates criteria

Delivery conditions	Basis, contents		Type of document	Document validated by
In accordance with the specifications of the order, and if required, also in accordance with official regulations and the corresponding technical rules	Manufacturing expertise	Without test results	Certificate of compliance with the order 2.1 according to EN 10204	The manufacturer
		With results of routine in-plant tests	Test report 2.2 according to EN 10204	
In accordance with the specifications of the order, and if required, also in accordance with official regulations and the corresponding technical rules	Results of tests on delivered lots e.g.: - chemical analysis - hardness - hardenability		Specific test report 2.3 according to EN10204	The manufacturer
In accordance with official regulations and the corresponding technical rules	Results of tests on delivered lots or specified test units, e.g.: - chemical analysis - mechanical properties - impact energy - hardness - hardenability		Inspection certificate 3.1.A according to EN 10204	The inspector designated in the official regulations
In accordance with the specifications of the order, and if required, also in accordance with official regulations and the corresponding technical rules			Inspection certificate 3.1.B according to EN 10204	The manufacturer's authorised representative independent of the manufacturing department
In accordance with the specifications of the order.			Inspection certificate 3.1.C according to EN 10204	The purchaser's authorised representative

### PLEASE TAKE NOTE:

Whilst every care has been taken in compiling the technical data in this brochure, it is given for information only, due to continuous material development and complex nature of the various factors used. DMV Stainless cannot be held responsible for the information contained herein and our customers should carefully check for themselves, where necessary, when making an appropriate selection; bearing in mind the conditions governing the fabrication of our alloys as well as the conditions in service.

Information contained in this brochure can be changed without notice.



DMV Stainless was incorporated in 1994 through the integration of the seamless stainless steel and nickel alloy tubular business of three well-established European corporations from Italy, Germany and France...

**D**almine, **M**annesmann and **V**allourec.

The objective of this consolidation was to establish the world's most comprehensive and flexible supplier of quality seamless stainless steel and nickel alloy pipes and tubes.

With facilities in France, Germany, Italy and the United States, DMV is in an excellent position to provide customer support on a global basis.

Through the rationalisation and optimization of the plants, techniques, facilities and personnel, DMV STAINLESS has become synonymous with the concept ...

**'Diversity is our Strength'.**

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