Medical

High Specification Tubing Solutions for Critical Medical Applications
TUBING EXCELLENCE

With over 70 years of engineering expertise in supplying high precision tubes, Fine Tubes and Superior Tube work closely with customers worldwide, developing high specification tubing solutions to help them solve their technical challenges. We manufacture high performance tubes for supercritical medical applications in an ever expanding range of stainless steel, titanium and other specialty alloys.

TUBING INNOVATIONS

Fine Tubes and Superior Tube benefit from a world-class reputation for innovative and high quality tubing solutions geared towards the medical industry. Here are a few examples:

1936 Superior Tube manufactures hypodermic needle tubing for critical medical instruments including catheters and cystoscopies.


1980 Superior Tube produces precision needle tubing for the "Radiation Implanter" - a medical device for the treatment of cancerous tumours.

1997 Superior Tube receives its first order for advanced L605 (cobalt-chromium) alloy tubing related to coronary stents.

2002 Fine Tubes develops profiled implant tubing for medical applications.

2003 Superior Tube's proprietary tube rolling process is used to produce titanium alloy tubing for artificial heart valve frames.

2004 Fine Tubes manufactures Ti 6Al-4V (Grade 5) tubing for femur and tibia bone nail implants.

2009 Superior Tube receives an award for its role in the development and market introduction of innovative transaortic valve replacements.
For over seven decades, design engineers have been relying on Fine Tubes and Superior Tube, two of the medical industry’s most technologically advanced manufacturers of highly engineered, small-diameter, precision alloy tubing. The demand for high performance stainless steel and titanium alloys that can offer excellent strength-to-weight ratios is constantly increasing. This, in combination with high levels of microbiological corrosion resistance and fatigue life properties, is the challenge that has been exceeded by our biocompatible medical materials.

We have the technical capability to achieve an OD surface finish down to 0.4μ m (16μ in) Ra or better with centre-less grinding and an ID surface finish down to 0.2μ m (8μ in) Ra or better with electropolishing. From advanced alloy precision tubing development to every day inventory management challenges, we’re ready to partner with you to help develop solutions for your unique requirements.

**MEDICAL APPLICATIONS:**
- Angioplasty and embolism
- Auto injection systems
- Biopsy needles
- Catheters
- Cannulas
- Cardiac electrodes
- Cardiac rhythm management
- Coronary and peripheral stents
- Dental implants
- Drug delivery
- Endoscopy equipment and instruments
- Heart valves
- Lag screws
- Neuromodulation devices
- Nuclear medicine
- Peripheral stents
- Spinal cages and screws
- Surgical implants
- Surgical instruments and tools
- Trauma nails and screws
- Trauma and orthopedic implants
MANUFACTURING CAPABILITIES

ALLOYS

Fine Tubes and Superior Tube produce a wide range of custom-sized tubing in an ever expanding range of alloys – available in three different forms, i.e. seamless, welded or welded & redrawn (Weldrawn™) finish.

<table>
<thead>
<tr>
<th>SEAMLESS, WELDED, WELDED &amp; REDRAWN</th>
</tr>
</thead>
<tbody>
<tr>
<td>Stainless Steel</td>
</tr>
<tr>
<td>304L, 316L, 316LVM, 15-5PH, 17-4PH, 17-7PH</td>
</tr>
<tr>
<td>Titanium</td>
</tr>
<tr>
<td>Ti CP (Grade 1 and Grade 2), Ti 3Al-2.5V (Grade 9), Ti 6Al-4V (Grade 5), Ti 6Al-4V ELI (Grade 23)</td>
</tr>
<tr>
<td>Specialty</td>
</tr>
<tr>
<td>35NLT, L605, MP35N™, Nitronic 50™, Tantalum</td>
</tr>
</tbody>
</table>

We also manufacture tubing in many other grades. Please contact us for more details.

SIZE RANGE

Size range for medical products is based upon manufacture of cold drawn tubing from 0.30 mm (0.012 in) to 50.8 mm (2 in) OD. Tolerances: OD and ID up to 0.0127 mm (0.0005 in) are achievable.

PRODUCTION FACILITIES

- Pilger mills
- Multi-roll rolling mills
- Draw benches
- Tube welding mills - In-line weld mills
- Controlled atmosphere heat treatment
- Bright annealing/hydrogen furnace
- Vacuum annealing
- Pickling & passivation plant
- NDT ultrasonic & eddy current testing
- Hydrostatic testing
- Radiographic examination
- Electropolishing capabilities
- Full chemical and physical laboratory analysis
### Supercritical Tubing • Grade Chart

#### Medical

For further details on our grades visit: www.finetubes.co.uk/products/tube-grades  www.supertioutube.com/products/our-grades

<table>
<thead>
<tr>
<th>Alloy Group</th>
<th>UNS No.</th>
<th>WNR</th>
<th>Chemical Analysis %</th>
<th>Density</th>
<th>Tensile Rm (min)</th>
<th>Yield Rp 0.2% (min)</th>
<th>Elong. %</th>
<th>Hardness HV</th>
<th>Properties</th>
</tr>
</thead>
<tbody>
<tr>
<td>Stainless Steel</td>
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<td></td>
<td></td>
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<td></td>
<td></td>
</tr>
<tr>
<td>304L S30403</td>
<td>1.4306</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Lower carbon of 304 with good weldability.</td>
</tr>
<tr>
<td>316L S31603</td>
<td>1.4404</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Standard AOD melt austenitic stainless steel grade.</td>
</tr>
<tr>
<td>316LVM S31673</td>
<td>1.4441</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Vacuum remelt or ESR to achieve highest microcleanliness levels and structural homogeneity.</td>
</tr>
<tr>
<td>15-5PH S15500</td>
<td>1.4545</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Precipitation hardening grade often used for surgical instruments.</td>
</tr>
<tr>
<td>17-4PH S17400</td>
<td>1.4542</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Capable of developing high mechanical properties by solution treatment and age hardening.</td>
</tr>
<tr>
<td>17-7 PH S17700</td>
<td>1.4568</td>
<td></td>
<td></td>
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<td></td>
<td></td>
<td></td>
<td></td>
<td>Capable of developing high mechanical properties by solution treatment &amp; age hardening.</td>
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<tr>
<td>3SNIT R30035</td>
<td>2.4999</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Lower titanium than MP35N for improved fatigue life.</td>
</tr>
<tr>
<td>L60S R30060</td>
<td>2.4964</td>
<td></td>
<td></td>
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<td></td>
<td></td>
<td>Cobalt chrome alloy ideal for implantable applications.</td>
</tr>
<tr>
<td>MP35N™ R30035</td>
<td>3.6583</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Nickel cobalt alloy with very high strength, toughness and outstanding corrosion resistance.</td>
</tr>
<tr>
<td>Nitronic 50™ S20910</td>
<td>1.3964</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Nitrogen strengthened austenitic grade with exceptional strength in the cold-worked condition.</td>
</tr>
<tr>
<td>Tantalum R05200</td>
<td>3.7025</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Commercia;ly pure tantalum.</td>
</tr>
<tr>
<td><strong>Stainless Steel</strong></td>
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<td></td>
<td></td>
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<td></td>
<td></td>
<td></td>
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<tr>
<td><strong>Specialty</strong></td>
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<td></td>
<td></td>
</tr>
<tr>
<td><strong>Titanium</strong></td>
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<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>CPGrade 1 R50250</td>
<td>3.7025</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>The most ductile and softest titanium alloy. A good solution for cold forming and corrosive environments.</td>
</tr>
<tr>
<td>CPGrade 2 R50400</td>
<td>3.7035</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Very high strength-to-weight ratio combined with excellent corrosion resistance.</td>
</tr>
<tr>
<td>Ti 3AL 2.5 V Grade 9 R56320</td>
<td>3.7194</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Cold worked 75 to 85% to result in moderately high strength and good ductility. Weldability on par with commercially pure grades and excellent torsion and corrosion resistance.</td>
</tr>
<tr>
<td>Ti 6Al4V Grade 5 R56400</td>
<td>3.7165</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Stronger than commercially pure titanium with the same stiffness and thermal properties excluding thermal conductivity. Excellent combination of corrosion resistance, weld and fabricability.</td>
</tr>
<tr>
<td>Ti 6Al4V Grade 23 EU R56401</td>
<td>3.7165</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Improved ductility and fracture toughness with some reduction in strength.</td>
</tr>
</tbody>
</table>
TUBING QUALITY

INTEGRITY ASSURANCE

The quality control process at Fine Tubes and Superior Tubes is critical in respect of consistently achieving the highest level of specification requirements. Reduction control through pilgering and drawing is specific to each product dimension and specification requirements. This is the driver for tolerance control, OD and ID surface finish control, inclusion levels and final grain size.

- OD surface roughness typically better than 0.75μ m (30μ in) Ra.
- ID surface roughness typically better than 1.5μ m (59μ in) Ra.

Rigorous process control ensures that grain sizes typically achieve levels finer than ASTM 8 per ASTM E112. Testing capabilities include non-destructive ultrasonic, eddy current and hydrostatic testing.

TUBE ADVANTAGES

High levels of ID and OD surface finish, tolerance and ovality controls yield a product which is a cost competitive alternative to the gun drilled technology. At the same time, it can offer additional benefits of consistency and small inside diameters over typical lengths of 3 m (10 ft).

- OD surface roughness can be further refined by centre-less grinding down to 0.4μ m (16μ in) Ra or better.
- ID surface roughness can be further refined by drawing down to 0.4μ m (16μ in), then electro-polished to achieve 0.2μ m (8μ in) Ra or better.

ID defect levels: UT tested to levels down to 50 microns (0.05 mm/0.0020 in).
Fatigue life: Control of texture combined with extra low levels of interstitial impurities leads to higher fatigue performance than equivalent drilled bars.
Tolerances: In-house control to ISO 286-2 h8.

<table>
<thead>
<tr>
<th>OUTSIDE DIAMETER</th>
<th>TOLERANCE +/-</th>
</tr>
</thead>
<tbody>
<tr>
<td>mm</td>
<td>inches</td>
</tr>
<tr>
<td>6 - 10</td>
<td>0.23 - 0.39</td>
</tr>
<tr>
<td>&gt;10 - 18</td>
<td>&gt; 0.39 - 0.70</td>
</tr>
<tr>
<td>&gt;18 - 30</td>
<td>&gt; 0.70 - 1.81</td>
</tr>
</tbody>
</table>

ID/OD ratio: Tube production can be controlled over full length to maintain small IDs from 0.3 to 0.15 of OD.

TUBING QUALITY STANDARDS

- ASTM F136-Ti6-4 ELI
- ASTM F138-316L-316LVM
- ASTM F1314-22Cr-13Ni-5Mn
- BS ISO 5832-9
- ISO-DIS 25832-1
GLOBAL PRESENCE

Through the partnership between U.K.-based Fine Tubes and U.S.-based Superior Tube, both companies can offer increased capabilities, leading to significantly reduced lead times, an extended product portfolio, increased global reach and outstanding customer service.

Fine Tubes and Superior Tube are collectively a unit of AMETEK, Inc., a leading global manufacturer of electronic instruments and electromechanical devices.

In addition to tube mills in the United Kingdom and the United States, we have sales offices in Germany, France, India and the United States, as well as an extensive network of partners in Asia, Europe and the Middle East.

Our tubing experts deliver high precision tubing to customers in over 35 countries worldwide.

GLOBAL SALES OFFICES AND AGENTS NETWORK

MILL LOCATIONS
OFFICES
AGENTS
1. CHINA
2. KOREA
3. JAPAN
4. MIDDLE EAST
HIGH PRECISION TUBES FOR DEMANDING ENVIRONMENTS
MEDICAL

FINE TUBES
Plymbridge Road
Plymouth
PL6 7LG
UNITED KINGDOM

E: medical.finetubes@ametek.com
T: +44 (0) 1752 876416
F: +44 (0) 1752 733301

www.finetubes.com

SALES OFFICES

Sales Office Europe West
23, Rue Antigna
F-45000 Orléans
FRANCE

E: sales.fr.finetubes@ametek.com
T: +33 (0) 238775-702
F: +33 (0) 238812-407

Sales Office Europe Central
AMETEK GmbH
Rudolf-Diesel-Strasse 16
D-40670 Meerbusch
GERMANY

E: sales.de.finetubes@ametek.com
T: +49 7345 235 9505
M: +49 173 3661337

Sales Office India
AMETEK Instruments India Pvt Ltd
601, Raaj Chambers
Old Nagardas Road
Andheri (East)
Mumbai - 400 069
INDIA

E: sales.in.finetubes@ametek.com
T: +91 (0) 22 6196 8200
F: +91 (0) 22 2836 3613

Sales Office U.S. West
11 631 NE 73rd Street
Kirkland, WA 98033-8107
UNITED STATES

E: dirk.fanning@ametek.com
T: +1 425.985.1398

Sales Office U.S. East
3900 Germantown Pike
Collegeville, PA 19426-3112
UNITED STATES

E: donna.l.brown@ametek.com
T: +1 610.489.5260

SUPERIOR TUBE
3900 Germantown Pike
Collegeville, PA 19426-3112
UNITED STATES

E: medical.superiortube@ametek.com
T: +1 610.489.5200
F: +1 610.489.5252

www.superiortube.com

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