

Cutting Stainless Steel Tubes

Overview¹

These directions will assist the user in properly cutting stainless steel tubes. Inline Design recommends using a [cold saw](#), [band saw](#), preferably oil fed. These saws will leave minimal burr and no heat marks. For round tubing, use [65S Stainless Steel Pipe Cutters](#).

Caution:

Wear protective ANSI approved safety glasses, working gloves and breathing mask all the times

Tools Required - *for demonstration, Inline Design is providing directions based on use of cut-off saw*

- 1) Cut-off saw
 - 2) Duct tape
 - 3) Abrasive disk/blade
 - 4) Paper towel
 - 5) [Disk sander](#)
 - 6) [Inner/outer reamer tool*](#)
-

Installation Instructions

- 1) Place duct tape on the clamp of the cut-off saw and to all other areas where the tube will touch the metal in order to protect the surface from getting scratched while being cut
 - 2) Mark cutting point, clamp the tubing in place and commence the cut
 - 3) Immerse the cut end into water to cool the cut tube
 - 4) File any sharp edges evenly with a fine metal file
 - 5) Clean the tube using paper towel and some household stainless cleaner
Note: if necessary, ream/deburr the outside and inside of the tube. Be careful not to scratch the tubing while deburring, keep the deburr tool straight
 - 6) To polish the cut, follow instructions for [maintaining stainless steel surface](#)
 - 7) Refer to [this document for installing end caps or flush angle fittings](#)
-

NOTE: A small amount of surface corrosion is not uncommon after a some exposure to weather or salty conditions. We recommend using our [passivation solution](#) or some sort of stainless polish to keep any surface corrosion from happening; more information available [on our Engineering Specs Page](#).

¹ This document includes hyperlinks and is intended to be viewed as a PDF file rather than print material