

Your KVA Martensitic Stainless tubes have been made in the U.S.A. from first quality domestic stainless alloys using the most modern forming, welding and precision thermal processing technology available...



For Framebuilders:

Machining tips:

- Tubes are hardened and tempered to 38-42HRC, so quality hole saws with cutting fluid/coolant are recommended for best tool life.
- If using abrasive belts/grinding drums for notching, take care not to overheat the tubes. Use coolant or dip in water periodically.

Brazing tips:

- Stainless steel lugs & braze-ons (type 304, 316 or 17-4PH) are recommended with 0.002-0.004" radial clearance.
- Low temp silver brazing alloy (Aufhauser A-56T, Harris Safety-Silv 56, or equivalent) recommended for minimal effect on tube strength.
- Brass brazing not recommended!!!

Welding tips:

- Stainless steel filler wire (ER309L) recommended for all joints - to steel, other stainless and KVA stainless tubes.
- Back purge with Argon gas.
- Post-weld tempering optional for improved fatigue performance (350-400°F for 20-30 min).
- Type 630 (17-4PH) wire can be used, but post-weld tempering as above is suggested.

General info:

- Steel lugs, braze-ons, mix-n-match tubes can be used but they must be painted to prevent corrosion.
- Take care not to contaminate KVA stainless tubes with rust-causing iron particles:
 - Use dedicated stainless sanding belts/pads
 - Do not use steel wool!!!

For Riders:

General Care instructions:

- Wipe down dirt, mud & grime after long rides with clean cloth.
- A mild soap solution can be used for stubborn road grime. Rinse & dry thoroughly.

Unpainted frames:

- After cleaning, to protect luster & finish, apply hi-quality automotive wax or stainless polish with soft, dry cloth & buff out.
- Alternatively, an anti-corrosion surface treatment spray can be used (Boeshield T-9 or equivalent)

Should any staining/spotting occur:

- Lightly buff with synthetic textured (Scotchbrite) pad or sponge in grain direction.
- Use WD-40 or similar for lubricant while removing stain.
- Use caution if tubes are mirror polished; check with your builder first and use WD-40 soaked soft cloth and work in small circles.
- Reapply wax, polish or protective coating when finished.
- Do not use steel wool!!!



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